

ISO/R 1938:1971-04 (E)

ISO system of limits and fits; Part II : Inspection of plain workpieces

Contents

Page

Introduction.....	5
1. Scope.....	6
2. General rules of inspection	6
2.1 Reference temperature and measuring force.....	6
2.2 Interpretation of size limits (Taylor principle)	6
2.3 Exceeding the limits.....	7
2.4 Choice of inspection method	7
3. Limit gauges	8
3.1 Gauge types	8
3.2 Application of the Taylor principle	8
3.3 Allowable deviation from the Taylor principle	8
3.4 Field of utilisation of the various types of limit gauges	9
3.5 General design features of limit gauges.....	9
3.6 Materials and further details of gauges	10
3.7 Definitions and inspection of gauge sizes	10
3.7.1 Cylindrical plug gauges	10
3.7.2 Spherical plug, disk and rod gauges.....	10
3.7.3 Cylindrical ring gauges.....	10
3.7.4 Gap gauges	11
3.8 Method of use of gauges	11
3.8.1 Gauges for holes	11
3.8.2 Gauges for shafts	12
3.9 Manufacturing tolerances and permissible wear of gauges.....	12
3.9.1 Symbols.....	12
3.9.2 Limit gauges	13
3.9.2.1 Positions of tolerance zones and wear limits in relation to workpiece limits	13
3.9.2.2 Tolerances on size of working gauges	13
3.9.2.3 Tolerances on form of working gauges	13
3.9.2.4 Adjustable gauges of sizes above 180 mm	13
3.9.3 Reference disks for gap gauges	14
3.9.3.1 Positions of tolerance zones with respect to the workpiece limits	14
3.9.3.2 Tolerances on size of reference disks	14
3.9.3.3 Tolerances on form of reference disks	14
3.9.3.4 Relation between tolerances on gap gauges and their reference disks	14
3.9.4 Reference ring and plug gauges for setting measuring instruments.....	14
3.9.5 Surface finish of gauges.....	14
3.10 Settlement of disputes	14
3.10.1 Inspection by the manufacturer	15
3.10.2 Inspection by the purchaser	15
3.11 Marking and designation of gauges	15
4. Indicating measuring instruments.....	15
4.1 Definitions relating to measurements	15
4.1.1 True size	15
4.1.2 Error of measurement	15
4.1.3 Systematic error	16
4.1.4 Random error	16
4.1.5 Average	16
4.1.6 Standard deviation	16
4.2 Types of measuring instruments.....	16
4.3 Measuring uncertainty of the instrument	16
4.4 Total measuring uncertainty	17

4.5	Inspection limits	17
4.6	Influence of form errors	17
Figures		
Fig. 1	- Extreme errors of form of hole allowed by the recommended interpretation of the limits of size	18
Fig. 2	- Extreme errors of form of shaft allowed by the recommended interpretation of the limits of size	19
Fig. 3	— Recommended types of gauges for holes	20
Fig. 4	- Recommended types of gauges for shafts	20
Fig. 5	- Types of gauges used to check holes, in order of preference	21
Fig. 6	- Types of gauges used to check shafts, in order of preference.....	21
Fig. 7	— Location of points where forces counterbalancing part of the weight of the gauge should be applied	22
Fig. 8	— Relation between manufacturing tolerances of gap gauges and of reference disks	22
Fig. 9	- Tolerance zones of limit gauges and reference disks	23
Fig. 10	- Normal distribution curve of instrument readings	24
Fig. 11	— Relation between "test limits" and the "limits of size"	24
Tables		
Table 1	— Manufacturing tolerances for gauges	25
Table 2	— Location of the gauge tolerances and the limit of maximum permissible gauge wear in relation to the nominal limit of the workpiece, for grades 6 to 16 (for $D < 500$ mm)	26
Table 2 A	- Location of the gauge tolerances and the limit of maximum permissible gauge wear in relation to the nominal limit of the workpiece, for grades 6 to 16 (for $D > 500$ mm)	27
Table 3	- Values of s_M (for $D < 500$ mm)	28
Table 3 A	— Values of s_M (for $D > 500$ mm)	28