

HB

中华人民共和国航空工业部部标准

HB3890-86

普通螺纹塞规

M52×1~M100×2

1986-12-30发布

1987-10-01实施

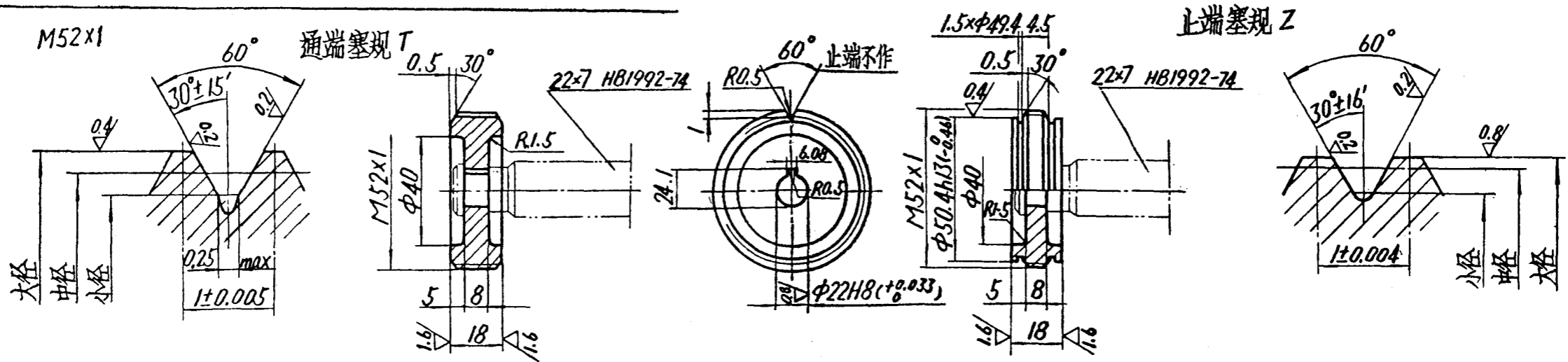
中华人民共和国航空工业部 批准

普通螺纹塞规

M52X1 ~ M100X2

代替

其余 ∇ 3.2



分类代号: 0422

标记示例: M52x1-4H, 4H5H 通止 的螺纹塞规

0422/M52x1-4H-T

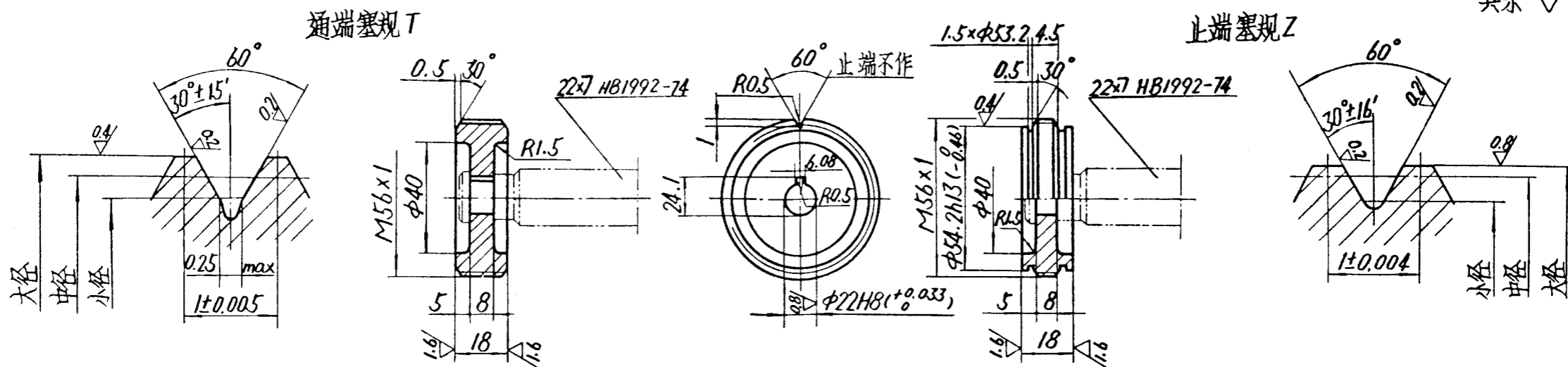
0422/M52x1-4H-Z

| 螺 纹 | | 通 端 塞 规 | | | | | 止 端 塞 规 | | | | | | | |
|---------|------------|---------|--------|-------------|--------|--------------|---------|-----------|---------|-------------|---------|--------------|--------|-----------|
| 公差带 | 中径偏差 $10m$ | | 大 径 | | 中 径 | | | 小径 \leq | 大 径 | | 中 径 | | | 小径 \leq |
| | ES | EI | 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 | 基本尺寸 | 极限偏差 | 磨损极限 | |
| 4H 4H5H | +H8 | 0 | 52.006 | ± 0.009 | 51.356 | ± 0.0045 | 51.3435 | 50.917 | 51.6725 | ± 0.009 | 51.4725 | ± 0.0045 | 51.463 | 50.917 |
| 5H 5H6H | +H50 | | 52.012 | ± 0.011 | 51.362 | ± 0.0055 | 51.3445 | | 51.7055 | ± 0.011 | 51.5055 | ± 0.0055 | 51.494 | |
| 6H | +H80 | | 52.016 | ± 0.014 | 51.366 | ± 0.007 | 51.345 | | 51.7355 | ± 0.011 | 51.5355 | ± 0.0055 | 51.524 | |
| 7H | +H36 | | 52.016 | ± 0.014 | 51.366 | ± 0.007 | 51.345 | | 51.793 | ± 0.014 | 51.593 | ± 0.007 | 51.578 | |
| 5G | +H76 | +26 | 52.038 | ± 0.011 | 51.388 | ± 0.0055 | 51.3705 | 50.943 | 51.7315 | ± 0.011 | 51.5315 | ± 0.0055 | 51.520 | 50.943 |
| 6G | +H26 | | 52.038 | ± 0.011 | 51.388 | ± 0.0055 | 51.3705 | | 51.7615 | ± 0.011 | 51.5615 | ± 0.0055 | 51.550 | |
| 7G | +H22 | | 52.042 | ± 0.014 | 51.392 | ± 0.007 | 51.371 | | 51.819 | ± 0.014 | 51.619 | ± 0.007 | 51.604 | |

1. 材料: CrMn 钢, 按 GB1299-77; 或 T12A 钢, 按 GB1298-77。
2. 热处理: 淬火 HRC58~65。
3. 切去两端不完整螺纹。
4. 技术条件按 HB 3908-86

普通螺纹塞规
M56x1

其余 $\nabla 3.2$



分类代号: 0422

0422/M56x1-4H-T

标记示例: M56x1-4H, 4H5H 通的螺纹塞规

0422/M56x1-4H-Z

| 螺 纹 | | 通 端 塞 规 | | | | | 止 端 塞 规 | | | | | | | |
|---------|--------------------|---------|--------|-------------|--------|--------------|---------|------------|---------|-------------|---------|--------------|--------|------------|
| 公差带 | 中径偏差 μm | | 大 径 | | 中 径 | | | 小 径 \leq | 大 径 | | 中 径 | | | 小 径 \leq |
| | ES | EI | 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 | 基本尺寸 | 极限偏差 | 磨损极限 | |
| 4H 4H5H | +118 | 0 | 56.006 | ± 0.009 | 55.356 | ± 0.0045 | 55.3435 | 54.917 | 55.6725 | ± 0.009 | 55.4725 | ± 0.0045 | 55.463 | 54.917 |
| 5H 5H6H | +150 | | 56.012 | ± 0.011 | 55.362 | ± 0.0055 | 55.3445 | | 55.7055 | ± 0.011 | 55.5055 | ± 0.0055 | 55.494 | |
| 6H | +180 | | 56.016 | ± 0.014 | 55.366 | ± 0.007 | 55.345 | | 55.7355 | ± 0.011 | 55.5355 | ± 0.0055 | 55.524 | |
| 7H | +236 | | 56.016 | ± 0.014 | 55.366 | ± 0.007 | 55.345 | | 55.793 | ± 0.014 | 55.593 | ± 0.007 | 55.578 | |
| 5g | +176 | +26 | 56.038 | ± 0.011 | 55.388 | ± 0.0055 | 55.3705 | 54.943 | 55.7315 | ± 0.011 | 55.5315 | ± 0.0055 | 55.520 | 54.943 |
| 6g | +206 | | 56.042 | ± 0.014 | 55.392 | ± 0.007 | 55.371 | | 55.7615 | ± 0.011 | 55.5615 | ± 0.0055 | 55.550 | |
| 7g | +262 | | 56.042 | ± 0.014 | 55.392 | ± 0.007 | 55.371 | | 55.819 | ± 0.014 | 55.619 | ± 0.007 | 55.604 | |

1. 材料: CrMn 钢, 按 GB1299-77; 或 T12A 钢, 按 GB1298-77.
2. 热处理: 淬火 HRC58~65.
3. 切去两端不完整螺纹。
4. 技术条件按 HB 3908-86