

HB

中华人民共和国航空工业部部标准

HB3894-86

普通螺纹环规

M105×1.5~M150×2

1986-12-30发布

1987-10-01实施

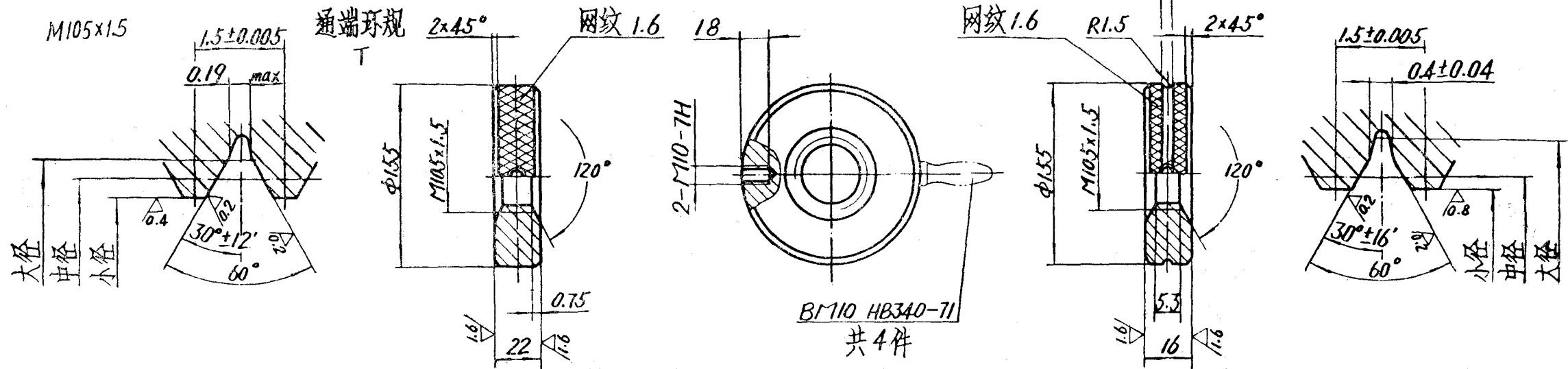
中华人民共和国航空工业部 批准

普通螺纹环规

M105x1.5~M150x2

代替

其余 $\nabla 3.2$

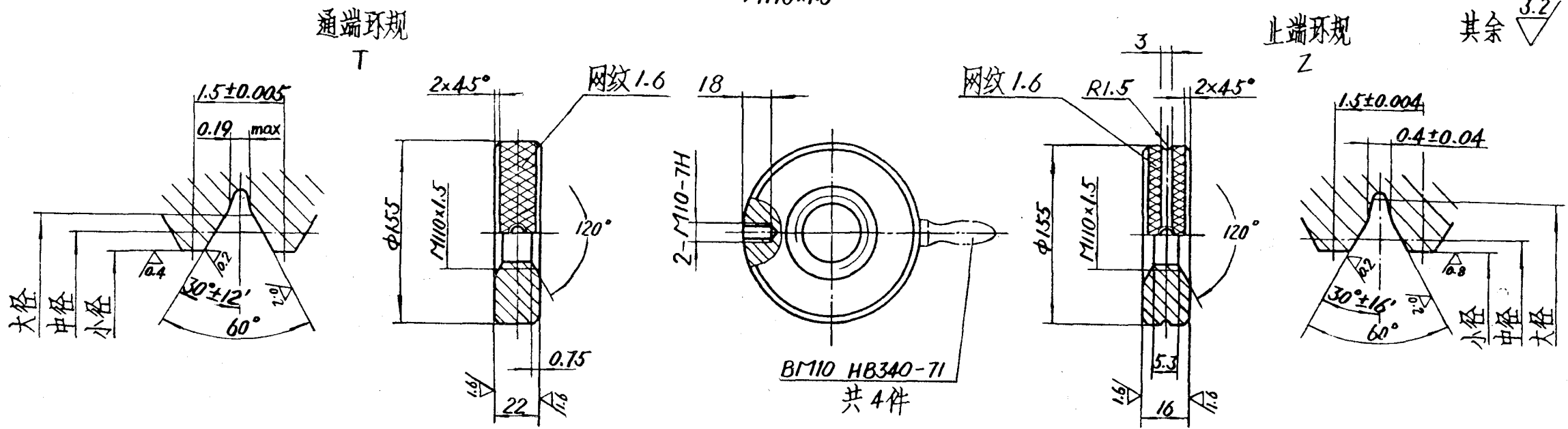


分类代号: 0440

标记示例: M105x1.5-5h4h.5h6h 通的螺纹环规 0440/M105x1.5-5h-T
0440/M105x1.5-5h-Z

螺 纹	通 规						止 规										
	公差带		大 径	中 径		小 径	大 径	中 径		小 径							
	es	ei		基本尺寸	极限偏差			磨损极限	基本尺寸	极限偏差	磨损极限	基本尺寸	极限偏差				
3h4h		-85	105.009	104.024	±0.007	104.040	±0.007	105.009	103.934	±0.007	103.946	103.634	±0.014				
4h		-106		104.024	±0.007			104.040	105.009	103.913	±0.007	103.925		103.613			
5h4h 5h6h	0	-132	105.011	104.018	±0.009	104.039	103.376	±0.009	105.011	103.885	±0.009	103.900	103.585	±0.018			
6h		-170		104.018	±0.009				104.039	105.011	103.847	±0.009	103.862		103.547		
7h6h		-212		104.014	±0.015				104.0395	±0.0115	104.986	103.8025	±0.0115		103.822	103.5025	±0.023
8h		-265		104.014	±0.015				104.0395	±0.0115	104.933	103.7495	±0.0115		103.769	103.4495	
5g6g	-32	-164	104.979	103.986	±0.009	104.007	103.344	±0.009	104.979	103.853	±0.009	103.868	103.553	±0.018			
6g		-202		103.986	±0.009				104.007	104.979	103.815	±0.009	103.830		103.515		
7g6g		-244		104.982	±0.015				104.0075	±0.0115	104.954	103.7705	±0.0115		103.790	103.4705	±0.023
8g		-297		104.982	±0.015				104.0075	±0.0115	104.901	103.7175	±0.0115		103.737	103.4175	
6f	-45	-215	104.966	103.973	±0.009	103.994	103.331	±0.009	104.966	103.802	±0.009	103.817	103.502	±0.018			
6e	-67	-237	104.944	103.951	±0.009	103.972	103.309	±0.009	104.944	103.780	±0.009	103.795	103.480				

普通螺纹环规
M110×1.5



分类代号: 0440

标记示例: M110×1.5-5h4h, 5h6h 通 的螺纹环规 0440/M110×1.5-5h-T
止 的螺纹环规 0440/M110×1.5-5h-Z

1. 材料: CrMn 钢, 按 GB1299-77.
2. 热处理: 淬火 HRC58~65.
3. 切去两端不完整螺纹.
4. 网纹滚花按 JB2-59.
5. 技术条件按 HB3908-86

螺 纹		通 规						止 规						
公差带	中径偏差 μm		大 径 ≥	中 径		小 径		大 径 ≥	中 径		小 径			
	es	ei		基本尺寸	极限偏差	磨损极限	基本尺寸		极限偏差	基本尺寸	极限偏差	磨损极限	基本尺寸	极限偏差
3h4h		-85	110.009	109.024	±0.007	109.040	108.376	±0.007	110.009	108.934	±0.007	108.946	108.634	±0.014
4h		-106							108.913	108.925		108.613		
5h4h 5h6h	0	-132	110.011	109.018	±0.009	109.039	108.376	±0.009	110.011	108.885	±0.009	108.900	108.585	±0.018
6h		-170							108.847	108.862		108.547		
7h6h		-212							109.986	108.8025		108.822	108.5025	
8h		-265							109.933	108.7495		108.769	108.4495	
5g6g	-32	-164	109.979	108.986	±0.009	109.007	108.344	±0.009	109.979	108.853	±0.009	108.868	108.553	±0.018
6g		-202							108.815	108.830		108.515		
7g6g		-244							109.954	108.7705		108.790	108.4705	
8g		-297							109.901	108.7175		108.737	108.4175	
6f	-45	-215	109.966	108.973	±0.009	108.994	108.331	±0.009	109.966	108.802	±0.009	108.817	108.502	±0.018
6e	-67	-237	109.944	108.951		108.972	108.309		109.944	108.780		108.795	108.480	