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AN AMERICAN NATIONAL STANDARD

Gages and Gaging for MJ Series Metric Screw Threads

ANSI/ASME B1.22M - 1985

(REVISION OF ANSI B1.22-1978)

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FOREWORD

(This Foreword is not part of ANSI/ASME B1.22M-1985.)

American National Standards Committee B1 for the standardization of screw threads was organized in 1920 as Sectional Committee B1 under the aegis of the American Engineering Standards Committee [later the American Standards Association, then the United States of America Standards Institute, and as of October 6, 1969, the American National Standards Institute, Inc. (ANSI)], with the Society of Automotive Engineers and the American Society of Mechanical Engineers as joint sponsors. As a result, a great deal of effort was expended through the years toward development of several inch screw thread standards, including the current inch gaging standard, ANSI/ASME B1.2-1983, Gages and Gaging for Unified Inch Screw Threads.

Recognizing the increasing need of industries in the United States for documentation of American gaging practice for metric screw threads, American National Standards Committee B1 charged its thread gaging Subcommittee 2 with the responsibility for producing such a standard. ANSI B1.16-1972 was developed as a standard for American gaging practice for metric screw threads; ANSI/ASME B1.16M-1984 is a revision of that standard.

With the development of the MJ series of metric screw threads, documented in ANSI B1.21, it became necessary to document the required thread gages that were not covered in the ANSI B1.16 standard. Committee B1 asked Subcommittee 2 to develop such a standard.

ANSI B1.22-1978 was developed by Subcommittee 2 to provide the essential specifications for gages and gaging practice necessary to fulfill the provisions of the product thread document ANSI B1.21, Metric Screw Threads — MJ Profile.

In 1982, Committee B1 was reorganized as the ASME Standards Committee B1, and it has operated under American Society of Mechanical Engineers procedures to produce and update standards which become ANSI Standards after final approval by the American National Standards Institute.

This publication, designated ANSI/ASME B1.22M-1985, does not have any references to conformance criteria, as Committee B1 has established B1.3M for all levels of acceptability for screw threads. A considerable amount of new material is added to cover the many options of gages and measuring equipment shown in B1.3M. Mn/Mt gages have been identified as NOT GO gages.

The proposed Standard was submitted by the ASME Board of Standardization to the American National Standards Institute. It was approved and formally designated as an American National Standard on September 26, 1985.

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