

JIS

JAPANESE INDUSTRIAL STANDARD

Assembling of bicycles

JIS D 9311—1994

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by

Japanese Standards Association

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

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Assembling of bicycles

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1. Scope This Japanese Industrial Standard specifies assembling mainly of sports bicycles (hereafter referred to as "S system assembling"), and of light roadsters (hereafter referred to as "R system assembling"), out of bicycles for general use specified in JIS D 9111.

Remarks 1. The standard cited in this Standard is as follows.

JIS D 9111 Classification and essential characteristics of cycles

2. This Standard may be applied to assembling of bicycles other than the above-mentioned, as appropriate.
3. In this Standard the units and numerical values shown in { } are in accordance with conventional units and are appended for informative reference.

2. Assembling The assembling shall be specified as the systems in which a worker assembles each bicycle at a definite position (single stationary working system), for the case of using an assembling stand in S system assembling and for the case of not using an assembling stand in R system assembling.

3. Constitution of parts Constitution of parts⁽¹⁾ of bicycle to be assembled by S system and R system shall be as given in Table 1.

Note (1) The constitution is an example to make clear the mutual relation between the specifications and assembling of parts of bicycle.

Table 1. Constitution of parts (example)

Classification of part	Name of parts	S system assembling (sports bicycle)	R system assembling (light roadster)
Body part	Frame-fork assembly	Diamond type, with forward opened rear fork end, brazed cable casing stops, pump pegs and dynamo bracket	Staggered type, with rearward opened rear fork end, provided with stoppers (convex part) for falling and rotation of lock
	Seat pillar	Straight type	
Steering device	Handlebar	Drop type	Brake lever combined type
	Handlebar grips	Bar tape (with back paste) and end caps	JIS 2 type
Driving device	Chainwheel and cranks	Double, cotterless nut fixing type	Single, cotted type
	Pedal	Ordinary pedals	
	Chain	$\frac{1}{2} \times \frac{3}{32}$, endless type	$\frac{1}{2} \times \frac{1}{8}$, clip connecting
	Free-wheel	Multiple (5-speed) free-wheel	Single free-wheel