

JIS

JAPANESE INDUSTRIAL STANDARD

**Corner and Fillet Radii
of Forged Parts
(Hot and Warm Forgings)**

JIS B 0706—1987

Translated and Published

by

Japanese Standards Association

In the event of any doubt arising,
the original Standard in Japanese is to be final authority.

JAPANESE INDUSTRIAL STANDARD

J I S

Corner and Fillet Radii
of Forged Parts
(Hot and Warm Forgings)

B 0706-1987

1. Scope

This Japanese Industrial Standard specifies the roundness values of corners and edges at sectional form transition parts and at plane form transition parts made by die forging in hot and warm process, hereinafter referred to as the "forged product" for ordinary steel and special steel forgings.

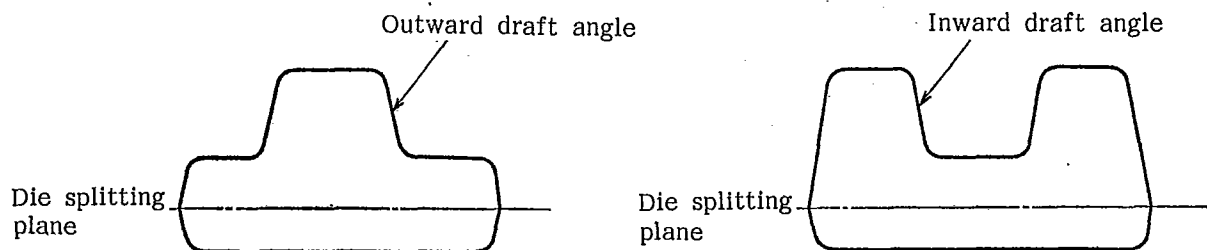
Remark: This standard specifies the recommended values of roundness which are considered generally economical in design drawings and in manufacture of forgings. It is advisable to provide a machine part with a unified roundness value as far as possible.

2. Definition

The terms used in this Standard shall be as follows:

- (1) draft angle An inclination given the side of forged products to tilt it against the forging direction for the purpose of expediting the flow of materials and facilitating the production of the products from the die immediately after the closed die forging. The kind of draft angle which helps the forged parts easily come off the die shall be called the outward draft angle. The kind which helps the forged part tighten the die shall be called the inward draft angle (see Fig. 1).

Fig. 1



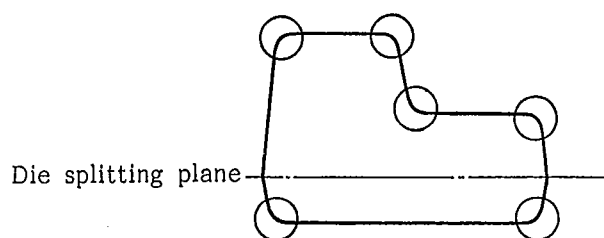
Applicable Standards:

JIS B 0415-Dimensional Tolerance for Steel Die Forgings
(Hammer and Press Forgings)

JIS Z 8601-Preferred Numbers

- (2) sectional form transition part The part where the contour line changes in the sectional area vertical to the die splitting surface of a forged product (the portions encircled by the signs ○ in Fig. 2).

Fig. 2



- (3) plane form transition part The part where the contour line changes in the sectional area parallel to the die splitting plane of a forged product (the portions encircled by the signs ○ in Fig. 3).

Fig. 3



- (4) corners and edges The corners and edges of the planes which constitute a forged product (see Fig. 4).

Fig. 4

