

JIS

JAPANESE INDUSTRIAL STANDARD

Taper Pins with Thread

JIS B 1358—1990

Translated and Published

by

Japanese Standards Association

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

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Taper Pins with Thread

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1. Scope

This Japanese Industrial Standard specifies the taper pins with steel internal thread and steel external thread of taper of $\frac{1}{50}$ used generally.

Further, in the case where the taper pins with steel internal thread and steel external thread are named generically, it is called simply as "pin".

Remark: Pins specified in this Standard, excluding the part applied with double underlines (=), are in accordance with ISO 8736-1986 and ISO 8737-1986.

2. Classification

Pins shall be divided according to type of thread and surface roughness of taper part into three classes of Table 1.

Table 1

Classification		Type of thread	Surface roughness of taper part ⁽¹⁾	Remark
Taper pins with internal thread	Class A	Internal thread	$R_a = 0.8 \mu\text{m}$	The thread according to type A of ISO 8736.
	Class B		$R_a = 3.2 \mu\text{m}$	The thread according to type B of ISO 8736.
Taper pins with external thread		External thread	$R_a = 3.2 \mu\text{m}$	The thread according to ISO 8737.

Note (1) R_a is in accordance with central-line average roughness specified in JIS B 0601.

Further, $R_a = 0.8 \mu\text{m}$ is that mainly according to grinding, and $R_a = 3.2 \mu\text{m}$ is that mainly according to turning.

Applicable Standards and Corresponding International Standards: See page 10

3. Hardness

The hardnesses of pins shall be in accordance with Table 2.

Table 2

Classification	Heat treatment	Hardness	
		Vickers hardness	Rockwell hardness
Taper pins with internal thread (class A, class B)	Not applied.	<u>HV 125 to 245</u>	<u>HRB 70 to HRC 21</u>
Taper pins with external thread	<u>Applied with quenching and tempering.</u>	<u>HV 255 to 327</u>	<u>HRC 23 to 33</u>

4. Shape and Dimensions

The shape and dimensions shall be in accordance with Table 3.

Table 3

Classification	Shape and dimensions	Range of nominal diameter mm
Taper pins with internal thread (class A, class B)	To be in accordance with Attached Table 1.	6 to 50
Taper pins with external thread	To be in accordance with Attached Table 2.	5 to 50

5. Threads

Threads of pins shall be in accordance with Table 4.

Table 4

Classification	Thread	
	Type	Grade
Taper pins with internal thread (class A, class B)	Internal thread of body of JIS B 0205	6 H of body of JIS B 0209. <u>However, for a while, grade 2 of Annex 1 of JIS B 0209 may be used.</u>
Taper pins with external thread	External thread of body of JIS B 0205	6 g of body of JIS B 0209. <u>However, for a while, grade 2 of Annex 1 of JIS B 0209 may be used.</u>