

JIS

JAPANESE INDUSTRIAL STANDARD

Limit gauges for metric fine screw threads

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JAPANESE INDUSTRIAL STANDARD

J I S

Limit gauges for metric fine screw threads

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1. Scope This Japanese Industrial Standard specifies the limit gauges used in the dimensional inspection of the screw threads for the tolerance classes of 4h, 6h, 6g and 8g of the external threads and the tolerance classes of 4H, 5H, 6H and 7H of the internal threads (hereafter, referred to as "limit gauges for screw threads") specified in JIS B 0211, and the gauges used for checking thereon (hereafter, referred to as "check gauges", and the limit gauges and check gauges for screw threads are generically called "gauges").

The limit and check gauges for screw threads applied to the tolerance classes 1, 2 and 3 of the external and internal threads specified in the Annex of JIS B 0211 are in accordance with the Annex of this Standard.

Remarks 1. The ranges of designations of screw threads for respective tolerance classes capable of being inspected by the gauges of this Standard are as given in the following.

Classification into external and internal thread	Those specified in the body of the Standard		Those specified in the Annex		Informative reference
	Tolerance class	Range of designation	Tolerance class	Range of designation	Fitting quality (1)
External thread	4 h	M1 × 0.2 to M150 × 2	Class 1	M1 × 0.2 to M150 × 2	Fine
	6 h 6 g	M1 × 0.2 to M1.4 × 0.2 M1.6 × 0.2 to M150 × 2	Class 2	M1 × 0.2 to M150 × 2	Medium
	8 g	M8 × 1 to M150 × 2	Class 3	M8 × 1 to M150 × 2	Coarse
Internal thread	4 H 5 H	M1 × 0.2 to M1.8 × 0.2 M2 × 0.25 to M150 × 2	Class 1	M1 × 0.2 to M150 × 2	Fine
	6 H	M2.5 × 0.35 to M150 × 2	Class 2	M2.5 × 0.35 to M150 × 2	Medium
	7 H	M4 × 0.5 to M150 × 2	Class 3	M4 × 0.5 to M150 × 2	Coarse

Note (1) The fitting quality is in accordance with JIS B 0211.

2. When inspections on the shapes of the flank, crest and root of the screw threads, the circularity of pitch diameter, surface roughness and others of the threaded fasteners are required, the measuring instruments other than the gauges of this Standard are to be used.
3. The cited standards to this Standard are given in the following :
 - JIS B 0207 Metric fine screw threads
 - JIS B 0211 Limits of sizes and tolerances for metric fine screw threads
 - JIS B 0261 Measuring method for parallel screw gauges
 - JIS B 3102 Gauge blanks for screw thread limit gauges
 - JIS B 7420 Limit gauges
 - JIS G 4404 Alloy tool steels

4. The corresponding International Standard to this Standard is as follows :

ISO 1502 ISO general-purpose metric screw threads – Gauges and gauging

2. Types, symbols, shapes, dimensions, permissible deviations and tolerances of limit gauges for screw threads The types and symbols of the limit gauges for screw threads shall be in accordance with Table 1, and the shapes, dimensions, permissible deviations and tolerances thereof shall be in accordance with Tables 6 to 11.

Table 1. Types and symbols of limit gauges for screw threads

Screw threads to be inspected	Portions to be inspected		Type of limit gauge for screw threads	Symbol	Applicable Table
External threads	Pitch diameter	Virtual	Go screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h GR 6 h GR 6 g GR 8 g GR	Table 6
		Nearly simple	NOT GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h NR 6 h NR 6 g NR 8 g NR	Table 7
	Major diameter		Plain GO ring gauge for major diameter (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h PR GO 6 h PR GO 6 g PR GO 8 g PR GO	Table 8
			Plain NOT GO ring gauge for major diameter (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h PR NOT GO 6 h PR NOT GO 6 g PR NOT GO 8 g PR NOT GO	
			Plain caliper gauge for major diameter (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h PC 6 h PC 6 g PC 8 g PC	
Internal threads	Pitch diameter	Virtual	GO screw plug gauge (For class 4 H thread) (For class 5 H thread) (For class 6 H thread) (For class 7 H thread)	4 H GP 5 H GP 6 H GP 7 H GP	Table 9
		Nearly simple	NOT GO screw plug gauge (For class 4 H thread) (For class 5 H thread) (For class 6 H thread) (For class 7 H thread)	4 H NP 5 H NP 6 H NP 7 H NP	Table 10
	Minor diameter		Plain plug gauge for minor diameter (For class 4 H thread) (For class 5 H thread) (For class 6 H thread) (For class 7 H thread)	4 H PP ⁽²⁾ 5 H PP 6 H PP 7 H PP	Table 11

Note ⁽²⁾ For those of which nominal diameters of screw threads are larger, when the plug gauges of GO and NOT GO are separately provided, the letters "GO" or "NOT GO" shall be appended after the gauge symbols.

Example : 6 HPP GO, 6 HPP NOT GO

3. Types, symbols, shapes, dimensions, permissible deviations and tolerances for check gauges Among the limit gauges for screw threads given in Table 1, the types and symbols of check gauges for the GO and NOT GO screw ring gauges shall be in accordance with Table 2, and the shapes, dimensions, permissible deviations and tolerances shall be in accordance with Tables 12 to 17.

Table 2. Types and symbols for check gauges

Limit gauge for screw thread to be checked	Type of check gauge	Symbol	Applicable Table
GO screw ring gauge	GO screw check plug for GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h GR GF 6 h GR GF 6 g GR GF 8 g GR GF	Table 12
	NOT GO screw check plug for GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h GR NF 6 h GR NF 6 g GR NF 8 g GR NF	Table 13
	Wear check plug for GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h GW 6 h GW 6 g GW 8 g GW	Table 14
NOT GO screw ring gauge	GO screw check plug for NOT GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h NR GF 6 h NR GF 6 g NR GF 8 g NR GF	Table 15
	NOT GO screw check plug for NOT GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h NR NF 6 h NR NF 6 g NR NF 8 g NR NF	Table 16
	Wear check plug for NOT GO screw ring gauge (For 4 h thread) (For 6 h thread) (For 6 g thread) (For 8 g thread)	4 h NW 6 h NW 6 g NW 8 g NW	Table 17

4. Mutual relationships of tolerances between screw threads and limit gauges for screw threads or check gauges As to the principal dimensions of the screw threads to be inspected and limit gauges for screw threads, or check gauges, the mutual relationships between the respective tolerances shall be given in Fig. 1.

Fig. 1. Explanatory diagram of mutual relationships of tolerances between screw threads and limit gauges for screw threads or check gauges
(Examples for screw threads of 5H·6H·7H and 6g·8g)

Gauge for external thread (Including check gauge)															Pitch diameter of external thread	Pitch diameter of internal thread	Gauge for internal thread				Minor diameter of internal thread
Major diameter of external thread																	Gauge for pitch dia.		Gauge for minor dia.		
																	Gauge for major diameter		Gauge for pitch diameter		
Plain calliper gauge for major diameter		Plain ring gauge for major diameter		For NOT GO screw ring gauge			NOT GO screw ring gauge	For GO screw ring gauge			GO screw ring gauge	GO screw plug gauge	NOT GO screw plug gauge	Plain plug gauge for minor diameter							
				Wear check plug	NOT GO screw check plug	GO screw check plug		Wear check plug	NOT GO screw check plug	GO screw check plug				GO side			NOT GO side				
GO side	NOT GO side	GO side	NOT GO side	Wear check plug	NOT GO screw check plug	GO screw check plug	NOT GO screw ring gauge	Wear check plug	NOT GO screw check plug	GO screw check plug	GO screw ring gauge	Pitch diameter of external thread	Pitch diameter of internal thread	GO screw plug gauge	NOT GO screw plug gauge	GO side	NOT GO side				
Basic size position of major diameter																					

Remarks: Tolerance zones and wear allowances illustrated above have the following meaning :

	Tolerances on external thread pitch diameter or major diameter		Tolerances on internal thread pitch diameter or minor diameter		Tolerances for screw ring gauges or calliper gauges and plain ring gauges
	Tolerances for screw or plain plug gauges		Minimum wear allowance		

5. Thread profiles of gauges

5.1 Thread profiles and application thereof The profiles of the gauges shall be the profiles having complete flanks and the profiles having truncated flanks, and the application thereof shall be in accordance with Table 3.

Table 3. Thread profiles and application thereof

Type of gauge	Profile with complete flanks		Profile with truncated flanks	
	Shape	Applicable gauges	Shape	Applicable gauges
Screw ring gauge	As shown in Fig. 2	GO screw ring gauge (GR)	As shown in Fig. 4	NOT GO screw ring gauge (NR)
Screw plug gauge	As shown in Fig. 3	GO screw plug gauge (GP) GO check plug for GO screw ring gauge (GR GF) GO check plug for NOT GO screw ring gauge (NR GF) NOT GO check plug for NOT GO screw ring gauge (NR NF) Wear check plug for NOT GO screw ring gauge (NW)	As shown in Fig. 5	NOT GO screw plug gauge (NP) NOT GO check plug for GO screw ring gauge (GR NF) Wear check plug for GO screw ring gauge (GW)

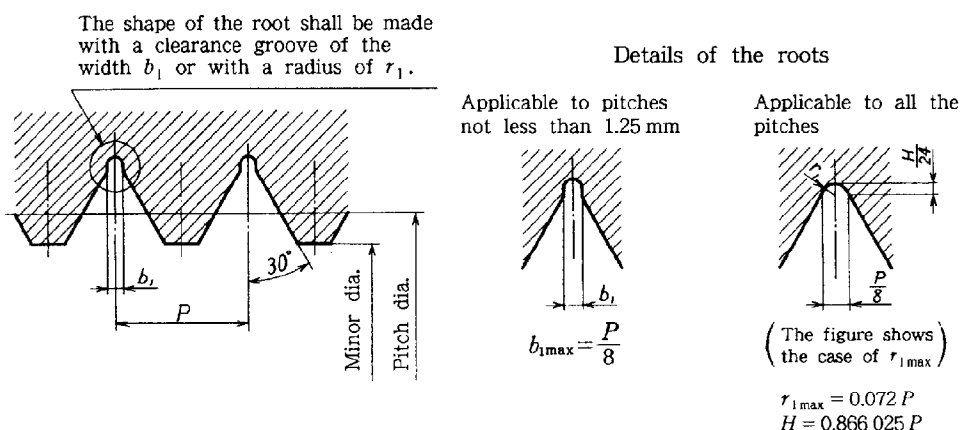
5.2 Profiles with complete flanks The profiles with complete flanks shall be as follows :

- (1) For screw ring gauges The profiles with complete flanks applied to screw ring gauges shall be made with a radius of r_1 ⁽³⁾ which contacts tangentially with the straight part of the flank, or with a clearance groove of the width b_1 ⁽⁴⁾ as shown Fig. 2 and their maximum values $r_{1\max}$ and $b_{1\max}$ shall be as given in Table 4. The shape of the clearance groove of root is not specified.

Notes ⁽³⁾ The shape of the root with this radius is applicable to all the pitches.

⁽⁴⁾ The shape of the root with this clearance groove is applicable to threads with pitches not less than 1.25 mm.

Fig. 2. Profile with complete flanks
(applicable to screw ring gauges)



- (2) For screw plug gauges The profiles with complete flanks applied to screw plug gauges shall be made with a radius of r_2 ⁽⁵⁾, as shown in Fig. 3, which contacts tangentially with the straight part of the flank, or with a clearance groove of the width b_2 ⁽⁶⁾, and their maximum values $r_{2\max}$ and $b_{2\max}$ shall be as given in Table 4. The shape of the clearance groove of root is not specified.

Notes ⁽⁵⁾ The shape of the root with this radius is applicable to all the pitches.

⁽⁶⁾ The shape of the root with this clearance groove is applicable to threads with pitches not less than 0.6 mm.

Fig. 3. Profile with complete flanks
(applicable to screw plug gauges)

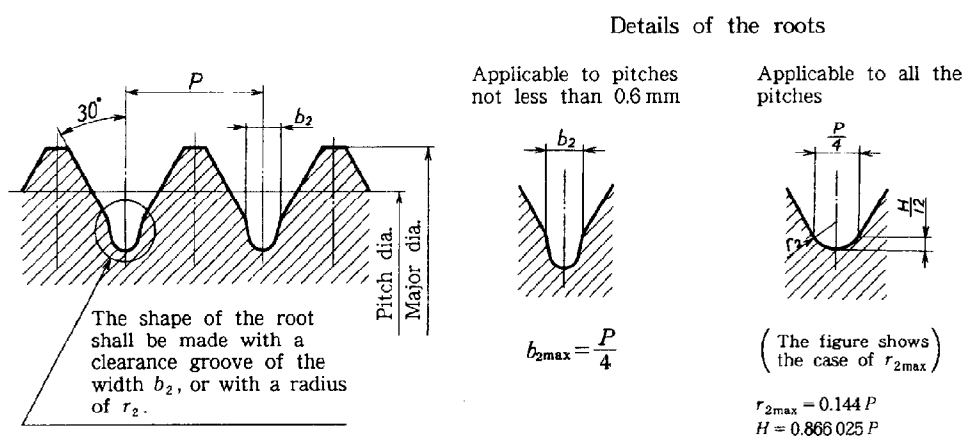


Table 4. Numerical values of profiles with complete flanks

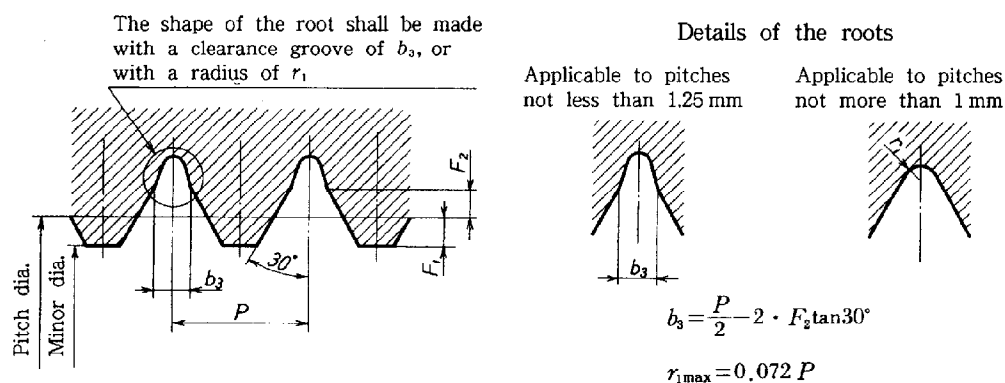
Unit : mm

Pitch P	$b_{1\max} = \frac{P}{8}$	$r_{1\max} = 0.072 P = \frac{H}{12}$	$b_{2\max} = \frac{P}{4}$	$r_{2\max} = 0.144 P$	$\frac{H}{24}$
0.2	—	0.014	—	0.029	0.007
0.25	—	0.018	—	0.036	0.009
0.3	—	0.022	—	0.043	0.011
0.35	—	0.025	—	0.050	0.012
0.4	—	0.029	—	0.058	0.014
0.45	—	0.032	—	0.065	0.016
0.5	—	0.036	—	0.072	0.018
0.6	—	0.043	0.15	0.086	0.022
0.7	—	0.050	0.17	0.1	0.025
0.75	—	0.054	0.19	0.11	0.027
0.8	—	0.058	0.2	0.11	0.029
1	—	0.072	0.25	0.14	0.036
1.25	0.15	0.090	0.31	0.18	0.045
1.5	0.19	0.108	0.37	0.21	0.054
1.75	0.22	0.126	0.44	0.25	0.063
2	0.25	0.144	0.5	0.29	0.072
2.5	0.32	0.180	0.61	0.36	0.090
3	0.4	0.217	0.75	0.43	0.108
3.5	0.48	0.253	0.88	0.5	0.126
4	0.5	0.288	1	0.58	0.144
4.5	0.55	0.325	1.1	0.65	0.162
5	0.6	0.361	1.25	0.72	0.180
5.5	0.7	0.397	1.4	0.79	0.198
6	0.8	0.433	1.5	0.86	0.217

5.3 Profiles with truncated flanks The profiles with truncated flanks shall be as follows :

- (1) For screw ring gauges The profiles with truncated flanks applied to screw ring gauges shall be made, for threads with pitches not more than 1 mm, with a radius of r_1 which contacts tangentially with the straight part of the flank, and shall be made, for threads with pitches not less than 1.25 mm, with a clearance groove of the width b_s as shown in Fig. 4. The maximum values of the radius, $r_{1\max}$, shall be as given in Table 4 and the values of the width of the clearance groove, b_s , shall be as given in Table 5. The shape of the clearance groove of root is not specified.

Fig. 4. Profiles with truncated flanks
(applicable to screw ring gauges)



- (2) For screw plug gauges The profiles with truncated flanks applied to screw plug gauges shall be made, for screw threads with pitches not more than 1 mm, with a radius of r_2 which contacts tangentially with the straight part of the flank, and for screw threads with pitches not less than 1.25 mm, with a clearance groove with the width b_3 , as shown in Fig. 5. The maximum values of the radius, $r_{2\max}$, shall be as given in Table 4, and the values of the width b_3 of the clearance groove shall be as given in Table 5. The shape of the clearance groove of root is not specified.

Fig. 5. Profiles with truncated flanks
(applicable to screw plug gauges)

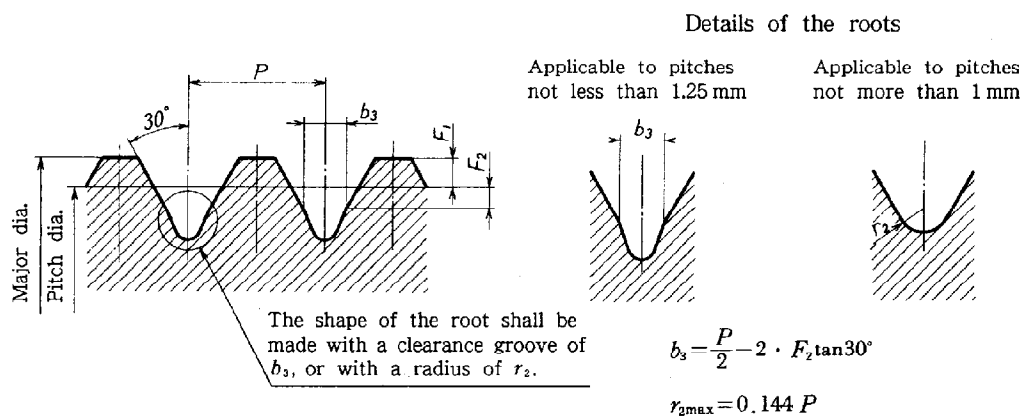


Table 5. Numerical values of profiles with truncated flanks

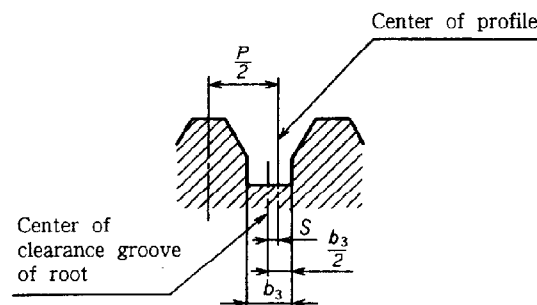
Unit : mm

Pitch P	$F_1=0.1 P$	F_2			b_3	
		$0.2 P$	$0.15 P$	$0.1 P$	Basic size	Permissible deviations ($\pm$)
0.2	0.02				See Note (7)	
0.25	0.025					
0.3	0.03					
0.35	0.035					
0.4	0.04					
0.45	0.045					
0.5	0.05					
0.6	0.06					
0.7	0.07					
0.75	0.075					
0.8	0.08					
1	0.1					
1.25	0.125	0.25			0.3	0.04
1.5	0.15	0.3			0.4	0.04
1.75	0.175	0.35			0.45	0.05
2	0.2	0.4	—		0.5	0.05
2.5	0.25	—	0.375		0.8	0.05
3	0.3	—	0.45		1.0	0.08
3.5	0.35		0.525	—	1.1	0.08
4	0.4		0.6	—	1.3	0.1
4.5	0.45		—	0.45	1.7	0.1
5	0.5			0.5	1.9	0.1
5.5	0.55			0.55	2.1	0.1
6	0.6			0.6	2.3	0.1

Note (7) To threads with pitches 0.2 to 1 mm, $r_{1\max}$ or $r_{2\max}$ specified in Table 4 shall be applied.

Remarks: The clearance groove of root, b_3 , may displace by an amount S given in Fig. 6 in relation to the center of the profile of thread, but its value shall be equal to the permissible deviation of b_3 . When the real displacement of the clearance groove is smaller than the permissible displacement S , the permissible deviation for b_3 can be increased by an amount which is double the difference between the permissible and real displacements.

Fig. 6. Displacement of the clearance groove of root for the profile with truncated flanks



6. Thread removal and chamfering of incomplete threads The incomplete threads of both ends of the screw threads shall either be removed to the starting position of the complete threads as given in Fig. 7, or be chamfered by 30° as given in Fig. 8.

The figures of Tables 9, 10 and 12 to 17 show the thread removal.

Fig. 7. Thread removal

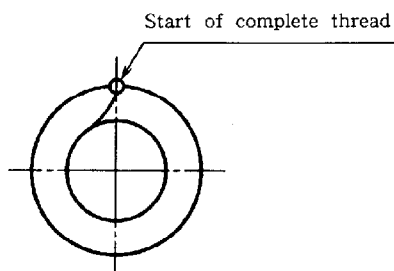
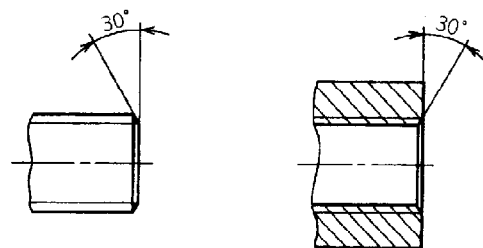


Fig. 8. Chamfer



7. Material, hardness and surface roughness The material of the gauges shall be SKS3 of JIS G 4404 or the material having the mechanical properties equal to or superior to this, and the hardness of the gauging part shall be 660 HV or over (58 HRC or over).

The surface roughness of gauging surface shall be $0.1 \mu m R_a$ or under. However, the materials, hardnesses and surface roughnesses of the ring gauges for major diameter, plain calliper gauges for major diameter and plug gauges for minor diameter shall be in accordance with JIS B 7420.

8. Inspection method of gauges The inspection methods of the gauges specified in the Standard shall be in accordance with JIS B 0261.

9. Temperature condition of measurement The numerical values of respective dimensions specified in this Standard shall be those of at 20°C .

10. Purposes of using limit gauges for screw threads and their usage, and decision on acceptance or rejection of screw threads by means of the limit gauges

10.1 Purposes of using limit gauges for external threads and their usage The purposes of using limit gauges to inspect external threads and their usage shall be in accordance with the following :

- (1) GO screw ring gauge (GR) This gauge shall be used to decide whether or not the virtual pitch diameter of external thread lies within the permissible limit specified on the GO side. The gauge shall be screwed into a machined external thread by hand without using excessive force. If it passes through the whole length of the external thread, the external thread shall be considered to pass the dimensional inspection by means of the GO screw ring gauge (GR).
- (2) NOT GO screw ring gauge (NR) This gauge shall be used to decide whether or not the actual pitch diameter of external thread exceeds the specified minimum permissible dimension. This gauge shall be screwed into the machined external thread by hand without using excessive force. If this gauge does not enter on either sides more than two turns of thread, the external thread shall be considered to pass the dimensional inspection by means of the NOT GO screw ring gauge (NR). For a machined external thread having a length of thread of three threads or less, the NOT GO screw ring gauge (NR) shall not pass completely through the thread portion.
- (3) Plain ring gauge for major diameter (PR) This gauge shall be used to decide whether or not the major diameter of external thread lies within the specified permissible limits on the GO and NOT GO sides. The gauge shall be put on a machined external thread by hand without using excessive force. If the plain GO ring gauge (PR GO) passes through the machined external thread and the plain NOT GO ring gauge (PR NOT GO) is not put on the thread, the machined external thread shall be considered to pass the dimensional inspection by means of the plain ring gauge for major diameter (PR).
- (4) Plain calliper gauge for major diameter (PC) This gauge shall be used to decide whether or not the major diameter of external thread lies within the specified permissible limits on the GO and NOT GO sides. The plain calliper gauge for major diameter (PC) shall be put on a machined external thread. If the GO side of the gauge (PC) passes through the machined thread by its own weight in any direction, and the NOT GO side of the gauge (PC) does not pass through the thread, the external thread shall be considered to pass the dimensional inspection by means of the plain calliper gauge for major diameter (PC).

10.2 Purposes of using limit gauges for internal threads and their usage The purposes of using limit gauges to inspect internal threads and their usage shall be in accordance with the following :

- (1) GO screw plug gauge (GP) This gauge shall be used to inspect whether or not the virtual pitch diameter of internal thread lies within the permissible limit specified on the GO side. This gauge shall be screwed into a machined internal thread by hand without using excessive force. If the gauge passes through the whole length of the internal thread, the internal thread shall be considered to pass the dimensional inspection by means of the GO screw plug gauge (GP).
- (2) NOT GO screw plug gauge (NP) This gauge shall be used to check whether or not the actual pitch diameter of internal thread is smaller than the specified maximum dimension. This gauge shall be screwed into a machined internal thread by hand without using excessive force. If the gauge does not enter on either sides more than two turns of thread, the internal thread shall be considered to pass the dimensional inspection by means of the NOT GO screw plug gauge (NP). For a internal thread having a length of thread of three threads or less, the NOT GO screw plug gauge (NP) shall not pass completely through the thread

portion.

- (3) Plain plug gauge for minor diameter (PP) This gauge shall be used to check whether or not the minor diameter of internal thread lies within the permissible limits specified on the GO and NOT GO sides. The plain plug gauge for minor diameter (PP) shall be screwed into machined internal thread by hand without using excessive force. If the GO side of the plug gauge passes through the thread and its NOT GO side does not enter on either sides more than one turn of thread the internal thread shall be considered to pass the dimensional inspection by means of the plain plug gauge for minor diameter (PP).

10.3 Decision on acceptance or rejection by limit gauges for screw threads The decision on acceptance or rejection by the limit gauges for screw threads shall be in accordance with the following :

- (1) For inspection on external threads In order to pass the inspection, the machined external threads shall pass the dimensional inspection by means of the gauges of (1), (2) and (3) of 10.1.

When the machined external threads have sufficient rigidity against deformation and have little potential errors on the circularity of major diameter, it should be preferable to use the plain calliper gauge (PC) of (4) of 10.1 instead of (3).

- (2) For inspection on internal threads In order to pass the inspection, the machined internal threads shall pass the dimensional inspection by means of the gauges of (1), (2) and (3) of 10.2.

10.4 Treatment of disagreement of decision on acceptance or rejection due to limit gauges for screw threads on transaction When any disagreement has occurred on the decision on acceptance or rejection by means of the limit gauges for screw threads due to the difference between the gauges used by the manufacturer's side and user's side, if the gauges of the side by which the acceptance has been decided conforms to the requirements of this Standard (taking the permissible wear into consideration), the screw threads shall be treated as has passed the dimensional inspection.

11. Purposes and methods of using check gauges and decision on acceptance or rejection by means of check gauges

11.1 Purposes and methods of using check gauges for GO screw ring gauges

The purposes and methods of use of the gauges to check the GO screw ring gauges shall be in accordance with the following :

- (1) GO screw check plug for GO screw ring gauge (GRGF) This plug shall be used to check the GO limit of the virtual pitch diameter of a new GO screw ring gauge (GR). When this check plug is screwed into the GO screw ring gauge (GR) by hand, it shall pass through the GO ring gauge without excessive force.
- (2) NOT GO screw check plug for GO screw ring gauge (GRNF) This plug shall be used to check the maximum permissible dimension of the pitch diameter of a new GO screw ring gauge (GR). When this check plug is screwed into the GO screw ring gauge (GR) by hand without using excessive force, it shall not enter into either end of the ring gauge beyond one turn of thread.

- (3) Wear check plug for GO screw ring gauge (GW) This check plug is used to check whether or not the pitch diameter of the GO screw ring gauge (GR) exceeds the specified wear limit. When the check plug is screwed into the GO screw ring gauge (GR) by hand without excessive force, it shall not enter into either end of the ring gauge beyond one turn of thread. If it enters beyond one turn of thread, the GO screw ring gauge (GR) shall be considered to exceed the specified wear limit.

11.2 Purposes and methods of using check gauges for NOT GO screw ring gauges

The purposes and methods of use of the gauges to check the NOT GO screw ring gauges shall be in accordance with the following :

- (1) GO screw check plug for NOT GO screw ring gauge (NRGF) This check plug is used to check the minimum permissible dimension of the pitch diameter of a new NOT GO screw ring gauge (NR). When the check plug is screwed into the ring gauge (NR) by hand, it shall pass through the gauge without excessive force.
- (2) NOT GO screw check plug for NOT GO screw ring gauge (NRNF) This check plug is used to check the maximum permissible dimension of the pitch diameter of a new NOT GO screw ring gauge (NR). When the check plug is screwed into NOT GO screw ring gauge (NR) by hand without excessive force, it shall not be screwed into either end of the gauge beyond one turn of thread.
- (3) Wear check plug for NOT GO screw ring gauge (NW) This check plug is used for checking whether or not the pitch diameter of a NOT GO screw ring gauge (NR) exceeds the specified wear limit. When the check plug is screwed into the NOT GO screw ring gauge (NR) without excessive force, it shall not be screwed into either side of the ring gauge beyond one turn of thread. If it is screwed beyond one turn of thread, the NOT GO screw ring gauge (NR) shall be considered to exceed the specified wear limit.

11.3 Decision on acceptance or rejection by means of the check gauges The decision on acceptance or rejection by means of the check gauges shall be in accordance with the following :

- (1) For GO screw ring gauge If a new GO screw ring gauge (GR) meets the requirements specified in (1) and (2) of 11.1, it shall be considered to pass the inspection.

If a GO screw ring gauge (GR) in use meets the requirements specified in (3) of 11.1, it shall be decided that the gauge does not exceed the specified wear limit.

- (2) For NOT GO screw ring gauge If a new NOT GO screw ring gauge (NR) meets the requirements specified in (1) and (2) of 11.2, it shall be considered to pass the inspection.

If a NOT GO screw ring gauge (NR) in use meets the requirements specified in (3) of 11.2, it shall be decided that the gauge does not exceed the specified wear limit.

12. Designation The products shall be designated by number or title of the Standard, thread direction (In the case of right-handed thread, it shall generally be omitted.), designation of screw thread, and symbol for gauge (*).

Note (*) Instead of symbol, tolerance class of threads and type of gauge may also be used.

Example 1. JIS B 0252		M10 × 1.25	6g GR		
Example 2. Limit gauge for metric fine screw thread	“左 (HIDARI)” in Japanese	M10 × 1.25		For 6g	GO screw ring gauge
(No. or title of standard)	(Thread direction)	(Designation of screw threads)	(Symbol for gauge)	(Tolerance class of threads)	(Type of gauge)

13. Marking On a suitable portion of the gauge, “左 (HIDARI)” in Japanese, symbol L or LH as far as left-handed thread is concerned; designation of screw thread; symbol for gauge; name of manufacturer or its abbreviation; month and year of manufacture or its abbreviation, or manufacture serial number shall be marked.

Examples: (Manufacturer's name or abbreviation, and month and year of manufacture or manufacturer serial number are omitted.)

For GO screw ring gauge	M10 × 1.25 – 6g GR or M10 × 1.25 6g GR
For GO plain ring gauge for major dia.	M10 × 1.25 – 6g PR GO or M10 × 1.25 6g PR GO
For GO and NOT GO screw plug gauge with left-handed thread (double head type)	GP 左 M10 × 1.25 – 6H NP
For plain plug gauge for minor dia. (double head type of GO and NOT GO)	M10 × 1.25 – 6H PP
For plain GO plug gauge for minor dia.	M60 × 1.5 – 6H PP GO
For GO and NOT GO screw check plug (double head type) for GO screw ring gauge	GR GF M10 × 1.25 – 6g GR NF or GF M10 × 1.25 – 6g GR NF
For wear check plug for GO screw ring gauge	M10 × 1.25 – 6g GW

14. Matters to be attended on handling At the time of the inspection of the threaded fastener, the gauge shall be screwed in without excessive force after the threaded fastener and the gauge have been cleansed sufficiently. After it is used, the foreign substances adhered to the gauge shall be washed off, and it shall be processed with the rust preventive treatment, and be stored in a place less in temperature change and humidity.

Table 6. Shape, dimension, permissible deviation, and tolerance for GO screw ring gauge (GR)
(Metric fine screw thread)

Gauge symbol	
For Class 4 h thread	4 h GR
For Class 6 h thread	6 h GR
For Class 6 g thread	6 g GR
For Class 8 g thread	8 g GR



Profile of thread shall have complete flanks (see Fig. 2)

Designation of thread to be inspected		Pitch diameter ⁽⁶⁾												Minor diameter												Unit: μm	
		For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				Basic size d_1 ⁽¹²⁾ (mm)	For Class 4 h thread			For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾			For Class 8 g thread			⁽¹³⁾ Pitch tolerance + Tolerance on half angle of thread (minute)			
		⁽¹¹⁾		For new gauge		⁽¹¹⁾		For new gauge		⁽¹¹⁾		For new gauge			Upper deviation + (mm)	Lower deviation - (mm)	Tolerance	Upper deviation + (mm)	Lower deviation - (mm)	Tolerance	Upper deviation + (mm)	Lower deviation - (mm)	Tolerance				
		$d_{2\text{max}}$				$d_{2\text{max}}$				$d_{2\text{max}}$																	
		(mm)	+	-	Tolerance	(mm)	+	-	Tolerance	(mm)	+	-	Tolerance														
M 1 $\times$ 0.2	0.870	8	0	8	0.870	8	0	8	—	—	—	—	0.703	4	4	8	+4	4	8	—	—	—	5	60			
M 1.1 $\times$ 0.2	0.970	8	0	8	0.970	8	0	8	—	—	—	—	0.883	4	4	8	+4	4	8	—	—	—	5	60			
M 1.2 $\times$ 0.2	1.070	8	0	8	1.070	8	0	8	—	—	—	—	0.983	4	4	8	+4	4	8	—	—	—	5	60			
M 1.4 $\times$ 0.2	1.270	8	0	8	1.270	8	0	8	—	—	—	—	1.183	4	4	8	+4	4	8	—	—	—	5	60			
M 1.6 $\times$ 0.2	1.470	8	0	8	1.453	8	0	8	—	—	—	—	1.383	4	4	8	13	21	8	—	—	—	5	60			
M 1.8 $\times$ 0.2	1.670	8	0	8	1.653	8	0	8	—	—	—	—	1.583	4	4	8	13	21	8	—	—	—	5	60			
M 2 $\times$ 0.25	1.838	8	0	8	1.820	7	3	10	—	—	—	—	1.729	4	4	8	13	23	10	—	—	—	5	48			
M 2.2 $\times$ 0.25	2.038	8	0	8	2.020	7	3	10	—	—	—	—	1.929	4	4	8	13	23	10	—	—	—	5	48			
M 2.5 $\times$ 0.35	2.273	8	0	8	2.254	7	3	10	—	—	—	—	2.121	4	4	8	14	24	10	—	—	—	5	35			
M 3 $\times$ 0.35	2.773	8	0	8	2.754	7	3	10	—	—	—	—	2.621	4	4	8	14	24	10	—	—	—	5	35			
M 3.5 $\times$ 0.35	3.273	8	0	8	3.254	7	3	10	—	—	—	—	3.121	4	4	8	14	24	10	—	—	—	5	35			
M 4 $\times$ 0.5	3.675	8	0	8	3.655	7	3	10	—	—	—	—	3.459	4	4	8	15	25	10	—	—	—	5	25			
M 4.5 $\times$ 0.5	4.175	8	0	8	4.155	7	3	10	—	—	—	—	3.959	4	4	8	15	25	10	—	—	—	5	25			
M 5 $\times$ 0.5	4.675	8	0	8	4.655	7	3	10	—	—	—	—	4.459	4	4	8	15	25	10	—	—	—	5	25			
M 5.5 $\times$ 0.5	5.175	8	0	8	5.155	7	3	10	—	—	—	—	4.959	4	4	8	15	25	10	—	—	—	5	25			
M 6 $\times$ 0.75	5.513	7	3	10	5.491	5	9	14	—	—	—	—	5.188	5	5	10	15	29	14	—	—	—	5	17			
M 7 $\times$ 0.75	6.513	7	3	10	6.491	5	9	14	—	—	—	—	6.188	5	5	10	15	29	14	—	—	—	5	17			
M 8 $\times$ 1	7.350	7	3	10	7.324	5	9	14	7.324	+1	17	18	6.917	5	5	10	19	33	14	17	35	18	5	15			
M 8 $\times$ 0.75	7.513	7	3	10	7.491	5	9	14	—	—	—	—	7.188	5	5	10	15	29	14	—	—	—	5	17			
M 9 $\times$ 1	8.350	7	3	10	8.324	5	9	14	8.324	+1	17	18	7.917	5	5	10	19	33	14	17	35	18	5	15			
M 9 $\times$ 0.75	8.513	7	3	10	8.491	5	9	14	—	—	—	—	8.188	5	5	10	15	29	14	—	—	—	5	17			
M 10 $\times$ 1.25	9.188	7	3	10	9.160	5	9	14	9.160	+1	17	18	8.647	5	5	10	21	35	14	19	37	18	5	13			
M 10 $\times$ 1	9.350	7	3	10	9.324	5	9	14	9.324	+1	17	18	8.917	5	5	10	19	33	14	17	35	18	5	15			
M 10 $\times$ 0.75	9.513	7	3	10	9.491	5	9	14	—	—	—	—	9.188	5	5	10	15	29	14	—	—	—	5	17			
M 11 $\times$ 1	10.350	7	3	10	10.324	5	9	14	10.324	+1	17	18	9.917	5	5	10	19	33	14	17	35	18	5	15			
M 11 $\times$ 0.75	10.513	7	3	10	10.491	5	9	14	—	—	—	—	10.188	5	5	10	15	29	14	—	—	—	5	17			
M 12 $\times$ 1.5	11.026	5	9	14	10.994	1	17	18	10.994	1	23	22	10.376	7	7	14	23	41	18	21	43	22	5	12			
M 12 $\times$ 1.25	11.188	5	9	14	11.160	1	17	18	11.160	1	23	22	10.647	7	7	14	19	37	18	17	39	22	5	13			

Table 6. GR (continued) (1)

Unit: μm

Designation of thread to be inspected	Pitch diameter ⁽⁵⁾												Minor diameter												⁽¹³⁾ Pitch tolerance Tolerance on half angle of thread (minute)
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				Basic size d_1 ⁽¹²⁾ (mm)	For Class 4 h thread			For Class 6 h thread and Class 6 g thread			For Class 8 g thread					
	⁽¹¹⁾ d_{2max} (mm)	For new gauge		Tolerance	⁽¹¹⁾ d_{2max} (mm)	For new gauge		Tolerance	⁽¹¹⁾ d_{2max} (mm)	For new gauge		Tolerance		Upper deviation +	Lower deviation -	Tolerance	Upper deviation +	Lower deviation -	Tolerance	Upper deviation +	Lower deviation -	Tolerance			
		Upper deviation +	Lower deviation -			Upper deviation +	Lower deviation -			Upper deviation +	Lower deviation -														
M 12 × 1	11.350	7	3	10	11.324	5	9	14	11.324	+1	17	18	10.917	5	5	10	19	33	14	17	35	18	5	15	
M 14 × 1.5	13.026	5	9	14	12.994	1	17	18	12.994	1	23	22	12.376	7	7	14	23	41	18	21	43	22	5	12	
M 14 × 1	13.350	7	3	10	13.324	5	9	14	13.324	+1	17	18	12.917	5	5	10	19	33	14	17	35	18	5	15	
M 15 × 1.5	14.026	5	9	14	13.994	1	17	18	13.994	1	23	22	13.376	7	7	14	23	41	18	21	43	22	5	12	
M 15 × 1	14.350	7	3	10	14.324	5	9	14	14.324	+1	17	18	13.917	5	5	10	19	33	14	17	35	18	5	15	
M 16 × 1.5	15.026	5	9	14	14.994	1	17	18	14.994	1	23	22	14.376	7	7	14	23	41	18	21	43	22	5	12	
M 16 × 1	15.350	7	3	10	15.324	5	9	14	15.324	+1	17	18	14.917	5	5	10	19	33	14	17	35	18	5	15	
M 17 × 1.5	16.026	5	9	14	15.994	1	17	18	15.994	1	23	22	15.376	7	7	14	23	41	18	21	43	22	5	12	
M 17 × 1	16.350	7	3	10	16.324	5	9	14	16.324	+1	17	18	15.917	5	5	10	19	33	14	17	35	18	5	15	
M 18 × 2	16.701	5	9	14	16.663	1	17	18	16.663	1	23	22	15.835	7	7	14	29	47	18	27	49	22	5	10	
M 18 × 1.5	17.026	5	9	14	16.994	1	17	18	16.994	1	23	22	16.376	7	7	14	23	41	18	21	43	22	5	12	
M 18 × 1	17.350	7	3	10	17.324	5	9	14	17.324	+1	17	18	16.917	5	5	10	19	33	14	17	35	18	5	15	
M 20 × 2	18.701	5	9	14	18.663	1	17	18	18.663	1	23	22	17.835	7	7	14	29	47	18	27	49	22	5	10	
M 20 × 1.5	19.026	5	9	14	18.994	1	17	18	18.994	1	23	22	18.376	7	7	14	23	41	18	21	43	22	5	12	
M 20 × 1	19.350	7	3	10	19.324	5	9	14	19.324	+1	17	18	18.917	5	5	10	19	33	14	17	35	18	5	15	
M 22 × 2	20.701	5	9	14	20.663	1	17	18	20.663	1	23	22	19.835	7	7	14	29	47	18	27	49	22	5	10	
M 22 × 1.5	21.026	5	9	14	20.994	1	17	18	20.994	1	23	22	20.376	7	7	14	23	41	18	21	43	22	5	12	
M 22 × 1	21.350	7	3	10	21.324	5	9	14	21.324	+1	17	18	20.917	5	5	10	19	33	14	17	35	18	5	15	
M 24 × 2	22.701	5	9	14	22.663	1	17	18	22.663	1	23	22	21.835	7	7	14	29	47	18	27	49	22	5	10	
M 24 × 1.5	23.026	5	9	14	22.994	1	17	18	22.994	1	23	22	22.376	7	7	14	23	41	18	21	43	22	5	12	
M 24 × 1	23.350	7	3	10	23.324	5	9	14	23.324	+1	17	18	22.917	5	5	10	19	33	14	17	35	18	5	15	
M 25 × 2	23.701	5	9	14	23.663	1	17	18	23.663	1	23	22	22.835	7	7	14	29	47	18	27	49	22	5	10	
M 25 × 1.5	24.026	5	9	14	23.994	1	17	18	23.994	1	23	22	23.376	7	7	14	23	41	18	21	43	22	5	12	
M 25 × 1	24.350	7	3	10	24.324	5	9	14	24.324	+1	17	18	23.917	5	5	10	19	33	14	17	35	18	5	15	
M 26 × 1.5	25.026	5	9	14	24.994	1	17	18	24.994	1	23	22	24.376	7	7	14	23	41	18	21	43	22	5	12	
M 27 × 2	25.701	5	9	14	25.663	1	17	18	25.663	1	23	22	24.835	7	7	14	29	47	18	27	49	22	5	10	
M 27 × 1.5	26.026	5	9	14	25.994	1	17	18	25.994	1	23	22	25.376	7	7	14	23	41	18	21	43	22	5	12	
M 27 × 1	26.350	7	3	10	26.324	5	9	14	26.324	+1	17	18	25.917	5	5	10	19	33	14	17	35	18	5	15	
M 28 × 2	26.701	5	9	14	26.663	1	17	18	26.663	1	23	22	25.835	7	7	14	29	47	18	27	49	22	5	10	
M 28 × 1.5	27.026	5	9	14	26.994	1	17	18	26.994	1	23	22	26.376	7	7	14	23	41	18	21	43	22	5	12	
M 28 × 1	27.350	7	3	10	27.324	5	9	14	27.324	+1	17	18	26.917	5	5	10	19	33	14	17	35	18	5	15	
M 30 × 3	28.051	5	9	14	28.003	1	17	18	28.003	1	23	22	26.752	7	7	14	39	57	18	37	59	22	5	9	
M 30 × 2	28.701	5	9	14	28.663	1	17	18	28.663	1	23	22	27.835	7	7	14	29	47	18	27	49	22	5	10	
M 30 × 1.5	29.026	5	9	14	28.994	1	17	18	28.994	1	23	22	28.376	7	7	14	23	41	18	21	43	22	5	12	
M 30 × 1	29.350	7	3	10	29.324	5	9	14	29.324	+1	17	18	28.917	5	5	10	19	33	14	17	35	18	5	15	
M 32 × 2	30.701	5	9	14	30.663	1	17	18	30.663	1	23	22	29.835	7	7	14	29	47	18	27	49	22	5	10	
M 32 × 1.5	31.026	5	9	14	30.994	1	17	18	30.994	1	23	22	30.376	7	7	14	23	41	18	21	43	22	5	12	
M 33 × 3	31.051	5	9	14	31.003	1	17	18	31.003	1	23	22	29.752	7	7	14	39	57	18	37	59	22	5	9	
M 33 × 2	31.701	5	9	14	31.663	1	17	18	31.663	1	23	22	30.835	7	7	14	29	47	18	27	49	22	5	10	
M 33 × 1.5	32.026	5	9	14	31.994	1	17	18	31.994	1	23	22	31.376	7	7	14	23	41	18	21	43	22	5	12	
M 35 × 1.5	34.026	5	9	14	33.994	1	17	18	33.994	1	23	22	33.376	7	7	14	23	41	18	21	43	22	5	12	
M 36 × 3	34.051	5	9	14	34.003	1	17	18	34.003	1	23	22	32.752	7	7	14	39	57	18	37	59	22	5	9	
M 36 × 2	34.701	5	9	14	34.663	1	17	18	34.663	1	23	22	33.835	7	7	14	29	47	18	27	49	22	5	10	
M 36 × 1.5	35.026	5	9	14	34.994	1	17	18	34.994	1	23	22	34.376	7	7	14	23	41	18	21	43	22	5	12	
M 38 × 1.5	37.026	5	9	14	36.994	1	17	18	36.994	1	23	22	36.376	7	7	14	23	41	18	21	43	22	5	12	
M 39 × 3	37.051	5	9	14	37.003	1	17	18	37.003	1	23	22	35.752	7	7	14	39	57	18	37	59	22	5	9	
M 39 × 2	37.701	5	9	14	37.663	1	17	18	37.663	1	23	22	36.835	7	7	14	29	47	18	27	49	22	5	10	
M 39 × 1.5	38.026	5	9	14	37.994	1	17	18	37.994	1	23	22	37.376	7	7	14	23	41	18	21	43	22	5	12	
M 40 × 3	38.051	5	9	14	38.003	1	17	18	38.003	1	23	22	36.752	7	7	14	39	57	18	37	59	22	5	9	
M 40 × 2	38.701	5	9	14	38.663	1	17	18	38.663	1	23	22	37.835	7	7	14	29	47	18	27	49	22	5	10	
M 40 × 1.5	39.026	5	9	14	38.994	1	17	18	38.994	1	23	22	38.376	7	7	14	23	41	18	21	43	22	5	12	
M 42 × 4	39.402	1	17	18	39.342	-1	23	22	39.342	5	35	30	37.670	9	9	18	49	71	22	45	75	30	5	8	
M 42 × 3	40.051	5	9	14	40.003	1	17	18	40.003	1	23	22	38.752	7	7	14	39	57	18	37	59	22	5	9	

Table 6. GR (continued) (2)

Designation of thread to be inspected	Pitch diameter ⁽⁸⁾												Minor diameter												Unit: μm	
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				Basic size d_1 ⁽¹²⁾ (mm)	For Class 4 h thread			For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾			For Class 8 g thread			⁽¹³⁾ Pitch tolerance Tolerance on half angle of thread (minute)			
	⁽¹¹⁾		For new gauge		⁽¹¹⁾		For new gauge		⁽¹¹⁾		For new gauge			Upper deviation +	Lower deviation -	Tolerance	Upper deviation -	Lower deviation +	Tolerance	Upper deviation -	Lower deviation +	Tolerance				
	$d_{2\text{max}}$				$d_{2\text{max}}$				$d_{2\text{max}}$																	
	(mm)	+	-			(mm)	+	-			(mm)	+	-													
M 42×2	40.701	5	9.14	40.663	1	17.18	40.663	1	23.22	39.835	7	7.14	29	47	18	27	49	22	5	10						
M 42×1.5	41.026	5	9.14	40.994	1	17.18	40.994	1	23.22	40.376	7	7.14	25	41	18	21	43	22	5	12						
M 45×4	42.402	1	17.18	42.342	-1	23.22	42.342	5	35.30	40.670	9	9.18	49	71	22	45	75	30	5	8						
M 45×3	43.051	5	9.14	43.003	1	17.18	43.003	1	23.22	41.752	7	7.14	39	57	18	37	59	22	5	9						
M 45×2	43.701	5	9.14	43.663	1	17.18	43.663	1	23.22	42.835	7	7.14	29	47	18	27	49	22	5	10						
M 45×1.5	44.026	5	9.14	43.994	1	17.18	43.994	1	23.22	43.376	7	7.14	23	41	18	21	43	22	5	12						
M 48×4	45.402	1	17.18	45.342	-1	23.22	45.342	5	35.30	43.670	9	9.18	49	71	22	45	75	30	5	8						
M 48×3	46.051	1	17.18	46.003	-1	23.22	46.003	5	35.30	44.752	9	9.18	37	59	22	33	63	30	5	9						
M 48×2	46.701	5	9.14	46.663	1	17.18	46.663	1	23.22	45.835	7	7.14	29	47	18	27	49	22	5	10						
M 48×1.5	47.026	5	9.14	46.994	1	17.18	46.994	1	23.22	46.376	7	7.14	23	41	18	21	43	22	5	12						
M 50×3	48.051	1	17.18	48.003	-1	23.22	48.003	5	35.30	46.752	9	9.18	37	59	22	33	63	30	5	9						
M 50×2	48.701	5	9.14	48.663	1	17.18	48.663	1	23.22	47.835	7	7.14	29	47	18	27	49	22	5	10						
M 50×1.5	49.026	5	9.14	48.994	1	17.18	48.994	1	23.22	48.376	7	7.14	23	41	18	21	43	22	5	12						
M 52×4	49.402	1	17.18	49.342	-1	23.22	49.342	5	35.30	47.670	9	9.18	49	71	22	45	75	30	5	8						
M 52×3	50.051	1	17.18	50.003	-1	23.22	50.003	5	35.30	48.752	9	9.18	37	59	22	33	63	30	5	9						
M 52×2	50.701	5	9.14	50.663	1	17.18	50.663	1	23.22	49.835	7	7.14	29	47	18	27	49	22	5	10						
M 52×1.5	51.026	5	9.14	50.994	1	17.18	50.994	1	23.22	50.376	7	7.14	23	41	18	21	43	22	5	12						
M 55×4	52.402	1	17.18	52.342	-1	23.22	52.342	5	35.30	50.670	9	9.18	49	71	22	45	75	30	5	8						
M 55×3	53.051	1	17.18	53.003	-1	23.22	53.003	5	35.30	51.752	9	9.18	37	59	22	33	63	30	5	9						
M 55×2	53.701	5	9.14	53.663	1	17.18	53.663	1	23.22	52.835	7	7.14	29	47	18	27	49	22	5	10						
M 55×1.5	54.026	5	9.14	53.994	1	17.18	53.994	1	23.22	53.376	7	7.14	23	41	18	21	43	22	5	12						
M 56×4	53.402	1	17.18	53.342	-1	23.22	53.342	5	35.30	51.670	9	9.18	49	71	22	45	75	30	5	8						
M 56×3	54.051	1	17.18	54.003	-1	23.22	54.003	5	35.30	52.752	9	9.18	37	59	22	33	63	30	5	9						
M 56×2	54.701	5	9.14	54.663	1	17.18	54.663	1	23.22	53.835	7	7.14	29	47	18	27	49	22	5	10						
M 56×1.5	55.026	5	9.14	54.994	1	17.18	54.994	1	23.22	54.376	7	7.14	23	41	18	21	43	22	5	12						
M 58×4	55.402	1	17.18	55.342	-1	23.22	55.342	5	35.30	53.670	9	9.18	49	71	22	45	75	30	5	8						
M 58×3	56.051	1	17.18	56.003	-1	23.22	56.003	5	35.30	54.752	9	9.18	37	59	22	33	63	30	5	9						
M 58×2	56.701	5	9.14	56.663	1	17.18	56.663	1	23.22	55.835	7	7.14	29	47	18	27	49	22	5	10						
M 58×1.5	57.026	5	9.14	56.994	1	17.18	56.994	1	23.22	56.376	7	7.14	23	41	18	21	43	22	5	12						
M 60×4	57.402	1	17.18	57.342	-1	23.22	57.342	5	35.30	55.670	9	9.18	49	71	22	45	75	30	5	8						
M 60×3	58.051	1	17.18	58.003	-1	23.22	58.003	5	35.30	56.752	9	9.18	37	59	22	33	63	30	5	9						
M 60×2	58.701	5	9.14	58.663	1	17.18	58.663	1	23.22	57.835	7	7.14	29	47	18	27	49	22	5	10						
M 60×1.5	59.026	5	9.14	58.994	1	17.18	58.994	1	23.22	58.376	7	7.14	23	41	18	21	43	22	5	12						
M 62×4	59.402	1	17.18	59.342	-1	23.22	59.342	5	35.30	57.670	9	9.18	49	71	22	45	75	30	6	8						
M 62×3	60.051	1	17.18	60.003	-1	23.22	60.003	5	35.30	58.752	9	9.18	37	59	22	33	63	30	5	9						
M 62×2	60.701	5	9.14	60.663	1	17.18	60.663	1	23.22	59.835	7	7.14	29	47	18	27	49	22	5	10						
M 62×1.5	61.026	5	9.14	60.994	1	17.18	60.994	1	23.22	60.376	7	7.14	23	41	18	21	43	22	5	12						
M 64×4	61.402	1	17.18	61.342	-1	23.22	61.342	5	35.30	59.670	9	9.18	49	71	22	45	75	30	6	8						
M 64×3	62.051	1	17.18	62.003	-1	23.22	62.003	5	35.30	60.752	9	9.18	37	59	22	33	63	30	5	9						
M 64×2	62.701	5	9.14	62.663	1	17.18	62.663	1	23.22	61.835	7	7.14	29	47	18	27	49	22	5	10						
M 64×1.5	63.026	5	9.14	62.994	1	17.18	62.994	1	23.22	62.376	7	7.14	23	41	18	21	43	22	5	12						
M 65×4	62.402	1	17.18	62.342	-1	23.22	62.342	5	35.30	60.670	9	9.18	49	71	22	45	75	30	6	8						
M 65×3	63.051	1	17.18	63.003	-1	23.22	63.003	5	35.30	61.752	9	9.18	37	59	22	33	63	30	5	9						
M 65×2	63.701	5	9.14	63.663	1	17.18	63.663	1	23.22	62.835	7	7.14	29	47	18	27	49	22	5	10						
M 65×1.5	64.026	5	9.14	63.994	1	17.18	63.994	1	23.22	63.376	7	7.14	23	41	18	21	43	22	5	12						
M 68×4	65.402	1	17.18	65.342	-1	23.22	65.342	5	35.30	63.670	9	9.18	49	71	22	45	75	30	6	8						
M 68×3	66.051	1	17.18	66.003	-1	23.22	66.003	5	35.30	64.752	9	9.18	37	59	22	33	63	30	5	9						
M 68×2	66.701	5	9.14	66.663	1	17.18	66.663	1	23.22	65.835	7	7.14	29	47	18	27	49	22	5	10						
M 68×1.5	67.026	5	9.14	66.994	1	17.18	66.994	1	23.22	66.376	7	7.14	23	41	18	21	43	22	5	12						
M 70×6	66.103	1	17.18	66.023	-1	23.22	66.023	5	35.30	63.505	9	9.18	69	91	22	65	95	30	6	8						
M 70×4	67.402	1	17.18	67.342	-1	23.22	67.342	5	35.30	65.670	9	9.18	49	71	22	45	75	30	6	8						
M 70×3	68.051	1	17.18	68.003	-1	23.22	68.003	5	35.30	66.752	9	9.18	37	59	22	33	63	30	5	9						
M 70×2	68.701	5	9.14	68.663	1	17.18	68.663	1	23.22	67.835	7	7.14	29	47	18	27	49	22	5	10						
M 70×1.5	69.026	5	9.14	68.994	1	17.18	68.994	1	23.22	68.376	7	7.14	23	41	18	21	43	22	5	12						
M 72×6	68.103	1	17.18	68.023	-1	23.22	68.023	5	35.30	65.505	9	9.18	69	91	22	65	95	30	6	8						
M 72×4	69.402	1	17.18	69.342	-1	23.22	69.342	5	35.30	67.670	9	9.18	49	71	22	45	75	30	6	8						
M 72×3	70.051	1	17.18	70.003	-1	23.22	70.003	5	35.30	68.752	9	9.18														

Table 6. GR (continued) (3)

Unit: μm

Designation of thread to be inspected	Pitch diameter ⁽⁸⁾												Minor diameter										(13)	Tolerance on half angle of thread (minute)
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				Basic size	For Class 4 h thread			For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾			For Class 8 g thread				
	⁽¹¹⁾				⁽¹¹⁾				⁽¹¹⁾					Upper deviation	Lower deviation	Tolerance	Upper deviation	Lower deviation	Tolerance	Upper deviation	Lower deviation	Tolerance		
	d _{2max}	+	-	Tolerance	d _{2max}	+	-	Tolerance	d _{2max}	+	-	Tolerance												
M 75 × 4	72.402	1	17 18	72.342	-1	23 22	72.342	5	35 30	70.670	9	9 18	49	71	22	45	75 30	6	8					
M 75 × 3	73.051	1	17 18	73.003	-1	23 22	73.003	5	35 30	71.752	9	9 18	37	59	22	33	63 30	5	9					
M 75 × 2	73.701	5	9 14	73.663	1	17 18	73.663	1	23 22	72.835	7	7 14	29	47	18	27	49 22	5	10					
M 75 × 1.5	74.026	5	9 14	73.994	1	17 18	73.994	1	23 22	73.376	7	7 14	23	41	18	21	43 22	5	12					
M 76 × 6	72.103	1	17 18	72.023	-1	23 22	72.023	5	35 30	69.505	9	9 18	69	91	22	65	95 30	6	8					
M 76 × 4	73.402	1	17 18	73.342	-1	23 22	73.342	5	35 30	71.670	9	9 18	49	71	22	45	75 30	6	8					
M 76 × 3	74.051	1	17 18	74.003	-1	23 22	74.003	5	35 30	72.752	9	9 18	37	59	22	33	63 30	5	9					
M 76 × 2	74.701	5	9 14	74.663	1	17 18	74.663	1	23 22	73.835	7	7 14	29	47	18	27	49 22	5	10					
M 76 × 1.5	75.026	5	9 14	74.994	1	17 18	74.994	1	23 22	74.376	7	7 14	23	41	18	21	43 22	5	12					
M 78 × 2	76.701	5	9 14	76.663	1	17 18	76.663	1	23 22	75.835	7	7 14	29	47	18	27	49 22	5	10					
M 80 × 6	76.103	1	17 18	76.023	-1	23 22	76.023	5	35 30	73.505	9	9 18	69	91	22	65	95 30	6	8					
M 80 × 4	77.402	1	17 18	77.342	-1	23 22	77.342	5	35 30	75.670	9	9 18	49	71	22	45	75 30	6	8					
M 80 × 3	78.051	1	17 18	78.003	-1	23 22	78.003	5	35 30	76.752	9	9 18	37	59	22	33	63 30	5	9					
M 80 × 2	78.701	5	9 14	78.663	1	17 18	78.663	1	23 22	77.835	7	7 14	29	47	18	27	49 22	5	10					
M 80 × 1.5	79.026	5	9 14	78.994	1	17 18	78.994	1	23 22	78.376	7	7 14	23	41	18	21	43 22	5	12					
M 82 × 2	80.701	5	9 14	80.663	1	17 18	80.663	1	23 22	79.835	7	7 14	29	47	18	27	49 22	5	10					
M 85 × 6	81.103	1	17 18	81.023	-1	23 22	81.023	5	35 30	78.505	9	9 18	69	91	22	65	95 30	6	8					
M 85 × 4	82.402	1	17 18	82.342	-1	23 22	82.342	5	35 30	80.670	9	9 18	49	71	22	45	75 30	6	8					
M 85 × 3	83.051	1	17 18	83.003	-1	23 22	83.003	5	35 30	81.752	9	9 18	37	59	22	33	63 30	5	9					
M 85 × 2	83.701	5	9 14	83.663	1	17 18	83.663	1	23 22	82.835	7	7 14	29	47	18	27	49 22	5	10					
M 90 × 6	86.103	1	17 18	86.023	-1	23 22	86.023	5	35 30	83.505	9	9 18	69	91	22	65	95 30	6	8					
M 90 × 4	87.402	1	17 18	87.342	-1	23 22	87.342	5	35 30	85.670	9	9 18	49	71	22	45	75 30	6	8					
M 90 × 3	88.051	1	17 18	88.003	-1	23 22	88.003	5	35 30	86.752	9	9 18	37	59	22	33	63 30	5	9					
M 90 × 2	88.701	5	9 14	88.663	1	17 18	88.663	1	23 22	87.835	7	7 14	29	47	18	27	49 22	5	10					
M 95 × 6	91.103	1	17 18	91.023	-1	23 22	91.023	5	35 30	88.505	9	9 18	69	91	22	65	95 30	6	8					
M 95 × 4	92.402	1	17 18	92.342	-1	23 22	92.342	5	35 30	90.670	9	9 18	49	71	22	45	75 30	6	8					
M 95 × 3	93.051	1	17 18	93.003	-1	23 22	93.003	5	35 30	91.752	9	9 18	37	59	22	33	63 30	5	9					
M 95 × 2	93.701	5	9 14	93.663	1	17 18	93.663	1	23 22	92.835	7	7 14	29	47	18	27	49 22	5	10					
M 100 × 6	96.103	1	17 18	96.023	-1	23 22	96.023	5	35 30	93.505	9	9 18	69	91	22	65	95 30	6	8					
M 100 × 4	97.402	1	17 18	97.342	-1	23 22	97.342	5	35 30	95.670	9	9 18	49	71	22	45	75 30	6	8					
M 100 × 3	98.051	1	17 18	98.003	-1	23 22	98.003	5	35 30	96.752	9	9 18	37	59	22	33	63 30	5	9					
M 100 × 2	98.701	5	9 14	98.663	1	17 18	98.663	1	23 22	97.835	7	7 14	29	47	18	27	49 22	5	10					
M 105 × 6	101.103	1	17 18	101.023	-1	23 22	101.023	5	35 30	98.505	9	9 18	69	91	22	65	95 30	6	8					
M 105 × 4	102.402	1	17 18	102.342	-1	23 22	102.342	5	35 30	100.670	9	9 18	49	71	22	45	75 30	6	8					
M 105 × 3	103.051	1	17 18	103.003	-1	23 22	103.003	5	35 30	101.752	9	9 18	37	59	22	33	63 30	5	9					
M 105 × 2	103.701	5	9 14	103.663	1	17 18	103.663	1	23 22	102.835	7	7 14	29	47	18	27	49 22	5	10					
M 110 × 6	106.103	1	17 18	106.023	-1	23 22	106.023	5	35 30	103.505	9	9 18	69	91	22	65	95 30	6	8					
M 110 × 4	107.402	1	17 18	107.342	-1	23 22	107.342	5	35 30	105.670	9	9 18	49	71	22	45	75 30	6	8					
M 110 × 3	108.051	1	17 18	108.003	-1	23 22	108.003	5	35 30	106.752	9	9 18	37	59	22	33	63 30	5	9					
M 110 × 2	108.701	5	9 14	108.663	1	17 18	108.663	1	23 22	107.835	7	7 14	29	47	18	27	49 22	5	10					
M 115 × 6	111.103	1	17 18	111.023	-1	23 22	111.023	5	35 30	108.505	9	9 18	69	91	22	65	95 30	6	8					
M 115 × 4	112.402	1	17 18	112.342	-1	23 22	112.342	5	35 30	110.670	9	9 18	49	71	22	45	75 30	6	8					
M 115 × 3	113.051	1	17 18	113.003	-1	23 22	113.003	5	35 30	111.752	9	9 18	37	59	22	33	63 30	5	9					
M 115 × 2	113.701	5	9 14	113.663	1	17 18	113.663	1	23 22	112.835	7	7 14	29	47	18	27	49 22	5	10					
M 120 × 6	116.103	1	17 18	116.023	-1	23 22	116.023	5	35 30	113.505	9	9 18	69	91	22	65	95 30	6	8					
M 120 × 4	117.402	1	17 18	117.342	-1	23 22	117.342	5	35 30	115.670	9	9 18	49	71	22	45	75 30	6	8					
M 120 × 3	118.051	1	17 18	118.003	-1	23 22	118.003	5	35 30	116.752	9	9 18	37	59	22	33	63 30	5	9					
M 120 × 2	118.701	5	9 14	118.663	1	17 18	118.663	1	23 22	117.835	7	7 14	29	47	18	27	49 22	5	10					
M 125 × 6	121.103	1	17 18	121.023	-1	23 22	121.023	5	35 30	118.505	9	9 18	69	91	22	65	95 30	6	8					
M 125 × 4	122.402	1	17 18	122.342	-1	23 22	122.342	5	35 30	120.670	9	9 18	49	71	22	45	75 30	6	8					
M 125 × 3	123.051	1	17 18	123.003	-1	23 22	123.003	5	35 30	121.752	9	9 18	37	59	22	33	63 30	5	9					
M 125 × 2	123.701	5	9 14	123.663	1	17 18	123.663	1	23 22	122.835	7	7 14	29	47	18	27	49 22	5	10					
M 130 × 6	126.103	1	17 18	126.023	-1	23 22	126.023	5	35 30	123.505	9	9 18	69	91	22	65	95 30	6	8					
M 130 × 4	127.402	1	17 18	127.342	-1	23 22	127.342	5	35 30	125.670	9	9 18	49	71	22	45	75 30	6	8					
M 130 × 3	128.051	1	17 18	128.003	-1	23 22	128.003	5	35 30	126.752	9	9 18	37	59	22	33	63 30	5	9					
M 130 × 2	128.701	5	9 14	128.663	1	17 18	128.663	1	23 22	127.835	7	7 14	29	47	18	27	49 22	5	10					
M 135 × 6	131.103	1	17 18	131.023	-1	23 22	131.023	5	35 30	128.505	9	9 18	69	91	22	65	95 30	6	8					
M 135 × 4	132.402	1	17 18	132.342	-1	23 22	132.342	5	35 30	130.670	9	9 18	49	71	22	45	75 30	6	8					
M 135 × 3	133.051	1	17 18	133.003	-1	23 22	133.003	5	35 30	131.752	9	9 18	37	59	22	33	63 30	5	9					
M 135 × 2	133.701	5	9 14	133.663	1	17 18	133.663	1	23 22	132.835	7	7 14	29	47	18	27	49 22	5	10					

Table 6. GR (continued) (4)

Designation of thread to be inspected	Pitch diameter ⁽⁸⁾												Minor diameter												⁽¹³⁾ Pitch tolerance Tolerance on half angle of thread (minute)		Unit: μm
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				Basic size	For Class 4 h thread			For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾			For Class 8 g thread							
	⁽¹¹⁾		For new gauge		⁽¹¹⁾		For new gauge		⁽¹¹⁾		For new gauge			Upper deviation	Lower deviation	Tolerance	Upper deviation	Lower deviation	Tolerance	Upper deviation	Lower deviation	Tolerance					
	$d_{2\text{max}}$	(mm)	+	-	$d_{2\text{max}}$	(mm)	+	-	$d_{2\text{max}}$	(mm)	+	-											d_1 ⁽¹²⁾	(mm)			
M 140 × 6	136.103	1	17	18	136.023	-1	23	22	136.023	5	35	30	133.505	9	9	18	69	91	22	65	95	30	6	8			
M 140 × 4	137.402	1	17	18	137.342	-1	23	22	137.342	5	35	30	135.670	9	9	18	49	71	22	45	75	30	6	8			
M 140 × 3	138.051	1	17	18	138.003	-1	23	22	138.003	5	35	30	136.752	9	9	18	37	59	22	33	63	30	5	9			
M 140 × 2	138.701	5	9	14	138.663	1	17	18	138.663	1	23	22	137.835	7	7	14	29	47	18	27	49	22	5	10			
M 145 × 6	141.103	1	17	18	141.023	-1	23	22	141.023	5	35	30	138.505	9	9	18	69	91	22	65	95	30	6	8			
M 145 × 4	142.402	1	17	18	142.342	-1	23	22	142.342	5	35	30	140.670	9	9	18	49	71	22	45	75	30	6	8			
M 145 × 3	143.051	1	17	18	143.003	-1	23	22	143.003	5	35	30	141.752	9	9	18	37	59	22	33	63	30	5	9			
M 145 × 2	143.701	5	9	14	143.663	1	17	18	143.663	1	23	22	142.835	7	7	14	29	47	18	27	49	22	5	10			
M 150 × 6	146.103	1	17	18	146.023	-1	23	22	146.023	5	35	30	143.505	9	9	18	69	91	22	65	95	30	6	8			
M 150 × 4	147.402	1	17	18	147.342	-1	23	22	147.342	5	35	30	145.670	9	9	18	49	71	22	45	75	30	6	8			
M 150 × 3	148.051	1	17	18	148.003	-1	23	22	148.003	5	35	30	146.752	9	9	18	37	59	22	33	63	30	5	9			
M 150 × 2	148.701	5	9	14	148.663	1	17	18	148.663	1	23	22	147.835	7	7	14	29	47	18	27	49	22	5	10			

Notes ⁽⁹⁾ This pitch diameter means simple pitch diameter.

⁽¹⁰⁾ The numerical values for threads of M 1.4 $\times$ 0.2 or smaller shall be applied to Class 6 h threads and the values for threads of M 1.6 $\times$ 0.2 or larger to Class 6 g threads.

⁽¹¹⁾ The numerical value, $d_{2\text{max}}$, is the same as the maximum limit of size, $d_{2\text{max}}$, of the pitch diameter of external threads given in Table 1 of JIS B 0211.

⁽¹²⁾ The value, d_1 , is the same as the basic size, d_1 , of the minor diameter of external threads specified in JIS B 0207.

⁽¹³⁾ Pitch tolerance shall include the lead drunkenness.

Remarks: The shapes and dimensions of the gauges given in this Table shall be in accordance with the requirements specified in JIS B 3102.

Table 7. Shape, dimension, permissible deviation, and tolerance for
NOT GO screw ring gauge (NR)
(Metric fine screw thread)

Gauge symbol	
For Class 4 h thread	4 h NR
For Class 6 h thread	6 h NR
For Class 6 g thread	6 g NR
For Class 8 g thread	8 g NR



The Profile of thread shall be
that with truncated flanks
(see Fig. 4)

Unit: μm																				
Designation of thread to be inspected	Pitch diameter ⁽⁸⁾												Minor diameter						⁽¹³⁾ Pitch tolerance	Tolerance on half angle of thread (minute)
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread			
	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁴⁾	⁽¹⁵⁾	⁽¹⁵⁾	⁽¹⁵⁾	⁽¹⁵⁾	⁽¹⁵⁾	⁽¹⁵⁾		
	$d_{2\text{min}}$ (mm)	Upper deviation	Lower deviation	Tolerance	$d_{2\text{min}}$ (mm)	Upper deviation	Lower deviation	Tolerance	$d_{2\text{min}}$ (mm)	Upper deviation	Lower deviation	Tolerance	d'_1 (mm)	Deviation $\pm$	d'_1 (mm)	Deviation $\pm$	d'_1 (mm)	Deviation $\pm$		
M 1 $\times$ 0.2	0.840	0	8	8	0.822	0	8	8	—	—	—	—	0.796	8	0.778	8	—	—	5	60
M 1.1 $\times$ 0.2	0.940	0	8	8	0.922	0	8	8	—	—	—	—	0.896	8	0.878	8	—	—	5	60
M 1.2 $\times$ 0.2	1.040	0	8	8	1.022	0	8	8	—	—	—	—	0.996	8	0.978	8	—	—	5	60
M 1.4 $\times$ 0.2	1.240	0	8	8	1.222	0	8	8	—	—	—	—	1.196	8	1.178	8	—	—	5	60
M 1.6 $\times$ 0.2	1.438	0	8	8	1.403	0	8	8	—	—	—	—	1.394	8	1.359	8	—	—	5	60
M 1.8 $\times$ 0.2	1.638	0	8	8	1.603	0	8	8	—	—	—	—	1.594	8	1.559	8	—	—	5	60
M 2 $\times$ 0.25	1.802	0	8	8	1.764	0	10	10	—	—	—	—	1.748	8	1.709	10	—	—	5	48
M 2.2 $\times$ 0.25	2.002	0	8	8	1.964	0	10	10	—	—	—	—	1.948	8	1.909	10	—	—	5	48
M 2.5 $\times$ 0.35	2.233	0	8	8	2.191	0	10	10	—	—	—	—	2.159	8	2.116	10	—	—	5	35
M 3 $\times$ 0.35	2.731	0	8	8	2.687	0	10	10	—	—	—	—	2.657	8	2.612	10	—	—	5	35
M 3.5 $\times$ 0.35	3.231	0	8	8	3.187	0	10	10	—	—	—	—	3.157	8	3.112	10	—	—	5	35
M 4 $\times$ 0.5	3.627	0	8	8	3.580	0	10	10	—	—	—	—	3.523	8	3.475	10	—	—	5	25
M 4.5 $\times$ 0.5	4.127	0	8	8	4.080	0	10	10	—	—	—	—	4.023	8	3.975	10	—	—	5	25
M 5 $\times$ 0.5	4.627	0	8	8	4.580	0	10	10	—	—	—	—	4.523	8	4.475	10	—	—	5	25
M 5.5 $\times$ 0.5	5.127	0	8	8	5.080	0	10	10	—	—	—	—	5.023	8	4.975	10	—	—	5	25
M 6 $\times$ 0.75	5.450	0	10	10	5.391	0	14	14	—	—	—	—	5.295	10	5.234	14	—	—	5	17
M 7 $\times$ 0.75	6.450	0	10	10	6.391	0	14	14	—	—	—	—	6.295	10	6.234	14	—	—	5	17
M 8 $\times$ 1	7.279	0	10	10	7.212	0	14	14	7.144	0	18	18	7.074	10	7.005	14	6.935	18	5	16
M 8 $\times$ 0.75	7.450	0	10	10	7.391	0	14	14	—	—	—	—	7.295	10	7.234	14	—	—	5	17
M 9 $\times$ 1	8.279	0	10	10	8.212	0	14	14	8.144	0	18	18	8.074	10	8.005	14	7.935	18	5	16
M 9 $\times$ 0.75	8.450	0	10	10	8.391	0	14	14	—	—	—	—	8.295	10	8.234	14	—	—	5	17
M 10 $\times$ 1.25	9.113	0	10	10	9.042	0	14	14	8.970	0	18	18	8.858	10	8.785	14	8.711	18	5	16
M 10 $\times$ 1	9.279	0	10	10	9.212	0	14	14	9.144	0	18	18	9.074	10	9.005	14	8.935	18	5	16
M 10 $\times$ 0.75	9.450	0	10	10	9.391	0	14	14	—	—	—	—	9.295	10	9.234	14	—	—	5	17
M 11 $\times$ 1	10.279	0	10	10	10.212	0	14	14	10.144	0	18	18	10.074	10	10.005	14	9.935	18	5	16
M 11 $\times$ 0.75	10.450	0	10	10	10.391	0	14	14	—	—	—	—	10.295	10	10.234	14	—	—	5	17
M 12 $\times$ 1.5	10.936	0	14	14	10.854	0	18	18	10.770	0	22	22	10.629	14	10.545	18	10.459	22	5	16
M 12 $\times$ 1.25	11.103	0	14	14	11.028	0	18	18	10.948	0	22	22	10.846	14	10.769	18	10.687	22	5	16

Unit: μm

Table 7. NR (continued) (1)

Designation of thread to be inspected	Pitch diameter ⁽⁹⁾												Minor diameter						⁽¹³⁾ Pitch tolerance	⁽¹³⁾ Tolerance on half angle of thread (minute)	Unit: μ m
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread				
	⁽¹⁴⁾ d_{2min} (mm)	Upper deviation	Lower deviation	Tolerance	⁽¹⁴⁾ d_{2min} (mm)	Upper deviation	Lower deviation	Tolerance	⁽¹⁴⁾ d_{2min} (mm)	Upper deviation	Lower deviation	Tolerance	⁽¹⁵⁾ d'_1 (mm)	Deviation	⁽¹⁵⁾ d'_1 (mm)	Deviation	⁽¹⁵⁾ d'_1 (mm)	Deviation			
																			$\pm$	$\pm$	$\pm$
M 12×1	11.275	0	10	10	11.206	0	14	14	11.134	0	18	18	11.070	10	10.999	14	10.925	18	5	16	
M 14×1.5	12.936	0	14	14	12.854	0	18	18	12.770	0	22	22	12.629	14	12.545	18	12.459	22	5	16	
M 14×1	13.275	0	10	10	13.206	0	14	14	13.134	0	18	18	13.070	10	12.999	14	12.925	18	5	16	
M 15×1.5	13.936	0	14	14	13.854	0	18	18	13.770	0	22	22	13.629	14	13.545	18	13.459	22	5	16	
M 15×1	14.275	0	10	10	14.206	0	14	14	14.134	0	18	18	14.070	10	13.999	14	13.925	18	5	16	
M 16×1.5	14.936	0	14	14	14.854	0	18	18	14.770	0	22	22	14.629	14	14.545	18	14.459	22	5	16	
M 16×1	15.275	0	10	10	15.206	0	14	14	15.134	0	18	18	15.070	10	14.999	14	14.925	18	5	16	
M 17×1.5	15.936	0	14	14	15.854	0	18	18	15.770	0	22	22	15.629	14	15.545	18	15.459	22	5	16	
M 17×1	16.275	0	10	10	16.206	0	14	14	16.134	0	18	18	16.070	10	15.999	14	15.925	18	5	16	
M 18×2	16.601	0	14	14	16.503	0	18	18	16.413	0	22	22	16.194	14	16.094	18	16.002	22	5	14	
M 18×1.5	16.936	0	14	14	16.854	0	18	18	16.770	0	22	22	16.629	14	16.545	18	16.459	22	5	16	
M 18×1	17.275	0	10	10	17.206	0	14	14	17.134	0	18	18	17.070	10	16.999	14	16.925	18	5	16	
M 20×2	18.601	0	14	14	18.503	0	18	18	18.413	0	22	22	18.194	14	18.094	18	18.002	22	5	14	
M 20×1.5	18.936	0	14	14	18.854	0	18	18	18.770	0	22	22	18.629	14	18.545	18	18.459	22	5	16	
M 20×1	19.275	0	10	10	19.206	0	14	14	19.134	0	18	18	19.070	10	18.999	14	18.925	18	5	16	
M 22×2	20.601	0	14	14	20.503	0	18	18	20.413	0	22	22	20.194	14	20.094	18	20.002	22	5	14	
M 22×1.5	20.936	0	14	14	20.854	0	18	18	20.770	0	22	22	20.629	14	20.545	18	20.459	22	5	16	
M 22×1	21.275	0	10	10	21.206	0	14	14	21.134	0	18	18	21.070	10	20.999	14	20.925	18	5	16	
M 24×2	22.595	0	14	14	22.493	0	18	18	22.398	0	22	22	22.188	14	22.084	18	21.987	22	5	14	
M 24×1.5	22.931	0	14	14	22.844	0	18	18	22.758	0	22	22	22.624	14	22.535	18	22.447	22	5	16	
M 24×1	23.270	0	10	10	23.199	0	14	14	23.124	0	18	18	23.065	10	22.992	14	22.915	18	5	16	
M 25×2	23.595	0	14	14	23.493	0	18	18	23.398	0	22	22	23.188	14	23.084	18	22.987	22	5	14	
M 25×1.5	23.931	0	14	14	23.844	0	18	18	23.758	0	22	22	23.624	14	23.535	18	23.447	22	5	16	
M 25×1	24.270	0	10	10	24.199	0	14	14	24.124	0	18	18	24.065	10	23.992	14	23.915	18	5	16	
M 26×1.5	24.931	0	14	14	24.844	0	18	18	24.758	0	22	22	24.624	14	24.535	18	24.447	22	5	16	
M 27×2	25.595	0	14	14	25.493	0	18	18	25.398	0	22	22	25.188	14	25.084	18	24.987	22	5	14	
M 27×1.5	25.931	0	14	14	25.844	0	18	18	25.758	0	22	22	25.624	14	25.535	18	25.447	22	5	16	
M 27×1	26.270	0	10	10	26.199	0	14	14	26.124	0	18	18	26.065	10	25.992	14	25.915	18	5	16	
M 28×2	26.595	0	14	14	26.493	0	18	18	26.398	0	22	22	26.188	14	26.084	18	25.987	22	5	14	
M 28×1.5	26.931	0	14	14	26.844	0	18	18	26.758	0	22	22	26.624	14	26.535	18	26.447	22	5	16	
M 28×1	27.270	0	10	10	27.199	0	14	14	27.124	0	18	18	27.065	10	26.992	14	26.915	18	5	16	
M 30×3	27.926	0	14	14	27.803	0	18	18	27.688	0	22	22	27.319	14	27.194	18	27.077	22	5	13	
M 30×2	28.595	0	14	14	28.493	0	18	18	28.398	0	22	22	28.188	14	28.084	18	27.987	22	5	14	
M 30×1.5	28.931	0	14	14	28.844	0	18	18	28.758	0	22	22	28.624	14	28.535	18	28.447	22	5	16	
M 30×1	29.270	0	10	10	29.199	0	14	14	29.124	0	18	18	29.065	10	28.992	14	28.915	18	5	16	
M 32×2	30.595	0	14	14	30.493	0	18	18	30.398	0	22	22	30.188	14	30.084	18	29.987	22	5	14	
M 32×1.5	30.931	0	14	14	30.844	0	18	18	30.758	0	22	22	30.624	14	30.535	18	30.447	22	5	16	
M 33×3	30.926	0	14	14	30.803	0	18	18	30.688	0	22	22	30.319	14	30.194	18	30.077	22	5	13	
M 33×2	31.595	0	14	14	31.493	0	18	18	31.398	0	22	22	31.188	14	31.084	18	30.987	22	5	14	
M 33×1.5	31.931	0	14	14	31.844	0	18	18	31.758	0	22	22	31.624	14	31.535	18	31.447	22	5	16	
M 35×1.5	33.931	0	14	14	33.844	0	18	18	33.758	0	22	22	33.624	14	33.535	18	33.447	22	5	16	
M 36×3	33.926	0	14	14	33.803	0	18	18	33.688	0	22	22	33.319	14	33.194	18	33.077	22	5	13	
M 36×2	34.595	0	14	14	34.493	0	18	18	34.398	0	22	22	34.188	14	34.084	18	33.987	22	5	14	
M 36×1.5	34.931	0	14	14	34.844	0	18	18	34.758	0	22	22	34.624	14	34.535	18	34.447	22	5	16	
M 38×1.5	36.931	0	14	14	36.844	0	18	18	36.758	0	22	22	36.624	14	36.535	18	36.447	22	5	16	
M 39×3	36.926	0	14	14	36.803	0	18	18	36.688	0	22	22	36.319	14	36.194	18	36.077	22	5	13	
M 39×2	37.595	0	14	14	37.493	0	18	18	37.398	0	22	22	37.188	14	37.084	18	36.987	22	5	14	
M 39×1.5	37.931	0	14	14	37.844	0	18	18	37.758	0	22	22	37.624	14	37.535	18	37.447	22	5	16	
M 40×3	37.926	0	14	14	37.803	0	18	18	37.688	0	22	22	37.319	14	37.194	18	37.077	22	5	13	
M 40×2	38.595	0	14	14	38.493	0	18	18	38.398	0	22	22	38.188	14	38.084	18	37.987	22	5	14	
M 40×1.5	38.931	0	14	14	38.844	0	18	18	38.758	0	22	22	38.624	14	38.535	18	38.447	22	5	16	
M 42×4	39.262	0	18	18	39.118	0	22	22	38.987	0	30	30	38.453	18	38.307	22	38.172	30	5	11	
M 42×3	39.926	0	14	14	39.803	0	18	18	39.688	0	22	22	39.319	14	39.194	18	39.077	22	5	13	

Unit: μm

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Table 7. NR (continued) (2)

Unit: μm

Designation of thread to be inspected	Pitch diameter ⁽⁸⁾												Minor diameter						⁽¹³⁾ Tolerance on half angle of thread (minute)	
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread			
	⁽¹⁴⁾ d_{2min} (mm)	Upper deviation	Lower deviation	Tolerance	⁽¹⁴⁾ d_{2min} (mm)	Upper deviation	Lower deviation	Tolerance	⁽¹⁴⁾ d_{2min} (mm)	Upper deviation	Lower deviation	Tolerance	⁽¹⁵⁾ d'_1 (mm)	Deviation ±	⁽¹⁵⁾ d'_1 (mm)	Deviation ±	⁽¹⁵⁾ d'_1 (mm)	Deviation ±		
M 42 × 2	40.595	0	14	14	40.493	0	18	18	40.398	0	22	22	40.188	14	40.084	18	39.987	22	5	14
M 42 × 1,5	40.931	0	14	14	40.844	0	18	18	40.758	0	22	22	40.624	14	40.535	18	40.447	22	5	16
M 45 × 4	42.262	0	18	18	42.118	0	22	22	41.987	0	30	30	41.453	18	41.307	22	41.172	30	5	11
M 45 × 3	42.926	0	14	14	42.803	0	18	18	42.688	0	22	22	42.319	14	42.194	18	42.077	22	5	13
M 45 × 2	43.595	0	14	14	43.493	0	18	18	43.398	0	22	22	43.188	14	43.084	18	42.987	22	5	14
M 45 × 1,5	43.931	0	14	14	43.844	0	18	18	43.758	0	22	22	43.624	14	43.535	18	43.447	22	5	16
M 48 × 4	45.252	0	18	18	45.106	0	22	22	44.967	0	30	30	44.443	18	44.295	22	44.152	30	5	11
M 48 × 3	45.919	0	18	18	45.791	0	22	22	45.668	0	30	30	45.310	18	45.180	22	45.053	30	5	13
M 48 × 2	46.589	0	14	14	46.483	0	18	18	46.383	0	22	22	46.182	14	46.074	18	45.972	22	5	14
M 48 × 1,5	46.926	0	14	14	46.834	0	18	18	46.744	0	22	22	46.619	14	46.525	18	46.433	22	5	16
M 50 × 3	47.919	0	18	18	47.791	0	22	22	47.668	0	30	30	47.310	18	47.180	22	47.053	30	5	13
M 50 × 2	48.589	0	14	14	48.483	0	18	18	48.383	0	22	22	48.182	14	48.074	18	47.972	22	5	14
M 50 × 1,5	48.926	0	14	14	48.834	0	18	18	48.744	0	22	22	48.619	14	48.525	18	48.433	22	5	16
M 52 × 4	49.252	0	18	18	49.106	0	22	22	48.967	0	30	30	48.443	18	48.295	22	48.152	30	5	11
M 52 × 3	49.919	0	18	18	49.791	0	22	22	49.668	0	30	30	49.310	18	49.180	22	49.053	30	5	13
M 52 × 2	50.589	0	14	14	50.483	0	18	18	50.383	0	22	22	50.182	14	50.074	18	49.972	22	5	14
M 52 × 1,5	50.926	0	14	14	50.834	0	18	18	50.744	0	22	22	50.619	14	50.525	18	50.433	22	5	16
M 55 × 4	52.252	0	18	18	52.106	0	22	22	51.967	0	30	30	51.443	18	51.295	22	51.152	30	5	11
M 55 × 3	52.919	0	18	18	52.791	0	22	22	52.668	0	30	30	52.310	18	52.180	22	52.053	30	5	13
M 55 × 2	53.589	0	14	14	53.483	0	18	18	53.383	0	22	22	53.182	14	53.074	18	52.972	22	5	14
M 55 × 1,5	53.926	0	14	14	53.834	0	18	18	53.744	0	22	22	53.619	14	53.525	18	53.433	22	5	16
M 56 × 4	53.252	0	18	18	53.106	0	22	22	52.967	0	30	30	52.443	18	52.295	22	52.152	30	5	11
M 56 × 3	53.919	0	18	18	53.791	0	22	22	53.668	0	30	30	53.310	18	53.180	22	53.053	30	5	13
M 56 × 2	54.589	0	14	14	54.483	0	18	18	54.383	0	22	22	54.182	14	54.074	18	53.972	22	5	14
M 56 × 1,5	54.926	0	14	14	54.834	0	18	18	54.744	0	22	22	54.619	14	54.525	18	54.433	22	5	16
M 58 × 4	55.252	0	18	18	55.106	0	22	22	54.967	0	30	30	54.443	18	54.295	22	54.152	30	5	11
M 58 × 3	55.919	0	18	18	55.791	0	22	22	55.668	0	30	30	55.310	18	55.180	22	55.053	30	5	13
M 58 × 2	56.589	0	14	14	56.483	0	18	18	56.383	0	22	22	56.182	14	56.074	18	55.972	22	5	14
M 58 × 1,5	56.926	0	14	14	56.834	0	18	18	56.744	0	22	22	56.619	14	56.525	18	56.433	22	5	16
M 60 × 4	57.252	0	18	18	57.106	0	22	22	56.967	0	30	30	56.443	18	56.295	22	56.152	30	5	11
M 60 × 3	57.919	0	18	18	57.791	0	22	22	57.668	0	30	30	57.310	18	57.180	22	57.053	30	5	13
M 60 × 2	58.589	0	14	14	58.483	0	18	18	58.383	0	22	22	58.182	14	58.074	18	57.972	22	5	14
M 60 × 1,5	58.926	0	14	14	58.834	0	18	18	58.744	0	22	22	58.619	14	58.525	18	58.433	22	5	16
M 62 × 4	59.252	0	18	18	59.106	0	22	22	58.967	0	30	30	58.443	18	58.295	22	58.152	30	5	11
M 62 × 3	59.919	0	18	18	59.791	0	22	22	59.668	0	30	30	59.310	18	59.180	22	59.053	30	5	13
M 62 × 2	60.589	0	14	14	60.483	0	18	18	60.383	0	22	22	60.182	14	60.074	18	59.972	22	5	14
M 62 × 1,5	60.926	0	14	14	60.834	0	18	18	60.744	0	22	22	60.619	14	60.525	18	60.433	22	5	16
M 64 × 4	61.252	0	18	18	61.106	0	22	22	60.967	0	30	30	60.443	18	60.295	22	60.152	30	5	11
M 64 × 3	61.919	0	18	18	61.791	0	22	22	61.668	0	30	30	61.310	18	61.180	22	61.053	30	5	13
M 64 × 2	62.589	0	14	14	62.483	0	18	18	62.383	0	22	22	62.182	14	62.074	18	61.972	22	5	14
M 64 × 1,5	62.926	0	14	14	62.834	0	18	18	62.744	0	22	22	62.619	14	62.525	18	62.433	22	5	16
M 65 × 4	62.252	0	18	18	62.106	0	22	22	61.967	0	30	30	61.443	18	61.295	22	61.152	30	5	11
M 65 × 3	62.919	0	18	18	62.791	0	22	22	62.668	0	30	30	62.310	18	62.180	22	62.053	30	5	13
M 65 × 2	63.589	0	14	14	63.483	0	18	18	63.383	0	22	22	63.182	14	63.074	18	62.972	22	5	14
M 65 × 1,5	63.926	0	14	14	63.834	0	18	18	63.744	0	22	22	63.619	14	63.525	18	63.433	22	5	16
M 68 × 4	65.252	0	18	18	65.106	0	22	22	64.967	0	30	30	64.443	18	64.295	22	64.152	30	5	11
M 68 × 3	65.919	0	18	18	65.791	0	22	22	65.668	0	30	30	65.310	18	65.180	22	65.053	30	5	13
M 68 × 2	66.589	0	14	14	66.483	0	18	18	66.383	0	22	22	66.182	14	66.074	18	65.972	22	5	14
M 68 × 1,5	66.926	0	14	14	66.834	0	18	18	66.744	0	22	22	66.619	14	66.525	18	66.433	22	5	16
M 70 × 6	65.923	0	18	18	65.743	0	22	22	65.573	0	30	30	64.714	18	64.532	22	64.358	30	6	10
M 70 × 4	67.252	0	18	18	67.106	0	22	22	66.967	0	30	30	66.443	18	66.295	22	66.152	30	5	11
M 70 × 3	67.919	0	18	18	67.791	0	22	22	67.668	0	30	30	67.310	18	67.180	22	67.053	30	5	13
M 70 × 2	68.589	0	14	14	68.483	0	18	18	68.383	0	22	22	68.182	14	68.074	18	67.972	22	5	14
M 70 × 1,5	68.926	0	14	14	68.834	0	18	18	68.744	0	22	22	68.619	14	68.525	18	68.433	22	5	16
M 72 × 6	67.923	0	18	18	67.743	0	22	22	67.573	0	30	30	66.714	18	66.532	22	66.358	30	6	10
M 72 × 4	69.252	0	18	18	69.106	0	22	22	68.967	0	30	30	68.443	18	68.295	22	68.152	30	5	11
M 72 × 3	69.919	0	18	18	69.791	0	22	22	69.668	0	30	30	69.310	18	69.180	22	69.053	30	5	13
M 72 × 2	70.589	0	14	14	70.483	0	18	18	70.383	0	22	22	70.182	14	70.074	18	69.972	22	5	14
M 72 × 1,5	70.926	0	14	14	70.834	0	18	18	70.744	0	22	22	70.619	14	70.525	18	70.433	22	5	16

Table 7. NR (continued) (3)

Designation of thread to be inspected	Pitch diameter ⁽⁶⁾												Minor diameter						⁽¹⁵⁾ Pitch tolerance ±	Tolerance on half angle of thread (minute) ±
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread			
	⁽¹⁴⁾				⁽¹⁴⁾				⁽¹⁴⁾				⁽¹⁵⁾		⁽¹⁵⁾		⁽¹⁵⁾			
	d_{2min}	Upper deviation	Lower deviation	Tolerance	d_{2min}	Upper deviation	Lower deviation	Tolerance	d_{2min}	Upper deviation	Lower deviation	Tolerance	d'_1	Deviation	d'_1	Deviation	d'_1	Deviation		
	(mm)				(mm)				(mm)				(mm)	±	(mm)	±	(mm)	±		
M 75×4	72.252	0	18	18	72.106	0	22	22	71.967	0	30	30	71.443	18	71.295	22	71.152	30	5	11
M 75×3	72.919	0	18	18	72.791	0	22	22	72.668	0	30	30	72.310	18	72.180	22	72.053	30	5	13
M 75×2	73.589	0	14	14	73.483	0	18	18	73.383	0	22	22	73.182	14	73.074	18	72.972	22	5	14
M 75×1.5	73.926	0	14	14	73.834	0	18	18	73.744	0	22	22	73.619	14	73.525	18	73.433	22	5	16
M 76×6	71.923	0	18	18	71.743	0	22	22	71.573	0	30	30	70.714	18	70.532	22	70.358	30	6	10
M 76×4	73.252	0	18	18	73.106	0	22	22	72.967	0	30	30	72.443	18	72.295	22	72.152	30	5	11
M 76×3	73.919	0	18	18	73.791	0	22	22	73.668	0	30	30	73.310	18	73.180	22	73.053	30	5	13
M 76×2	74.589	0	14	14	74.483	0	18	18	74.383	0	22	22	74.182	14	74.074	18	73.972	22	5	14
M 76×1.5	74.926	0	14	14	74.834	0	18	18	74.744	0	22	22	74.619	14	74.525	18	74.433	22	5	16
M 78×2	76.589	0	14	14	76.483	0	18	18	76.383	0	22	22	76.182	14	76.074	18	75.972	22	5	14
M 80×6	75.923	0	18	18	75.743	0	22	22	75.573	0	30	30	74.714	18	74.532	22	74.358	30	6	10
M 80×4	77.252	0	18	18	77.106	0	22	22	76.967	0	30	30	76.443	18	76.295	22	76.152	30	5	11
M 80×3	77.919	0	18	18	77.791	0	22	22	77.668	0	30	30	77.310	18	77.180	22	77.053	30	5	13
M 80×2	78.589	0	14	14	78.483	0	18	18	78.383	0	22	22	78.182	14	78.074	18	77.972	22	5	14
M 80×1.5	78.926	0	14	14	78.834	0	18	18	78.744	0	22	22	78.619	14	78.525	18	78.433	22	5	16
M 82×2	80.589	0	14	14	80.483	0	18	18	80.383	0	22	22	80.182	14	80.074	18	79.972	22	5	14
M 85×6	80.923	0	18	18	80.743	0	22	22	80.573	0	30	30	79.714	18	79.532	22	79.358	30	6	10
M 85×4	82.252	0	18	18	82.106	0	22	22	81.967	0	30	30	81.443	18	81.295	22	81.152	30	5	11
M 85×3	82.919	0	18	18	82.791	0	22	22	82.668	0	30	30	82.310	18	82.180	22	82.053	30	5	13
M 85×2	83.589	0	14	14	83.483	0	18	18	83.383	0	22	22	83.182	14	83.074	18	82.972	22	5	14
M 90×6	85.923	0	18	18	85.743	0	22	22	85.573	0	30	30	84.714	18	84.532	22	84.358	30	6	10
M 90×4	87.252	0	18	18	87.106	0	22	22	86.967	0	30	30	86.443	18	86.295	22	86.152	30	5	11
M 90×3	87.919	0	18	18	87.791	0	22	22	87.668	0	30	30	87.310	18	87.180	22	87.053	30	5	13
M 90×2	88.589	0	14	14	88.483	0	18	18	88.383	0	22	22	88.182	14	88.074	18	87.972	22	5	14
M 95×6	90.913	0	18	18	90.723	0	22	22	90.548	0	30	30	89.704	18	89.512	22	89.333	30	6	10
M 95×4	92.242	0	18	18	92.092	0	22	22	91.942	0	30	30	91.433	18	91.281	22	91.127	30	5	11
M 95×3	92.911	0	18	18	92.779	0	22	22	92.648	0	30	30	92.302	18	92.168	22	92.033	30	5	13
M 95×2	93.583	0	14	14	93.473	0	18	18	93.363	0	22	22	93.176	14	93.064	18	92.952	22	5	14
M 100×6	95.913	0	18	18	95.723	0	22	22	95.548	0	30	30	94.704	18	94.512	22	94.333	30	6	10
M 100×4	97.242	0	18	18	97.092	0	22	22	96.942	0	30	30	96.433	18	96.281	22	96.127	30	5	11
M 100×3	97.911	0	18	18	97.779	0	22	22	97.648	0	30	30	97.302	18	97.168	22	97.033	30	5	13
M 100×2	98.583	0	14	14	98.473	0	18	18	98.363	0	22	22	98.176	14	98.064	18	97.952	22	5	14
M 105×6	100.913	0	18	18	100.723	0	22	22	100.548	0	30	30	99.704	18	99.512	22	99.333	30	6	10
M 105×4	102.242	0	18	18	102.092	0	22	22	101.942	0	30	30	101.433	18	101.281	22	101.127	30	5	11
M 105×3	102.911	0	18	18	102.779	0	22	22	102.648	0	30	30	102.302	18	102.168	22	102.033	30	5	13
M 105×2	103.583	0	14	14	103.473	0	18	18	103.363	0	22	22	103.176	14	103.064	18	102.952	22	5	14
M 110×6	105.913	0	18	18	105.723	0	22	22	105.548	0	30	30	104.704	18	104.512	22	104.333	30	6	10
M 110×4	107.242	0	18	18	107.092	0	22	22	106.942	0	30	30	106.433	18	106.281	22	106.127	30	5	11
M 110×3	107.911	0	18	18	107.779	0	22	22	107.648	0	30	30	107.302	18	107.168	22	107.033	30	5	13
M 110×2	108.583	0	14	14	108.473	0	18	18	108.363	0	22	22	108.176	14	108.064	18	107.952	22	5	14
M 115×6	110.913	0	18	18	110.723	0	22	22	110.548	0	30	30	109.704	18	109.512	22	109.333	30	6	10
M 115×4	112.242	0	18	18	112.092	0	22	22	111.942	0	30	30	111.433	18	111.281	22	111.127	30	5	11
M 115×3	112.911	0	18	18	112.779	0	22	22	112.648	0	30	30	112.302	18	112.168	22	112.033	30	5	13
M 115×2	113.583	0	14	14	113.473	0	18	18	113.363	0	22	22	113.176	14	113.064	18	112.952	22	5	14
M 120×6	115.913	0	18	18	115.723	0	22	22	115.548	0	30	30	114.704	18	114.512	22	114.333	30	6	10
M 120×4	117.242	0	18	18	117.092	0	22	22	116.942	0	30	30	116.433	18	116.281	22	116.127	30	5	11
M 120×3	117.911	0	18	18	117.779	0	22	22	117.648	0	30	30	117.302	18	117.168	22	117.033	30	5	13
M 120×2	118.583	0	14	14	118.473	0	18	18	118.363	0	22	22	118.176	14	118.064	18	117.952	22	5	14
M 125×6	120.913	0	18	18	120.723	0	22	22	120.548	0	30	30	119.704	18	119.512	22	119.333	30	6	10
M 125×4	122.242	0	18	18	122.092	0	22	22	121.942	0	30	30	121.433	18	121.281	22	121.127	30	5	11
M 125×3	122.911	0	18	18	122.779	0	22	22	122.648	0	30	30	122.302	18	122.168	22	122.033	30	5	13
M 125×2	123.583	0	14	14	123.473	0	18	18	123.363	0	22	22	123.176	14	123.064	18	122.952	22	5	14
M 130×6	125.913	0	18	18	125.723	0	22	22	125.548	0	30	30	124.704	18	124.512	22	124.333	30	6	10
M 130×4	127.242	0	18	18	127.092	0	22	22	126.942	0	30	30	126.433	18	126.281	22	126.127	30	5	11
M 130×3	127.911	0	18	18	127.779	0	22	22	127.648	0	30	30	127.302	18	127.168	22	127.033	30	5	13
M 130×2	128.583	0	14	14	128.473	0	18	18	128.363	0	22	22	128.176	14	128.064	18	127.952	22	5	14
M 135×6	130.913	0	18	18	130.723	0	22	22	130.548	0	30	30	129.704	18	129.512	22	129.333	30	6	10
M 135×4	132.242	0	18	18	132.092	0	22	22	131.942	0	30	30	131.433	18	131.281	22	131.127	30	5	11
M 135×3	132.911	0	18	18	132.779	0	22	22	132.648	0	30	30	132.302	18	132.168	22	132.033	30	5	13

Unit: μm

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Table 7. NR (continued) (4)

Unit: μm																				
Designation of thread to be inspected	Pitch diameter ⁽⁸⁾												Minor diameter						⁽¹³⁾ Pitch tolerance $\pm$	Tolerance on half angle of thread (minute) $\pm$
	For Class 4 h thread				For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾				For Class 8 g thread				For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread			
	⁽¹⁴⁾				⁽¹⁴⁾				⁽¹⁴⁾				⁽¹⁵⁾		⁽¹⁵⁾		⁽¹⁵⁾			
	$d_{2\min}$ (mm)	Upper deviation	Lower deviation	Tolerance	$d_{2\min}$ (mm)	Upper deviation	Lower deviation	Tolerance	$d_{2\min}$ (mm)	Upper deviation	Lower deviation	Tolerance	d'_1 (mm)	Deviation $\pm$	d'_1 (mm)	Deviation $\pm$	d'_1 (mm)	Deviation $\pm$		
M 135×2	133.583	0	14	14	133.473	0	18	18	133.363	0	22	22	133.176	14	133.064	18	132.952	22	5	14
M 140×6	135.913	0	18	18	135.723	0	22	22	135.548	0	30	30	134.704	18	134.512	22	134.333	30	6	10
M 140×4	137.242	0	18	18	137.092	0	22	22	136.942	0	30	30	136.433	18	136.281	22	136.127	30	5	11
M 140×3	137.911	0	18	18	137.779	0	22	22	137.648	0	30	30	137.302	18	137.168	22	137.033	30	5	13
M 140×2	138.583	0	14	14	138.473	0	18	18	138.363	0	22	22	138.176	14	138.064	18	137.952	22	5	14
M 145×6	140.913	0	18	18	140.723	0	22	22	140.548	0	30	30	139.704	18	139.512	22	139.333	30	6	10
M 145×4	142.242	0	18	18	142.092	0	22	22	141.942	0	30	30	141.433	18	141.281	22	141.127	30	5	11
M 145×3	142.911	0	18	18	142.779	0	22	22	142.648	0	30	30	142.302	18	142.168	22	142.033	30	5	13
M 145×2	143.583	0	14	14	143.473	0	18	18	143.363	0	22	22	143.176	14	143.064	18	142.952	22	5	14
M 150×6	145.913	0	18	18	145.723	0	22	22	145.548	0	30	30	144.704	18	144.512	22	144.333	30	6	10
M 150×4	147.242	0	18	18	147.092	0	22	22	146.942	0	30	30	146.433	18	146.281	22	146.127	30	5	11
M 150×3	147.911	0	18	18	147.779	0	22	22	147.648	0	30	30	147.302	18	147.168	22	147.033	30	5	13
M 150×2	148.583	0	14	14	148.473	0	18	18	148.363	0	22	22	148.176	14	148.064	18	147.952	22	5	14

Notes ⁽⁹⁾ This pitch diameter means simple pitch diameter.

⁽¹⁰⁾ The numerical values for threads of M1.4×0.2 or smaller shall be applied to Class 6 h threads and the values for threads of M1.6×0.2 or larger to Class 6 g threads.

⁽¹³⁾ Pitch tolerances shall include the lead drunkenness.

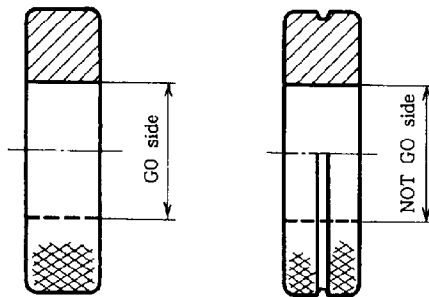
⁽¹⁴⁾ The value, $d_{2\min}$, is the same as the minimum limit of size, $d_{2\min}$, of the pitch diameter of external threads given in Table 1 of JIS B 0211.

⁽¹⁵⁾ The value of d'_1 indicates the theoretical size (the middle of tolerance).

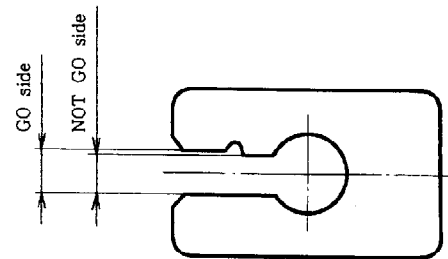
Remarks: The shapes and dimensions of the gauges given in this Table shall be in accordance with the requirements specified in JIS B 3102.

Table 8. Shape, dimension, permissible deviation, and tolerance for plain ring gauge (PR) or plain calliper gauge (PC) for major diameter (Metric fine screw thread)

Gauge symbol		
For Class 4 h thread	4 h PR	4 h PC
For Class 6 h thread	6 h PR	6 h PC
For Class 6 g thread	6 g PR	6 g PC
For Class 8 g thread	8 g PR	8 g PC



Plain ring gauge



Plain calliper gauge

Designation of thread to be inspected	GO side															NOT GO side					
	For Class 4 h thread					For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾					For Class 8 g thread					For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread	
	⁽¹⁸⁾		For new gauge			⁽¹⁸⁾		For new gauge			⁽¹⁸⁾		For new gauge			⁽¹⁷⁾		⁽¹⁷⁾		⁽¹⁷⁾	
	d_{max}	Upper deviation	Lower deviation	Tolerance	Wear limit	d_{max}	Upper deviation	Lower deviation	Tolerance	Wear limit	d_{max}	Upper deviation	Lower deviation	Tolerance	Wear limit	d_{min}	Deviation	d_{min}	Deviation	d_{min}	Deviation
	(mm)	—	—	—	—	(mm)	—	—	—	—	(mm)	—	—	—	—	(mm)	±	(mm)	±	(mm)	±
M 1 × 0.2	1.000	4	12	8	0	1.000	4	12	8	0	—	—	—	—	—	0.964	4	0.944	4	—	—
M 1.1 × 0.2	1.100	4	12	8	0	1.100	4	12	8	0	—	—	—	—	—	1.064	4	1.044	4	—	—
M 1.2 × 0.2	1.200	4	12	8	0	1.200	4	12	8	0	—	—	—	—	—	1.164	4	1.144	4	—	—
M 1.4 × 0.2	1.400	4	12	8	0	1.400	4	12	8	0	—	—	—	—	—	1.364	4	1.344	4	—	—
M 1.6 × 0.2	1.600	4	12	8	0	1.583	4	12	8	0	—	—	—	—	—	1.564	4	1.527	4	—	—
M 1.8 × 0.2	1.800	4	12	8	0	1.783	4	12	8	0	—	—	—	—	—	1.764	4	1.727	4	—	—
M 2 × 0.25	2.000	4	12	8	0	1.982	4	12	8	0	—	—	—	—	—	1.958	4	1.915	4	—	—
M 2.2 × 0.25	2.200	4	12	8	0	2.182	4	12	8	0	—	—	—	—	—	2.158	4	2.115	4	—	—
M 2.5 × 0.35	2.500	4	12	8	0	2.481	4	12	8	0	—	—	—	—	—	2.447	4	2.396	4	—	—
M 3 × 0.35	3.000	4	12	8	0	2.981	4	12	8	0	—	—	—	—	—	2.947	4	2.896	4	—	—
M 3.5 × 0.35	3.500	4	12	8	0	3.481	4	12	8	0	—	—	—	—	—	3.447	4	3.396	4	—	—
M 4 × 0.5	4.000	4	12	8	0	3.980	15	25	10	0	—	—	—	—	—	3.933	4	3.874	5	—	—
M 4.5 × 0.5	4.500	4	12	8	0	4.480	15	25	10	0	—	—	—	—	—	4.433	4	4.374	5	—	—
M 5 × 0.5	5.000	4	12	8	0	4.980	15	25	10	0	—	—	—	—	—	4.933	4	4.874	5	—	—
M 5.5 × 0.5	5.500	4	12	8	0	5.480	15	25	10	0	—	—	—	—	—	5.433	4	5.374	5	—	—
M 6 × 0.75	6.000	15	25	10	0	5.978	15	25	10	0	—	—	—	—	—	5.910	5	5.838	5	—	—
M 7 × 0.75	7.000	15	25	10	0	6.978	15	25	10	0	—	—	—	—	—	6.910	5	6.838	5	—	—
M 8 × 1	8.000	15	25	10	0	7.974	30	46	16	0	7.974	30	46	16	0	7.888	5	7.794	8	7.694	8
M 8 × 0.75	8.000	15	25	10	0	7.978	15	25	10	0	—	—	—	—	—	7.910	5	7.838	5	—	—
M 9 × 1	9.000	15	25	10	0	8.974	30	46	16	0	8.974	30	46	16	0	8.888	5	8.794	8	8.694	8
M 9 × 0.75	9.000	15	25	10	0	8.978	15	25	10	0	—	—	—	—	—	8.910	5	8.838	5	—	—
M 10 × 1.25	10.000	15	25	10	0	9.972	30	46	16	0	9.972	30	46	16	0	9.868	5	9.760	8	9.637	8
M 10 × 1	10.000	15	25	10	0	9.974	30	46	16	0	9.974	30	46	16	0	9.888	5	9.794	8	9.694	8
M 10 × 0.75	10.000	15	25	10	0	9.978	15	25	10	0	—	—	—	—	—	9.910	5	9.838	5	—	—
M 11 × 1	11.000	15	25	10	0	10.974	30	46	16	0	10.974	30	46	16	0	10.888	5	10.794	8	10.694	8
M 11 × 0.75	11.000	15	25	10	0	10.978	15	25	10	0	—	—	—	—	—	10.910	5	10.838	5	—	—
M 12 × 1.5	12.000	30	46	16	0	11.968	30	46	16	0	11.968	39	69	30	0	11.850	8	11.732	8	11.593	15
M 12 × 1.25	12.000	15	25	10	0	11.972	30	46	16	0	11.972	30	46	16	0	11.868	5	11.760	8	11.637	8
M 12 × 1	12.000	15	25	10	0	11.974	30	46	16	0	11.974	30	46	16	0	11.888	5	11.794	8	11.694	8

Unit: μm

Table 8. PR, PC (continued) (1)

Unit: μm

Designation of thread to be inspected	GO side															NOT GO side					
	For Class 4 h thread					For Class 6 h thread and Class 6 g thread ⁽¹⁶⁾					For Class 8 g thread					For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁶⁾		For Class 8 g thread	
	⁽¹⁸⁾		For new gauge		Wear limit	⁽¹⁸⁾		For new gauge		Wear limit	⁽¹⁸⁾		For new gauge		Wear limit	⁽¹⁷⁾		⁽¹⁷⁾		⁽¹⁷⁾	
	d_{max}	(mm)	Upper deviation	Lower deviation		d_{max}	(mm)	Upper deviation	Lower deviation		d_{max}	(mm)	Upper deviation	Lower deviation		d_{min}	Deviation	d_{min}	Deviation	d_{min}	Deviation
M 14×1.5	14.000	30	46	16	0	13.968	30	46	16	0	13.968	39	69	30	0	13.850	8	13.732	8	13.593	15
M 14×1	14.000	15	25	10	0	13.974	30	46	16	0	13.974	30	46	16	0	13.888	5	13.794	8	13.694	8
M 15×1.5	15.000	30	46	16	0	14.968	30	46	16	0	14.968	39	69	30	0	14.850	8	14.732	8	14.593	15
M 15×1	15.000	15	25	10	0	14.974	30	46	16	0	14.974	30	46	16	0	14.888	5	14.794	8	14.694	8
M 16×1.5	16.000	30	46	16	0	15.968	30	46	16	0	15.968	39	69	30	0	15.850	8	15.732	8	15.593	15
M 16×1	16.000	15	25	10	0	15.974	30	46	16	0	15.974	30	46	16	0	15.888	5	15.794	8	15.694	8
M 17×1.5	17.000	30	46	16	0	16.968	30	46	16	0	16.968	39	69	30	0	16.850	8	16.732	8	16.593	15
M 17×1	17.000	15	25	10	0	16.974	30	46	16	0	16.974	30	46	16	0	16.888	5	16.794	8	16.694	8
M 18×2	18.000	30	46	16	0	17.962	30	46	16	0	17.962	39	69	30	0	17.820	8	17.682	8	17.512	15
M 18×1.5	18.000	30	46	16	0	17.968	30	46	16	0	17.968	39	69	30	0	17.850	8	17.732	8	17.593	15
M 18×1	18.000	15	25	10	0	17.974	30	46	16	0	17.974	30	46	16	0	17.888	5	17.794	8	17.694	8
M 20×2	20.000	30	46	16	0	19.962	30	46	16	0	19.962	39	69	30	0	19.820	8	19.682	8	19.512	15
M 20×1.5	20.000	30	46	16	0	19.968	30	46	16	0	19.968	39	69	30	0	19.850	8	19.732	8	19.593	15
M 20×1	20.000	15	25	10	0	19.974	30	46	16	0	19.974	30	46	16	0	19.888	5	19.794	8	19.694	8
M 22×2	22.000	30	46	16	0	21.962	30	46	16	0	21.962	39	69	30	0	21.820	8	21.682	8	21.512	15
M 22×1.5	22.000	30	46	16	0	21.968	30	46	16	0	21.968	39	69	30	0	21.850	8	21.732	8	21.593	15
M 22×1	22.000	15	25	10	0	21.974	30	46	16	0	21.974	30	46	16	0	21.888	5	21.794	8	21.694	8
M 24×2	24.000	30	46	16	0	23.962	30	46	16	0	23.962	39	69	30	0	23.820	8	23.682	8	23.512	15
M 24×1.5	24.000	30	46	16	0	23.968	30	46	16	0	23.968	39	69	30	0	23.850	8	23.732	8	23.593	15
M 24×1	24.000	15	25	10	0	23.974	30	46	16	0	23.974	30	46	16	0	23.888	5	23.794	8	23.694	8
M 25×2	25.000	30	46	16	0	24.962	30	46	16	0	24.962	39	69	30	0	24.820	8	24.682	8	24.512	15
M 25×1.5	25.000	30	46	16	0	24.968	30	46	16	0	24.968	39	69	30	0	24.850	8	24.732	8	24.593	15
M 25×1	25.000	15	25	10	0	24.974	30	46	16	0	24.974	30	46	16	0	24.888	5	24.794	8	24.694	8
M 26×1.5	26.000	30	46	16	0	25.968	30	46	16	0	25.968	39	69	30	0	25.850	8	25.732	8	25.593	15
M 27×2	27.000	30	46	16	0	26.962	30	46	16	0	26.962	39	69	30	0	26.820	8	26.682	8	26.512	15
M 27×1.5	27.000	30	46	16	0	26.968	30	46	16	0	26.968	39	69	30	0	26.850	8	26.732	8	26.593	15
M 27×1	27.000	15	25	10	0	26.974	30	46	16	0	26.974	30	46	16	0	26.888	5	26.794	8	26.694	8
M 28×2	28.000	30	46	16	0	27.962	30	46	16	0	27.962	39	69	30	0	27.820	8	27.682	8	27.512	15
M 28×1.5	28.000	30	46	16	0	27.968	30	46	16	0	27.968	39	69	30	0	27.850	8	27.732	8	27.593	15
M 28×1	28.000	15	25	10	0	27.974	30	46	16	0	27.974	30	46	16	0	27.888	5	27.794	8	27.694	8
M 30×3	30.000	30	46	16	0	29.952	39	69	30	0	29.952	39	69	30	0	29.764	8	29.577	15	29.352	15
M 30×2	30.000	30	46	16	0	29.962	30	46	16	0	29.962	39	69	30	0	29.820	8	29.682	8	29.512	15
M 30×1.5	30.000	30	46	16	0	29.968	30	46	16	0	29.968	39	69	30	0	29.850	8	29.732	8	29.593	15
M 30×1	30.000	15	25	10	0	29.974	30	46	16	0	29.974	30	46	16	0	29.888	5	29.794	8	29.694	8
M 32×2	32.000	30	46	16	0	31.962	30	46	16	0	31.962	39	69	30	0	31.820	8	31.682	8	31.512	15
M 32×1.5	32.000	30	46	16	0	31.968	30	46	16	0	31.968	39	69	30	0	31.850	8	31.732	8	31.593	15
M 33×3	33.000	30	46	16	0	32.952	39	69	30	0	32.952	39	69	30	0	32.764	8	32.577	15	32.352	15
M 33×2	33.000	30	46	16	0	32.962	30	46	16	0	32.962	39	69	30	0	32.820	8	32.682	8	32.512	15
M 33×1.5	33.000	30	46	16	0	32.968	30	46	16	0	32.968	39	69	30	0	32.850	8	32.732	8	32.593	15
M 35×1.5	35.000	30	46	16	0	34.968	30	46	16	0	34.968	39	69	30	0	34.850	8	34.732	8	34.593	15
M 36×3	36.000	30	46	16	0	35.952	39	69	30	0	35.952	39	69	30	0	35.764	8	35.577	15	35.352	15
M 36×2	36.000	30	46	16	0	35.962	30	46	16	0	35.962	39	69	30	0	35.820	8	35.682	8	35.512	15
M 36×1.5	36.000	30	46	16	0	35.968	30	46	16	0	35.968	39	69	30	0	35.850	8	35.732	8	35.593	15
M 38×1.5	38.000	30	46	16	0	37.968	30	46	16	0	37.968	39	69	30	0	37.850	8	37.732	8	37.593	15
M 39×3	39.000	30	46	16	0	38.952	39	69	30	0	38.952	39	69	30	0	38.764	8	38.577	15	38.352	15
M 39×2	39.000	30	46	16	0	38.962	30	46	16	0	38.962	39	69	30	0	38.820	8	38.682	8	38.512	15
M 39×1.5	39.000	30	46	16	0	38.968	30	46	16	0	38.968	39	69	30	0	38.850	8	38.732	8	38.593	15
M 40×3	40.000	30	46	16	0	39.952	39	69	30	0	39.952	39	69	30	0	39.764	8	39.577	15	39.352	15
M 40×2	40.000	30	46	16	0	39.962	30	46	16	0	39.962	39	69	30	0	39.820	8	39.682	8	39.512	15
M 40×1.5	40.000	30	46	16	0	39.968	30	46	16	0	39.968	39	69	30	0	39.850	8	39.732	8	39.593	15
M 42×4	42.000	30	46	16	0	41.940	39	69	30	0	41.940	39	69	30	0	41.700	8	41.465	15	41.190	15
M 42×3	42.000	30	46	16	0	41.952	39	69	30	0	41.952	39	69	30	0	41.764	8	41.577	15	41.352	15
M 42×2	42.000	30	46	16	0	41.962	30	46	16	0	41.962	39	69	30	0	41.820	8	41.682	8	41.512	15
M 42×1.5	42.000	30	46	16	0	41.968	30	46	16	0	41.968	39	69	30	0	41.850	8	41.732	8	41.593	15

Table 8. PR, PC (continued) (2)

Unit: μm

Designation of thread to be inspected	GO side															NOT GO side					
	For Class 4 h thread					For Class 6 h thread and Class 6 g thread ⁽¹⁶⁾					For Class 8 g thread					For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁶⁾		For Class 8 g thread	
	For new gauge				Wear limit	For new gauge				Wear limit	For new gauge				Wear limit	⁽¹⁷⁾ d_{max} (mm)	Deviation $\pm$	⁽¹⁷⁾ d_{min} (mm)	Deviation $\pm$	⁽¹⁷⁾ d_{min} (mm)	Deviation $\pm$
	⁽¹⁶⁾ d_{max} (mm)	Upper deviation	Lower deviation	Tolerance		⁽¹⁶⁾ d_{max} (mm)	Upper deviation	Lower deviation	Tolerance		⁽¹⁶⁾ d_{max} (mm)	Upper deviation	Lower deviation	Tolerance							
M 45 × 4	45.000	30	46	16	0	44.940	39	69	30	0	44.940	39	69	30	0	44.700	8	44.465	15	44.190	15
M 45 × 3	45.000	30	46	16	0	44.952	39	69	30	0	44.952	39	69	30	0	44.764	8	44.577	15	44.352	15
M 45 × 2	45.000	30	46	16	0	44.962	30	46	16	0	44.962	39	69	30	0	44.820	8	44.682	8	44.512	15
M 45 × 1.5	45.000	30	46	16	0	44.968	30	46	16	0	44.968	39	69	30	0	44.850	8	44.732	8	44.593	15
M 48 × 4	48.000	30	46	16	0	47.940	39	69	30	0	47.940	39	69	30	0	47.700	8	47.465	15	47.190	15
M 48 × 3	48.000	30	46	16	0	47.952	39	69	30	0	47.952	39	69	30	0	47.764	8	47.577	15	47.352	15
M 48 × 2	48.000	30	46	16	0	47.962	30	46	16	0	47.962	39	69	30	0	47.820	8	47.682	8	47.512	15
M 48 × 1.5	48.000	30	46	16	0	47.968	30	46	16	0	47.968	39	69	30	0	47.850	8	47.732	8	47.593	15
M 50 × 3	50.000	30	46	16	0	49.952	39	69	30	0	49.952	39	69	30	0	49.764	8	49.577	15	49.352	15
M 50 × 2	50.000	30	46	16	0	49.962	30	46	16	0	49.962	39	69	30	0	49.820	8	49.682	8	49.512	15
M 50 × 1.5	50.000	30	46	16	0	49.968	30	46	16	0	49.968	39	69	30	0	49.850	8	49.732	8	49.593	15
M 52 × 4	52.000	30	46	16	0	51.940	39	69	30	0	51.940	39	69	30	0	51.700	8	51.465	15	51.190	15
M 52 × 3	52.000	30	46	16	0	51.952	39	69	30	0	51.952	39	69	30	0	51.764	8	51.577	15	51.352	15
M 52 × 2	52.000	30	46	16	0	51.962	30	46	16	0	51.962	39	69	30	0	51.820	8	51.682	8	51.512	15
M 52 × 1.5	52.000	30	46	16	0	51.968	30	46	16	0	51.968	39	69	30	0	51.850	8	51.732	8	51.593	15
M 55 × 4	55.000	30	46	16	0	54.940	39	69	30	0	54.940	39	69	30	0	54.700	8	54.465	15	54.190	15
M 55 × 3	55.000	30	46	16	0	54.952	39	69	30	0	54.952	39	69	30	0	54.764	8	54.577	15	54.352	15
M 55 × 2	55.000	30	46	16	0	54.962	30	46	16	0	54.962	39	69	30	0	54.820	8	54.682	8	54.512	15
M 55 × 1.5	55.000	30	46	16	0	54.968	30	46	16	0	54.968	39	69	30	0	54.850	8	54.732	8	54.593	15
M 56 × 4	56.000	30	46	16	0	55.940	39	69	30	0	55.940	39	69	30	0	55.700	8	55.465	15	55.190	15
M 56 × 3	56.000	30	46	16	0	55.952	39	69	30	0	55.952	39	69	30	0	55.764	8	55.577	15	55.352	15
M 56 × 2	56.000	30	46	16	0	55.962	30	46	16	0	55.962	39	69	30	0	55.820	8	55.682	8	55.512	15
M 56 × 1.5	56.000	30	46	16	0	55.968	30	46	16	0	55.968	39	69	30	0	55.850	8	55.732	8	55.593	15
M 58 × 4	58.000	30	46	16	0	57.940	39	69	30	0	57.940	39	69	30	0	57.700	8	57.465	15	57.190	15
M 58 × 3	58.000	30	46	16	0	57.952	39	69	30	0	57.952	39	69	30	0	57.764	8	57.577	15	57.352	15
M 58 × 2	58.000	30	46	16	0	57.962	30	46	16	0	57.962	39	69	30	0	57.820	8	57.682	8	57.512	15
M 58 × 1.5	58.000	30	46	16	0	57.968	30	46	16	0	57.968	39	69	30	0	57.850	8	57.732	8	57.593	15
M 60 × 4	60.000	30	46	16	0	59.940	39	69	30	0	59.940	39	69	30	0	59.700	8	59.465	15	59.190	15
M 60 × 3	60.000	30	46	16	0	59.952	39	69	30	0	59.952	39	69	30	0	59.764	8	59.577	15	59.352	15
M 60 × 2	60.000	30	46	16	0	59.962	30	46	16	0	59.962	39	69	30	0	59.820	8	59.682	8	59.512	15
M 60 × 1.5	60.000	30	46	16	0	59.968	30	46	16	0	59.968	39	69	30	0	59.850	8	59.732	8	59.593	15
M 62 × 4	62.000	30	46	16	0	61.940	39	69	30	0	61.940	39	69	30	0	61.700	8	61.465	15	61.190	15
M 62 × 3	62.000	30	46	16	0	61.952	39	69	30	0	61.952	39	69	30	0	61.764	8	61.577	15	61.352	15
M 62 × 2	62.000	30	46	16	0	61.962	30	46	16	0	61.962	39	69	30	0	61.820	8	61.682	8	61.512	15
M 62 × 1.5	62.000	30	46	16	0	61.968	30	46	16	0	61.968	39	69	30	0	61.850	8	61.732	8	61.593	15
M 64 × 4	64.000	30	46	16	0	63.940	39	69	30	0	63.940	39	69	30	0	63.700	8	63.465	15	63.190	15
M 64 × 3	64.000	30	46	16	0	63.952	39	69	30	0	63.952	39	69	30	0	63.764	8	63.577	15	63.352	15
M 64 × 2	64.000	30	46	16	0	63.962	30	46	16	0	63.962	39	69	30	0	63.820	8	63.682	8	63.512	15
M 64 × 1.5	64.000	30	46	16	0	63.968	30	46	16	0	63.968	39	69	30	0	63.850	8	63.732	8	63.593	15
M 65 × 4	65.000	30	46	16	0	64.940	39	69	30	0	64.940	39	69	30	0	64.700	8	64.465	15	64.190	15
M 65 × 3	65.000	30	46	16	0	64.952	39	69	30	0	64.952	39	69	30	0	64.764	8	64.577	15	64.352	15
M 65 × 2	65.000	30	46	16	0	64.962	30	46	16	0	64.962	39	69	30	0	64.820	8	64.682	8	64.512	15
M 65 × 1.5	65.000	30	46	16	0	64.968	30	46	16	0	64.968	39	69	30	0	64.850	8	64.732	8	64.593	15
M 68 × 4	68.000	30	46	16	0	67.940	39	69	30	0	67.940	39	69	30	0	67.700	8	67.465	15	67.190	15
M 68 × 3	68.000	30	46	16	0	67.952	39	69	30	0	67.952	39	69	30	0	67.764	8	67.577	15	67.352	15
M 68 × 2	68.000	30	46	16	0	67.962	30	46	16	0	67.962	39	69	30	0	67.820	8	67.682	8	67.512	15
M 68 × 1.5	68.000	30	46	16	0	67.968	30	46	16	0	67.968	39	69	30	0	67.850	8	67.732	8	67.593	15
M 70 × 6	70.000	39	69	30	0	69.920	39	69	30	0	69.920	39	81	42	0	69.625	15	69.320	15	68.970	21
M 70 × 4	70.000	30	46	16	0	69.940	39	69	30	0	69.940	39	69	30	0	69.700	8	69.465	15	69.190	15
M 70 × 3	70.000	30	46	16	0	69.952	39	69	30	0	69.952	39	69	30	0	69.764	8	69.577	15	69.352	15
M 70 × 2	70.000	30	46	16	0	69.962	30	46	16	0	69.962	39	69	30	0	69.820	8	69.682	8	69.512	15
M 70 × 1.5	70.000	30	46	16	0	69.968	30	46	16	0	69.968	39	69	30	0	69.850	8	69.732	8	69.593	15
M 72 × 6	72.000	39	69	30	0	71.920	39	69	30	0	71.920	39	81	42	0	71.625	15	71.320	15	70.970	21
M 72 × 4	72.000	30	46	16	0	71.940	39	69	30	0	71.940	39	69	30	0	71.700	8	71.465	15	71.190	15
M 72 × 3	72.000	30	46	16	0	71.952	39	69	30	0	71.952	39	69	30	0	71.764	8	71.577	15	71.352	15
M 72 × 2	72.000	30	46	16	0	71.962	30	46	16	0	71.962	39	69	30	0	71.820	8	71.682	8	71.512	15
M 72 × 1.5	72.000	30	46	16	0	71.968	30	46	16	0	71.968	39	69	30	0	71.850	8	71.732	8	71.593	15
M 75 × 4	75.000	30	46	16	0	74.940	39	69	30	0	74.940	39	69	30	0	74.700	8	74.465	15	74.190	15
M 75 × 3	75.000	30	46	16	0	74.952	39	69	30	0	74.952	39	69	30	0	74.764	8	74.577	15	74.352	15
M 75 × 2	75.000	30	46	16	0	74.962	30	46	16	0	74.962	39	69	30	0	74.820	8	74.682	8	74.512	15

Table 8. PR, PC (continued) (3)

Unit: μm

Designation of thread to be inspected	GO side														NOT GO side									
	For Class 4 h thread					For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾					For Class 8 g thread					For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁰⁾		For Class 8 g thread				
	⁽¹⁶⁾		For new gauge		Wear limit	⁽¹⁶⁾		For new gauge		Wear limit	⁽¹⁶⁾		For new gauge		Wear limit	⁽¹⁷⁾		Deviation	⁽¹⁷⁾		Deviation	⁽¹⁷⁾		Deviation
	d_{max} (mm)	Upper deviation —	Lower deviation —	Tolerance		d_{max} (mm)	Upper deviation —	Lower deviation —	Tolerance		d_{max} (mm)	Upper deviation —	Lower deviation —	Tolerance		d_{min} (mm)	Deviation ±		d_{min} (mm)	Deviation ±		d_{min} (mm)	Deviation ±	
M 75×1.5	75.000	30	46	16	0	74.968	30	46	16	0	74.968	39	69	30	0	74.850	8	74.732	8	74.593	15			
M 76×6	76.000	39	69	30	0	75.920	39	69	30	0	75.920	39	81	42	0	75.625	15	75.320	15	74.970	21			
M 76×4	76.000	30	46	16	0	75.940	39	69	30	0	75.940	39	69	30	0	75.700	8	75.465	15	75.190	15			
M 76×3	76.000	30	46	16	0	75.952	39	69	30	0	75.952	39	69	30	0	75.764	8	75.577	15	75.352	15			
M 76×2	76.000	30	46	16	0	75.962	30	46	16	0	75.962	39	69	30	0	75.820	8	75.682	8	75.512	15			
M 76×1.5	76.000	30	46	16	0	75.968	30	46	16	0	75.968	39	69	30	0	75.850	8	75.732	8	75.593	15			
M 78×2	78.000	30	46	16	0	77.962	30	46	16	0	77.962	39	69	30	0	77.820	8	77.682	8	77.512	15			
M 80×6	80.000	39	69	30	0	79.920	39	69	30	0	79.920	39	81	42	0	79.625	15	79.320	15	78.970	21			
M 80×4	80.000	30	46	16	0	79.940	39	69	30	0	79.940	39	69	30	0	79.700	8	79.465	15	79.190	15			
M 80×3	80.000	30	46	16	0	79.952	39	69	30	0	79.952	39	69	30	0	79.764	8	79.577	15	79.352	15			
M 80×2	80.000	30	46	16	0	79.962	30	46	16	0	79.962	39	69	30	0	79.820	8	79.682	8	79.512	15			
M 80×1.5	80.000	30	46	16	0	79.968	30	46	16	0	79.968	39	69	30	0	79.850	8	79.732	8	79.593	15			
M 82×2	82.000	30	46	16	0	81.962	30	46	16	0	81.962	39	69	30	0	81.820	8	81.682	8	81.512	15			
M 85×6	85.000	39	69	30	0	84.920	39	69	30	0	84.920	39	81	42	0	84.625	15	84.320	15	83.970	21			
M 85×4	85.000	30	46	16	0	84.940	39	69	30	0	84.940	39	69	30	0	84.700	8	84.465	15	84.190	15			
M 85×3	85.000	30	46	16	0	84.952	39	69	30	0	84.952	39	69	30	0	84.764	8	84.577	15	84.352	15			
M 85×2	85.000	30	46	16	0	84.962	30	46	16	0	84.962	39	69	30	0	84.820	8	84.682	8	84.512	15			
M 90×6	90.000	39	69	30	0	89.920	39	69	30	0	89.920	39	81	42	0	89.625	15	89.320	15	88.970	21			
M 90×4	90.000	30	46	16	0	89.940	39	69	30	0	89.940	39	69	30	0	89.700	8	89.465	15	89.190	15			
M 90×3	90.000	30	46	16	0	89.952	39	69	30	0	89.952	39	69	30	0	89.764	8	89.577	15	89.352	15			
M 90×2	90.000	30	46	16	0	89.962	30	46	16	0	89.962	39	69	30	0	89.820	8	89.682	8	89.512	15			
M 95×6	95.000	39	69	30	0	94.920	39	69	30	0	94.920	39	81	42	0	94.625	15	94.320	15	93.970	21			
M 95×4	95.000	30	46	16	0	94.940	39	69	30	0	94.940	39	69	30	0	94.700	8	94.465	15	94.190	15			
M 95×3	95.000	30	46	16	0	94.952	39	69	30	0	94.952	39	69	30	0	94.764	8	94.577	15	94.352	15			
M 95×2	95.000	30	46	16	0	94.962	30	46	16	0	94.962	39	69	30	0	94.820	8	94.682	8	94.512	15			
M 100×6	100.000	39	69	30	0	99.920	39	69	30	0	99.920	39	81	42	0	99.625	15	99.320	15	98.970	21			
M 100×4	100.000	30	46	16	0	99.940	39	69	30	0	99.940	39	69	30	0	99.700	8	99.465	15	99.190	15			
M 100×3	100.000	30	46	16	0	99.952	39	69	30	0	99.952	39	69	30	0	99.764	8	99.577	15	99.352	15			
M 100×2	100.000	30	46	16	0	99.962	30	46	16	0	99.962	39	69	30	0	99.820	8	99.682	8	99.512	15			
M 105×6	105.000	39	69	30	0	104.920	39	69	30	0	104.920	39	81	42	0	104.625	15	104.320	15	103.970	21			
M 105×4	105.000	30	46	16	0	104.940	39	69	30	0	104.940	39	69	30	0	104.700	8	104.465	15	104.190	15			
M 105×3	105.000	30	46	16	0	104.952	39	69	30	0	104.952	39	69	30	0	104.764	8	104.577	15	104.352	15			
M 105×2	105.000	30	46	16	0	104.962	30	46	16	0	104.962	39	69	30	0	104.820	8	104.682	8	104.512	15			
M 110×6	110.000	39	69	30	0	109.920	39	69	30	0	109.920	39	81	42	0	109.625	15	109.320	15	108.970	21			
M 110×4	110.000	30	46	16	0	109.940	39	69	30	0	109.940	39	69	30	0	109.700	8	109.465	15	109.190	15			
M 110×3	110.000	30	46	16	0	109.952	39	69	30	0	109.952	39	69	30	0	109.764	8	109.577	15	109.352	15			
M 110×2	110.000	30	46	16	0	109.962	30	46	16	0	109.962	39	69	30	0	109.820	8	109.682	8	109.512	15			
M 115×6	115.000	39	69	30	0	114.920	39	69	30	0	114.920	39	81	42	0	114.625	15	114.320	15	113.970	21			
M 115×4	115.000	30	46	16	0	114.940	39	69	30	0	114.940	39	69	30	0	114.700	8	114.465	15	114.190	15			
M 115×3	115.000	30	46	16	0	114.952	39	69	30	0	114.952	39	69	30	0	114.764	8	114.577	15	114.352	15			
M 115×2	115.000	30	46	16	0	114.962	30	46	16	0	114.962	39	69	30	0	114.820	8	114.682	8	114.512	15			
M 120×6	120.000	39	69	30	0	119.920	39	69	30	0	119.920	39	81	42	0	119.625	15	119.320	15	118.970	21			
M 120×4	120.000	30	46	16	0	119.940	39	69	30	0	119.940	39	69	30	0	119.700	8	119.465	15	119.190	15			
M 120×3	120.000	30	46	16	0	119.952	39	69	30	0	119.952	39	69	30	0	119.764	8	119.577	15	119.352	15			
M 120×2	120.000	30	46	16	0	119.962	30	46	16	0	119.962	39	69	30	0	119.820	8	119.682	8	119.512	15			
M 125×6	125.000	39	69	30	0	124.920	39	69	30	0	124.920	39	81	42	0	124.625	15	124.320	15	123.970	21			
M 125×4	125.000	30	46	16	0	124.940	39	69	30	0	124.940	39	69	30	0	124.700	8	124.465	15	124.190	15			
M 125×3	125.000	30	46	16	0	124.952	39	69	30	0	124.952	39	69	30	0	124.764	8	124.577	15	124.352	15			
M 125×2	125.000	30	46	16	0	124.962	30	46	16	0	124.962	39	69	30	0	124.820	8	124.682	8	124.512	15			
M 130×6	130.000	39	69	30	0	129.920	39	69	30	0	129.920	39	81	42	0	129.625	15	129.320	15	128.970	21			
M 130×4	130.000	30	46	16	0	129.940	39	69	30	0	129.940	39	69	30	0	129.700	8	129.465	15	129.190	15			
M 130×3	130.000	30	46	16	0	129.952	39	69	30	0	129.952	39	69	30	0	129.764	8	129.577	15	129.352	15			
M 130×2	130.000	30	46	16	0	129.962	30	46	16	0	129.962	39	69	30	0	129.820	8	129.682	8	129.512	15			
M 135×6	135.000	39	69	30	0	134.920	39	69	30	0	134.920	39	81	42	0	134.625	15	134.320	15	133.970	21			
M 135×4	135.000	30	46	16	0	134.940	39	69	30	0	134.940	39	69	30	0	134.700	8	134.465	15	134.190	15			
M 135×3	135.000	30	46	16	0	134.952	39	69	30	0	134.952	39	69	30	0	134.764	8	134.577	15	134.352	15			
M 135×2	135.000	30	46	16	0	134.962	30	46	16	0	134.962	39	69	30	0	134.820	8	134.682	8	134.512	15			
M 140×6	140.000	39	69	30	0	139.920	39	69	30	0	139.920	39	81	42	0	139.625	15							

Table 8. PR, PC (continued) (4)

Unit: μm

Unit: μm

Designation of thread to be inspected	GO side														NOT GO side							
	For Class 4 h thread					For Class 6 h thread and Class 6 g thread ⁽¹⁶⁾					For Class 8 g thread					For Class 4 h thread		For Class 6 h thread and Class 6 g thread ⁽¹⁶⁾		For Class 8 g thread		
	⁽¹⁶⁾		For new gauge		Wear limit	⁽¹⁶⁾		For new gauge		Wear limit	⁽¹⁶⁾		For new gauge		Wear limit	⁽¹⁷⁾	Deviation	⁽¹⁷⁾	Deviation	⁽¹⁷⁾	Deviation	
	d_{max} (mm)	Upper deviation — Lower deviation	Tolerance	d_{max} (mm)		Upper deviation — Lower deviation	Tolerance	d_{max} (mm)	Upper deviation — Lower deviation		Tolerance	d_{min} (mm)	Deviation $\pm$	d_{min} (mm)		Deviation $\pm$		d_{min} (mm)		Deviation $\pm$		
M 140×4	140.000	30	46	16	0	139.940	39	69	30	0	139.940	39	69	30	0	139.700	8	139.465	15	139.190	15	
M 140×3	140.000	30	46	16	0	139.952	39	69	30	0	139.952	39	69	30	0	139.764	8	139.577	15	139.352	15	
M 140×2	140.000	30	46	16	0	139.962	30	46	16	0	139.962	39	69	30	0	139.820	8	139.682	8	139.512	15	
M 145×6	145.000	39	69	30	0	144.920	39	69	30	0	144.920	39	81	42	0	144.625	15	144.320	15	143.970	21	
M 145×4	145.000	30	46	16	0	144.940	39	69	30	0	144.940	39	69	30	0	144.700	8	144.465	15	144.190	15	
M 145×3	145.000	30	46	16	0	144.952	39	69	30	0	144.952	39	69	30	0	144.764	8	144.577	15	144.352	15	
M 145×2	145.000	30	46	16	0	144.962	30	46	16	0	144.962	39	69	30	0	144.820	8	144.682	8	144.512	15	
M 150×6	150.000	39	69	30	0	149.920	39	69	30	0	149.920	39	81	42	0	149.625	15	149.320	15	148.970	21	
M 150×4	150.000	30	46	16	0	149.940	39	69	30	0	149.940	39	69	30	0	149.700	8	149.465	15	149.190	15	
M 150×3	150.000	30	46	16	0	149.952	39	69	30	0	149.952	39	69	30	0	149.764	8	149.577	15	149.352	15	
M 150×2	150.000	30	46	16	0	149.962	30	46	16	0	149.962	39	69	30	0	149.820	8	149.682	8	149.512	15	

Notes ⁽¹⁰⁾ The numerical values for threads of M1.4 $\times$ 0.2 or smaller shall be applied to Class 6 h threads and the values for threads of M1.6 $\times$ 0.2 or larger to Class 6 g threads.

⁽¹⁶⁾ The value, $d_{\max}$, is the same as the maximum limit of size, $d_{\max}$, of the major diameter of external threads given in Table 1 of JIS B 0211.

⁽¹⁷⁾ The value, $d_{\min}$, is the same as the minimum limit of size, $d_{\min}$, of the major diameter of external threads given in Table 1 of JIS B 0211.

Remarks: The shapes and dimensions of the gauges given in this Table are in compliance with JIS B 7420.

Table 9. GP (continued) (1)

Designation of thread to be inspected	Major diameter											Pitch diameter ^(a)														Unit: μm	
	Basic size D ⁽¹⁸⁾ (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾			For Class 6 H thread			For Class 7 H thread			$D_{2\text{min}}$ (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾				For Class 6 H thread				For Class 7 H thread				Pitch tolerance ⁽¹³⁾	Tolerance on half angle of thread (minute)		
		Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance		For new gauge		For new gauge		For new gauge		For new gauge									
												Upper devia- tion	Lower devia- tion	Toler- ance	Wear limit	Upper devia- tion	Lower devia- tion	Toler- ance	Wear limit	Upper devia- tion	Lower devia- tion	Toler- ance	Wear limit				
M 15×1.5	15.000	22	2	20	22	2	20	30	2	28	14.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 15×1	15.000	14	-2	16	22	2	20	22	2	20	14.350	10	2	8	6	17	7	10	5	17	7	10	5	5	15		
M 16×1.5	16.000	22	2	20	22	2	20	30	2	28	15.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 16×1	16.000	14	-2	16	22	2	20	22	2	20	15.350	10	2	8	6	17	7	10	5	17	7	10	5	5	15		
M 17×1.5	17.000	22	2	20	22	2	20	30	2	28	16.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 17×1	17.000	14	-2	16	22	2	20	22	2	20	16.350	10	2	8	6	17	7	10	5	17	7	10	5	5	15		
M 18×2	18.000	22	2	20	30	2	28	30	2	28	16.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 18×1.5	18.000	22	2	20	22	2	20	30	2	28	17.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 18×1	18.000	14	-2	16	22	2	20	22	2	20	17.350	10	2	8	6	17	7	10	5	17	7	10	5	5	15		
M 20×2	20.000	22	2	20	30	2	28	30	2	28	18.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 20×1.5	20.000	22	2	20	22	2	20	30	2	28	19.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 20×1	20.000	14	-2	16	22	2	20	22	2	20	19.350	10	2	8	6	17	7	10	5	17	7	10	5	5	15		
M 22×2	22.000	22	2	20	30	2	28	30	2	28	20.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 22×1.5	22.000	22	2	20	22	2	20	30	2	28	21.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 22×1	22.000	14	-2	16	22	2	20	22	2	20	21.350	10	2	8	6	17	7	10	5	17	7	10	5	5	15		
M 24×2	24.000	22	2	20	30	2	28	30	2	28	22.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 24×1.5	24.000	22	2	20	22	2	20	30	2	28	23.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 24×1	24.000	22	2	20	22	2	20	30	2	28	23.350	17	7	10	5	17	7	10	5	23	9	14	5	5	15		
M 25×2	25.000	22	2	20	30	2	28	30	2	28	23.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 25×1.5	25.000	22	2	20	22	2	20	30	2	28	24.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 25×1	25.000	22	2	20	22	2	20	30	2	28	24.350	17	7	10	5	17	7	10	5	23	9	14	5	5	15		
M 26×1.5	26.000	22	2	20	22	2	20	30	2	28	25.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 27×2	27.000	22	2	20	30	2	28	30	2	28	25.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 27×1.5	27.000	22	2	20	22	2	20	30	2	28	26.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 27×1	27.000	22	2	20	22	2	20	30	2	28	26.350	17	7	10	5	17	7	10	5	23	9	14	5	5	15		
M 28×2	28.000	22	2	20	30	2	28	30	2	28	26.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 28×1.5	28.000	22	2	20	22	2	20	30	2	28	27.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 28×1	28.000	22	2	20	22	2	20	30	2	28	27.350	17	7	10	5	17	7	10	5	23	9	14	5	5	15		
M 30×3	30.000	30	2	28	30	2	28	42	6	36	28.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 30×2	30.000	22	2	20	30	2	28	30	2	28	28.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 30×1.5	30.000	22	2	20	22	2	20	30	2	28	29.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 30×1	30.000	22	2	20	22	2	20	30	2	28	29.350	17	7	10	5	17	7	10	5	23	9	14	5	5	15		
M 32×2	32.000	22	2	20	30	2	28	30	2	28	30.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 32×1.5	32.000	22	2	20	22	2	20	30	2	28	31.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 33×3	33.000	30	2	28	30	2	28	42	6	36	31.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 33×2	33.000	22	2	20	30	2	28	30	2	28	31.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 33×1.5	33.000	22	2	20	22	2	20	30	2	28	32.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 35×1.5	35.000	22	2	20	22	2	20	30	2	28	34.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 36×3	36.000	30	2	28	30	2	28	42	6	36	34.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 36×2	36.000	22	2	20	30	2	28	30	2	28	34.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 36×1.5	36.000	22	2	20	22	2	20	30	2	28	35.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 38×1.5	38.000	22	2	20	22	2	20	30	2	28	37.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 39×3	39.000	30	2	28	30	2	28	42	6	36	37.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 39×2	39.000	22	2	20	30	2	28	30	2	28	37.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 39×1.5	39.000	22	2	20	22	2	20	30	2	28	38.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 40×3	40.000	30	2	28	30	2	28	42	6	36	38.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 40×2	40.000	22	2	20	30	2	28	30	2	28	38.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 40×1.5	40.000	22	2	20	22	2	20	30	2	28	39.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 42×4	42.000	30	2	28	30	2	28	42	6	36	39.402	23	9	14	5	23	9	14	5	33	15	18	3	5	8		
M 42×3	42.000	30	2	28	30	2	28	42	6	36	40.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 42×2	42.000	22	2	20	30	2	28	30	2	28	40.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 42×1.5	42.000	22	2	20	22	2	20	30	2	28	41.026	17	7	10	5	17	7	10	5	23	9	14	5	5	12		
M 45×4	45.000	30	2	28	30	2	28	42	6	36	42.402	23	9	14	5	23	9	14	5	33	15	18	3	5	8		
M 45×3	45.000	30	2	28	30	2	28	42	6	36	43.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		

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Table 9. GP (continued) (2)

Unit: μm

Designation of thread to be inspected	Major diameter										Pitch diameter ⁽⁹⁾														⁽¹³⁾ Tolerance on half angle of thread (minute)	
	Basic size D ⁽¹⁹⁾ (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾			For Class 6 H thread			For Class 7 H thread			D_{2min} (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾				For Class 6 H thread				For Class 7 H thread						
		Upper deviation		Tolerance	Upper deviation		Tolerance	Upper deviation		Tolerance		For new gauge		Wear limit		For new gauge		Wear limit		For new gauge		Wear limit				
		+	-		+	-		+	-			+	-			+	-			+	-			+		
		Lower deviation	Tolerance	Lower deviation	Tolerance	Lower deviation	Tolerance	Lower deviation	Tolerance	Lower deviation		Tolerance	Lower deviation			Tolerance	Lower deviation			Tolerance	Lower deviation	Tolerance	Lower deviation	Tolerance	Lower deviation	Tolerance
M 45 × 2	45,000	22	2	20	30	2	28	30	2	28	43,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 45 × 1.5	45,000	22	2	20	22	2	20	30	2	28	44,026	17	7	10	5	17	7	10	5	23	9	14	5	5	12	
M 48 × 4	48,000	30	2	28	30	2	28	42	6	36	45,402	23	9	14	5	23	9	14	5	33	15	18	3	5	8	
M 48 × 3	48,000	30	2	28	30	2	28	42	6	36	46,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 48 × 2	48,000	22	2	20	30	2	28	30	2	28	46,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 48 × 1.5	48,000	22	2	20	30	2	28	30	2	28	47,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 50 × 3	50,000	30	2	28	30	2	28	42	6	36	48,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 50 × 2	50,000	22	2	20	30	2	28	30	2	28	48,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 50 × 1.5	50,000	22	2	20	30	2	28	30	2	28	49,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 52 × 4	52,000	30	2	28	30	2	28	42	6	36	49,402	23	9	14	5	23	9	14	5	33	15	18	3	5	8	
M 52 × 3	52,000	30	2	28	30	2	28	42	6	36	50,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 52 × 2	52,000	22	2	20	30	2	28	30	2	28	50,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 52 × 1.5	52,000	22	2	20	30	2	28	30	2	28	51,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 55 × 4	55,000	30	2	28	30	2	28	42	6	36	52,402	23	9	14	5	23	9	14	5	33	15	18	3	5	8	
M 55 × 3	55,000	30	2	28	30	2	28	42	6	36	53,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 55 × 2	55,000	22	2	20	30	2	28	30	2	28	53,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 55 × 1.5	55,000	22	2	20	30	2	28	30	2	28	54,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 56 × 4	56,000	30	2	28	30	2	28	42	6	36	53,402	23	9	14	5	23	9	14	5	33	15	18	3	5	8	
M 56 × 3	56,000	30	2	28	30	2	28	42	6	36	54,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 56 × 2	56,000	22	2	20	30	2	28	30	2	28	54,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 56 × 1.5	56,000	22	2	20	30	2	28	30	2	28	55,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 58 × 4	58,000	30	2	28	30	2	28	42	6	36	55,402	23	9	14	5	23	9	14	5	33	15	18	3	5	8	
M 58 × 3	58,000	30	2	28	30	2	28	42	6	36	56,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 58 × 2	58,000	22	2	20	30	2	28	30	2	28	56,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 58 × 1.5	58,000	22	2	20	30	2	28	30	2	28	57,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 60 × 4	60,000	30	2	28	30	2	28	42	6	36	57,402	23	9	14	5	23	9	14	5	33	15	18	3	5	8	
M 60 × 3	60,000	30	2	28	30	2	28	42	6	36	58,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 60 × 2	60,000	22	2	20	30	2	28	30	2	28	58,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 60 × 1.5	60,000	22	2	20	30	2	28	30	2	28	59,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 62 × 4	62,000	30	2	28	30	2	28	42	6	36	59,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 62 × 3	62,000	30	2	28	30	2	28	42	6	36	60,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 62 × 2	62,000	22	2	20	30	2	28	30	2	28	60,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 62 × 1.5	62,000	22	2	20	30	2	28	30	2	28	61,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 64 × 4	64,000	30	2	28	30	2	28	42	6	36	61,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 64 × 3	64,000	30	2	28	30	2	28	42	6	36	62,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 64 × 2	64,000	22	2	20	30	2	28	30	2	28	62,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 64 × 1.5	64,000	22	2	20	30	2	28	30	2	28	63,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 65 × 4	65,000	30	2	28	30	2	28	42	6	36	62,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 65 × 3	65,000	30	2	28	30	2	28	42	6	36	63,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 65 × 2	65,000	22	2	20	30	2	28	30	2	28	63,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 65 × 1.5	65,000	22	2	20	30	2	28	30	2	28	64,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 68 × 4	68,000	30	2	28	30	2	28	42	6	36	65,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 68 × 3	68,000	30	2	28	30	2	28	42	6	36	66,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 68 × 2	68,000	22	2	20	30	2	28	30	2	28	66,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 68 × 1.5	68,000	22	2	20	30	2	28	30	2	28	67,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 70 × 6	70,000	30	2	28	42	6	36	42	6	36	66,103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	
M 70 × 4	70,000	30	2	28	30	2	28	42	6	36	67,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 70 × 3	70,000	30	2	28	30	2	28	42	6	36	68,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 70 × 2	70,000	22	2	20	30	2	28	30	2	28	68,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 70 × 1.5	70,000	22	2	20	30	2	28	30	2	28	69,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 72 × 6	72,000	30	2	28	42	6	36	42	6	36	68,103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	
M 72 × 4	72,000	30	2	28	30	2	28	42	6	36	69,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 72 × 3	72,000	30	2	28	30	2	28	42	6	36	70,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	
M 72 × 2	72,000	22	2	20	30	2	28	30	2	28	70,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	
M 72 × 1.5	72,000	22	2	20	30	2	28	30	2	28	71,026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	
M 75 × 4	75,000	30	2	28	30	2	28	42	6	36	72,402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	
M 75 × 3	75,000	30	2	28	30	2	28	42	6	36	73,051	23	9	14	5	2										

Table 9. GP (continued) (3)

Designation of thread to be inspected	Major diameter												Pitch diameter ⁽⁸⁾												Unit: μm	
	Basic size D ⁽¹⁰⁾ (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁶⁾			For Class 6 H thread			For Class 7 H thread			$D_{2\text{min}}$ (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾			For Class 6 H thread			For Class 7 H thread			Pitch tolerance $\pm$	Tolerance on half angle of thread (minute)	$\pm$	Tolerance on half angle of thread (minute)		
		Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance		For new gauge		For new gauge		For new gauge		For new gauge								
For new gauge		For new gauge		For new gauge		For new gauge																				
Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance									

M 76×6	76.000	30	2	28	42	6	36	42	6	36	72.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 76×4	76.000	30	2	28	30	2	28	42	6	36	73.402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	8
M 76×3	76.000	30	2	28	30	2	28	42	6	36	74.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 76×2	76.000	22	2	20	30	2	28	30	2	28	74.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 76×1.5	76.000	22	2	20	30	2	28	30	2	28	75.026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	12
M 78×2	78.000	22	2	20	30	2	28	30	2	28	76.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 80×6	80.000	30	2	28	42	6	36	42	6	36	76.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 80×4	80.000	30	2	28	30	2	28	42	6	36	77.402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	8
M 80×3	80.000	30	2	28	30	2	28	42	6	36	78.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 80×2	80.000	22	2	20	30	2	28	30	2	28	78.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 80×1.5	80.000	22	2	20	30	2	28	30	2	28	79.026	17	7	10	5	23	9	14	5	23	9	14	5	5	12	12
M 82×2	82.000	22	2	20	30	2	28	30	2	28	80.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 85×6	85.000	30	2	28	42	6	36	42	6	36	81.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 85×4	85.000	30	2	28	30	2	28	42	6	36	82.402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	8
M 85×3	85.000	30	2	28	30	2	28	42	6	36	83.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 85×2	85.000	22	2	20	30	2	28	30	2	28	83.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 90×6	90.000	30	2	28	42	6	36	42	6	36	86.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 90×4	90.000	30	2	28	30	2	28	42	6	36	87.402	23	9	14	5	23	9	14	5	33	15	18	3	6	8	8
M 90×3	90.000	30	2	28	30	2	28	42	6	36	88.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 90×2	90.000	22	2	20	30	2	28	30	2	28	88.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 95×6	95.000	30	2	28	42	6	36	42	6	36	91.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 95×4	95.000	30	2	28	42	6	36	42	6	36	92.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 95×3	95.000	30	2	28	30	2	28	42	6	36	93.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 95×2	95.000	22	2	20	30	2	28	30	2	28	93.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 100×6	100.000	30	2	28	42	6	36	42	6	36	96.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 100×4	100.000	30	2	28	42	6	36	42	6	36	97.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 100×3	100.000	30	2	28	30	2	28	42	6	36	98.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 100×2	100.000	22	2	20	30	2	28	30	2	28	98.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 105×6	105.000	30	2	28	42	6	36	42	6	36	101.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 105×4	105.000	30	2	28	42	6	36	42	6	36	102.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 105×3	105.000	30	2	28	30	2	28	42	6	36	103.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 105×2	105.000	22	2	20	30	2	28	30	2	28	103.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 110×6	110.000	30	2	28	42	6	36	42	6	36	106.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 110×4	110.000	30	2	28	42	6	36	42	6	36	107.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 110×3	110.000	30	2	28	30	2	28	42	6	36	108.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 110×2	110.000	22	2	20	30	2	28	30	2	28	108.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 115×6	115.000	30	2	28	42	6	36	42	6	36	111.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 115×4	115.000	30	2	28	42	6	36	42	6	36	112.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 115×3	115.000	30	2	28	30	2	28	42	6	36	113.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 115×2	115.000	22	2	20	30	2	28	30	2	28	113.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 120×6	120.000	30	2	28	42	6	36	42	6	36	116.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 120×4	120.000	30	2	28	42	6	36	42	6	36	117.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 120×3	120.000	30	2	28	30	2	28	42	6	36	118.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 120×2	120.000	22	2	20	30	2	28	30	2	28	118.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 125×6	125.000	30	2	28	42	6	36	42	6	36	121.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 125×4	125.000	30	2	28	42	6	36	42	6	36	122.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 125×3	125.000	30	2	28	30	2	28	42	6	36	123.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 125×2	125.000	22	2	20	30	2	28	30	2	28	123.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 130×6	130.000	30	2	28	42	6	36	42	6	36	126.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 130×4	130.000	30	2	28	42	6	36	42	6	36	127.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 130×3	130.000	30	2	28	30	2	28	42	6	36	128.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 130×2	130.000	22	2	20	30	2	28	30	2	28	128.701	17	7	10	5	23	9	14	5	23	9	14	5	5	10	10
M 135×6	135.000	30	2	28	42	6	36	42	6	36	131.103	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 135×4	135.000	30	2	28	42	6	36	42	6	36	132.402	23	9	14	5	33	15	18	3	33	15	18	3	6	8	8
M 135×3	135.000	30	2	28	30	2	28	42	6	36	133.051	23	9	14	5	23	9	14	5	33	15	18	3	5	9	9
M 135×2	135.000	22	2	20	30	2	28	30	2	<																

Table 9. GP (continued) (4)

Designation of thread to be inspected	Major diameter											Pitch diameter ⁽⁹⁾															⁽¹³⁾ Pitch tolerance Tolerance on half angle of thread (minute)
	Basic size $D^{(18)}$ (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾			For Class 6 H thread			For Class 7 H thread			D_{2min} (mm)	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾				For Class 6 H thread				For Class 7 H thread							
		Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance	Upper deviation +	Lower deviation +	Tolerance		For new gauge			For new gauge			For new gauge									
												Upper deviation +	Lower deviation +	Tolerance	Wear limit	Upper deviation +	Lower deviation +	Tolerance	Wear limit	Upper deviation +	Lower deviation +	Tolerance	Wear limit				
M 140×2	140,000	22	2	20	30	2	28	30	2	28	138,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 145×6	145,000	30	2	28	42	6	36	42	6	36	141,103	23	9	14	5	33	15	18	3	33	15	18	3	6	8		
M 145×4	145,000	30	2	28	42	6	36	42	6	36	142,402	23	9	14	5	33	15	18	3	33	15	18	3	6	8		
M 145×3	145,000	30	2	28	30	2	28	42	6	36	143,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 145×2	145,000	22	2	20	30	2	28	30	2	28	143,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		
M 150×6	150,000	30	2	28	42	6	36	42	6	36	146,103	23	9	14	5	33	15	18	3	33	15	18	3	6	8		
M 150×4	150,000	30	2	28	42	6	36	42	6	36	147,402	23	9	14	5	33	15	18	3	33	15	18	3	6	8		
M 150×3	150,000	30	2	28	30	2	28	42	6	36	148,051	23	9	14	5	23	9	14	5	33	15	18	3	5	9		
M 150×2	150,000	22	2	20	30	2	28	30	2	28	148,701	17	7	10	5	23	9	14	5	23	9	14	5	5	10		

Notes ⁽⁹⁾ This pitch diameter means simple pitch diameter.

⁽¹³⁾ Pitch tolerances shall include the lead drunkenness.

⁽¹⁸⁾ The numerical values for threads of M1.8×0.2 or smaller shall be applied to class 4 H threads and the values for threads of M2×0.25 or larger to Class 5 H threads.

⁽¹⁹⁾ The value, D , is the same as that of the major diameter, D , of internal threads specified in JIS B 0207.

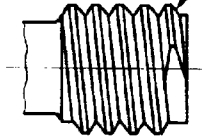
⁽²⁰⁾ The value, $D_{2\min}$, is the same as the minimum limit size, $D_{2\min}$, of the pitch diameter of internal threads given in Table 1 of JIS B 0211.

Remarks: The shapes and dimensions of the gauge given in this Table shall be in accordance with the requirements specified in JIS B 3102.

Table 10. Shape, dimension, permissible deviation, and tolerance
for NOT GO screw plug gauge (NP)
(Metric fine screw thread)

Gauge symbol	
For Class 4 H thread	4 HNP
For Class 5 H thread	5 HNP
For Class 6 H thread	6 HNP
For Class 7 H thread	7 HNP

The profile of thread shall be
that with truncated flanks
(see Fig. 5)



Designation of thread to be inspected		Major diameter						Pitch diameter ⁽⁸⁾												Unit: μm																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																		
		For Class 4 H thread and Class 5 H thread		For Class 6 H thread		For Class 7 H thread		For Class 4 H thread and Class 5 H thread ⁽¹⁰⁾				For Class 6 H thread				For Class 7 H thread				⁽¹³⁾ Pitch tolerance Tolerance on half angle of thread (minute)																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																		
		⁽²¹⁾ D' (mm)	Deviation $\pm$	⁽²¹⁾ D' (mm)	Deviation $\pm$	⁽²¹⁾ D' (mm)	Deviation $\pm$	⁽²²⁾ $D_{2\text{max}}$ (mm)	For new gauge			Wear limit	⁽²²⁾ $D_{2\text{max}}$ (mm)	For new gauge			Wear limit	⁽²²⁾ $D_{2\text{max}}$ (mm)	For new gauge			Wear limit																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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Table 10. NR (continued) (1)

Designation of thread to be inspected	Major diameter						Pitch diameter ⁽⁵⁾												(13) Pitch tolerance Tolerance on half angle of thread (minute)			
	For Class 4 H thread and Class 5 H thread		For Class 6 H thread		For Class 7 H thread		For Class 4 H thread and Class 5 H thread		For Class 6 H thread		For Class 7 H thread											
	(21)		(21)		(21)		(22)		For new gauge		For new gauge		(22)		For new gauge		For new gauge					
	D'	Deviation	D'	Deviation	D'	Deviation	D _{2max}	Upper deviation	Lower deviation	Tolerance	Wear limit	D _{2max}	Upper deviation	Lower deviation	Tolerance	Wear limit	D _{2max}	Upper deviation			Lower deviation	Tolerance
(mm)	±	(mm)	±	(mm)	±	(mm)	+	-				(mm)	+	-			(mm)	+	-			
M 17×1,5	16,481	10	16,521	10	16,569	14	16,176	10	0	10	6	16,216	10	0	10	6	16,262	14	0	14	8	5
M 17×1	16,679	8	16,715	10	16,755	10	16,475	8	0	8	5	16,510	10	0	10	6	16,550	10	0	10	6	5
M 18×2	17,276	10	17,320	14	17,373	14	16,871	10	0	10	6	16,913	14	0	14	8	16,966	14	0	14	8	5
M 18×1,5	17,481	10	17,521	10	17,569	14	17,176	10	0	10	6	17,216	10	0	10	6	17,262	14	0	14	8	5
M 18×1	17,679	8	17,715	10	17,755	10	17,475	8	0	8	5	17,510	10	0	10	6	17,550	10	0	10	6	5
M 20×2	19,276	10	19,320	14	19,373	14	18,871	10	0	10	6	18,913	14	0	14	8	18,966	14	0	14	8	5
M 20×1,5	19,481	10	19,521	10	19,569	14	19,176	10	0	10	6	19,216	10	0	10	6	19,262	14	0	14	8	5
M 20×1	19,679	8	19,715	10	19,755	10	19,475	8	0	8	5	19,510	10	0	10	6	19,550	10	0	10	6	5
M 22×2	21,276	10	21,320	14	21,373	14	20,871	10	0	10	6	20,913	14	0	14	8	20,966	14	0	14	8	5
M 22×1,5	21,481	10	21,521	10	21,569	14	21,176	10	0	10	6	21,216	10	0	10	6	21,262	14	0	14	8	5
M 22×1	21,679	8	21,715	10	21,755	10	21,475	8	0	8	5	21,510	10	0	10	6	21,550	10	0	10	6	5
M 24×2	23,286	10	23,332	14	23,388	14	22,881	10	0	10	6	22,925	14	0	14	8	22,981	14	0	14	8	5
M 24×1,5	23,491	10	23,531	10	23,583	14	23,186	10	0	10	6	23,226	10	0	10	6	23,276	14	0	14	8	5
M 24×1	23,687	10	23,725	10	23,769	14	23,482	10	0	10	6	23,520	10	0	10	6	23,562	14	0	14	8	5
M 25×2	24,286	10	24,332	14	24,388	14	23,881	10	0	10	6	23,925	14	0	14	8	23,981	14	0	14	8	5
M 25×1,5	24,491	10	24,531	10	24,583	14	24,186	10	0	10	6	24,226	10	0	10	6	24,276	14	0	14	8	5
M 25×1	24,687	10	24,725	10	24,769	14	24,482	10	0	10	6	24,520	10	0	10	6	24,562	14	0	14	8	5
M 26×1,5	25,491	10	25,531	10	25,583	14	25,186	10	0	10	6	25,226	10	0	10	6	25,276	14	0	14	8	5
M 27×2	26,286	10	26,332	14	26,388	14	25,881	10	0	10	6	25,925	14	0	14	8	25,981	14	0	14	8	5
M 27×1,5	26,491	10	26,531	10	26,583	14	26,186	10	0	10	6	26,226	10	0	10	6	26,276	14	0	14	8	5
M 27×1	26,687	10	26,725	10	26,769	14	26,482	10	0	10	6	26,520	10	0	10	6	26,562	14	0	14	8	5
M 28×2	27,286	10	27,332	14	27,388	14	26,881	10	0	10	6	26,925	14	0	14	8	26,981	14	0	14	8	5
M 28×1,5	27,491	10	27,531	10	27,583	14	27,186	10	0	10	6	27,226	10	0	10	6	27,276	14	0	14	8	5
M 28×1	27,687	10	27,725	10	27,769	14	27,482	10	0	10	6	27,520	10	0	10	6	27,562	14	0	14	8	5
M 30×3	28,870	14	28,923	14	28,995	18	28,263	14	0	14	8	28,316	14	0	14	8	28,386	18	0	18	10	5
M 30×2	29,286	10	29,332	14	29,388	14	28,881	10	0	10	6	28,925	14	0	14	8	28,981	14	0	14	8	5
M 30×1,5	29,491	10	29,531	10	29,583	14	29,186	10	0	10	6	29,226	10	0	10	6	29,276	14	0	14	8	5
M 30×1	29,687	10	29,725	10	29,769	14	29,482	10	0	10	6	29,520	10	0	10	6	29,562	14	0	14	8	5
M 32×2	31,286	10	31,332	14	31,388	14	30,881	10	0	10	6	30,925	14	0	14	8	30,981	14	0	14	8	5
M 32×1,5	31,491	10	31,531	10	31,583	14	31,186	10	0	10	6	31,226	10	0	10	6	31,276	14	0	14	8	5
M 33×3	31,870	14	31,923	14	31,995	18	31,263	14	0	14	8	31,316	14	0	14	8	31,386	18	0	18	10	5
M 33×2	32,286	10	32,332	14	32,388	14	31,881	10	0	10	6	31,925	14	0	14	8	31,981	14	0	14	8	5
M 33×1,5	32,491	10	32,531	10	32,583	14	32,186	10	0	10	6	32,226	10	0	10	6	32,276	14	0	14	8	5
M 35×1,5	34,491	10	34,531	10	34,583	14	34,186	10	0	10	6	34,226	10	0	10	6	34,276	14	0	14	8	5
M 36×3	34,870	14	34,923	14	34,995	18	34,263	14	0	14	8	34,316	14	0	14	8	34,386	18	0	18	10	5
M 36×2	35,286	10	35,332	14	35,388	14	34,881	10	0	10	6	34,925	14	0	14	8	34,981	14	0	14	8	5
M 36×1,5	35,491	10	35,531	10	35,583	14	35,186	10	0	10	6	35,226	10	0	10	6	35,276	14	0	14	8	5
M 38×1,5	37,491	10	37,531	10	37,583	14	37,186	10	0	10	6	37,226	10	0	10	6	37,276	14	0	14	8	5
M 39×3	37,870	14	37,923	14	37,995	18	37,263	14	0	14	8	37,316	14	0	14	8	37,386	18	0	18	10	5
M 39×2	38,286	10	38,332	14	38,388	14	37,881	10	0	10	6	37,925	14	0	14	8	37,981	14	0	14	8	5
M 39×1,5	38,491	10	38,531	10	38,583	14	38,186	10	0	10	6	38,226	10	0	10	6	38,276	14	0	14	8	5
M 40×3	38,870	14	38,923	14	38,995	18	38,263	14	0	14	8	38,316	14	0	14	8	38,386	18	0	18	10	5
M 40×2	39,286	10	39,332	14	39,388	14	38,881	10	0	10	6	38,925	14	0	14	8	38,981	14	0	14	8	5
M 40×1,5	39,491	10	39,531	10	39,583	14	39,186	10	0	10	6	39,226	10	0	10	6	39,276	14	0	14	8	5
M 42×4	40,445	14	40,509	14	40,586	18	39,638	14	0	14	8	39,702	14	0	14	8	39,777	18	0	18	10	5
M 42×3	40,870	14	40,923	14	40,995	18	40,263	14	0	14	8	40,316	14	0	14	8	40,386	18	0	18	10	5
M 42×2	41,286	10	41,332	14	41,388	14	40,881	10	0	10	6	40,925	14	0	14	8	40,981	14	0	14	8	5
M 42×1,5	41,491	10	41,531	10	41,583	14	41,186	10	0	10	6	41,226	10	0	10	6	41,276	14	0	14	8	5
M 45×4	43,445	14	43,509	14	43,586	18	42,638	14	0	14	8	42,702	14	0	14	8	42,777	18	0	18	10	5
M 45×3	43,870	14	43,923	14	43,995	18	43,263	14	0	14	8	43,316	14	0	14	8	43,386	18	0	18	10	5
M 45×2	44,286	10	44,332	14	44,388	14	43,881	10	0	10	6	43,925	14	0	14	8	43,981	14	0	14	8	5
M 45×1,5	44,491	10	44,531	10	44,583	14	44,186	10	0	10	6	44,226	10	0	10	6	44,276	14	0	14	8	5
M 48×4	46,459	14	46,524	14	46,611	18	45,652	14	0	14	8	45,717	14	0	14	8	45,802	18	0	18	10	5
M 48×3	46,882	14	46,938	14	47,015	18	46,275	14	0	14	8	46,331	14	0	14	8	46,406	18	0	18	10	5
M 48×2	47,296	10	47,344	14	47,408	14	46,891	10	0	10	6	46,937	14	0	14	8	47,001	14	0	14	8	5

Table 10. NR (continued) (2)

Designation of thread to be inspected	Major diameter						Pitch diameter ⁽⁹⁾														Unit: μm				
	For Class 4 H thread and Class 5 H thread		For Class 6 H thread		For Class 7 H thread		For Class 4 H thread and Class 5 H thread ⁽¹⁶⁾						For Class 6 H thread				For Class 7 H thread				(13)	Tolerance on half angle of thread (minute)			
	⁽²¹⁾		⁽²¹⁾		⁽²¹⁾		⁽²²⁾						⁽²²⁾				⁽²²⁾								
	D'	Deviation	D'	Deviation	D'	Deviation	$D_{2\text{max}}$	For new gauge	For new gauge	For new gauge	For new gauge	For new gauge	For new gauge	$D_{2\text{max}}$	For new gauge	For new gauge	For new gauge	For new gauge	$D_{2\text{max}}$	For new gauge			For new gauge	For new gauge	For new gauge
	(mm)	$\pm$	(mm)	$\pm$	(mm)	$\pm$	(mm)	Upper deviation +	Lower deviation -	Tolerance	Wear limit	(mm)	Upper deviation +	Lower deviation -	Tolerance	Wear limit	(mm)	Upper deviation +	Lower deviation -	Tolerance	Wear limit	(mm)	Upper deviation +	Lower deviation -	Tolerance
M 48×1.5	47.501	10	47.545	14	47.598	14	47.196	10	0	10	6	47.238	14	0	14	8	47.291	14	0	14	8	5	16		
M 50×3	48.882	14	48.938	14	49.015	18	48.275	14	0	14	8	48.331	14	0	14	8	48.406	18	0	18	10	5	13		
M 50×2	49.296	10	49.344	14	49.408	14	48.891	10	0	10	6	48.937	14	0	14	8	49.001	14	0	14	8	5	14		
M 50×1.5	49.501	10	49.545	14	49.598	14	49.196	10	0	10	6	49.238	14	0	14	8	49.291	14	0	14	8	5	16		
M 52×4	50.459	14	50.524	14	50.611	18	49.652	14	0	14	8	49.717	14	0	14	8	49.802	18	0	18	10	5	11		
M 52×3	50.882	14	50.938	14	51.015	18	50.275	14	0	14	8	50.331	14	0	14	8	50.406	18	0	18	10	5	13		
M 52×2	51.296	10	51.344	14	51.408	14	50.891	10	0	10	6	50.937	14	0	14	8	51.001	14	0	14	8	5	14		
M 52×1.5	51.501	10	51.545	14	51.598	14	51.196	10	0	10	6	51.238	14	0	14	8	51.291	14	0	14	8	5	16		
M 55×4	53.459	14	53.524	14	53.611	18	52.652	14	0	14	8	52.717	14	0	14	8	52.802	18	0	18	10	5	11		
M 55×3	53.882	14	53.938	14	54.015	18	53.275	14	0	14	8	53.331	14	0	14	8	53.406	18	0	18	10	5	13		
M 55×2	54.296	10	54.344	14	54.408	14	53.891	10	0	10	6	53.937	14	0	14	8	54.001	14	0	14	8	5	14		
M 55×1.5	54.501	10	54.545	14	54.598	14	54.196	10	0	10	6	54.238	14	0	14	8	54.291	14	0	14	8	5	16		
M 56×4	54.459	14	54.524	14	54.611	18	53.652	14	0	14	8	53.717	14	0	14	8	53.802	18	0	18	10	5	11		
M 56×3	54.882	14	54.938	14	55.015	18	54.275	14	0	14	8	54.331	14	0	14	8	54.406	18	0	18	10	5	13		
M 56×2	55.296	10	55.344	14	55.408	14	54.891	10	0	10	6	54.937	14	0	14	8	55.001	14	0	14	8	5	14		
M 56×1.5	55.501	10	55.545	14	55.598	14	55.196	10	0	10	6	55.238	14	0	14	8	55.291	14	0	14	8	5	16		
M 58×4	56.459	14	56.524	14	56.611	18	55.652	14	0	14	8	55.717	14	0	14	8	55.802	18	0	18	10	5	11		
M 58×3	56.882	14	56.938	14	57.015	18	56.275	14	0	14	8	56.331	14	0	14	8	56.406	18	0	18	10	5	13		
M 58×2	57.296	10	57.344	14	57.408	14	56.891	10	0	10	6	56.937	14	0	14	8	57.001	14	0	14	8	5	14		
M 58×1.5	57.501	10	57.545	14	57.598	14	57.196	10	0	10	6	57.238	14	0	14	8	57.291	14	0	14	8	5	16		
M 60×4	58.459	14	58.524	14	58.611	18	57.652	14	0	14	8	57.717	14	0	14	8	57.802	18	0	18	10	5	11		
M 60×3	58.882	14	58.938	14	59.015	18	58.275	14	0	14	8	58.331	14	0	14	8	58.406	18	0	18	10	5	13		
M 60×2	59.296	10	59.344	14	59.408	14	58.891	10	0	10	6	58.937	14	0	14	8	59.001	14	0	14	8	5	14		
M 60×1.5	59.501	10	59.545	14	59.598	14	59.196	10	0	10	6	59.238	14	0	14	8	59.291	14	0	14	8	5	16		
M 62×4	60.459	14	60.524	14	60.611	18	59.652	14	0	14	8	59.717	14	0	14	8	59.802	18	0	18	10	5	11		
M 62×3	60.882	14	60.938	14	61.015	18	60.275	14	0	14	8	60.331	14	0	14	8	60.406	18	0	18	10	5	13		
M 62×2	61.296	10	61.344	14	61.408	14	60.891	10	0	10	6	60.937	14	0	14	8	61.001	14	0	14	8	5	14		
M 62×1.5	61.501	10	61.545	14	61.598	14	61.196	10	0	10	6	61.238	14	0	14	8	61.291	14	0	14	8	5	16		
M 64×4	62.459	14	62.524	14	62.611	18	61.652	14	0	14	8	61.717	14	0	14	8	61.802	18	0	18	10	5	11		
M 64×3	62.882	14	62.938	14	63.015	18	62.275	14	0	14	8	62.331	14	0	14	8	62.406	18	0	18	10	5	13		
M 64×2	63.296	10	63.344	14	63.408	14	62.891	10	0	10	6	62.937	14	0	14	8	63.001	14	0	14	8	5	14		
M 64×1.5	63.501	10	63.545	14	63.598	14	63.196	10	0	10	6	63.238	14	0	14	8	63.291	14	0	14	8	5	16		
M 65×4	63.459	14	63.524	14	63.611	18	62.652	14	0	14	8	62.717	14	0	14	8	62.802	18	0	18	10	5	11		
M 65×3	63.882	14	63.938	14	64.015	18	63.275	14	0	14	8	63.331	14	0	14	8	63.406	18	0	18	10	5	13		
M 65×2	64.296	10	64.344	14	64.408	14	63.891	10	0	10	6	63.937	14	0	14	8	64.001	14	0	14	8	5	14		
M 65×1.5	64.501	10	64.545	14	64.598	14	64.196	10	0	10	6	64.238	14	0	14	8	64.291	14	0	14	8	5	16		
M 68×4	66.459	14	66.524	14	66.611	18	65.652	14	0	14	8	65.717	14	0	14	8	65.802	18	0	18	10	5	11		
M 68×3	66.882	14	66.938	14	67.015	18	66.275	14	0	14	8	66.331	14	0	14	8	66.406	18	0	18	10	5	13		
M 68×2	67.296	10	67.344	14	67.408	14	66.891	10	0	10	6	66.937	14	0	14	8	67.001	14	0	14	8	5	14		
M 68×1.5	67.501	10	67.545	14	67.598	14	67.196	10	0	10	6	67.238	14	0	14	8	67.291	14	0	14	8	5	16		
M 70×6	67.610	14	67.687	18	67.787	18	66.403	14	0	14	8	66.478	18	0	18	10	66.578	18	0	18	10	6	10		
M 70×4	68.459	14	68.524	14	68.611	18	67.652	14	0	14	8	67.717	14	0	14	8	67.802	18	0	18	10	5	11		
M 70×3	68.882	14	68.938	14	69.015	18	68.275	14	0	14	8	68.331	14	0	14	8	68.406	18	0	18	10	5	13		
M 70×2	69.296	10	69.344	14	69.408	14	68.891	10	0	10	6	68.937	14	0	14	8	69.001	14	0	14	8	5	14		
M 70×1.5	69.501	10	69.545	14	69.598	14	69.196	10	0	10	6	69.238	14	0	14	8	69.291	14	0	14	8	5	16		
M 72×6	69.610	14	69.687	18	69.787	18	68.403	14	0	14	8	68.478	18	0	18	10	68.578	18	0	18	10	6	10		
M 72×4	70.459	14	70.524	14	70.611	18	69.652	14	0	14	8	69.717	14	0	14	8	69.802	18	0	18	10	5	11		
M 72×3	70.882	14	70.938	14	71.015	18	70.275	14	0	14	8	70.331	14	0	14	8	70.406	18	0	18	10	5	13		
M 72×2	71.296	10	71.344	14	71.408	14	70.891	10	0	10	6	70.937	14	0	14	8	71.001	14	0	14	8	5	14		
M 72×1.5	71.501	10	71.545	14	71.598	14	71.196	10	0	10	6	71.238	14	0	14	8	71.291	14	0	14	8	5	16		
M 75×4	73.459	14	73.524	14	73.611	18	72.652	14	0	14	8	72.717	14	0	14	8	72.802	18	0	18	10	5	11		
M 75×3	73.882	14	73.938	14	74.015	18	73.275	14	0	14	8	73.331	14	0	14	8	73.406	18	0	18	10	5	13		
M 75×2	74.296	10	74.344	14	74.408	14	73.891	10	0	10	6	73.937	14	0	14	8	74.001	14	0	14	8	5	14		
M 75×1.5	74.501	10	74.545	14	74.598	14	74.196	10	0	10	6	74.238	14	0	14	8	74.291	14							

Table 10. NR (continued) (3)

Unit: μm

Designation of thread to be inspected	Major diameter						Pitch diameter ⁽⁶⁾																		⁽¹³⁾ Pitch tolerance ± Tolerance on half angle of thread (minute)
	For Class 4 H thread and Class 5 H thread		For Class 6 H thread		For Class 7 H thread		For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾						For Class 6 H thread						For Class 7 H thread						
	⁽²¹⁾		⁽²¹⁾		⁽²¹⁾		⁽²²⁾						⁽²²⁾						⁽²²⁾						
	D' (mm)	Deviation ±	D' (mm)	Deviation ±	D' (mm)	Deviation ±	D _{2max} (mm)	Upper devia- tion +	Lower devia- tion -	Toler- ance	Wear limit	D _{2max} (mm)	Upper devia- tion +	Lower devia- tion -	Toler- ance	Wear limit	D _{2max} (mm)	Upper devia- tion +	Lower devia- tion -	Toler- ance	Wear limit				
M 78×2	77.296	10	77.344	14	77.408	14	76.891	10	0	10	6	76.937	14	0	14	8	77.001	14	0	14	8	5	14		
M 80×6	77.610	14	77.687	18	77.787	18	76.403	14	0	14	8	76.478	18	0	18	10	76.578	18	0	18	10	6	10		
M 80×4	78.459	14	78.524	14	78.611	18	77.652	14	0	14	8	77.717	14	0	14	8	77.802	18	0	18	10	5	11		
M 80×3	78.882	14	78.938	14	79.015	18	78.275	14	0	14	8	78.331	14	0	14	8	78.406	18	0	18	10	5	13		
M 80×2	79.296	10	79.344	14	79.408	14	78.891	10	0	10	6	78.937	14	0	14	8	79.001	14	0	14	8	5	14		
M 80×1.5	79.501	10	79.545	14	79.598	14	79.196	10	0	10	6	79.238	14	0	14	8	79.291	14	0	14	8	5	16		
M 82×2	81.296	10	81.344	14	81.408	14	80.891	10	0	10	6	80.937	14	0	14	8	81.001	14	0	14	8	5	14		
M 85×6	82.610	14	82.687	18	82.787	18	81.403	14	0	14	8	81.478	18	0	18	10	81.578	18	0	18	10	6	10		
M 85×4	83.459	14	83.524	14	83.611	18	82.652	14	0	14	8	82.717	14	0	14	8	82.802	18	0	18	10	5	11		
M 85×3	83.882	14	83.938	14	84.015	18	83.275	14	0	14	8	83.331	14	0	14	8	83.406	18	0	18	10	5	13		
M 85×2	84.296	10	84.344	14	84.408	14	83.891	10	0	10	6	83.937	14	0	14	8	84.001	14	0	14	8	5	14		
M 90×6	87.610	14	87.687	18	87.787	18	86.403	14	0	14	8	86.478	18	0	18	10	86.578	18	0	18	10	6	10		
M 90×4	88.459	14	88.524	14	88.611	18	87.652	14	0	14	8	87.717	14	0	14	8	87.802	18	0	18	10	5	11		
M 90×3	88.882	14	88.938	14	89.015	18	88.275	14	0	14	8	88.331	14	0	14	8	88.406	18	0	18	10	5	13		
M 90×2	89.296	10	89.344	14	89.408	14	88.891	10	0	10	6	88.937	14	0	14	8	89.001	14	0	14	8	5	14		
M 95×6	92.625	14	92.712	18	92.812	18	91.418	14	0	14	8	91.503	18	0	18	10	91.603	18	0	18	10	6	10		
M 95×4	93.474	14	93.546	18	93.636	18	92.667	14	0	14	8	92.737	18	0	18	10	92.827	18	0	18	10	5	11		
M 95×3	93.894	14	93.958	14	94.035	18	93.287	14	0	14	8	93.351	14	0	14	8	93.426	18	0	18	10	5	13		
M 95×2	94.306	10	94.358	14	94.423	14	93.901	10	0	10	6	93.951	14	0	14	8	94.016	14	0	14	8	5	14		
M 100×6	97.625	14	97.712	18	97.812	18	96.418	14	0	14	8	96.503	18	0	18	10	96.603	18	0	18	10	6	10		
M 100×4	98.474	14	98.546	18	98.636	18	97.667	14	0	14	8	97.737	18	0	18	10	97.827	18	0	18	10	5	11		
M 100×3	98.894	14	98.958	14	99.035	18	98.287	14	0	14	8	98.351	14	0	14	8	98.426	18	0	18	10	5	13		
M 100×2	99.306	10	99.358	14	99.423	14	98.901	10	0	10	6	98.951	14	0	14	8	99.016	14	0	14	8	5	14		
M 105×6	102.625	14	102.712	18	102.812	18	101.418	14	0	14	8	101.503	18	0	18	10	101.603	18	0	18	10	6	10		
M 105×4	103.474	14	103.546	18	103.636	18	102.667	14	0	14	8	102.737	18	0	18	10	102.827	18	0	18	10	5	11		
M 105×3	103.894	14	103.958	14	104.035	18	103.287	14	0	14	8	103.351	14	0	14	8	103.426	18	0	18	10	5	13		
M 105×2	104.306	10	104.358	14	104.423	14	103.901	10	0	10	6	103.951	14	0	14	8	104.016	14	0	14	8	5	14		
M 110×6	107.625	14	107.712	18	107.812	18	106.418	14	0	14	8	106.503	18	0	18	10	106.603	18	0	18	10	6	10		
M 110×4	108.474	14	108.546	18	108.636	18	107.667	14	0	14	8	107.737	18	0	18	10	107.827	18	0	18	10	5	11		
M 110×3	108.894	14	108.958	14	109.035	18	108.287	14	0	14	8	108.351	14	0	14	8	108.426	18	0	18	10	5	13		
M 110×2	109.306	10	109.358	14	109.423	14	108.901	10	0	10	6	108.951	14	0	14	8	109.016	14	0	14	8	5	14		
M 115×6	112.625	14	112.712	18	112.812	18	111.418	14	0	14	8	111.503	18	0	18	10	111.603	18	0	18	10	6	10		
M 115×4	113.474	14	113.546	18	113.636	18	112.667	14	0	14	8	112.737	18	0	18	10	112.827	18	0	18	10	5	11		
M 115×3	113.894	14	113.958	14	114.035	18	113.287	14	0	14	8	113.351	14	0	14	8	113.426	18	0	18	10	5	13		
M 115×2	114.306	10	114.358	14	114.423	14	113.901	10	0	10	6	113.951	14	0	14	8	114.016	14	0	14	8	5	14		
M 120×6	117.625	14	117.712	18	117.812	18	116.418	14	0	14	8	116.503	18	0	18	10	116.603	18	0	18	10	6	10		
M 120×4	118.474	14	118.546	18	118.636	18	117.667	14	0	14	8	117.737	18	0	18	10	117.827	18	0	18	10	5	11		
M 120×3	118.894	14	118.958	14	119.035	18	118.287	14	0	14	8	118.351	14	0	14	8	118.426	18	0	18	10	5	13		
M 120×2	119.306	10	119.358	14	119.423	14	118.901	10	0	10	6	118.951	14	0	14	8	119.016	14	0	14	8	5	14		
M 125×6	122.625	14	122.712	18	122.812	18	121.418	14	0	14	8	121.503	18	0	18	10	121.603	18	0	18	10	6	10		
M 125×4	123.474	14	123.546	18	123.636	18	122.667	14	0	14	8	122.737	18	0	18	10	122.827	18	0	18	10	5	11		
M 125×3	123.894	14	123.958	14	124.035	18	123.287	14	0	14	8	123.351	14	0	14	8	123.426	18	0	18	10	5	13		
M 125×2	124.306	10	124.358	14	124.423	14	123.901	10	0	10	6	123.951	14	0	14	8	124.016	14	0	14	8	5	14		
M 130×6	127.625	14	127.712	18	127.812	18	126.418	14	0	14	8	126.503	18	0	18	10	126.603	18	0	18	10	6	10		
M 130×4	128.474	14	128.546	18	128.636	18	127.667	14	0	14	8	127.737	18	0	18	10	127.827	18	0	18	10	5	11		
M 130×3	128.894	14	128.958	14	129.035	18	128.287	14	0	14	8	128.351	14	0	14	8	128.426	18	0	18	10	5	13		
M 130×2	129.306	10	129.358	14	129.423	14	128.901	10	0	10	6	128.951	14	0	14	8	129.016	14	0	14	8	5	14		
M 135×6	132.625	14	132.712	18	132.812	18	131.418	14	0	14	8	131.503	18	0	18	10	131.603	18	0	18	10	6	10		
M 135×4	133.474	14	133.546	18	133.636	18	132.667	14	0	14	8	132.737	18	0	18	10	132.827	18	0	18	10	5	11		
M 135×3	133.894	14	133.958	14	134.035	18	133.287	14	0	14	8	133.351	14	0	14	8	133.426	18	0	18	10	5	13		
M 135×2	134.306	10	134.358	14	134.423	14	133.901	10	0	10	6	133.951	14	0	14	8	134.016	14	0	14	8	5	14		
M 140×6	137.625	14	137.712	18	137.812	18	136.418	14	0	14	8	136.503	18	0	18	10	136.603	18	0	18	10	6	10		
M 140×4	138.474	14	138.546	18	138.636	18	137.667	14	0	14	8	137.737	18	0	18	10	137.827	18	0	18	10	5	11		
M 140×3																									

Table 10. NR (continued) (4)

Designation of thread to be inspected	Major diameter						Pitch diameter ⁽⁸⁾														Unit: μm		
	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾		For Class 6 H thread		For Class 7 H thread		For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾						For Class 6 H thread				For Class 7 H thread				⁽¹³⁾ Pitch tolerance	Tolerance on half angle of thread (minute)	
	⁽²¹⁾		⁽²¹⁾		⁽²¹⁾		⁽²²⁾		For new gauge		Wear limit	⁽²²⁾		For new gauge		Wear limit	⁽²²⁾		For new gauge				Wear limit
	D'	Deviation	D'	Deviation	D'	Deviation	$D_{2\max}$	Upper deviation	Lower deviation	Tolerance		$D_{2\max}$	Upper deviation	Lower deviation	Tolerance		$D_{2\max}$	Upper deviation	Lower deviation	Tolerance			
	(mm)	$\pm$	(mm)	$\pm$	(mm)	$\pm$	(mm)	+	-			(mm)	+	-			(mm)	+	-				
M 150×6	147.625	14	147.712	18	147.812	18	146.418	14	0	14	8	146.503	18	0	18	10	146.603	18	0	18	10	6	10
M 150×4	148.474	14	148.546	18	148.636	18	147.667	14	0	14	8	147.737	18	0	18	10	147.827	18	0	18	10	5	11
M 150×3	148.894	14	148.958	14	149.035	18	148.287	14	0	14	8	148.351	14	0	14	8	148.426	18	0	18	10	5	13
M 150×2	149.306	10	149.358	14	149.423	14	148.901	10	0	10	6	148.951	14	0	14	8	149.016	14	0	14	8	5	14

Notes ⁽⁹⁾ This pitch diameter means simple pitch diameter.

⁽¹³⁾ Pitch tolerances shall include the lead drunkenness.

⁽¹⁸⁾ The numerical values for threads of M1.8×0.2 or smaller shall be applied to Class 4H threads and the values for threads of M2×0.25 or larger to Class 5H threads.

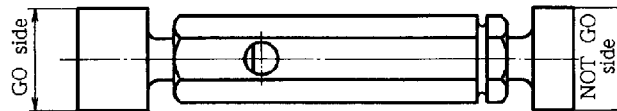
⁽²¹⁾ The value, D' , indicates the theoretical size (the middle of tolerance).

⁽²²⁾ The value, $D_{2\max}$, is the same as the maximum limit of size, $D_{2\max}$, of the pitch diameter of internal threads given in Table 1 of JIS B 0211.

Remarks: The shapes and dimensions of the gauges given in this Table shall be in accordance with the requirements specified in JIS B 3102.

Table 11. Shape, dimension, permissible deviation, and tolerance for plain plug gauge for minor diameter (PP)
(Metric fine screw thread)

Gauge symbol	
For Class 4 H thread	4 HPP
For Class 5 H thread	5 HPP
For Class 6 H thread	6 HPP
For Class 7 H thread	7 HPP



Unit: μm

Designation of thread to be inspected	GO side														NOT GO side									
	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾						For Class 6 H thread						For Class 7 H thread						For Class 4 H thread and Class 5 H thread ⁽¹⁶⁾		For Class 6 H thread		For Class 7 H thread	
	⁽²³⁾		For new gauge		Wear limit	⁽²³⁾		For new gauge		Wear limit	⁽²³⁾		For new gauge		Wear limit	⁽²⁴⁾		Deviation $\pm$	⁽²⁴⁾		Deviation $\pm$	⁽²⁴⁾		Deviation $\pm$
	$D_{1\min}$ (mm)	Upper deviation + Lower deviation -	Tolerance +	$D_{1\min}$ (mm)		Upper deviation + Lower deviation -	Tolerance +	$D_{1\min}$ (mm)	Upper deviation + Lower deviation -		Tolerance +	$D_{1\max}$ (mm)	Deviation $\pm$	$D_{1\max}$ (mm)		Deviation $\pm$	$D_{1\max}$ (mm)		Deviation $\pm$					
M 1 $\times$ 0.2	0.783	13	5	8	0	—	—	—	—	—	—	—	—	—	—	0.821	4	—	—	—	—	—	—	
M 1.1 $\times$ 0.2	0.883	13	5	8	0	—	—	—	—	—	—	—	—	—	—	0.921	4	—	—	—	—	—	—	
M 1.2 $\times$ 0.2	0.983	13	5	8	0	—	—	—	—	—	—	—	—	—	—	1.021	4	—	—	—	—	—	—	
M 1.4 $\times$ 0.2	1.183	13	5	8	0	—	—	—	—	—	—	—	—	—	—	1.221	4	—	—	—	—	—	—	
M 1.6 $\times$ 0.2	1.383	13	5	8	0	—	—	—	—	—	—	—	—	—	—	1.421	4	—	—	—	—	—	—	
M 1.8 $\times$ 0.2	1.583	13	5	8	0	—	—	—	—	—	—	—	—	—	—	1.621	4	—	—	—	—	—	—	
M 2 $\times$ 0.25	1.729	13	5	8	0	—	—	—	—	—	—	—	—	—	—	1.785	4	—	—	—	—	—	—	
M 2.2 $\times$ 0.25	1.929	13	5	8	0	—	—	—	—	—	—	—	—	—	—	1.985	4	—	—	—	—	—	—	
M 2.5 $\times$ 0.35	2.121	13	5	8	0	2.121	13	5	8	0	—	—	—	—	—	2.201	4	2.221	4	—	—	—	—	
M 3 $\times$ 0.35	2.621	13	5	8	0	2.621	13	5	8	0	—	—	—	—	—	2.701	4	2.721	4	—	—	—	—	
M 3.5 $\times$ 0.35	3.121	13	5	8	0	3.121	13	5	8	0	—	—	—	—	—	3.201	4	3.221	4	—	—	—	—	
M 4 $\times$ 0.5	3.459	27	17	10	0	3.459	27	17	10	0	3.459	27	17	10	0	3.571	5	3.599	5	3.639	5	—	—	
M 4.5 $\times$ 0.5	3.959	27	17	10	0	3.959	27	17	10	0	3.959	27	17	10	0	4.071	5	4.099	5	4.139	5	—	—	
M 5 $\times$ 0.5	4.459	27	17	10	0	4.459	27	17	10	0	4.459	27	17	10	0	4.571	5	4.599	5	4.639	5	—	—	
M 5.5 $\times$ 0.5	4.959	27	17	10	0	4.959	27	17	10	0	4.959	27	17	10	0	5.071	5	5.099	5	5.139	5	—	—	
M 6 $\times$ 0.75	5.188	27	17	10	0	5.188	46	30	16	0	5.188	46	30	16	0	5.338	5	5.378	8	5.424	8	—	—	
M 7 $\times$ 0.75	6.188	27	17	10	0	6.188	46	30	16	0	6.188	46	30	16	0	6.338	5	6.378	8	6.424	8	—	—	
M 8 $\times$ 1	6.917	46	30	16	0	6.917	46	30	16	0	6.917	46	30	16	0	7.107	8	7.153	8	7.217	8	—	—	
M 8 $\times$ 0.75	7.188	27	17	10	0	7.188	46	30	16	0	7.188	46	30	16	0	7.338	5	7.378	8	7.424	8	—	—	
M 9 $\times$ 1	7.917	46	30	16	0	7.917	46	30	16	0	7.917	46	30	16	0	8.107	8	8.153	8	8.217	8	—	—	
M 9 $\times$ 0.75	8.188	27	17	10	0	8.188	46	30	16	0	8.188	46	30	16	0	8.338	5	8.378	8	8.424	8	—	—	
M 10 $\times$ 1.25	8.647	46	30	16	0	8.647	46	30	16	0	8.647	46	30	16	0	8.859	8	8.912	8	8.982	8	—	—	
M 10 $\times$ 1	8.917	46	30	16	0	8.917	46	30	16	0	8.917	46	30	16	0	9.107	8	9.153	8	9.217	8	—	—	
M 10 $\times$ 0.75	9.188	27	17	10	0	9.188	46	30	16	0	9.188	46	30	16	0	9.338	5	9.378	8	9.424	8	—	—	
M 11 $\times$ 1	9.917	46	30	16	0	9.917	46	30	16	0	9.917	46	30	16	0	10.107	8	10.153	8	10.217	8	—	—	
M 11 $\times$ 0.75	10.188	27	17	10	0	10.188	46	30	16	0	10.188	46	30	16	0	10.338	5	10.378	8	10.424	8	—	—	
M 12 $\times$ 1.5	10.376	46	30	16	0	10.376	46	30	16	0	10.376	46	30	16	0	10.612	8	10.676	8	10.751	8	—	—	
M 12 $\times$ 1.25	10.647	46	30	16	0	10.647	46	30	16	0	10.647	46	30	16	0	10.859	8	10.912	8	10.982	8	—	—	
M 12 $\times$ 1	10.917	46	30	16	0	10.917	46	30	16	0	10.917	46	30	16	0	11.107	8	11.153	8	11.217	8	—	—	
M 14 $\times$ 1.5	12.376	46	30	16	0	12.376	46	30	16	0	12.376	46	30	16	0	12.612	8	12.676	8	12.751	8	—	—	
M 14 $\times$ 1	12.917	46	30	16	0	12.917	46	30	16	0	12.917	46	30	16	0	13.107	8	13.153	8	13.217	8	—	—	
M 15 $\times$ 1.5	13.376	46	30	16	0	13.376	46	30	16	0	13.376	46	30	16	0	13.612	8	13.676	8	13.751	8	—	—	
M 15 $\times$ 1	13.917	46	30	16	0	13.917	46	30	16	0	13.917	46	30	16	0	14.107	8	14.153	8	14.217	8	—	—	
M 16 $\times$ 1.5	14.376	46	30	16	0	14.376	46	30	16	0	14.376	46	30	16	0	14.612	8	14.676	8	14.751	8	—	—	
M 16 $\times$ 1	14.917	46	30	16	0	14.917	46	30	16	0	14.917	46	30	16	0	15.107	8	15.153	8	15.217	8	—	—	

Table 11. PP (continued) (1)

Unit: μm

Designation of thread to be inspected	GO side															NOT GO side							
	For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾										For Class 6 H thread					For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾		For Class 6 H thread		For Class 7 H thread			
	For new gauge					For new gauge					For new gauge					For new gauge		For new gauge		For new gauge			
	D_{1min} (mm)	Upper devia- tion +	Lower devia- tion +	Toler- ance	Wear limit	D_{1min} (mm)	Upper devia- tion +	Lower devia- tion +	Toler- ance	Wear limit	D_{1min} (mm)	Upper devia- tion +	Lower devia- tion +	Toler- ance	Wear limit	D_{1max} (mm)	Deviation $\pm$	D_{1max} (mm)	Deviation $\pm$	D_{1max} (mm)	Deviation $\pm$		
M 17×1.5	15.376	46	30	16	0	15.376	46	30	16	0	15.376	46	30	16	0	15.612	8	15.676	8	15.751	8		
M 17×1	15.917	46	30	16	0	15.917	46	30	16	0	15.917	46	30	16	0	16.107	8	16.153	8	16.217	8		
M 18×2	15.835	46	30	16	0	15.835	46	30	16	0	15.835	65	39	26	0	16.135	8	16.210	8	16.310	13		
M 18×1.5	16.376	46	30	16	0	16.376	46	30	16	0	16.376	46	30	16	0	16.612	8	16.676	8	16.751	8		
M 18×1	16.917	46	30	16	0	16.917	46	30	16	0	16.917	46	30	16	0	17.107	8	17.153	8	17.217	8		
M 20×2	17.835	46	30	16	0	17.835	46	30	16	0	17.835	65	39	26	0	18.135	8	18.210	8	18.310	13		
M 20×1.5	18.376	46	30	16	0	18.376	46	30	16	0	18.376	46	30	16	0	18.612	8	18.676	8	18.751	8		
M 20×1	18.917	46	30	16	0	18.917	46	30	16	0	18.917	46	30	16	0	19.107	8	19.153	8	19.217	8		
M 22×2	19.835	46	30	16	0	19.835	46	30	16	0	19.835	65	39	26	0	20.135	8	20.210	8	20.310	13		
M 22×1.5	20.376	46	30	16	0	20.376	46	30	16	0	20.376	46	30	16	0	20.612	8	20.676	8	20.751	8		
M 22×1	20.917	46	30	16	0	20.917	46	30	16	0	20.917	46	30	16	0	21.107	8	21.153	8	21.217	8		
M 24×2	21.835	46	30	16	0	21.835	46	30	16	0	21.835	65	39	26	0	22.135	8	22.210	8	22.310	13		
M 24×1.5	22.376	46	30	16	0	22.376	46	30	16	0	22.376	46	30	16	0	22.612	8	22.676	8	22.751	8		
M 24×1	22.917	46	30	16	0	22.917	46	30	16	0	22.917	46	30	16	0	23.107	8	23.153	8	23.217	8		
M 25×2	22.835	46	30	16	0	22.835	46	30	16	0	22.835	65	39	26	0	23.135	8	23.210	8	23.310	13		
M 25×1.5	23.376	46	30	16	0	23.376	46	30	16	0	23.376	46	30	16	0	23.612	8	23.676	8	23.751	8		
M 25×1	23.917	46	30	16	0	23.917	46	30	16	0	23.917	46	30	16	0	24.107	8	24.153	8	24.217	8		
M 26×1.5	24.376	46	30	16	0	24.376	46	30	16	0	24.376	46	30	16	0	24.612	8	24.676	8	24.751	8		
M 27×2	24.835	46	30	16	0	24.835	46	30	16	0	24.835	65	39	26	0	25.135	8	25.210	8	25.310	13		
M 27×1.5	25.376	46	30	16	0	25.376	46	30	16	0	25.376	46	30	16	0	25.612	8	25.676	8	25.751	8		
M 27×1	25.917	46	30	16	0	25.917	46	30	16	0	25.917	46	30	16	0	26.107	8	26.153	8	26.217	8		
M 28×2	25.835	46	30	16	0	25.835	46	30	16	0	25.835	65	39	26	0	26.135	8	26.210	8	26.310	13		
M 28×1.5	26.376	46	30	16	0	26.376	46	30	16	0	26.376	46	30	16	0	26.612	8	26.676	8	26.751	8		
M 28×1	26.917	46	30	16	0	26.917	46	30	16	0	26.917	46	30	16	0	27.107	8	27.153	8	27.217	8		
M 30×3	26.752	65	39	26	0	26.752	65	39	26	0	26.752	65	39	26	0	27.152	13	27.252	13	27.382	13		
M 30×2	27.835	46	30	16	0	27.835	46	30	16	0	27.835	65	39	26	0	28.135	8	28.210	8	28.310	13		
M 30×1.5	28.376	46	30	16	0	28.376	46	30	16	0	28.376	46	30	16	0	28.612	8	28.676	8	28.751	8		
M 30×1	28.917	46	30	16	0	28.917	46	30	16	0	28.917	46	30	16	0	29.107	8	29.153	8	29.217	8		
M 32×2	29.835	46	30	16	0	29.835	46	30	16	0	29.835	65	39	26	0	30.135	8	30.210	8	30.310	13		
M 32×1.5	30.376	46	30	16	0	30.376	46	30	16	0	30.376	46	30	16	0	30.612	8	30.676	8	30.751	8		
M 33×3	29.752	65	39	26	0	29.752	65	39	26	0	29.752	65	39	26	0	30.152	13	30.252	13	30.382	13		
M 33×2	30.835	46	30	16	0	30.835	46	30	16	0	30.835	65	39	26	0	31.135	8	31.210	8	31.310	13		
M 33×1.5	31.376	46	30	16	0	31.376	46	30	16	0	31.376	46	30	16	0	31.612	8	31.676	8	31.751	8		
M 35×1.5	33.376	46	30	16	0	33.376	46	30	16	0	33.376	46	30	16	0	33.612	8	33.676	8	33.751	8		
M 36×3	32.752	65	39	26	0	32.752	65	39	26	0	32.752	65	39	26	0	33.152	13	33.252	13	33.382	13		
M 36×2	33.835	46	30	16	0	33.835	46	30	16	0	33.835	65	39	26	0	34.135	8	34.210	8	34.310	13		
M 36×1.5	34.376	46	30	16	0	34.376	46	30	16	0	34.376	46	30	16	0	34.612	8	34.676	8	34.751	8		
M 38×1.5	36.376	46	30	16	0	36.376	46	30	16	0	36.376	46	30	16	0	36.612	8	36.676	8	36.751	8		
M 39×3	35.752	65	39	26	0	35.752	65	39	26	0	35.752	65	39	26	0	36.152	13	36.252	13	36.382	13		
M 39×2	36.835	46	30	16	0	36.835	46	30	16	0	36.835	65	39	26	0	37.135	8	37.210	8	37.310	13		
M 39×1.5	37.376	46	30	16	0	37.376	46	30	16	0	37.376	46	30	16	0	37.612	8	37.676	8	37.751	8		
M 40×3	36.752	65	39	26	0	36.752	65	39	26	0	36.752	65	39	26	0	37.152	13	37.252	13	37.382	13		
M 40×2	37.835	46	30	16	0	37.835	46	30	16	0	37.835	65	39	26	0	38.135	8	38.210	8	38.310	13		
M 40×1.5	38.376	46	30	16	0	38.376	46	30	16	0	38.376	46	30	16	0	38.612	8	38.676	8	38.751	8		
M 42×4	37.670	65	39	26	0	37.670	65	39	26	0	37.670	88	42	46	0	38.145	13	38.270	13	38.420	23		
M 42×3	38.752	65	39	26	0	38.752	65	39	26	0	38.752	65	39	26	0	39.152	13	39.252	13	39.382	13		
M 42×2	39.835	46	30	16	0	39.835	46	30	16	0	39.835	65	39	26	0	40.135	8	40.210	8	40.310	13		
M 42×1.5	40.376	46	30	16	0	40.376	46	30	16	0	40.376	46	30	16	0	40.612	8	40.676	8	40.751	8		
M 45×4	40.670	65	39	26	0	40.670	65	39	26	0	40.670	88	42	46	0	41.145	13	41.270	13	41.420	23		
M 45×3	41.752	65	39	26	0	41.752	65	39	26	0	41.752	65	39	26	0	42.152	13	42.252	13	42.382	13		
M 45×2	42.835	46	30	16	0	42.835	46	30	16	0	42.835	65	39	26	0	43.135	8	43.210	8	43.310	13		
M 45×1.5	43.376	46	30	16	0	43.376	46	30	16	0	43.376	46	30	16	0	43.612	8	43.676	8	43.751	8		
M 48×4	43.670	65	39	26	0	43.670	65	39	26	0	43.670	88	42	46	0	44.145	13	44.270	13	44.420	23		
M 48×3	44.752	65	39	26	0	44.752	65	39	26	0	44.752	65	39	26	0	45.152	13	45.252	13	45.382	13		
M 48×2	45.835	46	30	16	0	45.835	46	30	16	0	45.835	65	39	26	0	46.135	8	46.210	8	46.310	13		

Table 11. PP (continued) (2)

Unit: μm

Designation of thread to be inspected	GO side															NOT GO side											
	For Class 4 H thread and Class 5 H thread ⁽¹⁶⁾						For Class 6 H thread						For Class 7 H thread						For Class 4 H thread and Class 5 H thread ⁽¹⁸⁾		For Class 6 H thread		For Class 7 H thread				
	⁽²³⁾					Wear limit	⁽²³⁾					Wear limit	⁽²³⁾					Wear limit	⁽²⁴⁾		Deviation ±	⁽²⁴⁾		Deviation ±	⁽²⁴⁾		Deviation ±
	For new gauge						For new gauge						For new gauge						Deviation			Deviation			Deviation		
	D_{1min} (mm)	Upper devia- tion +	Lower devia- tion +	Toler- ance			D_{1min} (mm)	Upper devia- tion +	Lower devia- tion +	Toler- ance			D_{1min} (mm)	Upper devia- tion +	Lower devia- tion +	Toler- ance			D_{1max} (mm)			D_{1max} (mm)			D_{1max} (mm)		
M 48×1.5	46.376	46	30	16	0	46.376	46	30	16	0	46.376	46	30	16	0	46.612	8	46.676	8	46.751	8	46.676	8	46.751	8		
M 50×3	46.752	65	39	26	0	46.752	65	39	26	0	46.752	65	39	26	0	47.152	13	47.252	13	47.382	13	47.252	13	47.382	13		
M 50×2	47.835	46	30	16	0	47.835	46	30	16	0	47.835	46	30	26	0	48.135	8	48.210	8	48.310	13	48.135	8	48.310	13		
M 50×1.5	48.376	46	30	16	0	48.376	46	30	16	0	48.376	46	30	16	0	48.612	8	48.676	8	48.751	8	48.612	8	48.751	8		
M 52×4	47.670	65	39	26	0	47.670	65	39	26	0	47.670	88	42	46	0	48.145	13	48.270	13	48.420	23	48.145	13	48.270	13		
M 52×3	48.752	65	39	26	0	48.752	65	39	26	0	48.752	65	39	26	0	49.152	13	49.252	13	49.382	13	49.152	13	49.252	13		
M 52×2	49.835	46	30	16	0	49.835	46	30	16	0	49.835	65	39	26	0	50.135	8	50.210	8	50.310	13	50.135	8	50.310	13		
M 52×1.5	50.376	46	30	16	0	50.376	46	30	16	0	50.376	46	30	16	0	50.612	8	50.676	8	50.751	8	50.612	8	50.751	8		
M 55×4	50.670	65	39	26	0	50.670	65	39	26	0	50.670	88	42	46	0	51.145	13	51.270	13	51.420	23	51.145	13	51.270	13		
M 55×3	51.752	65	39	26	0	51.752	65	39	26	0	51.752	65	39	26	0	52.152	13	52.252	13	52.382	13	52.152	13	52.252	13		
M 55×2	52.835	46	30	16	0	52.835	46	30	16	0	52.835	65	39	26	0	53.135	8	53.210	8	53.310	13	53.135	8	53.210	8		
M 55×1.5	53.376	46	30	16	0	53.376	46	30	16	0	53.376	46	30	16	0	53.612	8	53.676	8	53.751	8	53.612	8	53.751	8		
M 56×4	51.670	65	39	26	0	51.670	65	39	26	0	51.670	88	42	46	0	52.145	13	52.270	13	52.420	23	52.145	13	52.270	13		
M 56×3	52.752	65	39	26	0	52.752	65	39	26	0	52.752	65	39	26	0	53.152	13	53.252	13	53.382	13	53.152	13	53.252	13		
M 56×2	53.835	46	30	16	0	53.835	46	30	16	0	53.835	65	39	26	0	54.135	8	54.210	8	54.310	13	54.135	8	54.210	8		
M 56×1.5	54.376	46	30	16	0	54.376	46	30	16	0	54.376	46	30	16	0	54.612	8	54.676	8	54.751	8	54.612	8	54.751	8		
M 58×4	53.670	65	39	26	0	53.670	65	39	26	0	53.670	88	42	46	0	54.145	13	54.270	13	54.420	23	54.145	13	54.270	13		
M 58×3	54.752	65	39	26	0	54.752	65	39	26	0	54.752	65	39	26	0	55.152	13	55.252	13	55.382	13	55.152	13	55.252	13		
M 58×2	55.835	46	30	16	0	55.835	46	30	16	0	55.835	65	39	26	0	56.135	8	56.210	8	56.310	13	56.135	8	56.210	8		
M 58×1.5	56.376	46	30	16	0	56.376	46	30	16	0	56.376	46	30	16	0	56.612	8	56.676	8	56.751	8	56.612	8	56.751	8		
M 60×4	55.670	65	39	26	0	55.670	65	39	26	0	55.670	88	42	46	0	56.145	13	56.270	13	56.420	23	56.145	13	56.270	13		
M 60×3	56.752	65	39	26	0	56.752	65	39	26	0	56.752	65	39	26	0	57.152	13	57.252	13	57.382	13	57.152	13	57.252	13		
M 60×2	57.835	46	30	16	0	57.835	46	30	16	0	57.835	65	39	26	0	58.135	8	58.210	8	58.310	13	58.135	8	58.210	8		
M 60×1.5	58.376	46	30	16	0	58.376	46	30	16	0	58.376	46	30	16	0	58.612	8	58.676	8	58.751	8	58.612	8	58.676	8		
M 62×4	57.670	65	39	26	0	57.670	65	39	26	0	57.670	88	42	46	0	58.145	13	58.270	13	58.420	23	58.145	13	58.270	13		
M 62×3	58.752	65	39	26	0	58.752	65	39	26	0	58.752	65	39	26	0	59.152	13	59.252	13	59.382	13	59.152	13	59.252	13		
M 62×2	59.835	46	30	16	0	59.835	46	30	16	0	59.835	65	39	26	0	60.135	8	60.210	8	60.310	13	60.135	8	60.210	8		
M 62×1.5	60.376	46	30	16	0	60.376	46	30	16	0	60.376	46	30	16	0	60.612	8	60.676	8	60.751	8	60.612	8	60.676	8		
M 64×4	59.670	65	39	26	0	59.670	65	39	26	0	59.670	88	42	46	0	60.145	13	60.270	13	60.420	23	60.145	13	60.270	13		
M 64×3	60.752	65	39	26	0	60.752	65	39	26	0	60.752	65	39	26	0	61.152	13	61.252	13	61.382	13	61.152	13	61.252	13		
M 64×2	61.835	46	30	16	0	61.835	46	30	16	0	61.835	65	39	26	0	62.135	8	62.210	8	62.310	13	62.135	8	62.210	8		
M 64×1.5	62.376	46	30	16	0	62.376	46	30	16	0	62.376	46	30	16	0	62.612	8	62.676	8	62.751	8	62.612	8	62.676	8		
M 65×4	60.670	65	39	26	0	60.670	65	39	26	0	60.670	88	42	46	0	61.145	13	61.270	13	61.420	23	61.145	13	61.270	13		
M 65×3	61.752	65	39	26	0	61.752	65	39	26	0	61.752	65	39	26	0	62.152	13	62.252	13	62.382	13	62.152	13	62.252	13		
M 65×2	62.835	46	30	16	0	62.835	46	30	16	0	62.835	65	39	26	0	63.135	8	63.210	8	63.310	13	63.135	8	63.210	8		
M 65×1.5	63.376	46	30	16	0	63.376	46	30	16	0	63.376	46	30	16	0	63.612	8	63.676	8	63.751	8	63.612	8	63.676	8		
M 68×4	63.670	65	39	26	0	63.670	65	39	26	0	63.670	88	42	46	0	64.145	13	64.270	13	64.420	23	64.145	13	64.270	13		
M 68×3	64.752	65	39	26	0	64.752	65	39	26	0	64.752	65	39	26	0	65.152	13	65.252	13	65.382	13	65.152	13	65.252	13		
M 68×2	65.835	46	30	16	0	65.835	46	30	16	0	65.835	65	39	26	0	66.135	8	66.210	8	66.310	13	66.135	8	66.210	8		
M 68×1.5	66.376	46	30	16	0	66.376	46	30	16	0	66.376	46	30	16	0	66.612	8	66.676	8	66.751	8	66.612	8	66.676	8		
M 70×6	63.505	65	39	26	0	63.505	88	42	46	0	63.505	88	42	46	0	64.135	13	64.305	23	64.505	23	64.135	13	64.305	23		
M 70×4	65.670	65	39	26	0	65.670	65	39	26	0	65.670	88	42	46	0	66.145	13	66.270	13	66.420	23	66.145	13	66.270	13		
M 70×3	66.752	65	39	26	0	66.752	65	39	26	0	66.752	65	39	26	0	67.152	13	67.252	13	67.382	13	67.152	13	67.252	13		
M 70×2	67.835	46	30	16	0	67.835	46	30	16	0	67.835	65	39	26	0	68.135	8	68.210	8	68.310	13	68.135	8	68.210	8		
M 70×1.5	68.376	46	30	16	0	68.376	46	30	16	0	68.376	46	30	16	0	68.612	8	68.676	8	68.751	8	68.612	8	68.676	8		
M 72×6	65.505	65	39	26	0	65.505	88	42	46	0	65.505	88	42	46	0	66.135	13	66.305	23	66.505	23	66.135	13	66.305	23		
M 72×4	67.670	65	39	26	0	67.670	65	39	26	0	67.670	88	42	46	0	68.145	13	68.270	13	68.420	23	68.145	13	68.270	13		
M 72×3	68.752	65	39	26	0	68.752	65	39	26	0	68.752	65	39	26	0	69.152	13	69.252	13	69.382	13	69.152	13	69.252	13		
M 72×2	69.835	46	30	16	0	69.835	46	30	16	0	69.835	65	39	26	0	70.135	8	70.210	8	70.310	13	70.135	8	70.210	8		
M 72×1.5	70.376	46	30	16	0	70.376	46	30	16	0	70.376	4															