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CEYLON STANDARD 158 : 1972

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SPECIFICATION FOR TEE SQUARES

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BUREAU OF CEYLON STANDARDS

SPECIFICATION FOR TEE SQUARES (METRIC UNITS)

C.S. 158 : 1972

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CEYLON STANDARD SPECIFICATION FOR TEE SQUARES

(Metric Units)

FOREWORD

This Ceylon Standard was prepared by the Drafting Committee on Drawing Boards and Tee Squares under the authority of the Metric Divisional Committee of the Bureau of Ceylon Standards, and was approved for adoption and publication by the Council of the Bureau on 4th August 1972.

This Standard lays down requirements of Tee Squares for use with Drawing Boards specified in C.S. 157 'Ceylon Standard Specification for Drawing Boards.'

All dimensions specified in this standard are in metric (SI) units. Inch equivalents of these dimensions are given within brackets. These equivalent values have been calculated in accordance with C.S. 116 : 1971 'Ceylon Standard for Principles of Conversion.'

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or measurement, shall be rounded off in accordance with C.S. 102, 'Presentation of Numerical Values.' The number of significant places retained in the rounded off value shall be the same as that of the value specified in this standard.

In preparing this standard assistance derived from the following Indian and British Standards is acknowledged.

IS : 1360–1963 : Specification for Engineers' Pattern Tee Squares,

BS : 1266–1958 : Engineers' Pattern Tee Squares,

BS : 1268–1958 : Students' Tee Squares.

1. SCOPE

This Standard specifies the dimensions, materials and constructional details of Tee Squares.

2. DIMENSIONS

Dimensions of the finished tee squares shall be as given in Table and Fig. 1.

3. CONSTRUCTIONAL REQUIREMENTS

The tapered blade shall be screwed upon the stock without being either sunk or mortised into it so that, in use, the upper surface of the stock is in the same plane as the surface of the board. Working edges shall be securely glued to the blade and stock respectively and shall be bevelled.

4. MATERIALS

4.1 Blade and the stock shall be made of any one of the following species of timber

Teak (*Tectona grandis* Linn.f)
Mahogany (*Swietenia macrophylla* King).

4.2 The Working edges of the stock and blade shall be made of a well seasoned, dense, close and fine-grained wood such as ebony (*Diospyros ebenum* Koenig).

4.3 The timber used shall be well seasoned and mature, free from knots, splits, checks, sap, and other defects which may affect the serviceability of the tee squares and shall have a moisture content of 12% to 15% determined in the manner described in Appendix A.

4.4 The blade shall be glued and fixed to the stock by means of two hard wood dowel pins and six counter-sunk head brass wood screws conforming to C.S. 6 : 1967 (Ceylon Standard Specification for Wood Screws).

5. QUALITY OF MANUFACTURE

All edges shall be true. Working edges of blade and stock shall be straight to within the limits given in Table I when measured with the use of a straight edge and form an angle of $90° \pm 0°30'$. Blade and stock shall be free from bow and twist within the limits given in Table I.

6. OTHER REQUIREMENTS

A round hole approximately 10 mm (0.4 in) in diameter, shall be provided in the blade as shown in Fig. 1.

7. FINISH

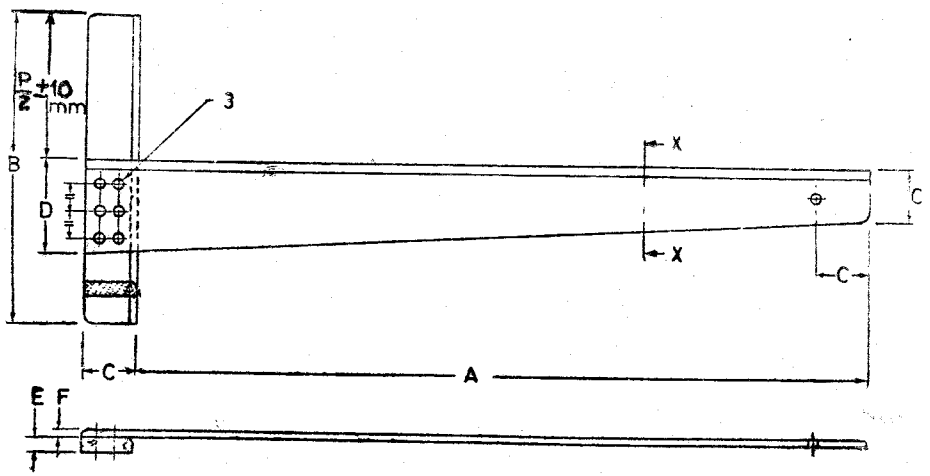
7.1 The tee squares shall be finished smooth all over. They shall be waxed or polished all over except the working edges which shall be left clean.

8. PACKAGING

8.1 Unless otherwise specified each tee square shall be properly protected to prevent damage, in particular to the working edges, in transit and in store.

TABLE I
DIMENSIONS OF TEE SQUARES

A		B		C		D		E		F		Tolerance on straightness of working edge of blade	Bow or Twist	Recommended for use with Drawing Board size (given in C.S. 157)
Dimension	Tolerance	Dimension	Tolerance	Dimension	Tolerance	Dimension	Tolerance	Dimension	Tolerance	Dimension	Tolerance			
mm (in)	mm	mm (in)	mm	mm (in)	mm	mm (in)	mm	mm (in)	mm	mm (in)	mm	mm (in)	mm (in)	mm (in)
1500 (59.1)	±5	440 (17.3)	±5	70 (2.8)	±3	120 (4.7)	±5	16 (0.6)	±1	7 (0.28)	±0.5	0.5 (0.02)	1.5 (0.06)	1000×1500 (39.4×59.1)
1270 (50.0)	±5	400 (15.7)	±5	65 (2.6)	±3	110 (4.3)	±5	16 (0.6)	±1	6 (0.24)	±0.5	0.5 (0.02)	1.5 (0.06)	920×1270 (36.2×50.0)
920 (36.2)	±3	350 (13.8)	±3	60 (2.4)	±3	100 (3.9)	±5	16 (0.6)	±1	6 (0.24)	±0.5	0.3 (0.01)	1.0 (0.04)	650×920 (25.6×36.2)
650 (25.6)	±3	300 (11.8)	±3	50 (2.0)	±3	90 (3.5)	±5	14 (0.5)	±1	5 (0.20)	±0.5	0.3 (0.01)	0.5 (0.02)	470×650 (18.5×25.6)
500 (19.7)	±3	280 (11.0)	±3	45 (1.8)	±3	80 (3.1)	±5	14 (0.5)	±1	5 (0.20)	±0.5	0.2 (0.008)	0.5 (0.02)	350×500 (13.8×19.7)



1. Enlarged view at A.
2. Section XX.
3. Counter sunk head wood screws and dowel pins.

APPENDIX A

METHOD FOR THE DETERMINATION OF MOISTURE CONTENT

(i) Selection of samples

For the purpose of carrying out the test for moisture content the purchaser, or his representative, may select, during the course of manufacture, suitable samples of the timber used in the construction.

If the test for moisture content is to be carried out immediately after the cutting of the samples, these samples may take the form of the test pieces specified in (ii) Method of test, but if the first weighing cannot be carried out immediately after the cutting of the sample, the samples shall consist of pieces not less than 480 mm (18.9 in) in length cut from the stock. The final test pieces shall be cut from the middle of the above pieces when the test is made.

(ii) Method of test

The test pieces of the timber shall be taken at a point not less than 230 mm (9.1 in) from the end of the sample and shall be cut to include the full cross section of the samples and shall be 20 mm (0.8 in) long in the direction of the grain. They shall be weighed (M_1) immediately after cutting and then dried in an oven at a temperature of 100° to 105°C until the mass is constant (M_0) and again weighed immediately after removal from the drying oven; the percentage of moisture content (X) shall then be determined from the formula:

$$X = \frac{M_1 - M_0}{M_0} \times 100$$

where M_1 = initial mass, M_0 = dry mass, X = moisture content.

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