

# JIS

JAPANESE  
INDUSTRIAL  
STANDARD

Translated and Published by  
Japanese Standards Association

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**JIS B 4239** : 1999  
(JSTA/JSA)

**Involute spline broaches**

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ICS 25.100.25

**Descriptors** : involute splines, broaches

**Reference number** : JIS B 4239 : 1999 (E)

B 4239 : 1999

## Foreword

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of International Trade and Industry through deliberations at the Japanese Industrial Standards Committee, as the result of proposal for revision of Japanese Industrial Standard submitted by the Japan Small Tool Makers Association (JSTA)/the Japanese Standards Association (JSA) with the draft being attached, based on the provision of Article 12 Clause 1 of the Industrial Standardization Law. Consequently **JIS B 4239:1988** is replaced with this Standard.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

Date of Establishment: 1982-06-15

Date of Revision: 1999-12-20

Date of Public Notice in Official Gazette: 1999-12-20

Investigated by: Japanese Industrial Standards Committee

Divisional Council on Factory  
Automation

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JIS B 4239:1999 First English edition published in 2001-05

Translated and published by: Japanese Standards Association  
4-1-24, Akasaka, Minato-ku, Tokyo, 107-8440 JAPAN

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## Involute spline broaches

**Introduction** This Japanese Industrial Standard specifies broaches that process holes of involute spline specified in **JIS D 2001** *Involute spline for automobiles*, and now has been revised by reason that **JIS D 2001** was withdrawn and unified with **JIS B 1603** *Straight cylindrical involute splines — Side fit — Generalities, dimensions and inspection*.

**1 Scope** This Standard specifies involute spline broaches (hereafter referred to as "broaches") which process spline holes corresponding to modules ( $m$ ) 0.5 mm to 5 mm of involute spline holes specified in **JIS B 1603** (hereafter referred to as "spline holes").

**2 Normative references** The following standards contain provisions which, through reference in this Standard, constitute provisions of this Standard. The most recent editions of the standards (including amendments) indicated below shall be applied.

- JIS B 0102 Vocabulary of gear terms — Definitions related to geometry
- JIS B 0175 *Broaches — Vocabulary*
- JIS B 0401-2 *ISO system of limits and fits — Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts*
- JIS B 0405 *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*
- JIS B 0601 *Surface roughness — Definitions and designation*
- JIS B 0651 *Surface texture — Instruments for the assessment of surface texture — Profile method*
- JIS B 0659 *Roughness comparison specimens*
- JIS B 1603 *Straight cylindrical involute splines — Side fit — Generalities, dimensions and inspection*
- JIS B 4237 *Dimensions of pull and follower ends of broach*
- JIS B 7502 *Micrometer callipers*
- JIS B 7503
- JIS B 7513 *Precision surface plates*
- JIS B 7519 *Microindicators*
- JIS B 7533 *Dial test indicators (lever type)*
- JIS B 7726 *Rockwell hardness test — Verification of testing machines*
- JIS B 7734 *Knoop hardness test — Verification of testing machines*
- JIS G 4403 *High speed tool steels*
- JIS Z 2245 *Rockwell hardness test — Test method*
- JIS Z 2251 *Knoop hardness test — Test method*