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SRI LANKA STANDARD 268:1974

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SPECIFICATION FOR ISO METRIC SCREW THREADS

Part IV — Tolerancing System

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BUREAU OF CEYLON STANDARDS

SPECIFICATION FOR ISO METRIC SCREW THREADS

PART IV — TOLERANCING SYSTEM

S. L. S. 268 : 1974

Gr.7

BUREAU OF CEYLON STANDARDS
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Sri Lanka 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 include all the necessary provisions of a contract.

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SRI LANKA STANDARD SPECIFICATION FOR ISO METRIC SCREW THREADS

Part IV—Tolerancing System

FOREWORD

This Sri Lanka Standard Specification was prepared by the Drafting Committee on Metric Screw Threads. 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 21st May, 1974.

Although this standard is not a revision of the C.S. 96, "Specification for Dimensions of Parallel Coarse Screw Threads of Whitworth Form", this standard will replace it in due course.

This standard is being issued in different parts as under

Part	I	—	Basic and Design Profiles
Part	II	—	Pitch/Diameter combinations
Part	III	—	Basic Dimensions
Part	IV	—	Tolerancing System
Part	V	—	Tolerances
Part	VI	—	Limits of sizes for commercial bolts screws and nuts.

This standard (Part IV) is based on ISO/R 965/1, "ISO General Purpose Metric Screw Threads — Tolerances, Principles and Basic Data" issued by the International Organisation for Standardization. In the preparation of this standard the assistance derived from the publications of the Indian Standards Institution is acknowledged.

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 shall be rounded off in accordance with C.S. 102. The number of significant places retained in the rounded off value should be the same as that of the specified value.

1. SCOPE

This standard (Part IV) specifies a tolerance system for ISO Metric Screw Threads for the diameter range 1 to 300 mm. The tolerance values have been tabulated for the normal length of engagement only.

2. TERMINOLOGY AND SYMBOLS

2.1 **Terminology:** For the purpose of this standard the following terms shall apply.

2.1.1 **Nut Thread:** This shall mean to include the internal threads.

2.1.2 **Bolt Thread:** This shall mean to include the external threads.

2.1.3 **Crest Diameter:** Crest diameter shall mean, in case of nut threads, minor diameter and in case of bolt thread, major diameter.

2.2 **Symbols:** The various symbols used in this standard shall denote the quantities given below against each:

Symbol	*Explanation*
D	basic major diameter of nut thread
D_1	basic minor diameter of nut thread
D_2	basic pitch diameter of nut thread
d	basic major diameter of bolt thread
d_1	basic minor diameter of bolt thread
d_2	basic pitch diameter of bolt thread
d_3	design minor diameter of bolt thread
P	pitch
R	bolt root radius
S	designation for thread engagement group short
N	designation for thread engagement group normal
L	designation for thread engagement group long
T	tolerance
T_{D_1} T_{D_2} Td T_{d_2}	tolerances for D_1, D_2, d, d_2.
ei, EI	lower deviations
es, ES	upper deviations

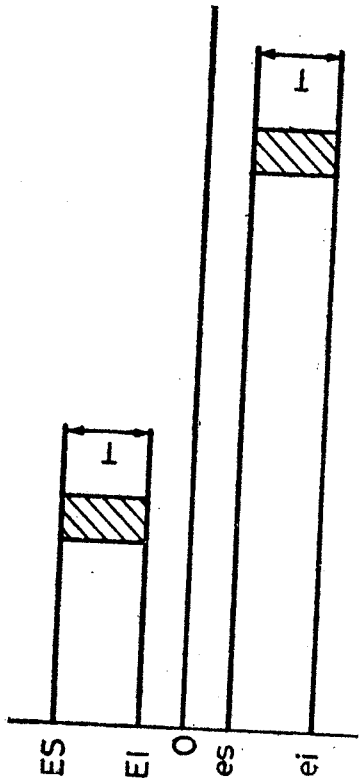


Fig. 1—Tolerance positions with respect to Zero line (basic size)

3. STRUCTURE OF THE TOLERANCE SYSTEM

3.1 The system provides for tolerances defined by tolerance grades, tolerance positions, and also a selection of grades and positions constituting tolerance classes.

3.2 Tolerance Grades — For each of the two main elements, pitch diameter and crest diameter, a number of tolerance grades have been established as follows:

	Tolerance Grade
Minor diameter of nut threads	4, 5, 6, 7, 8
Major diameter of bolt threads	4, 6, 8
Pitch diameter of nut threads	4, 5, 6, 7, 8
Pitch diameter of bolt threads	3, 4, 5, 6, 7, 8, 9

3.2.1 The grades 3, 4 and 5 correspond to precision threads where little variation of fit is required as well as to short lengths of thread engagement.

3.2.2 The grade 6 should be used for medium quality corresponding to the general run of commercial bolts and nuts.

3.2.3 The grades 7, 8 and 9 correspond to threads produced by less precise methods, such as cutting screw threads directly on hot rolled bars and long blind holes. These grades are intended for coarse quality as well as for long lengths of thread engagement.

3.3 **Tolerance Position**

3.3.1 The tolerance position shall be so as to meet the current coating thicknesses and the requirements of easy assembly. The tolerance positions for bolt and nut threads are as indicated in Figs. 2, 3, 4 and 5.

3.3.2 The tolerance position 'e', however, is limited to pitches 0.5 mm and coarser.

3.4 **Tolerance Classes** — The combination of tolerance grade and tolerance position shall constitute a tolerance class. In principle, any of the tolerance grades may be combined with any of the tolerance positions thereby giving rise to a large number of tolerance classes. In order to reduce the number of gauges and tools, the tolerance classes should preferably be chosen from Tables 1 and 2.

3.4.1 Any of the preferred tolerance classes for nuts may be combined with any of the preferred tolerance classes for bolts. However, in order to guarantee sufficient overlap, the finished components should preferably be made to form the fits H/g, H/h or G/h (for P less than 0.5 only H/h is recommended).

Examples:

M6	—	6H/6g
M12 x 1.25	—	5H/4h
M20 x 2	—	7G/6h

4. LENGTHS OF THREAD ENGAGEMENT

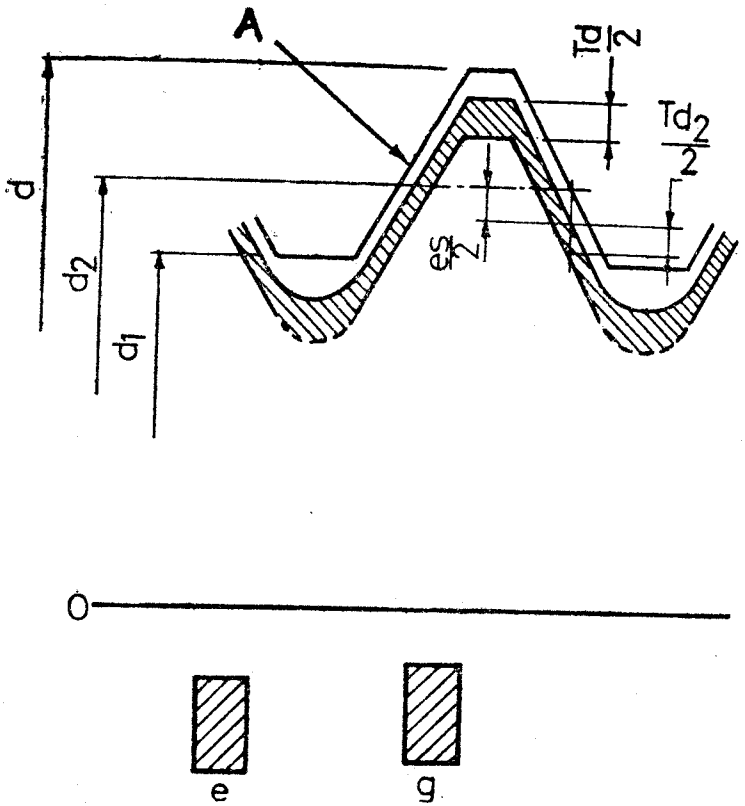
4.1 The lengths of thread engagement are classified as short (S), normal (N) and long (L).

For the calculation of the *limits* of the normal length of thread engagement, l_N in table 3, the following rule has been applied.

l_N min. — $2.24\ P\ d^{0.2}$
l_N max. — $6.7\ P\ d^{0.2}$

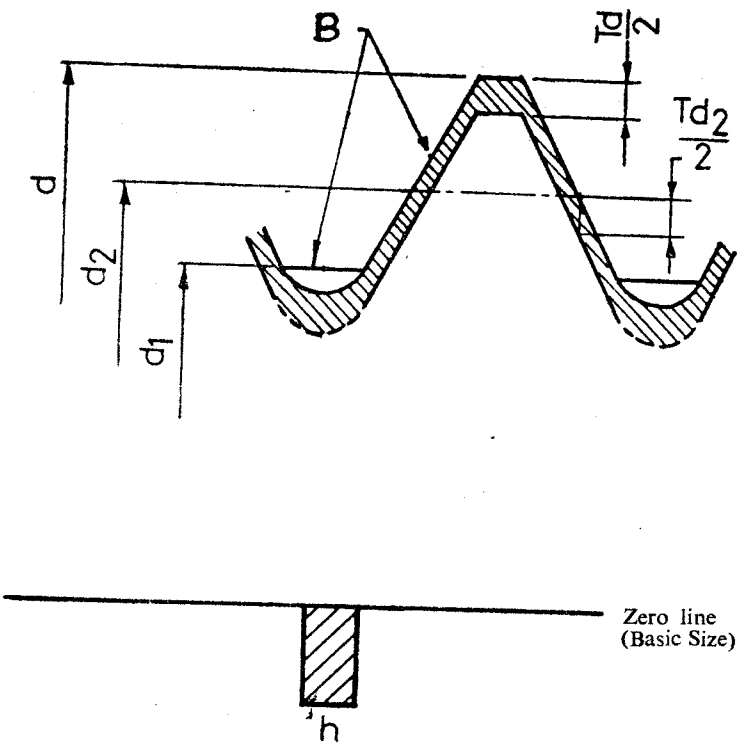
Where l_N, P, and d are in mm.

For each pitch within a certain diameter range, d has been set equal to the smallest diameter (within the range) which appears in the general plan for pitch diameter combinations.



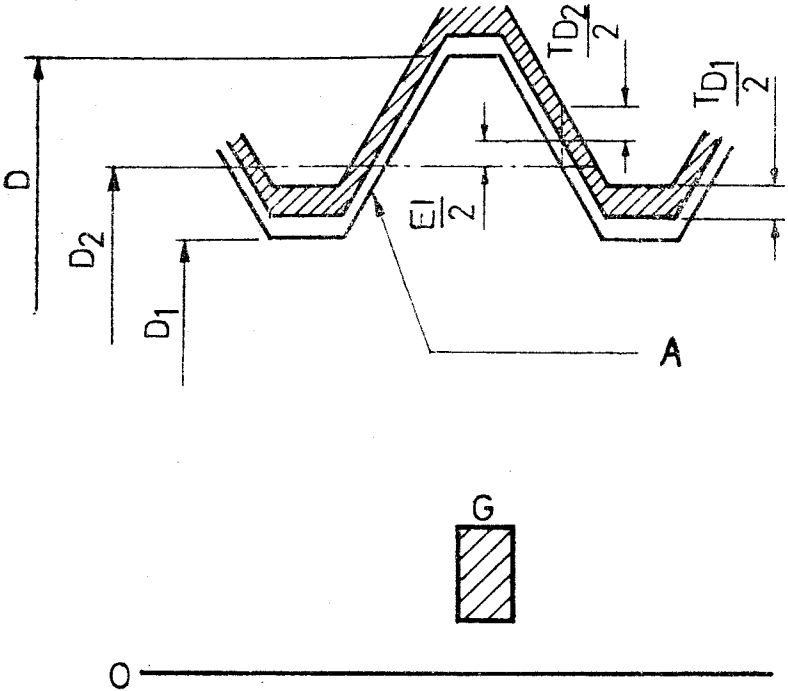
(A—ISO Basic Profile)

Fig. 2—Bolt Threads with Tolerance Positions *e* and *g*



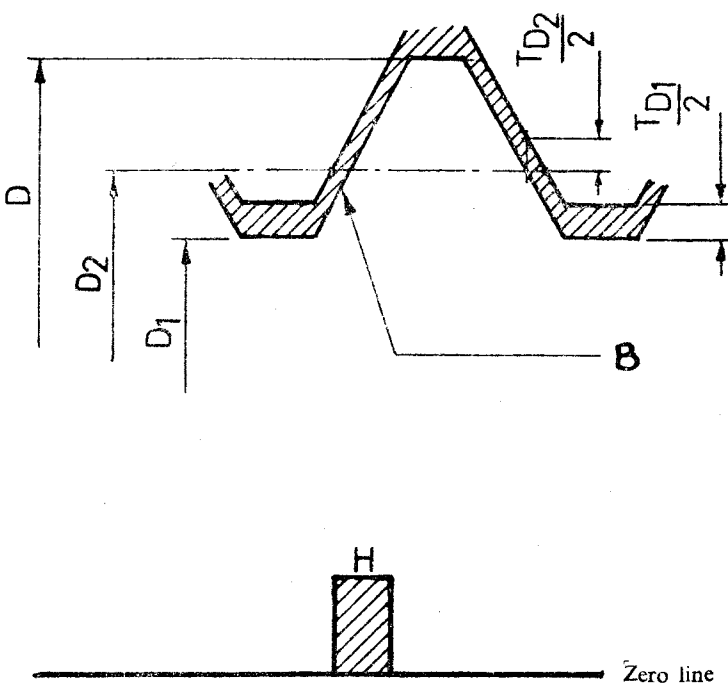
(B—ISO Basic Profile)

Fig. 3—Bolt Threads with Tolerance Position *h*



(A—ISO Basic Profile)

Fig. 4—Nut Thread with Tolerance Position *G*



(B—ISO Basic Profile)

Fig. 5—Nut Thread with Tolerance Position *H*

TABLE 1

PREFERRED TOLERANCE CLASSES FOR NUTS
(Clause 3.4)

Tolerance Quality	*Tolerance Position G*			*Tolerance Position H*		
	S	*N*	*L*	*S*	*N*	*L*
Fine				†4H	†5H	†6H
Medium	‡5G	‡6G	‡7G	*5H	*6H	*7H
Coarse		‡7G	‡8G		†7H	8H

* These classes are first choice
† These classes are second choice
‡ These classes are third choice: they should be avoided

TABLE 2

PREFERRED TOLERANCE CLASSES FOR BOLTS (Clause 3.4)

Tolerance Quality	*Tolerance Position e*			*Tolerance Position g*			*Tolerance Position h*		
	S	*N*	*L*	*S*	*N*	*L*	*S*	*N*	*L*
Fine							‡3h 4h	†4h	‡5h 4h
Medium		*6e	‡7e6e	‡5g6g	*6g	‡7g6g	‡5h 6h	†6h	‡7h 6h
Coarse					†8g	‡9g8g			

Note:

* These classes are first choice
† These classes are second choice
‡ These classes are third choice: they should be avoided

Tolerance classes within the frames are selected for commercial bolt and nut threads.

* Exceptions are the values for threads with P=0.75 mm and finer.

5. FUNDAMENTAL DEVIATIONS

5.1 The fundamental deviations for the nut and bolt threads for the various tolerance positions are calculated on the basis of the following formulae:

$$EI_G = + (15+11P) \qquad es_e = - (50+11P)^*$$

$$EI_H = 0 \qquad es_g = - (15+11P)$$

$$es_h = 0$$

EI, es in μm, P in mm

5.2 The values of fundamental deviations for the various pitches are given in Table 4. Those values apply to the basic dimensions of design profiles of nut and bolt threads given in Part III of the standard. These values have been calculated from the formulae given in 5.1 and then rounded off to the nearest value in R40 series of preferred numbers (C.S. 103).

6. CREST DIAMETER TOLERANCES

6.1 Bolt Crest Diameter Tolerance

The bolt crest diameter tolerance Td (that is, major diameter tolerance of bolt thread) is calculated by the following formula:

$$Td(6) = 180 \sqrt[3]{p2} - \sqrt{P^{3.15}}$$

Td in μm
P in mm

Tolerances for other grades are obtained from Td (6) values according to the table given below:

Tolerance Grade

4	6	8
0.63 Td (6)	Td (6)	1.6 Td (6)

6.2 Nut Crest Diameter Tolerance

The nut crest diameter tolerance TD_1 (that is, minor diameter tolerance of nut thread) is calculated by the following formulae:

* Exceptions are the values for threads with P=0.75 mm and finer.

TD_1 (6) = 433 P—190 $P^{1.22}$ for pitches 0.2 to 0.8 mm

TD_1 (6) = 230 $P^{0.7}$ for pitches 1 mm and coarser

TD_1 in μm and

P in mm

Tolerances for other grades are obtained from TD_1, (6) values according to the table given below:

TOLERANCE GRADE

4	5	6	7	8
0.63 TD_1 (6)	0.8 TD_1 (6)	TD_1 (6)	1.25 TD_1 (6)	1.6 TD_1 (6)

6.3 The crest diameter tolerances, Td for the bolt major diameter and TD_1 for the nut minor diameter, are given in Tables 5 and 6. These values have been calculated from the formulae given in 6.1 and 6.2 and then rounded off to the nearest value in R 40 series of preferred numbers (C.S. 103).

7. PITCH DIAMETER TOLERANCES

7.1 Formula for pitch diameter tolerance for bolt threads shall be as given below:

Bolt pitch diameter tolerance Td_2 (6) = 90 $P^{0.4}d^{0.1}$

Td_2 in μm

P and d in mm

Tolerances for other grades are obtained from Td_2 (6) values according to the table given below

TOLERANCE GRADE

3	4	5	6	7	8	9
0.5Td_2 (6)	0. 63Td_2 (6)	0. 8Td_2 (6)	Td_2 (6)	1. 25Td_2 (6)	1. 6Td_2 (6)	2Td_2 (6)

7.2 The nut pitch diameter tolerance TD_2 is obtained from TD_2 (6) values according to the table given below.

Tolerance Grade

4	5	6	7	8
0.85Td_2 (6)	1.06Td_2 (6)	1.32Td_2 (6)	1.7Td_2 (6)	2.12Td_2 (6)

7.3 The pitch diameter tolerance for bolt threads Td_2 and for nut threads TD_2 are given in Tables 7 and 8. These values have been calculated from the formula given in 7.1 and 7.2 and then rounded off to the nearest value in R 40 series of preferred numbers (C. S. 103).

Note: No Td_2 values are given in the table when the calculated values exceed the Td values in the tolerance grades which are combined in the tables for preferred tolerance classes. No TD_2 values are given in the table when calculated values exceed 0.25 P.

8. Root Diameter Limits

8.1 **Nut Major Diameter Limits** — The minimum major diameter of the nut thread shall be specified by the EI-values.

The maximum major diameter of the nut thread shall not be specified.

8.2 **Bolt Minor Diameter Limits** — The maximum minor diameter of the bolt thread shall be specified by the os-values based on H/6 truncation and will in practice enable a GO ring gauge with truncation of H/4 to enter (see Fig. 6).

For the design of tools, comparator plates, etc., the minimum minor diameter of the bolt thread shall be calculated with truncation of H/8 = 0.108 P. Consequently the lower deviation should be calculated in accordance with $ei = es-(Td_2 + 0.072P)$.

8.3 For normal applications the root radius is not specified but for high strength applications (fatigue and/or shock load), it is recommended to specify that the root profile for bolt threads should not present a radius of curvature R less than 0.1 P (see Table 9), which corresponds approximately to a truncation of 3H/16 for the upper limiting profile and H/8 for the lower limiting profile (see Fig. 7).

Such requirements should be specified by adding the minimum root radius to the tolerance designation.

The decisive maximum limit of the bolt thread minor diameter is equal to the basic bolt thread minor diameter less the amount indicated by X Fig. 7.

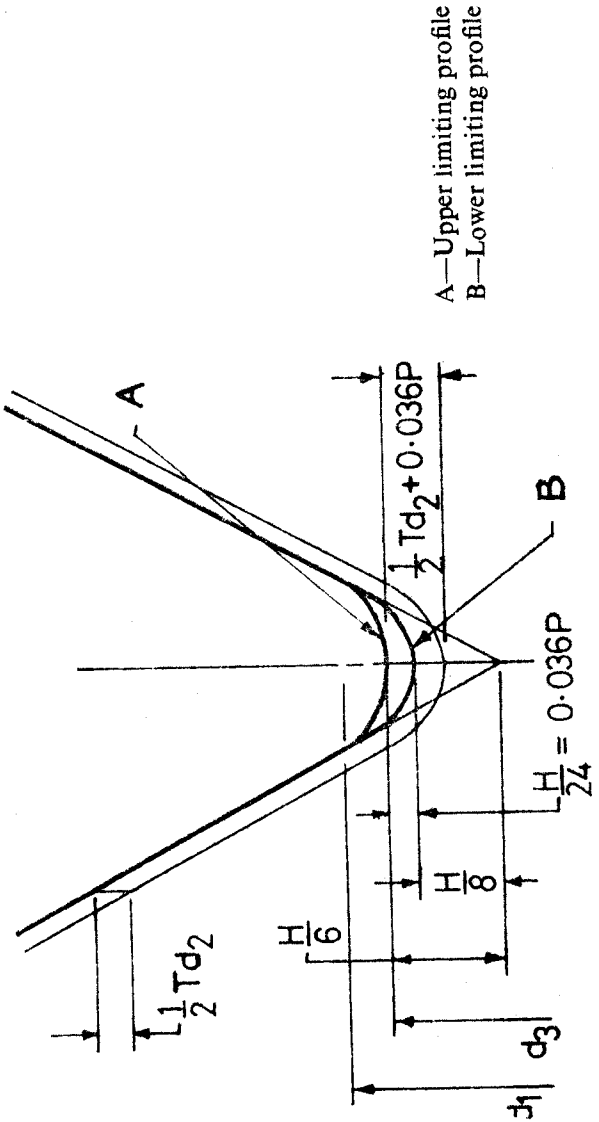


Fig. 6—Bolt Minor Diameter Limits

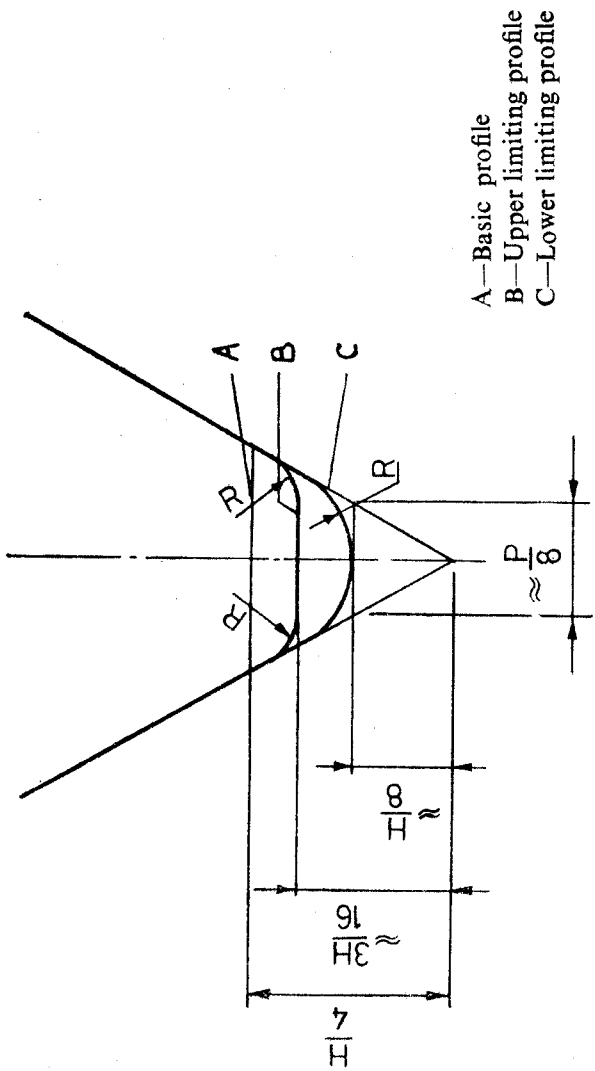


Fig. 7—Bolt Root Profile for High Strength Applications

9. DESIGNATION

9.1 A complete screw thread designation shall consist of:

(a) size designation, and

(b) tolerance class designation.

9.1.1 Size Designation

Size of a screw thread shall be designated by the letter 'M' followed by the diameter and the pitch, the two being separated by the sign 'X'. Where there is no indication of pitch, it shall mean coarse pitch is implied.

9.1.2 Tolerance Class Designation

This shall include a class designation for the pitch diameter tolerance followed by a class designation for the crest diameter tolerance. Each class designation shall consist of:

(a) a figure indicating tolerance grade (see 3.1) and

(b) a letter indicating tolerance position (see 3.2).

Where the class designation for pitch diameter tolerance is only given, the same class designation applies to the crest diameter tolerance as well.

Examples :

External Thread

M6 — 5g 6g

- 6g — Class designation for pitch diameter tolerance
- 5g — Class designation for crest diameter tolerance

Internal Thread

M20 x 2 — 6H

- 6H — Class designation for pitch and crest diameter tolerance (same)

Note: Where no tolerances are specified, class 6H and 6g will be applicable for nut threads and bolt threads, respectively.

TABLE 3 — LENGTH OF THREAD ENGAGEMENT

(Unit : Millimetre)

Basic major diameter *d*		Pitch P	Length of thread engagement			
			S	N		L
over	up to & incl.		up to & incl.	over	up to & incl.	over
0.99	1.4	0.2	0.5	0.5	1.4	1.4
		0.25	0.6	0.6	1.7	1.7
		0.3	0.7	0.7	2	2
1.4	2.8	0.2	0.5	0.5	1.5	1.5
		0.25	0.6	0.6	1.9	1.9
		0.35	0.8	0.8	2.6	2.6
		0.4	1	1	3	3
		0.45	1.3	1.3	3,8	3.8
2.8	**5.6**	0.35	1	1	3	3
		0.5	1.5	1.5	4.5	4.5
		0.6	1.7	1.7	5	5
		0.7	2	2	6	6
		0.75	2.2	2.2	6.7	6.7
		0.8	2.5	2.5	7.5	7.5
5.6	**11.2**	0.75	2.4	2.4	7.1	7.1
		1	3	3	9	9
		1.25	4	4	12	12
		1,5	5	5	15	15
11.2	**22.4**	1	3.8	3.8	11	11
		1.25	4.5	4.5	13	13
		1.5	5.6	5.6	16	16
		1.75	6	6	18	18
		2	8	8	24	24
		2.5	10	10	30	30
22.4	**45**	1	4	4	12	12
		1.5	6.3	6.3	19	19
		2	8.5	8.5	25	25
		3	12	12	36	36
		3.5	15	15	45	45
		4	18	18	53	53
		4.5	21	21	63	63
45	**90**	1.5	7.5	7.5	22	22
		2	9.5	9.5	28	28
		3	15	15	45	45
		4	19	19	56	56
		5	24	24	71	71
		5.5	28	28	85	85
		6	32	32	95	95
90	**180**	2	12	12	12	36
		3	18	18	53	53
		4	24	24	71	71
		6	36	36	106	106
180	**355**	3	20	20	60	60
		4	26	26	80	80
		6	40	40	118	118

TABLE 4 — FUNDAMENTAL DEVIATION OF NUT THREADS AND BOLT THREADS

Pitch *P*	Fundamental deviation				
	Nut thread D_2, D_1		Bolt thread d, d_2		
	G *EI*	H *EI*	e *es*	g *es*	h *es*
mm	um	um	um	um	um
0.2	+17	0		—17	0
0.25	+18	0		—18	0
0.3	+18	0		—18	0
0.35	+19	0		—19	0
0.4	+19	0		—19	0
0.45	+20	0		—20	0
0.5	+20	0	— 50	—20	0
0.6	+21	0	— 53	—21	0
0.7	+22	0	— 56	—22	0
0.75	+22	0	— 56	—22	0
0.8	+24	0	— 60	—24	0
1	+26	0	— 60	—26	0
1.25	+28	0	— 63	—28	0
1.5	+32	0	— 67	—32	0
1.75	+34	0	— 71	—34	0
2	+38	0	— 71	—38	0
2.5	+42	0	— 80	—42	0
3	+48	0	— 85	—48	0
3.5	+53	0	— 90	—53	0
4	+60	0	— 95	—60	0
4.5	+63	0	—100	—63	0
5	+71	0	—106	—71	0
5.5	+75	0	—112	—75	0
6	+80	0	—118	—80	0

TABLE 5 — BOLT MAJOR DIAMETER TOLERANCES *Td*
(Clause 6.3)

Values in u m

Pitch	Tolerance grade		
P mm	4	6	8
0.2	36	56	—
0.25	42	67	—
0.3	48	75	—
0.35	53	85	—
0.4	60	95	—
0.45	63	100	—
0.5	67	106	—
0.6	80	125	—
0.7	90	140	—
0.75	90	140	—
0.8	95	150	236
1	112	180	280
1.25	132	212	335
1.5	150	236	375
1.75	170	265	425
2	180	280	450
2.5	212	335	530
3	236	375	600
3.5	265	425	670
4	300	475	750
4.5	315	500	800
5	335	530	850
5.5	355	560	900
6	375	600	950

TABLE 6 — NUT MINOR DIAMETER TOLERANCES TD_1
(Clause 6.3)

Values in u m

Pitch	Tolerance grade				
P mm	4	5	6	7	8
0.2	38	—	—	—	—
0.25	45	56	—	—	—
0.3	53	67	85	—	—
0.35	63	80	100	—	—
0.4	71	90	112	—	—
0.45	80	100	125	—	—
0.5	90	112	140	180	—
0.6	100	125	160	200	—
0.7	112	140	180	224	—
0.75	118	150	190	236	—
0.8	125	160	200	250	315
1	150	190	236	300	375
1.25	170	312	265	335	425
1.5	190	236	300	375	475
1.75	212	265	335	425	530
2	236	300	375	475	600
2.5	280	355	450	560	710
3	315	400	500	630	800
3.5	355	450	560	710	900
4	375	475	600	750	950
4.5	425	530	670	850	1 060
5	450	560	710	900	1 120
5.5	475	600	750	950	1 180
6	500	630	800	1000	1 250

TABLE 7 — BOLT PITCH DIAMETER TOLERANCES TD_2

(Clause 7.3)

Values in u m

Basic Major diameter d m m		Pitch	Tolerance grade						
Above	up to and including	P mm	3	4	5	6	7	8	9
0.99	**1.4**	0.2	24	30	38	48	—	—	—
		0.25	26	34	42	53	—	—	—
		0.3	28	36	45	56	—	—	—
1.5	**2.8**	0.2	25	32	40	50	—	—	—
		0.25	28	36	45	56	—	—	—
		0.35	32	40	50	63	80	—	—
		0.4	34	42	53	67	85	—	—
		0.45	36	45	56	71	90	—	—
2.8	**5.6**	0.35	34	42	53	67	85	—	—
		0.5	38	48	60	75	95	—	—
		0.6	42	53	67	85	106	—	—
		0.7	45	56	71	90	112	—	—
		0.75	45	56	71	90	112	—	—
		0.8	48	60	75	95	118	150	190
5.6	**11.2**	0.75	50	63	80	100	125	—	—
		1	56	71	90	112	140	180	224
		1.25	60	75	95	118	150	190	236
		1.5	67	85	106	132	170	212	265
11.2	**22.4**	1	60	75	95	118	150	190	236
		1.25	67	85	106	132	170	212	265
		1.5	71	90	112	140	180	224	280
		1.75	75	95	118	150	190	236	300
		2	80	100	125	160	200	250	315
		2.5	85	106	132	170	212	265	335
22.4	**45**	1	63	80	100	125	160	200	250
		1.5	75	95	118	150	190	236	300
		2	85	106	132	170	212	265	335
		3	100	125	160	200	250	315	400
		3.5	106	132	170	212	265	335	425
		4	112	140	180	224	280	355	450
		4.5	118	150	190	236	300	375	475
45	**90**	1.5	80	100	125	160	200	250	315
		2	90	112	140	180	224	280	355
		3	106	132	170	212	265	335	425
		4	118	150	190	236	300	375	475
		5	125	160	200	250	315	400	500
		5.5	132	170	212	265	335	425	530
		6	140	180	224	280	355	450	560
90	**180**	2	95	118	150	190	236	300	375
		3	112	140	180	224	280	355	450
		4	125	160	200	250	315	400	500
		6	150	190	236	300	375	475	600
180	**300**	3	125	160	200	250	315	400	500
		4	140	180	224	280	355	450	560
		6	160	200	250	315	400	500	630

TABLE 8 — NUT PITCH DIAMETER TOLERANCES TD_2

(Clause 7.3)

Values in u m

Basic major diameter d m m		Pitch	Tolerance grade				
Above	up to and including	P mm	4	5	6	7	8
0.99	**1.4**	0.2	40	—	—	—	—
		0.25	45	56	—	—	—
		0.3	48	60	75	—	—
1.5	**2.8**	0.2	42	—	—	—	—
		0.25	48	60	—	—	—
		0.35	53	67	85	—	—
		0.4	56	71	90	—	—
		0.45	60	75	95	—	—
2.8	**5.6**	0.35	56	71	90	—	—
		0.5	63	80	100	125	—
		0.6	71	90	112	140	—
		0.7	75	95	118	150	—
		0.75	75	95	118	150	—
		0.8	80	100	125	160	200
5.6	**11.2**	0.75	85	106	132	170	—
		1	95	118	150	190	236
		1.25	100	125	160	200	250
		1.5	112	140	180	224	280
11.2	**22.4**	1	100	125	160	200	250
		1.25	112	140	180	224	280
		1.5	118	150	190	236	300
		1.75	125	160	200	250	315
		2	132	170	212	265	335
		2.5	140	180	224	280	355
22.4	**45**	1	106	132	170	212	—
		1.5	125	160	200	250	315
		2	140	180	224	280	355
		3	170	212	265	335	425
		3.5	180	224	280	355	450
		4	190	236	300	375	475
		4.5	200	250	315	400	500
45	**90**	1.5	132	170	212	265	335
		2	150	190	236	300	375
		3	180	224	280	355	450
		4	200	250	315	400	500
		5	212	265	335	425	530
		5.5	224	280	355	450	560
		6	236	300	375	475	600
90	**180**	2	160	200	250	315	400
		3	190	236	300	375	475
		4	212	265	335	425	530
		6	250	315	400	500	630
180	**300**	3	212	265	335	425	530
		4	236	300	375	475	600
		6	265	335	425	530	670

TABLE 9 — MINIMUM ROOT RADII FOR HIGH STRENGTH APPLICATIONS

(Clause 8.3)

Pitch P mm	R Min μm	Pitch P mm	R Min. μm
0.2	20	1.25	125
0.25	25	1.5	150
0.3	30	1.75	175
0.35	35	2	200
0.4	40	2.5	250
0.45	45	3	300
0.5	50	3.5	350
0.6	60	4	400
0.7	70	4.5	450
0.75	75	5	500
0.8	80	5.5	550
1	100	6	600

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