

JIS

JAPANESE INDUSTRIAL STANDARD

Cylindrical Squares

JIS B 7539—1971

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Cylindrical Squares

B 7539-1971
(Reaffirmed: 1986)1. Scope

This Japanese Industrial Standard specifies the cylindrical squares made of cast iron and steel to be used mainly for the measurement of perpendicularity.

2. Classification

The cylindrical squares shall be classified according to their materials into two kinds made of cast iron and steel and the relation between classification and length shall, in general, be as given in Table 1.

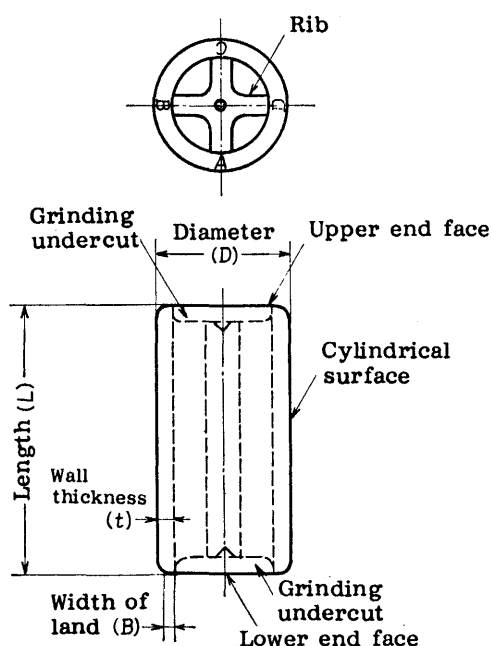
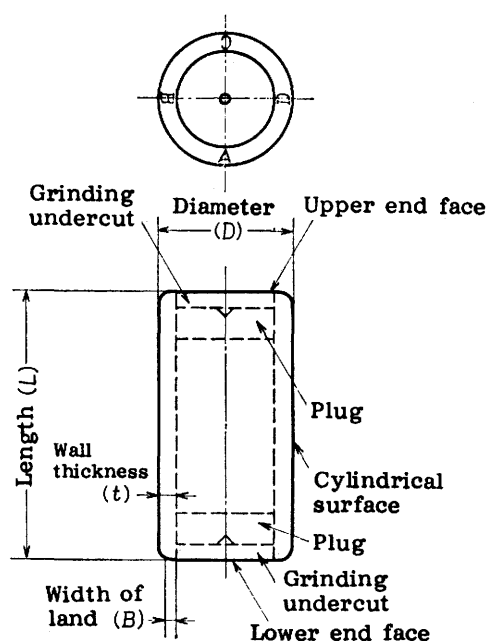
Table 1. Classification

Unit: mm

Classification	Length				
Made of cast iron	400	600	800	1000	1200
Made of steel	150	200	300	400	600

3. Names of Main Parts

The names of main parts of cylindrical squares shall be as given in Fig. 1 and Fig. 2.

Fig. 1. Cylindrical Square
(with Ribs)Fig. 2. Cylindrical Square
(with Plugs)

Reference Standards:

JIS B 1011-Centre Holes

JIS G 4401-Carbon Tool Steels

JIS G 5501-Gray Iron Castings