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STANDARD

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JIS R 7202 : 2011

(JCA)

**Testing methods for taper screw thread
angle and pitch diameter of cylindrical
machined graphite electrodes**

(Amendment 1)

JIS R 7202:2008 was revised under date of November 21, 2011.
The revised items are included in this Amendment 1 and use
this in combination with JIS R 7202:2008.

ICS 25.180.10

Reference number : JIS R 7202 : 2011 (E)

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Foreword

This translation has been made based on the Amendment to the original Japanese Industrial Standard revised by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee as the result of proposal for revision of Japanese Industrial Standard with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law applicable to the case of revision by the provision of Article 14.

Consequently, JIS R 7202:2008 is partially replaced with this Amendment.

Date of Establishment: 1952-10-23

Date of Revision: 2011-11-21

Date of Public Notice in Official Gazette: 2011-11-21

Investigated by: Japanese Industrial Standards Committee
Standards Board

Technical Committee on Ceramics

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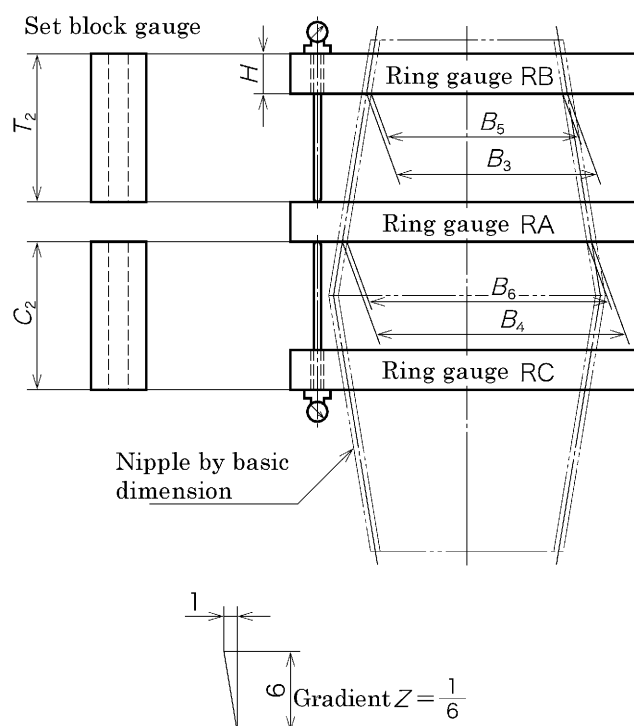
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Testing methods for taper screw thread angle and pitch diameter of cylindrical machined graphite electrodes (Amendment 1)

JIS R 7202:2008 is revised as follows.

5.2 Shapes and combination of measuring instruments

Replace figure 4 by the following.



NOTE: Symbols in the figure correspond to symbols in tables 3-1, 3-2, 4-1 and 4-2.

Figure 4 Combination of ring gauges

5.3 Dimensions of measuring instruments, tolerances thereon and clamping torque

Replace tables 2-1, 2-2, 3-1, 3-2, 4-1 and 4-2 by the following.

Table 2-1 Dimensions of plug gauge and tolerances thereon (4TPI)

Unit: mm

Designa- tion of joint	Type of gauge	Major diameter of large end face		Pitch diameter of large end face		Included angle (half angle)		Pitch of thread		1/2 of taper		Gauge thickness		Run-out of large end face of thread axial centre (max.)	Paralle- lism of both end faces (max.)													
		K_1	Toler- ances	B_1	Toler- ances	$\alpha/2$		P		Z		H																
		Dimen- sion K_2		Dimen- sion B_2		Angle	Toler- ances	Dimen- sion	Toler- ances	Angle	Toler- ances	Dimen- sion	Toler- ances															
122T4N	PA	102.271	± 0.060	99.111	± 0.025	30°	$\pm 10'$	6.350	± 0.010 ^{a)} ± 0.015 ^{b)}	$9^\circ 27' 44''$ (1/6)	$+ 1' 20''$ 0	19.0	± 0.2	0.020	0.010													
139T4N	PA	118.905		115.745																								
	PB	119.733		116.573																								
	PB	136.367		133.207																								
152T4N	PA	132.317		129.157																								
	PB	149.067		145.907																								
177T4N	PA	153.483		150.323	± 0.030							25.0																
	PB	174.467		171.307																								
203T4N	PA	172.533		169.373																								
203T4L	PB	199.867		196.707																								
222T4N	PA	184.783		181.623																								
222T4L	PB	218.917		215.757																								
241T4N	PA	203.833		200.673								30.0																
241T4L	PB	237.967		234.807																								
269T4N	PA	223.947		220.787																								
269T4L	PB	266.547		263.387																								
298T4N	PA	252.517		249.357																								
298T4L	PB	295.117		291.957																								
317T4N	PA	271.567		268.407																								
317T4L	PB	314.167		311.007																								
355T4N	PA	309.667		306.507																								
355T4L	PB	352.267		349.107																								
374T4N	PA	328.717		325.557	± 0.010 ^{a)} ± 0.020 ^{b)}																							
374T4L	PB	371.317		368.157																								
406T4N	PA	360.467		357.307																								
	PB	403.067		399.907								33.0 or 35.0																
NOTE: K_1 , K_2 , B_1 and B_2 correspond to symbols in figure 1 and figure 2. Notes ^{a)} Tolerance on single pitch. ^{b)} Tolerance on cumulative pitch.																												