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AMENDMENT 1
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ISO general purpose metric screw threads — Tolerances —

Part 5: Limits of sizes for internal screw threads to mate with hot-dip galvanized external screw threads with maximum size of tolerance position h before galvanizing

AMENDMENT 1

Filetages métriques ISO pour usages généraux — Tolérances —

Partie 5: Dimensions limites pour filetages intérieurs pour assemblages avec des filetages extérieurs galvanisés à chaud de position de tolérance maximale h avant galvanisation

AMENDEMENT 1

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This document was prepared by Technical Committee ISO/TC 1, *Screw threads*.

A list of all parts in the ISO 965 series can be found on the ISO website.

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ISO general purpose metric screw threads — Tolerances —

Part 5:
Limits of sizes for internal screw threads to mate with hot-dip galvanized external screw threads with maximum size of tolerance position h before galvanizing

AMENDMENT 1

Scope, first paragraph

Replace “deviations” with “limit deviations”.

Replace “ISO 262” with “the coarse thread series of ISO 262 (from M8 to M64)”.

Scope, third to fifth paragraphs

Replace the third to fifth paragraphs, including the two formulae for fundamental deviations AZ and AX, with the following:

"Internal threads shall be tapped after the hot-dip galvanizing process has been completed, therefore no galvanizing coating is present on the surface of internal threads."

Normative references

Change all the references to be undated.

Move ISO 68-1, ISO 262 and ISO 898-2 into the Bibliography.

Update the title of ISO 5408 as follows:

"ISO 5408, *Screw threads — Vocabulary*"

Clause 5

Change the clause title to "Limit deviations".

Replace the first paragraph with the following:

"The limit deviations for internal screw threads as specified in Table 1 are derived from the formulae for fundamental deviations below and from tolerances specified in ISO 965-1."

Clause 5, Table 1

Change the table title to "Limit deviations".

Add the limit deviations for M8 as follows:

Table 1 — Limit deviations

Thread	Pitch	Internal thread				
			Pitch diameter		Minor diameter	
	P	Tolerance class	*ES*	*EI*	*ES*	*EI*
	mm		µm	µm	µm	µm
M8	1,25	6AZ	+ 485	+ 325	+ 590	+ 325
		6AX	+ 415	+ 255	+ 520	+ 255

Clause 6

Add the following new fourth paragraph:

"The actual root contour shall not at any point transgress the basic profile and fundamental deviation."

Add the limits for M8 in Table 2 as follows:

Table 2 — Internal screw thread limits of sizes for tolerance class 6AZ

Dimensions in millimetres

Thread	Length of thread engagement		Major diameter[a]	Pitch diameter[a]		Minor diameter[c]	
	over	up to and including	min.[b]	max.	min.	max.	min.
M8	4	12	8,325	7,673	7,513	7,237	6,972

Add the limits for M8 in Table 3 as follows:

Table 3 — Internal screw thread limits of sizes for tolerance class 6AX

Dimensions in millimetres

Thread	Length of thread engagement		Major diameter[a]	Pitch diameter[a]		Minor diameter[c]	
	over	up to and including	min.[b]	max.	min.	max.	min.
M8	4	12	8,255	7,603	7,443	7,167	6,902