UDC 621.753.1:621.735.32.016.2

JIS

JAPANESE INDUSTRIAL STANDARD

Dimensional Tolerance for Steel Die Forgings (Upsetting)

JIS B 0416-1975

Translated and Published

by

Japanese Standards Association

Printed in Japan

In the event of any doubt arising,
the original Standard in Japanese is to be final authority.

UDC 621.753.1:621.735.32.016.2

JAPANESE INDUSTRIAL STANDARD J I S

Dimensional Tolerance for Steel Die Forgings (Upsetting)

B 0416-1975
(Reaffirmed: 1994)

1. Scope

This Japanese Industrial Standard specifies the dimensional tolerances and deviations for thickness, diameter, step dimension, length, centre-to-centre dimension, fillet and edge radii, draft angle, mismatch and eccentricity, camber, eccentricity for deep hole, residual flash and trimmed flat, burrs and fins, surface unevenness, deformation of sheared end, and local deformation of unforged portion of hot upset forgings ([1]) formed by upsetters of carbon steel and alloy steel, hereinafter referred to as the "forgings".

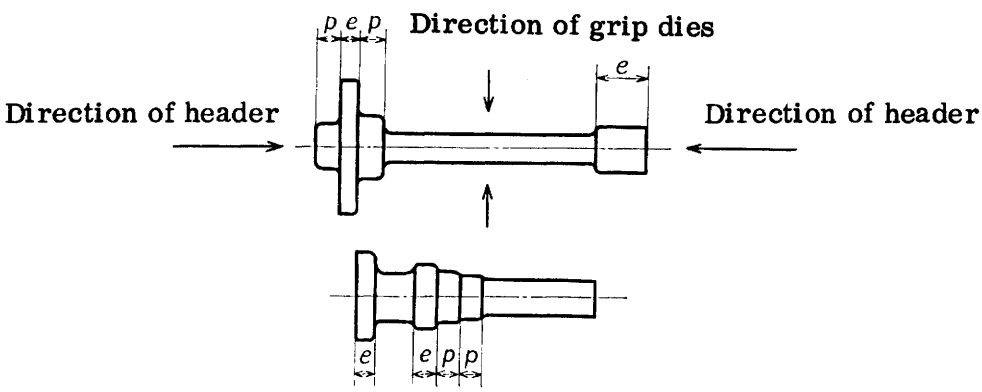
Note ([1]) The forgings herein stated imply the final products at the time of delivery.

2. Definitions

The principal terms used in this standard are as defined below.

(1) thickness Thickness, parallel to the axis of the bar stock of upset portion, of a portion which is perpendicular to the die parting line between the header and the grip dies (see Fig. 1).

Fig. 1. Dimensions of Thickness and Step



e: thickness
p: step dimension

(2) diameter All diameters which are perpendicular to the axis of the bar stock of upset portions (see Fig. 2).