මෙය රාජ්‍ය භාෂාවෙන් වෙනම මුද්‍රණය කර ඇත.

ලංකා ප්‍රමිති 96: 1970
CEYLON STANDARD 96: 1970
විශ්ව දශම වර්ග කිරීම U.D.C. 621: 882·082

විට්ව'ත් හැඩය ඇති සමාන්තර දළ ඉස්කුරුප්පු පොටවල මාන පිළිබඳ ලංකා ප්‍රමිති පිරිවිතර

Ceylon Standard Specification for Dimensions of Parallel Coarse Screw Thread of Whitworth Form

ලංකා ප්‍රමිති කාර්යාංශය
BUREAU OF CEYLON STANDARDS

CEYLON STANDARD SPECIFICATION FOR DIMENSIONS OF PARALLEL COARSE SCREW THREAD OF WHITWORTH FORM

C. S. 96: 1970

Gr.5

BUREAU OF CEYLON STANDARDS
53, Dharmapala Mawatha,
COLOMBO 3.

Ceylon Standards are subject to periodical revision in order to accommodate the progress made by industry. Suggestions for improvement will be recorded and brought to the notice of the Committees to which the revisions are entrusted.

This Standard does not purport to included all the necessary provisions of a contract.

BUREAU OF CEYLON STANDARDS
53, Dharmapala Mawatha,
Colombo 3.

Telephone: 26051, 26054, 26055 Telegrams: "PRAMIKA"

CEYLON STANDARD SPECIFICATION FOR DIMENSIONS OF PARALLEL COARSE SCREW THREAD OF WHITWORTH FORM

FOREWORD

This Ceylon Standard specification for parallel coarse screw thread of the Whitworth form has been prepared by the Drafting Committee on nuts and bolts. It was approved by the Mechanical Engineering Divisional Committee of the Bureau of Ceylon Standards and was authorised for adoption and publication by the Council of the Bureau on 14th August, 1970.

This standard includes details of basic sizes, limits and tolerances for British Standard Whitworth screw thread. These correspond to the medium class and free class bolts and normal class nuts of British Standard Specifications.

The British Standard on parallel screw thread of Whitworth form and the Indian Standard on screw threads were consulted in the preparation of this standard and the assistance gained therefrom is acknowledged.

1. SCOPE

This Ceylon Standard relates to parallel coarse screw threads of Whitworth form used for general engineering purposes. It provides for screw thread diameters from $\frac{1}{8}$ in to 6 in.

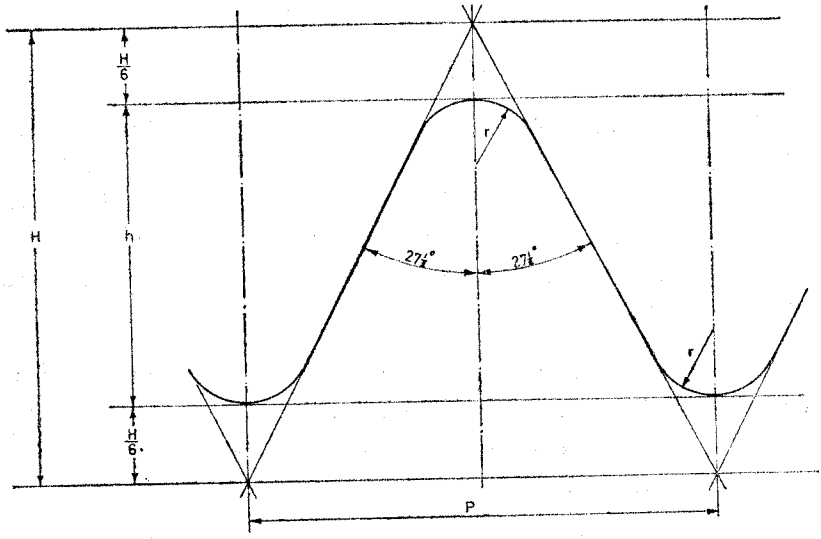
This standard is not intended to apply to threaded pipe joints, screw threads associated with interference fits such as those on the metal ends of studs and in the corresponding tapped holes, or to screw threads which are subject to high temperature.

2. DEFINITIONS

The definitions of terms relating to parallel threads are given in Appendix A.

3. THREAD FORM

The Whitworth basic thread form is shown in Fig. 1 below.



H = 0.960491p

h = $\frac{2}{3}$H = 0.640327p

H/6 = 0.160062p

r = 0.137329p

p = pitch

Fig. 1 Basic from of whitworth thread.

It is symmetrical V thread in which the angle between the flanks measured in an axial plane is 55°. One sixth of the sharp V is truncated at top and bottom, the thread being rounded equally at crests and roots by circular arcs blending tangentially with the flanks, the theoretical depth of thread being thus 0.640327 times the nominal pitch.

This basic thread depths calculated from the above definition are rounded off to the nearest 0.0001 inch.

4. CLASSES OF FIT

4·1 The classes of fit or classes of tolerance specified herein shall be medium class and free class for bolts and normal class for nuts.

The relative magnitudes and dispositions of the effective diameter tolerance zones for the class of tolerance mentioned above is shown in Fig. 2. It will be noted that the lower limit of the nut is always the basic size. An allowance amounting to 0.3x medium class bolt effective diameter tolerance is provided for mediums and free class bolts at nominal diameter $\frac{3}{4}$ in and below, between the lower limit for the nut (basic size) and the upper limit for the bolt.

4·1·1 **Medium class bolts and nuts.** The medium class applies to the better class of ordinary interchangeable screw threads.

4·1·2 **Free class bolts.** The free class applies to the majority of bolts of ordinary commercial quality.

4·1·3 **Normal class nuts.** The normal class applies to ordinary commercial quality nuts; this class is intended for use with medium or free class bolts.

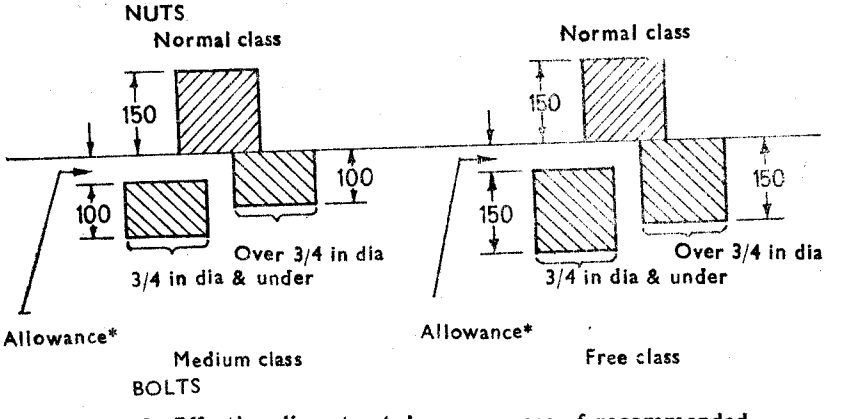


Fig. 2 Effective diameter tolerance zones of recommended combinations of classes of bolts & nuts.

Note:-

The medium class bolt effective diameter tolerance is shown as 100 units and the other values as expressed as a percentage of this tolerance.

5. DIMENSIONS AND TOLERANCES

5·1 A pictorial representation of the assembled condition of the nut and bolt threads, their tolerances and the allowance between them for the recommended combinations of clauses is shown in Fig. 3 and 4.

* See Clause 4

5·2 The basic sizes of the coarse thread series is given in Table 1 below:-

TABLE 1

BASIC SIZES OF THE COARSE THREAD SERIES

1	2	3	4	5	6	7	8
Nominal size	Number of threads per inch	Pitch	Depth of thread	Major diameter	Effective diameter	Minor diameter	Cross Sectional area at bottom of thread
in	in	in	in	in	in	in	sq. in
1/8*	40	0·02500	0·0160	0·1250	0·1090	0·0930	0·0068
3/16	24	0·04167	0·0267	0·1875	0·1608	0·1341	0·0141
1/4	20	0·05000	0·0320	0·2500	0·2180	0·1860	0·0272
5/16	18	0·05556	0·0356	0·3125	0·2769	0·2413	0·0457
3/8	16	0·06250	0·0400	0·3750	0·3350	0·2950	0·0683
7/16	14	0·07143	0·0457	0·4375	0·3918	0·3461	0·0941
1/2	12	0·08333	0·0534	0·5000	0·4466	0·3932	0·1214
9/16*	12	0·08333	0·0534	0·5625	0·5091	0·4557	0·1631
5/8	11	0·09091	0·0582	0·6250	0·5668	0·5086	0·2032
11/16*	11	0·09091	0·0582	0·6875	0·6293	0·5711	0·2562
3/4	10	0·10000	0·0640	0·7500	0·6860	0·6220	0·3039
7/8	9	0·11111	0·0711	0·8750	0·8039	0·7328	0·4218
1	8	0·12500	0·0800	1·0000	0·9200	0·8400	0·5542
1 1/8	7	0·14286	0·0915	1·1250	1·0335	0·9420	0·6969
1 1/4	7	0·14286	0·0915	1·2500	1·1585	1·0670	0·8942
1 1/2	6	0·16667	0·1067	1·5000	1·3933	1·2866	1·3000
1 3/4	5	6·20000	0·1281	1·7500	1·6219	1·4938	1·7530
2	4·5	0·22222	0·1423	2·0000	1·8577	1·7154	2·3110
2 1/4	4	0·25000	0·1601	2·2500	2·0899	1·9298	2·9250
2 1/2	4	0·25000	0·1601	2·5000	2·3399	2·1798	3·7320
2 3/4	3·5	0·28571	0·1830	2·7500	2·5670	2·3840	4·4640
3	3·5	0·28571	0·1830	3·0000	2·8170	2·6340	5·4490
3 1/4*	3·25	0·30769	0·1970	3·2500	3·0530	2·8560	6·4060
3 1/2	3·25	0·30769	0·1970	3·5000	3·3030	3·1060	7·5770
3 3/4*	3	0·33333	0·2134	3·7500	3·5366	3·3232	8·6740
4	3	0·33333	0·2134	4·0000	3·7866	3·5732	10·0300
4 1/2	2·875	0·34783	0·2227	4·5000	4·2773	4·0546	12·9100
5	2·75	0·36364	0·2328	5·0000	4·7672	4·5344	16·1500
5 1/2	2·625	0·38095	0·2439	5·5000	5·2561	5·0122	19·7300
6	2·5	0·40000	0·2561	6·0000	5·7439	5·4878	23·6500

* To be dispensed with wherever possible.

† Dimensionally, the ⅛ in. x 40 t.p.i. thread belongs more appropriately to the B.S.F. series, but it has for so long been associated with the B.S.W. series that it is now included herein.

A — Max. minor dia. of nut

B — Basic minor dia.

Min. minor dia. of nut

C — Max. minor dia. of bolt

D — Min. minor dia. of bolt

E — Min. eff. dia. of bolt

F — Max. eff dia. of bolt

G — Basic eff. dia

Min. eff. dia of nut

H — Max. eff. dia of nut

I — Minor major dia. of bolt

J — Max. major dia of bolt

K — Basic major dia.

Min. major dia. of utn

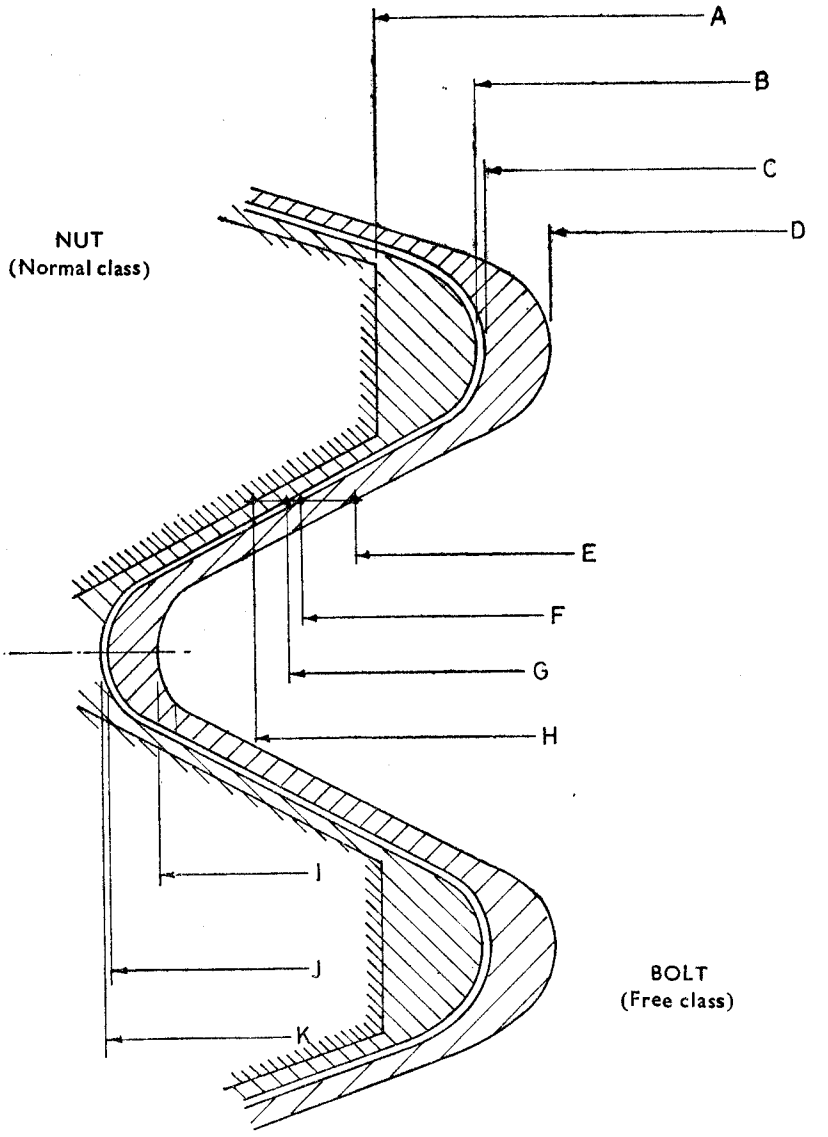


Fig. 3 Tolerance zones for medium class bolts with allowance and normal class nut ¼ in. B.S.W. (20 t.p.i.) illustrated

Note:- The maximum bolt dimensions refer to unplated bolts only.

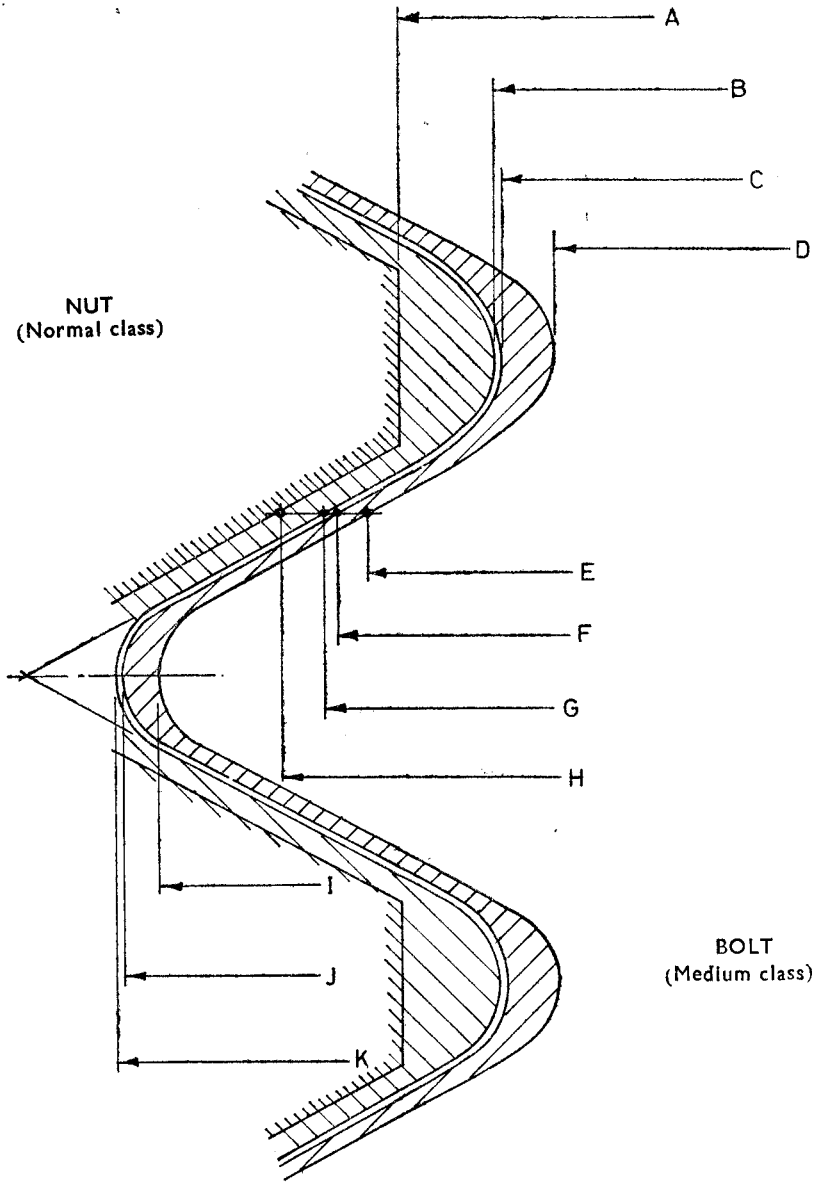


Fig. 4 Tolerance zones for free class bolt with allowance and normal class nut $\frac{1}{4}$ in. B·S·W· (20 t·p·i·) illustrated.

Note:- The maximum dimensions apply to unplated bolts only.

A — Max. minor dia. of nut

B — Basic minor dia.

Min. minor dia of nut

C — Max. minor dia. of bolt

D — Min. minor dia of bolt

E — Min. eff. dia. of bolt

F — Max. eff. dia. of bolt

G — Basic eff. dia.

Min. eff. dia. of nut

H — Max. eff. dia. of nut

I — Min. major dia. of bolt

J — Max. major dia. of bolt

K — Basic major dia.

Min. major dia. of nut

5·3 The dimensions and tolerances of normal class coarse pitch threads for nuts are shown in Table 2 below:-

TABLE 2.

NUTS - NORMAL CLASS LIMITS AND TOLERANCES

1	2	3	4	5	6	7	8	9
Nominal size	Number of threads per inch	Major diameter	Effective diameter			Minor diameter		
		Min.	Max.	Tol.	Min.	Max.	Tol.	Min.
in	in	in	in	in	in	in	in	in
¼*	40	0·1250	0·1133	0·0043	0·1090	0·1020	0·0090	0·0930
3/16	24	0·1875	0·1660	0·0052	0·1608	0·1474	0·0133	0·1341
1/4	20	0·2500	0·2238	0·0058	0·2180	0·2030	0·0170	0·1860
5/16	18	0·3125	0·2832	0·0063	0·2769	0·2594	0·0181	0·2413
3/8	16	0·3750	0·3418	0·0068	0·3350	0·3145	0·0195	0·2950
7/16	14	0·4375	0·3991	0·0073	0·3918	0·3674	0·0213	0·3461
1/2	12	0·5000	0·4543	0·0077	0·4466	0·4169	0·0237	0·3932
9/16*	12	0·5625	0·5171	0·0080	0·5091	0·4794	0·0237	0·4557
5/8	11	0·6250	0·5752	0·0084	0·5668	0·5338	0·0252	0·5086
11/16*	11	0·6875	0·6379	0·0086	0·6293	0·5963	0·0252	0·5711
3/4	10	0·7500	0·6950	0·0090	0·6860	0·6490	0·0270	0·6220
7/8	9	0·8750	0·8135	0·0096	0·8039	0·7620	0·0290	0·7328
1	8	1·0000	0·9302	0·0102	0·9200	0·8720	0·0320	0·8400
1⅛	7	1·1250	1·0442	0·0107	1·0355	0·9776	0·0356	0·9420
1¼	7	1·2500	1·1696	0·0111	1·1585	1·1026	0·0356	1·0670
1½	6	1·5000	1·4053	0·0120	1·3933	1·3269	0·0403	1·2866
1⅞	5	1·7500	1·6348	0·0129	1·6219	1·5408	0·0470	1·4938
2	4·5	2·0000	1·8714	0·0137	1·8577	1·7668	0·0514	1·7154
2¼	4	2·2500	2·1043	0·0144	2·0899	1·9868	0·0570	1·9298
2½	4	2·5000	2·3548	0·0149	2·3399	2·2368	0·0570	2·1798
2⅞	3·5	2·7500	2·5827	0·0157	2·5670	2·4481	0·0641	2·3840
3	3·5	3·0000	2·8331	0·0161	2·8170	2·6981	0·0641	2·6340
3¼*	3·25	3·2500	3·0697	0·0167	3·0530	2·9245	0·0685	2·8560
3½	3·25	3·5000	3·3201	0·0171	3·3030	3·1745	0·0685	3·1060
3⅞	3	3·7500	3·5543	0·0177	3·5366	3·3969	0·0737	3·3232
4	3	4·0000	3·8047	0·0181	3·7866	3·6469	0·0737	3·5732
4½	2·875	4·5000	4·2962	0·0189	4·2773	4·1312	0·0766	4·0546
5	2·75	5·0000	4·7869	0·0197	4·7672	4·6141	0·0797	4·5344
5½	2·625	5·5000	5·2766	0·0205	5·2561	5·0954	0·0832	5·0122
6	2·5	6·0000	5·7651	0·0212	5·7439	5·5748	0·0870	5·4878

* To be dispensed with wherever possible.

5·4 The dimensions and tolerances of medium class coarse pitch threads for bolts and screws are shown in Table 3.

TABLE 3

BOLTS - MEDIUM CLASS - LIMITS AND TOLERANCES

(a) Nominal sizes up to and including $\frac{3}{4}$ in.

1	2	3	4	5	6	7	8	9	10	11	12	13	14
Nominal size	Number of threads per inch	Major diameter				Effective diameter				Minor diameter			
		Unplated or before plating			After plating	Unplated or before plating			After plating	Unplated or before plating			After plating
		Max.	Tol.	Min.	Max.	Max.	Tol.	Min.	Max.	Max.	Tol.	Min.	Max.
in		in	in	in	in	in	in	in	in	in	in	in	in
1/8*	40	0·1238	0·0045	0·1193	0·1250	0·1078	0·0029	0·1049	0·1090	0 0918	0·0061	0·0857	0·0930
3/16	24	0·1863	0·0055	0·1808	0·1875	0·1596	0·0035	0·1561	0·1608	0·1329	0·0076	0·1253	0 1341
1/4	20	0·2488	0·0061	0·2427	0·2500	0·2168	0·0039	0·2129	0·2180	0·1848	0·0084	0·1764	0·1860
5/16	18	0·3112	0·0066	0·3046	0·3125	0·2756	0·0042	0·2714	0·2769	0·2400	0·0089	0·2311	0·2413
3/8	16	0·3736	0·0070	0·3666	0·3750	0·3336	0·0045	0·3291	0·3350	0·2936	0 0095	0·2841	0·2950
7/16	14	0·4360	0·0075	0·4285	0·4375	0·3903	0·0048	0·3855	0·3918	0·3446	0·0101	0·3345	0·3461
1/2	12	0·4985	0·0081	0·4904	0·5000	0·4451	0·0052	0·4399	0·4466	0·3917	0·0110	0·3807	0·3932
9/16*	12	0·5609	0·0082	0·5527	0·5625	0·5075	0·0053	0·5022	0·5091	0·4541	0·0111	0·4430	0·4557
5/8	11	0·6233	0·0085	0·6147	0·6250	0·5651	0·0056	0·5595	0·5668	0·5069	0·0116	0·4953	0·5086
11/16*	11	0·6858	0·0088	0·6770	0·6875	0·6276	0·0058	0·6218	0·6293	0·5694	0·0118	0·5576	0·5711
3/4	10	0·7482	0·0092	0·7390	0·7500	0·6842	0·0060	0·6782	0·6860	0·6202	0·0123	0·6079	0·6220

* To be dispensed with wherever possible.

TABLE 4

BOLTS - FREE CLASS - LIMITS AND TOLERANCES

(a) Nominal sizes up to and including $\frac{3}{4}$ in.

1	2	3	4	5	6	7	8	9	10	11	12	13	14
Nominal size	Number of threads per inch	Major diameter				Effective diameter				Minor diameter			
		Unplated or before plating			After plating	Unplated or before plating			After plating	Unplated or before plating			After plating
		Max.	Tol.	Min.	Max.	Max.	Tol.	Min.	Max.	Max.	Tol.	Min.	Max.
in		in	in	in	in	in	in	in	in	in	in	in	in
1/8*	40	0·1238	0·0059	0·1179	0·1250	0·1078	0·0043	0·1035	0·1090	0·0918	0·0075	0·0843	0·0930
3/16	24	0·1863	0·0072	0·1791	0·1875	0·1596	0·0052	0·1544	0·1608	0·1329	0·0093	0·1236	0·1341
1/4	20	0·2488	0·0080	0·2408	0·2500	0·2168	0·0058	0·2110	0·2180	0·1848	0·0103	0·1745	0·1860
5/16	18	0·3112	0·0087	0·3025	0·3125	0·2756	0·0063	0·2693	0·2769	0·2400	0·0110	0·2290	0·2413
3/8	16	0·3736	0·0093	0·3643	0·3750	0·3336	0·0068	0·3268	0·3350	0·2936	0·0118	0·2818	0·2950
7/16	14	0·4360	0·0100	0·4260	0·4375	0·3903	0·0073	0·3830	0·3918	0·3446	0·0126	0·3320	0·3461
1/2	12	0·4985	0·0106	0·4879	0·5000	0·4451	0·0077	0·4374	0·4466	0·3917	0·0135	0·3782	0·3932
9/16*	12	0·5609	0·0109	0·5500	0·5625	0·5075	0·0080	0·4995	0·5091	0·4541	0·0138	0·4403	0·4557
5/8	11	0·6233	0·0114	0·6119	0·6250	0·5651	0·0084	0·5567	0·5668	0·5069	0·0144	0·4925	0·5086
11/16*	11	0·6858	0·0116	0·6742	0·6875	0·6276	0·0086	0·6190	0·6293	0·5694	0·0146	0·5548	0·5711
3/4	10	0·7482	0·0122	0·7360	0·7500	0·6842	0·0090	0·6752	0·6860	0·6202	0·0153	0·6049	0·6220

* To be dispensed with wherever possible.

Table 4 – Continuation

TABLE 4
BOLTS - FREE CLASS - LIMITS AND TOLERANCES

(b) Nominal sizes above $\frac{3}{4}$ in.

1	2	3	4	5	6	7	8	9	10	11
Nominal size	Number of threads per inch	Major diameter			Effective diameter			Minor diameter		
		Max.	Tol.	Min.	Max.	Tol.	Min.	Max.	Tol.	Min.
in		in	in	in	in	in	in	in	in	in
7/8	9	0·8750	0·0129	0·8621	0·8039	0·0096	0·7943	0·7328	0·0163	0·7165
1	8	1·0000	0·0137	0·9863	0·9200	0·0102	0·9098	0 8400	0·0173	0·8227
1 1/8	7	1·1250	0·0145	1·1105	1·0335	0·0107	1·0228	0·9420	0·0183	0·9237
1 1/4	7	1·2500	0·0149	1·2351	1·1585	0·0111	1·1474	1·0670	0·0187	1·0483
1 1/2	6	1·5000	0·0161	1·4839	1·3933	0·0120	1·3813	1·2866	0·0202	1·2664
1 3/4	5	1·7500	0·0174	1·7326	1·6219	0·0129	1·6090	1·4938	0·0218	1·4720
2	4·5	2·0000	0·0184	1·9816	1·8577	0·0137	1·8440	1·7154	0 0231	1·6923
2 1/4	4	2·2500	0·0194	2·2306	2·0899	0·0144	2·0755	1·9298	0·0244	1·9054
2 1/2	4	2·5000	0·0199	2·4801	2·3399	0·0149	2·3250	2·1798	0·0249	2·1549
2 3/4	3·5	2·7500	0·0210	2·7290	2·5670	0·0157	2·5513	2·3840	0·0264	2·3576
3	3·5	3·0000	0·0214	2·9786	2·8170	0·0161	2·8009	2·6340	0·0268	2·6072
3 1/4*	3·25	3·2500	0·0223	3·2277	3·0530	0 0167	3·0363	2·8560	0·0278	2·8282
3 1/2	3·25	3·5000	0·0227	3·4773	3·3030	0·0171	3·2859	3·1060	0·0282	3·0778
3 3/4*	3	3·7500	0·0235	3·7265	3·5366	0·0177	3·5189	3·3232	0·0293	3·2939
4	3	4·0000	0·0239	3·9761	3·7866	0 0181	3·7685	3·5732	0·0296	3·5436
4 1/2	2·875	4·5000	0·0248	4·4752	4·2773	0·0189	4·2584	4·0546	0·0307	4·0239
5	2·75	5·0000	0 0257	4·9743	4·7672	0·0197	4·7475	4·5344	0·0318	4·5026
5 1/2	2·625	5·5000	0 0267	5·4733	5·2561	0·0205	5·2356	5·0122	0·0328	4·9794
6	2·5	6·0000	0·0275	5·9725	5·7439	0·0212	5·7227	5·4878	0·0339	5·4539

* To be dispensed with wherever possible.

6. DESIGNATION

In drawings and related documents the screw thread covered in this Standard shall be designated by the following:-

(a) Name of series BSW

(b) Basic major diameter of thread

(c) Number of threads per inch

(d) Class of fit

If the thread is left-hand the symbol LH should follow the designation.

e. g.

$\frac{1}{4}$ in – 20 B.S.W. free class
or $\frac{1}{2}$ in – 12 B.S.W. LH medium class

APPENDIX A

A-1 Definitions relating to parallel screw threads.

A-1·1 **Screw thread** – The ridge produced by forming, on the surface of a cylinder or cone, a continuous helical or spiral groove of uniform section, such that, the distance measured parallel to the axis between two corresponding points on its contour is proportional to their relative angular displacement about the axis.

A-1·2 **Parallel screw thread** – A thread formed on the surface of a cylinder (see fig. 5).

A-1·3 **Form** – The shape of one complete profile of the thread between corresponding points, at the bottom of adjacent grooves, as shown in an axial plane section.

A-1·4 **Basic Form** – The theoretical form on which the design forms for both the external and internal threads are based (see Fig. 1).

A-1·5 **Design Form** - The form of the external and internal thread in relation to which the limits of tolerances are assigned.

A-1·6 **Flanks** - Those parts of the surface on either side of the thread, the intersection of which with an axial plane are theoretically straight lines (see Fig. 5).

A-1·7 **Crest** - That part of the surface of a thread which connects adjacent flanks at the top of the ridge (see Fig. 6 and 7).

A-1·8 **Included angle of thread** - The angle between the flanks of the thread measured in an axial plane section (see Fig. 5).

A-1·9 **Axis** - The axis of the pitch cylinder of a screw thread (see Fig 6 & 7).

A-1·10 **Pitch** - The distance, measured parallel to the axis, between corresponding points on adjacent thread forms in the same axial plane section and on the same side of the axis (see Fig. 8).

A-1·11 **Major diameter** - The diameter of the major cylinder of a parallel thread in a specified plane normal to the axis (see Fig. 6 & 7).

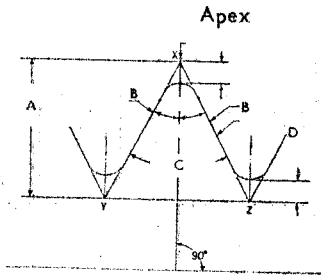
A-1·12 **Minor diameter** - The diameter of the minor cylinder of a parallel thread in a specified plane normal to the axis (see Fig. 6 & 7).

A-1·13 **Pitch diameter** - The diameter of the pitch cylinder of a parallel thread in a specified plane normal to the axis (see Fig. 6 & 7).

A-1·14 **Fit** - The relationship existing between two mating parts with respect to the amount of clearance which is present.

A-1·15 **Class of fit** - Indicates the general character of the fit that may occur between pairs of mating parts made within prescribed limits.

A-1·16 **Depth of thread** - The radial distance between its major and minor cylinders.



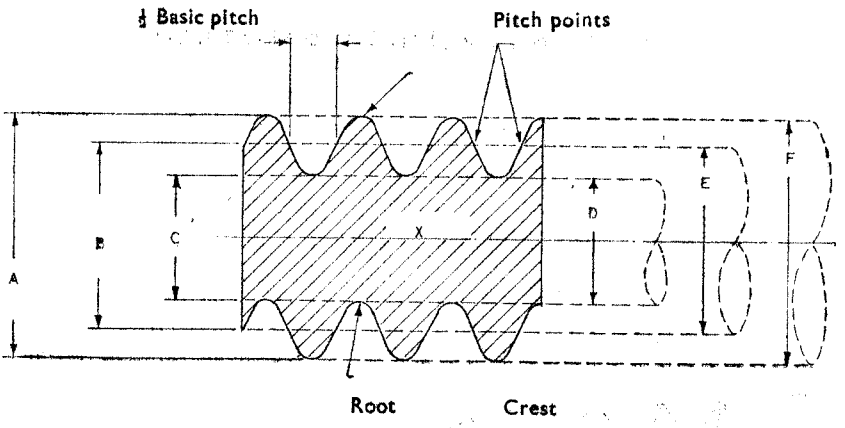
A = Height of fundamental triangle

B = Flank

C = Included angle

D = Basic truncation

FIG. 5. Fundamental Triangle and Basic Truncation of a Parallel Screw Thread.



A = Major dia.

B = Pitch dia.

C = Minor dia.

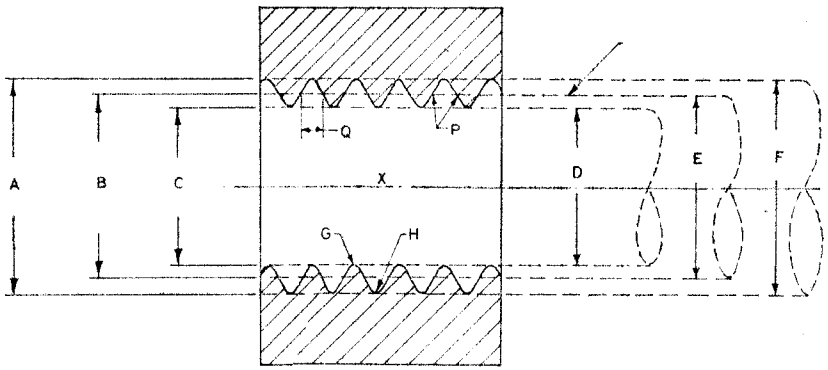
D = Minor cylinder

E = Pitch cylinder

F = Major cylinder

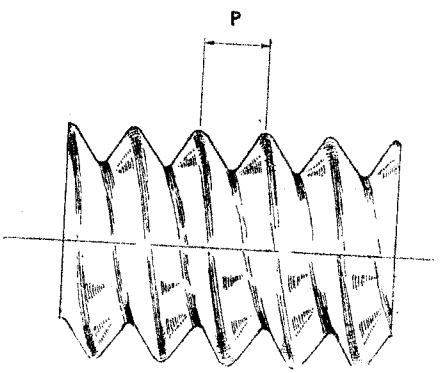
X = Axis

FIG. 6. External Parallel Screw Thread.



A = Major dia.
B = Pitch dia.
C = Minor dia.
D = Minor cylinder
E = Pitch cylinder
F = Major cylinder
G = Crest
H = Root
P = Pitch point
O = ½ Basic pitch

FIG. 7. INTERNAL PARALLEL SCREW THREAD.



P = Pitch

FIG. 8. SINGLE-START SCREW THREAD (RIGHT HAND)

BUREAU OF CEYLON STANDARDS

The Bureau of Ceylon Standards (BCS) is the national standards organisation of Ceylon and was established by the Hon. Minister of Industries & Fisheries, as provided for by the Bureau of Ceylon Standards Act, No. 38 of 1964.

The principal objects of the Bureau as set out in the Act are to promote standards in industry and commerce, prepare national standard specifications and codes of practice and operate a Standardisation Marks Scheme and provide testing facilities, as the need arises.

The Bureau is financed by Government grants and the sale of its publications. Financial and administrative control is vested in a Council appointed in accordance with the provisions of the Act.

The detailed preparation of standard specifications are done by Drafting Committees composed of experts in each particular field assisted by permanent officers of the Bureau. These Committees are appointed by Divisional Committees, which are appointed by the Council. All members of the Drafting and Divisional Committees render their services in an honorary capacity. In preparing the standard specifications the Bureau endeavours to ensure adequate representation of all view points.

In the international field the Bureau represents Ceylon in the International Organisation for Standardisation (ISO) and will participate in such fields of standardisation as are of special interest to Ceylon.

Printed at the Swadeshi Printers 341, Olcott Mawatha, Colombo 10 for the Bureau of Ceylon Standards, 53, Dharmapala Mawatha, Colombo 3.