

BS 959:2008

Incorporating Corrigendum No. 1



BSI Standards Publication

Specification for internal micrometers (including stick micrometers)

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Summary of pages

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Foreword

Publishing information

This British Standard is published by BSI and came into effect on 30 November 2008. It was prepared by Technical Committee TDW/4, *Technical product realization*. A list of organizations represented on this committee can be obtained on request to its secretary.

Supersession

This British Standard supersedes BS 959:1950, which is withdrawn.

Information about this document

This British Standard has been fully revised to bring it up to date.

Text introduced by or altered by Corrigendum No. 1 is indicated in the text by tags C1 C1. Minor editorial corrections are not tagged.

Presentational conventions

The provisions of this standard are presented in roman (i.e. upright) type. Its requirements are expressed in sentences in which the principal auxiliary verb is “shall”.

Commentary, explanation and general informative material is presented in smaller italic type, and does not constitute a normative element.

Contractual and legal considerations

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

Compliance with a British Standard cannot confer immunity from legal obligations.

1 Scope

This standard specifies requirements for internal micrometers comprising a measuring head, extension rods with or without spacing collars, and, in the smaller sizes, a handle.

Provision is made for three sizes of measuring heads, in both metric and inch units, as shown in Table 1 and Table 2.

NOTE Attention is drawn to the fact that metric dimensions are not necessarily direct conversions of the imperial dimensions.

Table 1 Measuring heads – metric measurements

Size of head	Length of graduated scale on barrel	Usual ranges of the instrument when used with extension rods
	mm	mm
Size 1	5 or 6.5	25-50
Size 2	10 or 13	50-150 50-200 50-300
Size 3	25	200+

Table 2 Measuring heads – inch measurements

Size of head	Length of graduated scale on barrel	Usual ranges of the instrument when used with extension rods
	in	in
Size 1	$\frac{1}{4}$	1-2
Size 2	$\frac{1}{2}$ or 1	2-6 2-8 2-12
Size 3	1	8+

This standard also covers stick micrometers, which are designed for the measurement of longer internal lengths, and comprise the following parts:

- a 150 mm or 300 mm or 6 in or 12 in micrometer unit, fitted with a micrometer of 25 mm or 1 in range, and having rounded terminal faces;
- a series of extension rods which, together with the micrometer unit, permit a continuous range of measurement up to the maximum length required.

Annex A gives a method of test for the accuracy of internal micrometer readings.

2 Normative references

The following referenced document is indispensable for the application of this document. The latest edition of the referenced document (including any amendments) applies.

BS 84, *Parallel screw threads of Whitworth form – Requirements*