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## 中华人民共和国航天工业部部标准

QJ 444 — 84

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### 孔用光滑极限量规应用尺寸

1984 — 10 — 22 发布

1985 — 03 — 01 实施

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中华人民共和国航天工业部 批 准

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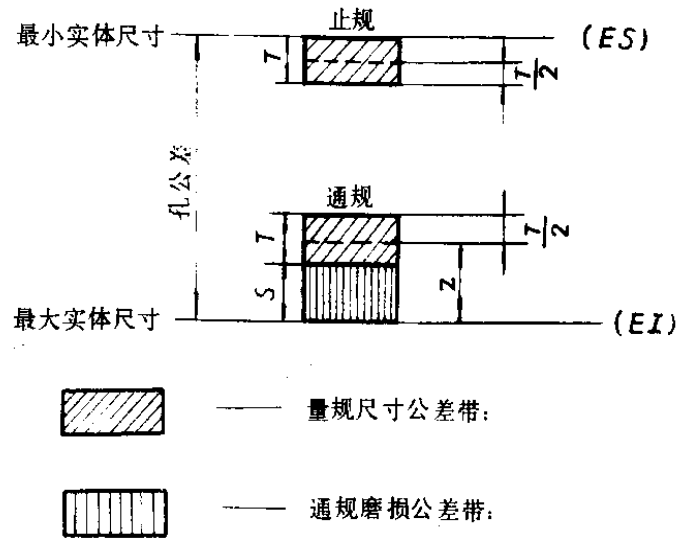
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# 孔用光滑极限量规应用尺寸

本标准规定了孔用光滑极限量规应用尺寸。该量规用于检验按GB 1801-79《公差与配合 尺寸至500 mm孔、轴公差带与配合》规定的我部常用公差带的孔。

本标准是根据GB 1957-81《光滑极限量规》制定的。

量规公差带图



T — 量规尺寸公差;

Z — 通规尺寸公差带的中心到工件最大实体尺寸之间的距离;

S — 通规磨损公差;

ES — 孔的上偏差;

EI — 孔的下偏差。

## 2 量规的形状和位置公差

量规的形状和位置误差应在其尺寸公差带内。其公差为量规尺寸公差的50%。当量规尺寸公差小于或等于0.002毫米时,其形状和位置公差为0.001毫米。

## 3 量规应用尺寸

量规应用尺寸按表1~42的规定。

表1 H6孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差    |              | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限     |
|---------|-----|--------------|--------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>E S | 下 偏 差<br>E I | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |              |              | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| —       | 3   | + 0.006      | 0            | + 0.0015          | + 0.0005 | 0.0010 | + 0.0060 | + 0.0050 | 0.0010 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.008      | 0            | + 0.0020          | + 0.0008 | 0.0012 | + 0.0080 | + 0.0068 | 0.0012 |                    |
| 6       | 10  | + 0.009      | 0            | + 0.0023          | + 0.0009 | 0.0014 | + 0.0090 | + 0.0076 | 0.0014 |                    |
| 10      | 14  | + 0.011      | 0            | + 0.0028          | + 0.0012 | 0.0016 | + 0.0110 | + 0.0094 | 0.0016 |                    |
| 14      | 18  |              |              |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.013      | 0            | + 0.0034          | + 0.0014 | 0.0020 | + 0.0130 | + 0.0110 | 0.0020 |                    |
| 24      | 30  |              |              |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.016      | 0            | + 0.0040          | + 0.0016 | 0.0024 | + 0.0160 | + 0.0136 | 0.0024 |                    |
| 40      | 50  |              |              |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.019      | 0            | + 0.0048          | + 0.0020 | 0.0028 | + 0.0190 | + 0.0162 | 0.0028 |                    |
| 65      | 80  |              |              |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.022      | 0            | + 0.0054          | + 0.0022 | 0.0032 | + 0.0220 | + 0.0188 | 0.0032 |                    |
| 100     | 120 |              |              |                   |          |        |          |          |        |                    |
| 120     | 140 | + 0.025      | 0            | + 0.0063          | + 0.0025 | 0.0038 | + 0.0250 | + 0.0212 | 0.0038 |                    |
| 140     | 160 |              |              |                   |          |        |          |          |        |                    |
| 160     | 180 | + 0.029      | 0            | + 0.0072          | + 0.0028 | 0.0044 | + 0.0290 | + 0.0246 | 0.0044 |                    |
| 180     | 200 |              |              |                   |          |        |          |          |        |                    |
| 200     | 225 | + 0.032      | 0            | + 0.0080          | + 0.0032 | 0.0048 | + 0.0320 | + 0.0272 | 0.0048 |                    |
| 225     | 250 |              |              |                   |          |        |          |          |        |                    |
| 250     | 280 | + 0.036      | 0            | + 0.0089          | + 0.0035 | 0.0054 | + 0.0360 | + 0.0306 | 0.0054 |                    |
| 280     | 315 |              |              |                   |          |        |          |          |        |                    |
| 315     | 355 | + 0.040      | 0            | + 0.0100          | + 0.0040 | 0.0060 | + 0.0400 | + 0.0340 | 0.0060 |                    |
| 355     | 400 |              |              |                   |          |        |          |          |        |                    |
| 400     | 450 | + 0.040      | 0            | + 0.0100          | + 0.0040 | 0.0060 | + 0.0400 | + 0.0340 | 0.0060 |                    |
| 450     | 500 |              |              |                   |          |        |          |          |        |                    |

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表 2 H 7 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 损<br>极 限      |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                        |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                        |
| —       | 3   | + 0.010     | 0           | + 0.0022          | + 0.0010 | 0.0012 | + 0.0100 | + 0.0088 | 0.0012 | 为最大实体尺寸<br>〔即孔的最小极限尺寸〕 |
| 3       | 6   | + 0.012     | 0           | + 0.0027          | + 0.0013 | 0.0014 | + 0.0120 | + 0.0106 | 0.0014 |                        |
| 6       | 10  | + 0.015     | 0           | + 0.0033          | + 0.0015 | 0.0018 | + 0.0150 | + 0.0132 | 0.0018 |                        |
| 10      | 14  | + 0.018     | 0           | + 0.0038          | + 0.0018 | 0.0020 | + 0.0180 | + 0.0160 | 0.0020 |                        |
| 14      | 18  |             |             |                   |          |        |          |          |        |                        |
| 18      | 24  | + 0.021     | 0           | + 0.0046          | + 0.0022 | 0.0024 | + 0.0210 | + 0.0186 | 0.0024 |                        |
| 24      | 30  |             |             |                   |          |        |          |          |        |                        |
| 30      | 40  | + 0.025     | 0           | + 0.0055          | + 0.0025 | 0.0030 | + 0.0250 | + 0.0220 | 0.0030 |                        |
| 40      | 50  |             |             |                   |          |        |          |          |        |                        |
| 50      | 65  | + 0.030     | 0           | + 0.0064          | + 0.0028 | 0.0036 | + 0.0300 | + 0.0264 | 0.0036 |                        |
| 65      | 80  |             |             |                   |          |        |          |          |        |                        |
| 80      | 100 | + 0.035     | 0           | + 0.0075          | + 0.0033 | 0.0042 | + 0.0350 | + 0.0308 | 0.0042 |                        |
| 100     | 120 |             |             |                   |          |        |          |          |        |                        |
| 120     | 140 | + 0.040     | 0           | + 0.0084          | + 0.0036 | 0.0048 | + 0.0400 | + 0.0352 | 0.0048 |                        |
| 140     | 160 |             |             |                   |          |        |          |          |        |                        |
| 160     | 180 | + 0.046     | 0           | + 0.0097          | + 0.0043 | 0.0054 | + 0.0460 | + 0.0406 | 0.0054 |                        |
| 180     | 200 |             |             |                   |          |        |          |          |        |                        |
| 200     | 225 | + 0.052     | 0           | + 0.0110          | + 0.0050 | 0.0060 | + 0.0520 | + 0.0460 | 0.0060 |                        |
| 225     | 250 |             |             |                   |          |        |          |          |        |                        |
| 250     | 280 | + 0.057     | 0           | + 0.0125          | + 0.0055 | 0.0070 | + 0.0570 | + 0.0500 | 0.0070 |                        |
| 280     | 315 |             |             |                   |          |        |          |          |        |                        |
| 315     | 355 | + 0.063     | 0           | + 0.0140          | + 0.0060 | 0.0080 | + 0.0630 | + 0.0550 | 0.0080 |                        |
| 355     | 400 |             |             |                   |          |        |          |          |        |                        |
| 400     | 450 | + 0.063     | 0           | + 0.0140          | + 0.0060 | 0.0080 | + 0.0630 | + 0.0550 | 0.0080 |                        |
| 450     | 500 |             |             |                   |          |        |          |          |        |                        |

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表3 H8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差 |       | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限 |
|---------|-----|-----------|-------|-------------------|----------|--------|----------|----------|--------|----------------|
|         |     | 上 偏 差     | 下 偏 差 | 通 规               |          |        | 止 规      |          |        |                |
| 大 于     | 至   | ES        | EI    | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                |
| —       | 3   | + 0.014   | 0     | + 0.0028          | + 0.0012 | 0.0016 | + 0.0140 | + 0.0124 | 0.0016 |                |
| 3       | 6   | + 0.018   | 0     | + 0.0036          | + 0.0016 | 0.0020 | + 0.0180 | + 0.0160 | 0.0020 |                |
| 6       | 10  | + 0.022   | 0     | + 0.0044          | + 0.0020 | 0.0024 | + 0.0220 | + 0.0196 | 0.0024 |                |
| 10      | 14  | + 0.027   | 0     | + 0.0054          | + 0.0026 | 0.0028 | + 0.0270 | + 0.0242 | 0.0028 |                |
| 14      | 18  |           |       |                   |          |        |          |          |        |                |
| 18      | 24  | + 0.033   | 0     | + 0.0067          | + 0.0033 | 0.0034 | + 0.0330 | + 0.0296 | 0.0034 |                |
| 24      | 30  |           |       |                   |          |        |          |          |        |                |
| 30      | 40  | + 0.039   | 0     | + 0.0080          | + 0.0040 | 0.0040 | + 0.0390 | + 0.0350 | 0.0040 |                |
| 40      | 50  |           |       |                   |          |        |          |          |        |                |
| 50      | 65  | + 0.046   | 0     | + 0.0093          | + 0.0047 | 0.0046 | + 0.0460 | + 0.0414 | 0.0046 |                |
| 65      | 80  |           |       |                   |          |        |          |          |        |                |
| 80      | 100 | + 0.054   | 0     | + 0.0107          | + 0.0053 | 0.0054 | + 0.0540 | + 0.0486 | 0.0054 |                |
| 100     | 120 |           |       |                   |          |        |          |          |        |                |
| 120     | 140 | + 0.063   | 0     | + 0.0120          | + 0.0060 | 0.0060 | + 0.0630 | + 0.0570 | 0.0060 |                |
| 140     | 160 |           |       |                   |          |        |          |          |        |                |
| 160     | 180 |           |       |                   |          |        |          |          |        |                |
| 180     | 200 | + 0.072   | 0     | + 0.0135          | + 0.0065 | 0.0070 | + 0.0720 | + 0.0650 | 0.0080 |                |
| 200     | 225 |           |       |                   |          |        |          |          |        |                |
| 225     | 250 |           |       |                   |          |        |          |          |        |                |
| 250     | 280 | + 0.081   | 0     | + 0.0150          | + 0.0070 | 0.0080 | + 0.0810 | + 0.0730 | 0.0080 |                |
| 280     | 315 |           |       |                   |          |        |          |          |        |                |
| 315     | 355 | + 0.089   | 0     | + 0.0165          | + 0.0075 | 0.0090 | + 0.0890 | + 0.0800 | 0.0090 |                |
| 355     | 400 |           |       |                   |          |        |          |          |        |                |
| 400     | 450 | + 0.097   | 0     | + 0.0190          | + 0.0090 | 0.0100 | + 0.0970 | + 0.0870 | 0.0100 |                |
| 450     | 500 |           |       |                   |          |        |          |          |        |                |

为最大实体尺寸「即孔的最小极限尺寸」

表4 H9孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| 大 于     | 至   |             |             |                   |          |        |          |          |        |                    |
| —       | 3   | + 0.025     | 0           | + 0.0040          | + 0.0020 | 0.0020 | + 0.0250 | + 0.0230 | 0.0020 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.030     | 0           | + 0.0052          | + 0.0028 | 0.0024 | + 0.0300 | + 0.0276 | 0.0024 |                    |
| 6       | 10  | + 0.036     | 0           | + 0.0064          | + 0.0036 | 0.0028 | + 0.0360 | + 0.0332 | 0.0028 |                    |
| 10      | 14  | + 0.043     | 0           | + 0.0077          | + 0.0043 | 0.0034 | + 0.0430 | + 0.0396 | 0.0034 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.052     | 0           | + 0.0090          | + 0.0050 | 0.0040 | + 0.0520 | + 0.0480 | 0.0040 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.062     | 0           | + 0.0105          | + 0.0055 | 0.0050 | + 0.0620 | + 0.0570 | 0.0050 |                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.074     | 0           | + 0.0120          | + 0.0060 | 0.0060 | + 0.0740 | + 0.0680 | 0.0060 |                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.087     | 0           | + 0.0135          | + 0.0065 | 0.0070 | + 0.0870 | + 0.0800 | 0.0070 |                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                    |
| 120     | 140 | + 0.100     | 0           | + 0.0160          | + 0.0080 | 0.0080 | + 0.1000 | + 0.0920 | 0.0080 |                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                    |
| 160     | 180 | + 0.115     | 0           | + 0.0185          | + 0.0095 | 0.0090 | + 0.1150 | + 0.1060 | 0.0090 |                    |
| 180     | 200 |             |             |                   |          |        |          |          |        |                    |
| 200     | 225 | + 0.130     | 0           | + 0.0210          | + 0.0110 | 0.0100 | + 0.1300 | + 0.1200 | 0.0100 |                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                    |
| 250     | 280 | + 0.140     | 0           | + 0.0235          | + 0.0125 | 0.0110 | + 0.1400 | + 0.1290 | 0.0110 |                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                    |
| 315     | 355 | + 0.155     | 0           | + 0.0260          | + 0.0140 | 0.0120 | + 0.1550 | + 0.1430 | 0.0120 |                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                    |
| 400     | 450 | + 0.155     | 0           | + 0.0260          | + 0.0140 | 0.0120 | + 0.1550 | + 0.1430 | 0.0120 |                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                    |

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表 5 H10孔用量规应用尺寸

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| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| --      | 3   | + 0.040     | 0           | + 0.0052          | + 0.0028 | 0.0024 | + 0.0400 | + 0.0376 | 0.0024 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.048     | 0           | + 0.0065          | + 0.0035 | 0.0030 | + 0.0480 | + 0.0450 | 0.0030 |                    |
| 6       | 10  | + 0.058     | 0           | + 0.0078          | + 0.0042 | 0.0036 | + 0.0580 | + 0.0544 | 0.0036 |                    |
| 10      | 14  | + 0.070     | 0           | + 0.0100          | + 0.0060 | 0.0040 | + 0.0700 | + 0.0660 | 0.0040 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.084     | 0           | + 0.0115          | + 0.0065 | 0.0050 | + 0.0840 | + 0.0790 | 0.0050 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.100     | 0           | + 0.0140          | + 0.0080 | 0.0060 | + 0.1000 | + 0.0940 | 0.0060 |                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.120     | 0           | + 0.0165          | + 0.0095 | 0.0070 | + 0.1200 | + 0.1130 | 0.0070 |                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.140     | 0           | + 0.0190          | + 0.0110 | 0.0080 | + 0.1400 | + 0.1320 | 0.0080 |                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                    |
| 120     | 140 | + 0.160     | 0           | + 0.0225          | + 0.0135 | 0.0090 | + 0.1600 | + 0.1510 | 0.0090 |                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                    |
| 160     | 180 | + 0.185     | 0           | + 0.0250          | + 0.0150 | 0.0100 | + 0.1850 | + 0.1750 | 0.0100 |                    |
| 180     | 200 |             |             |                   |          |        |          |          |        |                    |
| 200     | 225 | + 0.210     | 0           | + 0.0280          | + 0.0160 | 0.0120 | + 0.2100 | + 0.1980 | 0.0120 |                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                    |
| 250     | 280 | + 0.230     | 0           | + 0.0320          | + 0.0180 | 0.0140 | + 0.2300 | + 0.2160 | 0.0140 |                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                    |
| 315     | 355 | + 0.250     | 0           | + 0.0360          | + 0.0200 | 0.0160 | + 0.2500 | + 0.2340 | 0.0160 |                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                    |
| 400     | 450 | + 0.250     | 0           | + 0.0360          | + 0.0200 | 0.0160 | + 0.2500 | + 0.2340 | 0.0160 |                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                    |

表 6 H11孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 损<br>极 限                      |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |  |
|         |     |             |             | 上 偏 差             | 下 偏 差    | 公 差    | 上 偏 差    | 下 偏 差    | 公 差    |  |
| 大 于     | 至   |             |             |                   |          |        |          |          |        | 为 最 大 实 体 尺 寸<br>〔 即 孔 的 最 小 极 限 尺 寸 〕 |
| —       | 3   | + 0.060     | 0           | + 0.0075          | + 0.0045 | 0.0030 | + 0.0600 | + 0.0570 | 0.0030 |  |
| 3       | 6   | + 0.075     | 0           | + 0.0100          | + 0.0060 | 0.0040 | + 0.0750 | + 0.0710 | 0.0040 |  |
| 6       | 10  | + 0.090     | 0           | + 0.0115          | + 0.0065 | 0.0050 | + 0.0900 | + 0.0850 | 0.0050 |  |
| 10      | 14  | + 0.110     | 0           | + 0.0140          | + 0.0080 | 0.0060 | + 0.1100 | + 0.1040 | 0.0060 |  |
| 14      | 18  |             |             |                   |          |        |          |          |        |  |
| 18      | 24  | + 0.130     | 0           | + 0.0165          | + 0.0095 | 0.0070 | + 0.1300 | + 0.1230 | 0.0070 |  |
| 24      | 30  |             |             |                   |          |        |          |          |        |  |
| 30      | 40  | + 0.160     | 0           | + 0.0200          | + 0.0120 | 0.0080 | + 0.1600 | + 0.1520 | 0.0080 |  |
| 40      | 50  |             |             |                   |          |        |          |          |        |  |
| 50      | 65  | + 0.190     | 0           | + 0.0235          | + 0.0145 | 0.0090 | + 0.1900 | + 0.1810 | 0.0090 |  |
| 65      | 80  |             |             |                   |          |        |          |          |        |  |
| 80      | 100 | + 0.220     | 0           | + 0.0270          | + 0.0170 | 0.0100 | + 0.2200 | + 0.2100 | 0.0100 |  |
| 100     | 120 |             |             |                   |          |        |          |          |        |  |
| 120     | 140 | + 0.250     | 0           | + 0.0310          | + 0.0190 | 0.0120 | + 0.2500 | + 0.2380 | 0.0120 |  |
| 140     | 160 |             |             |                   |          |        |          |          |        |  |
| 160     | 180 | + 0.290     | 0           | + 0.0360          | + 0.0220 | 0.0140 | + 0.2900 | + 0.2760 | 0.0140 |  |
| 180     | 200 |             |             |                   |          |        |          |          |        |  |
| 200     | 225 |             |             |                   |          |        |          |          |        |  |
| 225     | 250 |             |             |                   |          |        |          |          |        |  |
| 250     | 280 | + 0.320     | 0           | + 0.0400          | + 0.0240 | 0.0160 | + 0.3200 | + 0.3040 | 0.0160 |  |
| 280     | 315 |             |             |                   |          |        |          |          |        |  |
| 315     | 355 | + 0.360     | 0           | + 0.0450          | + 0.0270 | 0.0180 | + 0.3600 | + 0.3420 | 0.0180 |  |
| 355     | 400 |             |             |                   |          |        |          |          |        |  |
| 400     | 450 | + 0.400     | 0           | + 0.0500          | + 0.0300 | 0.0200 | + 0.4000 | + 0.3800 | 0.0200 |  |
| 450     | 500 |             |             |                   |          |        |          |          |        |  |

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表7 H12孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差 |       | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-----------|-------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差     | 下 偏 差 | 通 规               |          |        | 止 规      |          |        |                            |
| 大 于     | 至   | ES        | EI    | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| -       | 3   | + 0.100   | 0     | + 0.0110          | + 0.0070 | 0.0040 | + 0.1000 | + 0.0960 | 0.0040 |                            |
| 3       | 6   | + 0.120   | 0     | + 0.0135          | + 0.0085 | 0.0050 | + 0.1200 | + 0.1150 | 0.0050 |                            |
| 6       | 10  | + 0.150   | 0     | + 0.0160          | + 0.0100 | 0.0060 | + 0.1500 | + 0.1440 | 0.0060 |                            |
| 10      | 14  | + 0.180   | 0     | + 0.0185          | + 0.0115 | 0.0070 | + 0.1800 | + 0.1730 | 0.0070 |                            |
| 14      | 18  |           |       |                   |          |        |          |          |        |                            |
| 18      | 24  | + 0.210   | 0     | + 0.0220          | + 0.0140 | 0.0080 | + 0.2100 | + 0.2020 | 0.0080 |                            |
| 24      | 30  |           |       |                   |          |        |          |          |        |                            |
| 30      | 40  | + 0.250   | 0     | + 0.0270          | + 0.0170 | 0.0100 | + 0.2500 | + 0.2400 | 0.0100 |                            |
| 40      | 50  |           |       |                   |          |        |          |          |        |                            |
| 50      | 65  | + 0.300   | 0     | + 0.0320          | + 0.0200 | 0.0120 | + 0.3000 | + 0.2880 | 0.0120 |                            |
| 65      | 80  |           |       |                   |          |        |          |          |        |                            |
| 80      | 100 | + 0.350   | 0     | + 0.0370          | + 0.0230 | 0.0140 | + 0.3500 | + 0.3360 | 0.0140 |                            |
| 100     | 120 |           |       |                   |          |        |          |          |        |                            |
| 120     | 140 | + 0.400   | 0     | + 0.0430          | + 0.0270 | 0.0160 | + 0.4000 | + 0.3840 | 0.0160 |                            |
| 140     | 160 |           |       |                   |          |        |          |          |        |                            |
| 160     | 180 |           |       |                   |          |        |          |          |        |                            |
| 180     | 200 | + 0.460   | 0     | + 0.0490          | + 0.0310 | 0.0180 | + 0.4600 | + 0.4420 | 0.0180 |                            |
| 200     | 225 |           |       |                   |          |        |          |          |        |                            |
| 225     | 250 |           |       |                   |          |        |          |          |        |                            |
| 250     | 280 | + 0.520   | 0     | + 0.0550          | + 0.0350 | 0.0200 | + 0.5200 | + 0.5000 | 0.0200 |                            |
| 280     | 315 |           |       |                   |          |        |          |          |        |                            |
| 315     | 355 | + 0.570   | 0     | + 0.0610          | + 0.0390 | 0.0220 | + 0.5700 | + 0.5480 | 0.0220 |                            |
| 355     | 400 |           |       |                   |          |        |          |          |        |                            |
| 400     | 450 | + 0.630   | 0     | + 0.0670          | + 0.0430 | 0.0240 | + 0.6300 | + 0.6060 | 0.0240 |                            |
| 450     | 500 |           |       |                   |          |        |          |          |        |                            |

表 8 H13孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 损<br>极 限      |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                        |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                        |
| 大 于     | 至   |             |             |                   |          |        |          |          |        |                        |
| —       | 3   | + 0.140     | 0           | + 0.0170          | + 0.0110 | 0.0060 | + 0.1400 | + 0.1340 | 0.0060 | 为最大实体尺寸<br>「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.180     | 0           | + 0.0195          | + 0.0125 | 0.0070 | + 0.1800 | + 0.1730 | 0.0070 |                        |
| 6       | 10  | + 0.220     | 0           | + 0.0240          | + 0.0160 | 0.0080 | + 0.2200 | + 0.2120 | 0.0080 |                        |
| 10      | 14  | + 0.270     | 0           | + 0.0290          | + 0.0190 | 0.0100 | + 0.2700 | + 0.2600 | 0.0100 |                        |
| 14      | 18  |             |             |                   |          |        |          |          |        |                        |
| 18      | 24  | + 0.330     | 0           | + 0.0340          | + 0.0220 | 0.0120 | + 0.3300 | + 0.3180 | 0.0120 |                        |
| 24      | 30  |             |             |                   |          |        |          |          |        |                        |
| 30      | 40  | + 0.390     | 0           | + 0.0410          | + 0.0270 | 0.0140 | + 0.3900 | + 0.3760 | 0.0140 |                        |
| 40      | 50  |             |             |                   |          |        |          |          |        |                        |
| 50      | 65  | + 0.460     | 0           | + 0.0480          | + 0.0320 | 0.0160 | + 0.4600 | + 0.4440 | 0.0160 |                        |
| 65      | 80  |             |             |                   |          |        |          |          |        |                        |
| 80      | 100 | + 0.540     | 0           | + 0.0560          | + 0.0360 | 0.0200 | + 0.5400 | + 0.5200 | 0.0200 |                        |
| 100     | 120 |             |             |                   |          |        |          |          |        |                        |
| 120     | 140 | + 0.630     | 0           | + 0.0630          | + 0.0410 | 0.0220 | + 0.6300 | + 0.6080 | 0.0220 |                        |
| 140     | 160 |             |             |                   |          |        |          |          |        |                        |
| 160     | 180 | + 0.720     | 0           | + 0.0730          | + 0.0470 | 0.0260 | + 0.7200 | + 0.6940 | 0.0260 |                        |
| 180     | 200 |             |             |                   |          |        |          |          |        |                        |
| 200     | 225 | + 0.810     | 0           | + 0.0800          | + 0.0520 | 0.0280 | + 0.8100 | + 0.7820 | 0.0280 |                        |
| 225     | 250 |             |             |                   |          |        |          |          |        |                        |
| 250     | 280 | + 0.890     | 0           | + 0.0900          | + 0.0580 | 0.0320 | + 0.8900 | + 0.8580 | 0.0320 |                        |
| 280     | 315 |             |             |                   |          |        |          |          |        |                        |
| 315     | 355 | + 0.970     | 0           | + 0.0980          | + 0.0620 | 0.0360 | + 0.9700 | + 0.9340 | 0.0360 |                        |
| 355     | 400 |             |             |                   |          |        |          |          |        |                        |
| 400     | 450 | + 0.970     | 0           | + 0.0980          | + 0.0620 | 0.0360 | + 0.9700 | + 0.9340 | 0.0360 |                        |
| 450     | 500 |             |             |                   |          |        |          |          |        |                        |

表9 H14孔用量规应用尺寸

mm

10

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规 磨 损 极 限        |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上 偏 差             | 下 偏 差    | 公 差    | 上 偏 差    | 下 偏 差    | 公 差    |                    |
| 大 于     | 至   |             |             |                   |          |        |          |          |        |                    |
| —       | 3   | + 0.25      | 0           | + 0.0245          | + 0.0155 | 0.0090 | + 0.2500 | + 0.2410 | 0.0090 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.30      | 0           | + 0.0305          | + 0.0195 | 0.0110 | + 0.3000 | + 0.2890 | 0.0110 |                    |
| 6       | 10  | + 0.36      | 0           | + 0.0365          | + 0.0235 | 0.0130 | + 0.3600 | + 0.3570 | 0.0130 |                    |
| 10      | 14  | + 0.43      | 0           | + 0.0425          | + 0.0275 | 0.0150 | + 0.4300 | + 0.4150 | 0.0150 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.52      | 0           | + 0.0490          | + 0.0310 | 0.0180 | + 0.5200 | + 0.5020 | 0.0180 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.62      | 0           | + 0.0610          | + 0.0390 | 0.0220 | + 0.6200 | + 0.5980 | 0.0220 |                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.74      | 0           | + 0.0730          | + 0.0470 | 0.0260 | + 0.7400 | + 0.7140 | 0.0260 |                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.87      | 0           | + 0.0850          | + 0.0550 | 0.0300 | + 0.8700 | + 0.8400 | 0.0300 |                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                    |
| 120     | 140 | + 1.00      | 0           | + 0.0975          | + 0.0625 | 0.0350 | + 1.0000 | + 0.9650 | 0.0350 |                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                    |
| 160     | 180 | + 1.15      | 0           | + 0.1100          | + 0.0700 | 0.0400 | + 1.1500 | + 1.1100 | 0.0400 |                    |
| 180     | 200 |             |             |                   |          |        |          |          |        |                    |
| 200     | 225 | + 1.30      | 0           | + 0.1225          | + 0.0775 | 0.0450 | + 1.3000 | + 1.2550 | 0.0450 |                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                    |
| 250     | 280 | + 1.40      | 0           | + 0.1350          | + 0.0850 | 0.0500 | + 1.4000 | + 1.3500 | 0.0500 |                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                    |
| 315     | 355 | + 1.55      | 0           | + 0.1475          | + 0.0925 | 0.0550 | + 1.5500 | + 1.4950 | 0.0550 |                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                    |
| 400     | 450 | + 1.55      | 0           | + 0.1475          | + 0.0925 | 0.0550 | + 1.5500 | + 1.4950 | 0.0550 |                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                    |

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表10 A 10孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |                      | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|----------------------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |                      |                            |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差                  |                            |
| 大 于     | 至   |             |             |                   |          |        |          |          |                      |                            |
| —       | 3   | + 0.310     | + 0.270     | + 0.2752          | + 0.2728 | 0.0024 | + 0.3100 | + 0.3076 | 0.0024               | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| 3       | 6   | + 0.318     | + 0.270     | + 0.2765          | + 0.2735 | 0.0030 | + 0.3180 | + 0.3150 | 0.0030               |                            |
| 6       | 10  | + 0.338     | + 0.280     | + 0.2878          | + 0.2842 | 0.0036 | + 0.3380 | + 0.3344 | 0.0036               |                            |
| 10      | 14  | + 0.360     | + 0.290     | + 0.3000          | + 0.2960 | 0.0040 | + 0.3600 | + 0.3560 | 0.0040               |                            |
| 14      | 18  |             |             |                   |          |        |          |          |                      |                            |
| 18      | 24  | + 0.384     | + 0.300     | + 0.3115          | + 0.3065 | 0.0050 | + 0.3840 | + 0.3790 | 0.0040 <sup>50</sup> |                            |
| 24      | 30  |             |             |                   |          |        |          |          |                      |                            |
| 30      | 40  | + 0.410     | + 0.310     | + 0.3240          | + 0.3180 | 0.0060 | + 0.4100 | + 0.4040 | 0.0060               |                            |
| 40      | 50  | + 0.420     | + 0.320     | + 0.3340          | + 0.3280 | 0.0060 | + 0.4200 | + 0.4140 | 0.0060               |                            |
| 50      | 65  | + 0.460     | + 0.340     | + 0.3565          | + 0.3495 | 0.0070 | + 0.4600 | + 0.4530 | 0.0070               |                            |
| 65      | 80  | + 0.480     | + 0.360     | + 0.3765          | + 0.3695 | 0.0070 | + 0.4800 | + 0.4730 | 0.0070               |                            |
| 80      | 100 | + 0.520     | + 0.380     | + 0.3990          | + 0.3910 | 0.0080 | + 0.5200 | + 0.5120 | 0.0080               |                            |
| 100     | 120 | + 0.550     | + 0.410     | + 0.4290          | + 0.4210 | 0.0080 | + 0.5500 | + 0.5420 | 0.0080               |                            |
| 120     | 140 | + 0.620     | + 0.460     | + 0.4825          | + 0.4735 | 0.0090 | + 0.6200 | + 0.6110 | 0.0090               |                            |
| 140     | 160 | + 0.680     | + 0.520     | + 0.5425          | + 0.5335 | 0.0090 | + 0.6800 | + 0.6710 | 0.0090               |                            |
| 160     | 180 | + 0.740     | + 0.580     | + 0.6025          | + 0.5935 | 0.0090 | + 0.7400 | + 0.7310 | 0.0090               |                            |
| 180     | 200 | + 0.845     | + 0.660     | + 0.6850          | + 0.6750 | 0.0100 | + 0.8450 | + 0.8350 | 0.0100               |                            |
| 200     | 225 | + 0.925     | + 0.740     | + 0.7650          | + 0.7550 | 0.0100 | + 0.9250 | + 0.9150 | 0.0100               |                            |
| 225     | 250 | + 1.005     | + 0.820     | + 0.8450          | + 0.8350 | 0.0100 | + 1.0050 | + 0.9950 | 0.0100               |                            |
| 250     | 280 | + 1.130     | + 0.920     | + 0.9480          | + 0.9360 | 0.0120 | + 1.1300 | + 1.1180 | 0.0120               |                            |
| 280     | 315 | + 1.260     | + 1.050     | + 1.0780          | + 1.0660 | 0.0120 | + 1.2600 | + 1.2480 | 0.0120               |                            |
| 315     | 355 | + 1.430     | + 1.200     | + 1.2320          | + 1.2180 | 0.0140 | + 1.4300 | + 1.4160 | 0.0140               |                            |
| 355     | 400 | + 1.580     | + 1.350     | + 1.3820          | + 1.3680 | 0.0140 | + 1.5800 | + 1.5660 | 0.0140               |                            |
| 400     | 450 | + 1.750     | + 1.500     | + 1.5360          | + 1.5200 | 0.0160 | + 1.7500 | + 1.7340 | 0.0160               |                            |
| 450     | 500 | + 1.900     | + 1.650     | + 1.6860          | + 1.6700 | 0.0160 | + 1.9000 | + 1.8840 | 0.0160               |                            |

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表11

A 11孔用量规应用尺寸

mm

12

| 基 本 尺 寸 |     | 孔 极 限 偏 差 量 规 极 限 偏 差 及 公 差 |         |             |          |        |          |          |        | 通规<br>磨损<br>极限 |     |     |
|---------|-----|-----------------------------|---------|-------------|----------|--------|----------|----------|--------|----------------|-----|-----|
|         |     | 上 偏 差<br>ES                 |         | 下 偏 差<br>EI |          | 通 规    |          |          | 止 规    |                |     |     |
|         |     |                             |         |             |          | 上偏差    | 下偏差      | 公 差      | 上偏差    |                | 下偏差 | 公 差 |
| 大 于     | 至   |                             |         |             |          |        |          |          |        |                |     |     |
| —       | 3   | + 0.330                     | + 0.270 | + 0.2775    | + 0.2745 | 0.0030 | + 0.3300 | + 0.3270 | 0.0030 |                |     |     |
| 3       | 6   | + 0.345                     | + 0.270 | + 0.2800    | + 0.2760 | 0.0040 | + 0.3450 | + 0.3410 | 0.0040 |                |     |     |
| 6       | 10  | + 0.370                     | + 0.280 | + 0.2915    | + 0.2865 | 0.0050 | + 0.3700 | + 0.3650 | 0.0050 |                |     |     |
| 10      | 14  | + 0.400                     | + 0.290 | + 0.3040    | + 0.2980 | 0.0060 | + 0.4000 | + 0.3940 | 0.0060 |                |     |     |
| 14      | 18  |                             |         |             |          |        |          |          |        |                |     |     |
| 18      | 24  | + 0.430                     | + 0.300 | + 0.3165    | + 0.3095 | 0.0070 | + 0.4300 | + 0.4230 | 0.0070 |                |     |     |
| 24      | 30  |                             |         |             |          |        |          |          |        |                |     |     |
| 30      | 40  | + 0.470                     | + 0.310 | + 0.3300    | + 0.3220 | 0.0080 | + 0.4700 | + 0.4620 | 0.0080 |                |     |     |
| 40      | 50  | + 0.480                     | + 0.320 | + 0.3400    | + 0.3320 | 0.0080 | + 0.4800 | + 0.4720 | 0.0080 |                |     |     |
| 50      | 65  | + 0.530                     | + 0.340 | + 0.3635    | + 0.3545 | 0.0090 | + 0.5300 | + 0.5210 | 0.0090 |                |     |     |
| 65      | 80  | + 0.550                     | + 0.360 | + 0.3835    | + 0.3745 | 0.0090 | + 0.5500 | + 0.5410 | 0.0090 |                |     |     |
| 80      | 100 | + 0.600                     | + 0.380 | + 0.4070    | + 0.3975 | 0.0100 | + 0.6000 | + 0.5900 | 0.0100 |                |     |     |
| 100     | 120 | + 0.630                     | + 0.410 | + 0.4370    | + 0.4270 | 0.0100 | + 0.6300 | + 0.6200 | 0.0100 |                |     |     |
| 120     | 140 | + 0.710                     | + 0.460 | + 0.4910    | + 0.4790 | 0.0120 | + 0.7100 | + 0.6980 | 0.0120 |                |     |     |
| 140     | 160 | + 0.770                     | + 0.520 | + 0.5510    | + 0.5390 | 0.0120 | + 0.7700 | + 0.7580 | 0.0120 |                |     |     |
| 160     | 180 | + 0.830                     | + 0.580 | + 0.6110    | + 0.5990 | 0.0120 | + 0.8300 | + 0.8180 | 0.0120 |                |     |     |
| 180     | 200 | + 0.950                     | + 0.660 | + 0.6960    | + 0.6820 | 0.0140 | + 0.9500 | + 0.9360 | 0.0140 |                |     |     |
| 200     | 225 | + 1.030                     | + 0.740 | + 0.7760    | + 0.7620 | 0.0140 | + 1.0300 | + 1.0160 | 0.0140 |                |     |     |
| 225     | 250 | + 1.110                     | + 0.820 | + 0.8560    | + 0.8420 | 0.0140 | + 1.1100 | + 1.0960 | 0.0140 |                |     |     |
| 250     | 280 | + 1.240                     | + 0.920 | + 0.9600    | + 0.9440 | 0.0160 | + 1.2400 | + 1.2240 | 0.0160 |                |     |     |
| 280     | 315 | + 1.370                     | + 1.050 | + 1.0900    | + 1.0740 | 0.0160 | + 1.3700 | + 1.3540 | 0.0160 |                |     |     |
| 315     | 355 | + 1.560                     | + 1.200 | + 1.2450    | + 1.2270 | 0.0180 | + 1.5600 | + 1.5420 | 0.0180 |                |     |     |
| 355     | 400 | + 1.710                     | + 1.350 | + 1.3950    | + 1.3770 | 0.0180 | + 1.7100 | + 1.6920 | 0.0180 |                |     |     |
| 400     | 450 | + 1.900                     | + 1.500 | + 1.5500    | + 1.5300 | 0.0200 | + 1.9000 | + 1.8800 | 0.0200 |                |     |     |
| 450     | 500 | + 2.050                     | + 1.650 | + 1.7000    | + 1.6800 | 0.0200 | + 2.0500 | + 2.0300 | 0.0200 |                |     |     |

为最大实体尺寸「即孔的最小极限尺寸」

为最大实体尺寸「即孔的最小极限尺寸」

表12 B11孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| 大 于     | 至   |             |             |                   |          |        |          |          |        | 为最大实体尺寸「即孔的最小极限尺寸」 |
| —       | 3   | + 0.200     | + 0.140     | + 0.1475          | + 0.1445 | 0.0030 | + 0.2000 | + 0.1970 | 0.0030 |                    |
| 3       | 6   | + 0.215     | + 0.140     | + 0.1500          | + 0.1460 | 0.0040 | + 0.2150 | + 0.2110 | 0.0040 |                    |
| 6       | 10  | + 0.240     | + 0.150     | + 0.1615          | + 0.1565 | 0.0050 | + 0.2400 | + 0.2350 | 0.0050 |                    |
| 10      | 14  | + 0.260     | + 0.150     | + 0.1640          | + 0.1580 | 0.0060 | + 0.2600 | + 0.2540 | 0.0060 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.290     | + 0.160     | + 0.1765          | + 0.1695 | 0.0070 | + 0.2900 | + 0.2830 | 0.0070 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.330     | + 0.170     | + 0.1900          | + 0.1820 | 0.0080 | + 0.3300 | + 0.3220 | 0.0080 |                    |
| 40      | 50  | + 0.340     | + 0.180     | + 0.2000          | + 0.1920 | 0.0080 | + 0.3400 | + 0.3320 | 0.0080 |                    |
| 50      | 65  | + 0.380     | + 0.190     | + 0.2135          | + 0.2045 | 0.0090 | + 0.3800 | + 0.3710 | 0.0090 |                    |
| 65      | 80  | + 0.390     | + 0.200     | + 0.2235          | + 0.2145 | 0.0090 | + 0.3900 | + 0.3810 | 0.0090 |                    |
| 80      | 100 | + 0.440     | + 0.220     | + 0.2470          | + 0.2370 | 0.0100 | + 0.4400 | + 0.4300 | 0.0100 |                    |
| 100     | 120 | + 0.460     | + 0.240     | + 0.2670          | + 0.2570 | 0.0100 | + 0.4600 | + 0.4500 | 0.0100 |                    |
| 120     | 140 | + 0.510     | + 0.260     | + 0.2910          | + 0.2790 | 0.0120 | + 0.5100 | + 0.4980 | 0.0120 |                    |
| 140     | 160 | + 0.530     | + 0.280     | + 0.3110          | + 0.2990 | 0.0120 | + 0.5300 | + 0.5180 | 0.0120 |                    |
| 160     | 180 | + 0.560     | + 0.310     | + 0.3410          | + 0.3290 | 0.0120 | + 0.5600 | + 0.5480 | 0.0120 |                    |
| 180     | 200 | + 0.630     | + 0.340     | + 0.3760          | + 0.3620 | 0.0140 | + 0.6300 | + 0.6160 | 0.0140 |                    |
| 200     | 225 | + 0.670     | + 0.380     | + 0.4160          | + 0.4020 | 0.0140 | + 0.6700 | + 0.6560 | 0.0140 |                    |
| 225     | 250 | + 0.710     | + 0.420     | + 0.4560          | + 0.4420 | 0.0140 | + 0.7100 | + 0.6960 | 0.0140 |                    |
| 250     | 280 | + 0.800     | + 0.480     | + 0.5200          | + 0.5040 | 0.0160 | + 0.8000 | + 0.7840 | 0.0160 |                    |
| 280     | 315 | + 0.860     | + 0.540     | + 0.5800          | + 0.5640 | 0.0160 | + 0.8600 | + 0.8440 | 0.0160 |                    |
| 315     | 355 | + 0.960     | + 0.600     | + 0.6450          | + 0.6270 | 0.0180 | + 0.9600 | + 0.9420 | 0.0180 |                    |
| 355     | 400 | + 1.040     | + 0.680     | + 0.7250          | + 0.7070 | 0.0180 | + 1.0400 | + 1.0220 | 0.0180 |                    |
| 400     | 450 | + 1.160     | + 0.760     | + 0.8100          | + 0.7900 | 0.0200 | + 1.1600 | + 1.1400 | 0.0200 |                    |
| 450     | 500 | + 1.240     | + 0.840     | + 0.8900          | + 0.8700 | 0.0200 | + 1.2400 | + 1.2200 | 0.0200 |                    |

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表13 B12 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |         | 通规<br>磨损<br>极限     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|---------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |         |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差     |                    |
| 大 于     | 至   |             |             |                   |          |        |          |          |         | 为最大实体尺寸「即孔的最小极限尺寸」 |
| —       | 3   | + 0.240     | + 0.140     | + 0.1510          | + 0.1470 | 0.0040 | + 0.2100 | + 0.2360 | 0.00400 |                    |
| 3       | 6   | + 0.260     | + 0.140     | + 0.1540          | + 0.1490 | 0.0050 | + 0.2600 | + 0.2550 | 0.00500 |                    |
| 6       | 10  | + 0.300     | + 0.150     | + 0.1660          | + 0.1600 | 0.0060 | + 0.3000 | + 0.2940 | 0.00600 |                    |
| 10      | 14  | + 0.330     | + 0.150     | + 0.1690          | + 0.1620 | 0.0070 | + 0.3300 | + 0.3230 | 0.00700 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |         |                    |
| 18      | 24  | + 0.370     | + 0.160     | + 0.1820          | + 0.1740 | 0.0080 | + 0.3700 | + 0.3620 | 0.00800 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |         |                    |
| 30      | 40  | + 0.420     | + 0.170     | + 0.1970          | + 0.1870 | 0.0100 | + 0.4200 | + 0.4100 | 0.01000 |                    |
| 40      | 50  | + 0.430     | + 0.180     | + 0.2070          | + 0.1970 | 0.0100 | + 0.4300 | + 0.4200 | 0.01000 |                    |
| 50      | 65  | + 0.490     | + 0.190     | + 0.2220          | + 0.2100 | 0.0120 | + 0.4900 | + 0.4780 | 0.01200 |                    |
| 65      | 80  | + 0.500     | + 0.200     | + 0.2320          | + 0.2200 | 0.0120 | + 0.5000 | + 0.4880 | 0.01200 |                    |
| 80      | 100 | + 0.570     | + 0.220     | + 0.2570          | + 0.2430 | 0.0140 | + 0.5700 | + 0.5560 | 0.01400 |                    |
| 100     | 120 | + 0.590     | + 0.240     | + 0.2770          | + 0.2630 | 0.0140 | + 0.5900 | + 0.5760 | 0.02400 |                    |
| 120     | 140 | + 0.660     | + 0.260     | + 0.3030          | + 0.2870 | 0.0160 | + 0.6600 | + 0.6440 | 0.01600 |                    |
| 140     | 160 | + 0.680     | + 0.280     | + 0.3230          | + 0.3070 | 0.0160 | + 0.6800 | + 0.6640 | 0.01600 |                    |
| 160     | 180 | + 0.710     | + 0.310     | + 0.3530          | + 0.3370 | 0.0160 | + 0.7100 | + 0.6940 | 0.01600 |                    |
| 180     | 200 | + 0.800     | + 0.340     | + 0.3890          | + 0.3710 | 0.0180 | + 0.8000 | + 0.7820 | 0.01800 |                    |
| 200     | 225 | + 0.840     | + 0.380     | + 0.4290          | + 0.4110 | 0.0180 | + 0.8400 | + 0.8220 | 0.01800 |                    |
| 225     | 250 | + 0.880     | + 0.420     | + 0.4690          | + 0.4510 | 0.0180 | + 0.8800 | + 0.8620 | 0.01800 |                    |
| 250     | 280 | + 1.000     | + 0.480     | + 0.5350          | + 0.5150 | 0.0200 | + 1.0000 | + 0.9800 | 0.02000 |                    |
| 280     | 316 | + 1.060     | + 0.540     | + 0.5950          | + 0.5750 | 0.0200 | + 1.0600 | + 1.0400 | 0.02000 |                    |
| 315     | 355 | + 1.170     | + 0.600     | + 0.6610          | + 0.6390 | 0.0220 | + 1.1700 | + 1.1480 | 0.02200 |                    |
| 355     | 405 | + 1.250     | + 0.680     | + 0.7410          | + 0.7190 | 0.0220 | + 1.2500 | + 1.2280 | 0.02200 |                    |
| 400     | 450 | + 1.390     | + 0.760     | + 0.8270          | + 0.8030 | 0.0240 | + 1.3900 | + 1.3660 | 0.02400 |                    |
| 450     | 500 | + 1.470     | + 0.840     | + 0.9070          | + 0.8830 | 0.0240 | + 1.4700 | + 1.4460 | 0.02400 |                    |

表14 C11 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 拟<br>极 限                 |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|-----------------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                   |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                                   |
| 大 于     | 至   |             |             |                   |          |        |          |          |        |                                   |
| —       | 3   | + 0.120     | + 0.060     | + 0.0675          | + 0.0640 | 0.0030 | + 0.1200 | + 0.1170 | 0.0030 | 为 最 大 实 体 尺 寸 「即 孔 的 最 小 极 限 尺 寸」 |
| 3       | 6   | + 0.145     | + 0.070     | + 0.0800          | + 0.0760 | 0.0040 | + 0.1450 | + 0.1410 | 0.0040 |                                   |
| 6       | 10  | + 0.170     | + 0.080     | + 0.0915          | + 0.0865 | 0.0050 | + 0.1700 | + 0.1650 | 0.0050 |                                   |
| 10      | 14  | + 0.205     | + 0.095     | + 0.1090          | + 0.1030 | 0.0060 | + 0.2050 | + 0.1990 | 0.0060 |                                   |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                   |
| 18      | 24  | + 0.240     | + 0.110     | + 0.1265          | + 0.1195 | 0.0070 | + 0.2400 | + 0.2330 | 0.0070 |                                   |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                   |
| 30      | 40  | + 0.280     | + 0.120     | + 0.1400          | + 0.1320 | 0.0080 | + 0.2800 | + 0.2720 | 0.0080 |                                   |
| 40      | 50  | + 0.290     | + 0.130     | + 0.1500          | + 0.1420 | 0.0080 | + 0.2900 | + 0.2820 | 0.0080 |                                   |
| 50      | 65  | + 0.330     | + 0.140     | + 0.1635          | + 0.1545 | 0.0090 | + 0.3300 | + 0.3210 | 0.0090 |                                   |
| 65      | 80  | + 0.340     | + 0.150     | + 0.1735          | + 0.1645 | 0.0090 | + 0.3400 | + 0.3310 | 0.0090 |                                   |
| 80      | 100 | + 0.390     | + 0.170     | + 0.1970          | + 0.1870 | 0.0100 | + 0.3900 | + 0.3800 | 0.0100 |                                   |
| 100     | 120 | + 0.400     | + 0.180     | + 0.2070          | + 0.1970 | 0.0100 | + 0.4000 | + 0.3900 | 0.0100 |                                   |
| 120     | 140 | + 0.450     | + 0.200     | + 0.2310          | + 0.2190 | 0.0120 | + 0.4500 | + 0.4380 | 0.0120 |                                   |
| 140     | 160 | + 0.460     | + 0.210     | + 0.2410          | + 0.2290 | 0.0120 | + 0.4600 | + 0.4480 | 0.0120 |                                   |
| 160     | 180 | + 0.480     | + 0.230     | + 0.2610          | + 0.2490 | 0.0120 | + 0.4800 | + 0.4680 | 0.0120 |                                   |
| 180     | 200 | + 0.530     | + 0.240     | + 0.2760          | + 0.2620 | 0.0140 | + 0.5300 | + 0.5160 | 0.0140 |                                   |
| 200     | 225 | + 0.550     | + 0.260     | + 0.2960          | + 0.2820 | 0.0140 | + 0.5500 | + 0.5360 | 0.0140 |                                   |
| 225     | 250 | + 0.570     | + 0.280     | + 0.3160          | + 0.3020 | 0.0140 | + 0.5700 | + 0.5560 | 0.0140 |                                   |
| 250     | 280 | + 0.620     | + 0.300     | + 0.3400          | + 0.3240 | 0.0160 | + 0.6200 | + 0.6040 | 0.0160 |                                   |
| 280     | 315 | + 0.650     | + 0.330     | + 0.3700          | + 0.3540 | 0.0160 | + 0.6500 | + 0.6340 | 0.0160 |                                   |
| 315     | 355 | + 0.720     | + 0.360     | + 0.4050          | + 0.3870 | 0.0180 | + 0.7200 | + 0.7020 | 0.0180 |                                   |
| 355     | 400 | + 0.760     | + 0.400     | + 0.4450          | + 0.4270 | 0.0180 | + 0.7600 | + 0.7420 | 0.0180 |                                   |
| 400     | 450 | + 0.840     | + 0.440     | + 0.4900          | + 0.4700 | 0.0200 | + 0.8400 | + 0.8200 | 0.0200 |                                   |
| 450     | 500 | + 0.880     | + 0.480     | + 0.5300          | + 0.5100 | 0.0200 | + 0.8800 | + 0.8600 | 0.0200 |                                   |

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表15 C12 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| —       | 3   | + 0.160     | + 0.060     | + 0.0710          | + 0.0670 | 0.0040 | + 0.1600 | + 0.1560 | 0.0040 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.190     | + 0.070     | + 0.0840          | + 0.0790 | 0.0050 | + 0.1900 | + 0.1850 | 0.0050 |                    |
| 6       | 10  | + 0.230     | + 0.080     | + 0.0960          | + 0.0900 | 0.0060 | + 0.2300 | + 0.2240 | 0.0060 |                    |
| 10      | 14  | + 0.275     | + 0.095     | + 0.1140          | + 0.1070 | 0.0070 | + 0.2750 | + 0.2680 | 0.0070 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.320     | + 0.110     | + 0.1320          | + 0.1240 | 0.0080 | + 0.3200 | + 0.3120 | 0.0080 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.370     | + 0.120     | + 0.1470          | + 0.1370 | 0.0100 | + 0.3700 | + 0.3600 | 0.0100 |                    |
| 40      | 50  | + 0.380     | + 0.130     | + 0.1570          | + 0.1470 | 0.0100 | + 0.3800 | + 0.3700 | 0.0100 |                    |
| 50      | 65  | + 0.440     | + 0.140     | + 0.1720          | + 0.1600 | 0.0120 | + 0.4400 | + 0.4280 | 0.0120 |                    |
| 65      | 80  | + 0.450     | + 0.150     | + 0.1820          | + 0.1700 | 0.0120 | + 0.4500 | + 0.4380 | 0.0120 |                    |
| 80      | 100 | + 0.520     | + 0.170     | + 0.2070          | + 0.1930 | 0.0140 | + 0.5200 | + 0.5060 | 0.0140 |                    |
| 100     | 120 | + 0.530     | + 0.180     | + 0.2170          | + 0.2030 | 0.0140 | + 0.5300 | + 0.5160 | 0.0140 |                    |
| 120     | 140 | + 0.600     | + 0.200     | + 0.2430          | + 0.2270 | 0.0160 | + 0.6000 | + 0.5840 | 0.0160 |                    |
| 140     | 160 | + 0.610     | + 0.210     | + 0.2530          | + 0.2370 | 0.0160 | + 0.6100 | + 0.5940 | 0.0160 |                    |
| 160     | 180 | + 0.630     | + 0.230     | + 0.2730          | + 0.2570 | 0.0160 | + 0.6300 | + 0.6140 | 0.0160 |                    |
| 180     | 200 | + 0.700     | + 0.240     | + 0.2890          | + 0.2710 | 0.0180 | + 0.7000 | + 0.6820 | 0.0180 |                    |
| 200     | 225 | + 0.720     | + 0.260     | + 0.3090          | + 0.2910 | 0.0180 | + 0.7200 | + 0.7020 | 0.0180 |                    |
| 225     | 250 | + 0.740     | + 0.280     | + 0.3290          | + 0.3110 | 0.0180 | + 0.7400 | + 0.7220 | 0.0180 |                    |
| 250     | 280 | + 0.820     | + 0.300     | + 0.3550          | + 0.3350 | 0.0200 | + 0.8200 | + 0.8000 | 0.0200 |                    |
| 280     | 315 | + 0.850     | + 0.330     | + 0.3850          | + 0.3650 | 0.0200 | + 0.8500 | + 0.8300 | 0.0200 |                    |
| 315     | 355 | + 0.930     | + 0.360     | + 0.4210          | + 0.3990 | 0.0220 | + 0.9300 | + 0.9080 | 0.0220 |                    |
| 355     | 400 | + 0.970     | + 0.400     | + 0.4610          | + 0.4390 | 0.0220 | + 0.9700 | + 0.9480 | 0.0220 |                    |
| 400     | 450 | + 1.070     | + 0.440     | + 0.5070          | + 0.4830 | 0.0240 | + 1.0700 | + 1.0460 | 0.0240 |                    |
| 450     | 500 | + 1.110     | + 0.480     | + 0.5470          | + 0.5230 | 0.0240 | + 1.1100 | + 1.0860 | 0.0240 |                    |

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表16 D 8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限                     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|------------------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                    |
| 大 于     | 至   |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                                    |
| —       | 3   | + 0.034     | + 0.020     | + 0.0228          | + 0.0212 | 0.0016 | + 0.0340 | + 0.0324 | 0.0016 | 为最大<br>实体尺寸<br>「即孔的<br>最小极限<br>尺寸」 |
| 3       | 6   | + 0.048     | + 0.030     | + 0.0336          | + 0.0316 | 0.0020 | + 0.0480 | + 0.0460 | 0.0020 |                                    |
| 6       | 10  | + 0.062     | + 0.040     | + 0.0444          | + 0.0420 | 0.0024 | + 0.0620 | + 0.0596 | 0.0024 |                                    |
| 10      | 14  | + 0.077     | + 0.050     | + 0.0554          | + 0.0526 | 0.0028 | + 0.0770 | + 0.0742 | 0.0028 |                                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                    |
| 18      | 24  | + 0.098     | + 0.065     | + 0.0717          | + 0.0683 | 0.0034 | + 0.0980 | + 0.0946 | 0.0034 |                                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                    |
| 30      | 40  | + 0.119     | + 0.080     | + 0.0880          | + 0.0840 | 0.0040 | + 0.1190 | + 0.1150 | 0.0040 |                                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                                    |
| 50      | 65  | + 0.146     | + 0.100     | + 0.1093          | + 0.1047 | 0.0046 | + 0.1460 | + 0.1414 | 0.0046 |                                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                                    |
| 80      | 100 | + 0.174     | + 0.120     | + 0.1307          | + 0.1253 | 0.0054 | + 0.1740 | + 0.1686 | 0.0054 |                                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                                    |
| 120     | 140 | + 0.208     | + 0.145     | + 0.1570          | + 0.1510 | 0.0060 | + 0.2080 | + 0.2020 | 0.0060 |                                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                                    |
| 160     | 180 |             |             |                   |          |        |          |          |        |                                    |
| 180     | 200 | + 0.242     | + 0.170     | + 0.1835          | + 0.1765 | 0.0070 | + 0.2420 | + 0.2350 | 0.0070 |                                    |
| 200     | 225 |             |             |                   |          |        |          |          |        |                                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                                    |
| 250     | 280 | + 0.274     | + 0.190     | + 0.2050          | + 0.1970 | 0.0080 | + 0.2740 | + 0.2630 | 0.0080 |                                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                                    |
| 315     | 355 | + 0.299     | + 0.210     | + 0.2265          | + 0.2175 | 0.0090 | + 0.2990 | + 0.2900 | 0.0090 |                                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                                    |
| 400     | 450 | + 0.327     | + 0.230     | + 0.2490          | + 0.2390 | 0.0100 | + 0.3270 | + 0.3170 | 0.0100 |                                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                                    |

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表17 D 9 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 损<br>极 限  |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| —       | 3   | + 0.045     | + 0.020     | + 0.0240          | + 0.0220 | 0.0020 | + 0.0450 | + 0.0430 | 0.0020 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.060     | + 0.030     | + 0.0352          | + 0.0328 | 0.0024 | + 0.0600 | + 0.0576 | 0.0024 |                    |
| 6       | 10  | + 0.076     | + 0.040     | + 0.0464          | + 0.0436 | 0.0028 | + 0.0760 | + 0.0732 | 0.0028 |                    |
| 10      | 14  | + 0.093     | + 0.050     | + 0.0577          | + 0.0543 | 0.0034 | + 0.0930 | + 0.0896 | 0.0034 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.117     | + 0.065     | + 0.0740          | + 0.0700 | 0.0040 | + 0.1170 | + 0.1130 | 0.0040 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.142     | + 0.080     | + 0.0905          | + 0.0855 | 0.0050 | + 0.1420 | + 0.1370 | 0.0050 |                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.174     | + 0.100     | + 0.1120          | + 0.1060 | 0.0060 | + 0.1740 | + 0.1680 | 0.0060 |                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.207     | + 0.120     | + 0.1335          | + 0.1265 | 0.0070 | + 0.2070 | + 0.2000 | 0.0070 |                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                    |
| 120     | 140 | + 0.245     | + 0.145     | + 0.1610          | + 0.1530 | 0.0080 | + 0.2450 | + 0.2370 | 0.0080 |                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                    |
| 160     | 180 |             |             |                   |          |        |          |          |        |                    |
| 180     | 200 | + 0.285     | + 0.170     | + 0.1885          | + 0.1795 | 0.0090 | + 0.2850 | + 0.2760 | 0.0090 |                    |
| 200     | 225 |             |             |                   |          |        |          |          |        |                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                    |
| 250     | 280 | + 0.320     | + 0.190     | + 0.2110          | + 0.2010 | 0.0100 | + 0.3200 | + 0.3100 | 0.0100 |                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                    |
| 315     | 355 | + 0.350     | + 0.210     | + 0.2335          | + 0.2225 | 0.0110 | + 0.3500 | + 0.3390 | 0.0110 |                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                    |
| 400     | 450 | + 0.385     | + 0.230     | + 0.2560          | + 0.2440 | 0.0120 | + 0.3850 | + 0.3730 | 0.0120 |                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                    |

表18 D11 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限                     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|------------------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                                    |
| —       | 3   | + 0.080     | + 0.020     | + 0.0275          | + 0.0245 | 0.0030 | + 0.0800 | + 0.0770 | 0.0030 | 为最大<br>实体尺寸<br>「即孔的<br>最小极限<br>尺寸」 |
| 3       | 6   | + 0.105     | + 0.030     | + 0.0400          | + 0.0360 | 0.0040 | + 0.1050 | + 0.1010 | 0.0040 |                                    |
| 6       | 10  | + 0.130     | + 0.040     | + 0.0515          | + 0.0465 | 0.0050 | + 0.1300 | + 0.1250 | 0.0050 |                                    |
| 10      | 14  | + 0.160     | + 0.050     | + 0.0640          | + 0.0580 | 0.0060 | + 0.1600 | + 0.1540 | 0.0060 |                                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                    |
| 18      | 24  | + 0.195     | + 0.065     | + 0.0815          | + 0.0745 | 0.0070 | + 0.1950 | + 0.1880 | 0.0070 |                                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                    |
| 30      | 40  | + 0.240     | + 0.080     | + 0.1000          | + 0.0920 | 0.0080 | + 0.2400 | + 0.2320 | 0.0080 |                                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                                    |
| 50      | 65  | + 0.290     | + 0.100     | + 0.1235          | + 0.1145 | 0.0090 | + 0.2900 | + 0.2810 | 0.0090 |                                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                                    |
| 80      | 100 | + 0.340     | + 0.120     | + 0.1470          | + 0.1370 | 0.0100 | + 0.3400 | + 0.3300 | 0.0100 |                                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                                    |
| 120     | 140 | + 0.395     | + 0.145     | + 0.1760          | + 0.1640 | 0.0120 | + 0.3950 | + 0.4460 | 0.0120 |                                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                                    |
| 160     | 180 |             |             |                   |          |        |          |          |        |                                    |
| 180     | 200 | + 0.460     | + 0.170     | + 0.2060          | + 0.1920 | 0.0140 | + 0.4600 | + 0.4460 | 0.0140 |                                    |
| 200     | 225 |             |             |                   |          |        |          |          |        |                                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                                    |
| 250     | 280 | + 0.510     | + 0.190     | + 0.2300          | + 0.2140 | 0.0160 | + 0.5100 | + 0.4940 | 0.0160 |                                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                                    |
| 315     | 355 | + 0.570     | + 0.210     | + 0.2550          | + 0.2370 | 0.0180 | + 0.5700 | + 0.5520 | 0.0180 |                                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                                    |
| 400     | 450 | + 0.630     | + 0.230     | + 0.2800          | + 0.2600 | 0.0200 | + 0.6300 | + 0.6100 | 0.0200 |                                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                                    |

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表10 E 8 孔用早规 尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| -       | 3   | + 0.028     | + 0.014     | + 0.0168          | + 0.0152 | 0.0016 | + 0.0280 | + 0.0264 | 0.0016 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.038     | + 0.020     | + 0.0236          | + 0.0216 | 0.0020 | + 0.0380 | + 0.0360 | 0.0020 |                    |
| 6       | 10  | + 0.047     | + 0.025     | + 0.0294          | + 0.0270 | 0.0024 | + 0.0470 | + 0.0446 | 0.0024 |                    |
| 10      | 14  | + 0.059     | + 0.032     | + 0.0374          | + 0.0346 | 0.0028 | + 0.0590 | + 0.0562 | 0.0028 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.073     | + 0.040     | + 0.0467          | + 0.0433 | 0.0034 | + 0.0730 | + 0.0696 | 0.0034 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.089     | + 0.050     | + 0.0580          | + 0.0540 | 0.0040 | + 0.0890 | + 0.0850 | 0.0040 |                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.106     | + 0.060     | + 0.0693          | + 0.0647 | 0.0046 | + 0.1060 | + 0.1014 | 0.0046 |                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.126     | + 0.072     | + 0.0827          | + 0.0773 | 0.0054 | + 0.1260 | + 0.1206 | 0.0054 |                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                    |
| 120     | 140 | + 0.148     | + 0.085     | + 0.0970          | + 0.0910 | 0.0060 | + 0.1480 | + 0.1420 | 0.0060 |                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                    |
| 160     | 180 | + 0.172     | + 0.100     | + 0.1135          | + 0.1065 | 0.0070 | + 0.1720 | + 0.1650 | 0.0070 |                    |
| 180     | 200 |             |             |                   |          |        |          |          |        |                    |
| 200     | 225 | + 0.191     | + 0.110     | + 0.1250          | + 0.1170 | 0.0080 | + 0.1910 | + 0.1830 | 0.0080 |                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                    |
| 250     | 280 | + 0.214     | + 0.125     | + 0.1415          | + 0.1325 | 0.0090 | + 0.2140 | + 0.2050 | 0.0090 |                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                    |
| 315     | 355 | + 0.232     | + 0.135     | + 0.1540          | + 0.1440 | 0.0100 | + 0.2320 | + 0.2220 | 0.0100 |                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                    |
| 400     | 450 | + 0.232     | + 0.135     | + 0.1540          | + 0.1440 | 0.0100 | + 0.2320 | + 0.2220 | 0.0100 |                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                    |

表20 F 7 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 损<br>极 限  |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|--------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                    |
| 大 于     | 至   |             |             |                   |          |        |          |          |        |                    |
|         | 3   | + 0.016     | + 0.006     | + 0.0082          | + 0.0070 | 0.0012 | + 0.0160 | + 0.0148 | 0.0012 | 为最大实体尺寸「即孔的最小极限尺寸」 |
| 3       | 6   | + 0.022     | + 0.010     | + 0.0127          | + 0.0113 | 0.0014 | + 0.0220 | + 0.0206 | 0.0014 |                    |
| 6       | 10  | + 0.028     | + 0.013     | + 0.0163          | + 0.0145 | 0.0018 | + 0.0280 | + 0.0262 | 0.0018 |                    |
| 10      | 14  | + 0.034     | + 0.016     | + 0.0198          | + 0.0178 | 0.0020 | + 0.0340 | + 0.0320 | 0.0020 |                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                    |
| 18      | 24  | + 0.041     | + 0.020     | + 0.0246          | + 0.0222 | 0.0024 | + 0.0410 | + 0.0386 | 0.0024 |                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                    |
| 30      | 40  | + 0.050     | + 0.025     | + 0.0305          | + 0.0275 | 0.0030 | + 0.0500 | + 0.0470 | 0.0030 |                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                    |
| 50      | 65  | + 0.060     | + 0.030     | + 0.0364          | + 0.0328 | 0.0036 | + 0.0600 | + 0.0564 | 0.0036 |                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                    |
| 80      | 100 | + 0.071     | + 0.036     | + 0.0435          | + 0.0393 | 0.0042 | + 0.0710 | + 0.0668 | 0.0042 |                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                    |
| 120     | 140 | + 0.071     | + 0.036     | + 0.0514          | + 0.0466 | 0.0048 | + 0.0830 | + 0.0782 | 0.0048 |                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                    |
| 160     | 180 | + 0.083     | + 0.043     | + 0.0597          | + 0.0543 | 0.0054 | + 0.0960 | + 0.0906 | 0.0054 |                    |
| 180     | 200 |             |             |                   |          |        |          |          |        |                    |
| 200     | 225 | + 0.108     | + 0.056     | + 0.0670          | + 0.0610 | 0.0060 | + 0.1080 | + 0.1020 | 0.0060 |                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                    |
| 250     | 280 | + 0.119     | + 0.062     | + 0.0745          | + 0.0675 | 0.0070 | + 0.1190 | + 0.1120 | 0.0070 |                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                    |
| 315     | 355 | + 0.131     | + 0.068     | + 0.0820          | + 0.0740 | 0.0080 | + 0.1310 | + 0.1230 | 0.0080 |                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                    |
| 400     | 450 | + 0.131     | + 0.068     | + 0.0820          | + 0.0740 | 0.0080 | + 0.1310 | + 0.1230 | 0.0080 |                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                    |

表21 F 8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                            |
| 大 小     | 等   |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | + 0.020     | + 0.006     | + 0.0088          | + 0.0072 | 0.0016 | + 0.0200 | + 0.0184 | 0.0016 |                            |
| 3       | 6   | + 0.028     | + 0.010     | + 0.0136          | + 0.0116 | 0.0020 | + 0.0280 | + 0.0260 | 0.0020 |                            |
| 6       | 10  | + 0.035     | + 0.013     | + 0.0174          | + 0.0150 | 0.0024 | + 0.0350 | + 0.0326 | 0.0024 |                            |
| 10      | 14  | + 0.043     | + 0.016     | + 0.0214          | + 0.0186 | 0.0028 | + 0.0430 | + 0.0402 | 0.0028 |                            |
| 14      | 18  |             |             |                   |          |        |          |          |        |                            |
| 18      | 24  | + 0.053     | + 0.020     | + 0.0267          | + 0.0233 | 0.0034 | + 0.0530 | + 0.0496 | 0.0034 |                            |
| 24      | 30  |             |             |                   |          |        |          |          |        |                            |
| 30      | 40  | + 0.064     | + 0.025     | + 0.0330          | + 0.0290 | 0.0040 | + 0.0640 | + 0.0600 | 0.0040 |                            |
| 40      | 50  |             |             |                   |          |        |          |          |        |                            |
| 50      | 65  | + 0.076     | + 0.030     | + 0.0393          | + 0.0347 | 0.0046 | + 0.0760 | + 0.0714 | 0.0046 |                            |
| 65      | 80  |             |             |                   |          |        |          |          |        |                            |
| 80      | 100 | + 0.090     | + 0.036     | + 0.0467          | + 0.0413 | 0.0054 | + 0.0900 | + 0.0846 | 0.0054 |                            |
| 100     | 120 |             |             |                   |          |        |          |          |        |                            |
| 120     | 140 | + 0.106     | + 0.043     | + 0.0550          | + 0.0490 | 0.0060 | + 0.1060 | + 0.1000 | 0.0060 |                            |
| 140     | 160 |             |             |                   |          |        |          |          |        |                            |
| 160     | 180 | + 0.122     | + 0.050     | + 0.06350         | + 0.0565 | 0.0070 | + 0.1220 | + 0.1150 | 0.0070 |                            |
| 180     | 200 |             |             |                   |          |        |          |          |        |                            |
| 200     | 225 | + 0.137     | + 0.056     | + 0.0710          | + 0.0630 | 0.0080 | + 0.1370 | + 0.1290 | 0.0080 |                            |
| 225     | 250 |             |             |                   |          |        |          |          |        |                            |
| 250     | 280 | + 0.151     | + 0.062     | + 0.0785          | + 0.0695 | 0.0090 | + 0.1510 | + 0.1420 | 0.0090 |                            |
| 280     | 315 |             |             |                   |          |        |          |          |        |                            |
| 315     | 355 | + 0.165     | + 0.068     | + 0.0870          | + 0.0770 | 0.0100 | + 0.1650 | + 0.1550 | 0.0100 |                            |
| 355     | 400 |             |             |                   |          |        |          |          |        |                            |
| 400     | 450 | + 0.165     | + 0.068     | + 0.0870          | + 0.0770 | 0.0100 | + 0.1650 | + 0.1550 | 0.0100 |                            |
| 450     | 500 |             |             |                   |          |        |          |          |        |                            |

表22 F9孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规 磨 损 极 限          |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                      |
| 大 于     | 至   |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                      |
| —       | 3   | + 0.031     | + 0.006     | + 0.0100          | + 0.0080 | 0.0020 | + 0.0310 | + 0.0290 | 0.0020 | 为最大实体尺寸<br>即孔的最小极限尺寸 |
| 3       | 6   | + 0.040     | + 0.010     | + 0.0152          | + 0.0128 | 0.0024 | + 0.0400 | + 0.0376 | 0.0024 |                      |
| 6       | 10  | + 0.049     | + 0.013     | + 0.0194          | + 0.0166 | 0.0028 | + 0.0490 | + 0.0462 | 0.0028 |                      |
| 10      | 14  | + 0.059     | + 0.016     | + 0.0237          | + 0.0203 | 0.0034 | + 0.0590 | + 0.0556 | 0.0034 |                      |
| 14      | 18  |             |             |                   |          |        |          |          |        |                      |
| 18      | 24  | + 0.072     | + 0.020     | + 0.0290          | + 0.0250 | 0.0040 | + 0.0720 | + 0.0680 | 0.0040 |                      |
| 24      | 30  |             |             |                   |          |        |          |          |        |                      |
| 30      | 40  | + 0.087     | + 0.025     | + 0.0355          | + 0.0305 | 0.0050 | + 0.0870 | + 0.0820 | 0.0050 |                      |
| 40      | 50  |             |             |                   |          |        |          |          |        |                      |
| 50      | 65  | + 0.104     | + 0.030     | + 0.0420          | + 0.0360 | 0.0060 | + 0.1040 | + 0.0980 | 0.0060 |                      |
| 65      | 80  |             |             |                   |          |        |          |          |        |                      |
| 80      | 100 | + 0.123     | + 0.036     | + 0.0495          | + 0.0425 | 0.0070 | + 0.1230 | + 0.1160 | 0.0070 |                      |
| 100     | 120 |             |             |                   |          |        |          |          |        |                      |
| 120     | 140 | + 0.143     | + 0.043     | + 0.0590          | + 0.0510 | 0.0080 | + 0.1430 | + 0.1350 | 0.0080 |                      |
| 140     | 160 |             |             |                   |          |        |          |          |        |                      |
| 160     | 180 |             |             |                   |          |        |          |          |        |                      |
| 180     | 200 | + 0.165     | + 0.050     | + 0.0685          | + 0.0595 | 0.0090 | + 0.1650 | + 0.1560 | 0.0090 |                      |
| 200     | 225 |             |             |                   |          |        |          |          |        |                      |
| 225     | 250 |             |             |                   |          |        |          |          |        |                      |
| 250     | 280 | + 0.186     | + 0.056     | + 0.0770          | + 0.0670 | 0.0100 | + 0.1860 | + 0.1760 | 0.0100 |                      |
| 280     | 315 |             |             |                   |          |        |          |          |        |                      |
| 315     | 355 | + 0.202     | + 0.062     | + 0.0855          | + 0.0745 | 0.0110 | + 0.2020 | + 0.1910 | 0.0110 |                      |
| 355     | 400 |             |             |                   |          |        |          |          |        |                      |
| 400     | 450 | + 0.223     | + 0.068     | + 0.0940          | + 0.0820 | 0.0120 | + 0.2230 | + 0.2110 | 0.0120 |                      |
| 450     | 500 |             |             |                   |          |        |          |          |        |                      |

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表23 G 6 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                            |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                            |
| —       | 3   | + 0.008     | + 0.002     | + 0.0035          | + 0.0025 | 0.0010 | + 0.0080 | + 0.0070 | 0.0010 | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| 3       | 6   | + 0.012     | + 0.004     | + 0.0060          | + 0.0048 | 0.0012 | + 0.0120 | + 0.0108 | 0.0012 |                            |
| 6       | 10  | + 0.014     | + 0.005     | + 0.0073          | + 0.0059 | 0.0014 | + 0.0140 | + 0.0126 | 0.0014 |                            |
| 10      | 14  | + 0.017     | + 0.006     | + 0.0088          | + 0.0072 | 0.0016 | + 0.0170 | + 0.0154 | 0.0016 |                            |
| 14      | 18  |             |             |                   |          |        |          |          |        |                            |
| 18      | 24  | + 0.020     | + 0.007     | + 0.0104          | + 0.0084 | 0.0020 | + 0.0200 | + 0.0180 | 0.0020 |                            |
| 24      | 30  |             |             |                   |          |        |          |          |        |                            |
| 30      | 40  | + 0.025     | + 0.009     | + 0.0130          | + 0.0106 | 0.0024 | + 0.0250 | + 0.0226 | 0.0024 |                            |
| 40      | 50  |             |             |                   |          |        |          |          |        |                            |
| 50      | 65  | + 0.029     | + 0.010     | + 0.0148          | + 0.0120 | 0.0028 | + 0.0290 | + 0.0262 | 0.0028 |                            |
| 65      | 80  |             |             |                   |          |        |          |          |        |                            |
| 80      | 100 | + 0.034     | + 0.012     | + 0.0174          | + 0.0142 | 0.0032 | + 0.0340 | + 0.0308 | 0.0032 |                            |
| 100     | 120 |             |             |                   |          |        |          |          |        |                            |
| 120     | 140 | + 0.034     | + 0.014     | + 0.0203          | + 0.0165 | 0.0038 | + 0.0390 | + 0.0352 | 0.0038 |                            |
| 140     | 160 |             |             |                   |          |        |          |          |        |                            |
| 160     | 180 | + 0.039     | + 0.015     | + 0.0222          | + 0.0178 | 0.0044 | + 0.0440 | + 0.0396 | 0.0044 |                            |
| 180     | 200 |             |             |                   |          |        |          |          |        |                            |
| 200     | 225 | + 0.049     | + 0.017     | + 0.0250          | + 0.0202 | 0.0048 | + 0.0490 | + 0.0442 | 0.0048 |                            |
| 225     | 250 |             |             |                   |          |        |          |          |        |                            |
| 250     | 280 | + 0.054     | + 0.018     | + 0.0269          | + 0.0215 | 0.0054 | + 0.0540 | + 0.0486 | 0.0054 |                            |
| 280     | 315 |             |             |                   |          |        |          |          |        |                            |
| 315     | 355 | + 0.060     | + 0.020     | + 0.0300          | + 0.0240 | 0.0060 | + 0.0600 | + 0.0540 | 0.0060 |                            |
| 355     | 400 |             |             |                   |          |        |          |          |        |                            |
| 400     | 450 | + 0.060     | + 0.020     | + 0.0300          | + 0.0240 | 0.0060 | + 0.0600 | + 0.0540 | 0.0060 |                            |
| 450     | 500 |             |             |                   |          |        |          |          |        |                            |

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表24 G 7 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限                   |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                  |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                                  |
| —       | 3   | + 0.012     | + 0.002     | + 0.0042          | + 0.0030 | 0.0012 | + 0.0120 | + 0.0108 | 0.0012 | 为最大<br>实体尺寸<br>即孔的<br>最小极<br>限尺寸 |
| 3       | 6   | + 0.016     | + 0.004     | + 0.0067          | + 0.0053 | 0.0014 | + 0.0160 | + 0.0146 | 0.0014 |                                  |
| 6       | 10  | + 0.020     | + 0.005     | + 0.0083          | + 0.0065 | 0.0018 | + 0.0200 | + 0.0182 | 0.0018 |                                  |
| 10      | 14  | + 0.024     | + 0.006     | + 0.0098          | + 0.0078 | 0.0020 | + 0.0240 | + 0.0220 | 0.0020 |                                  |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                  |
| 18      | 24  | + 0.028     | + 0.007     | + 0.0116          | + 0.0092 | 0.0024 | + 0.0280 | + 0.0258 | 0.0024 |                                  |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                  |
| 30      | 40  | + 0.034     | + 0.009     | + 0.0145          | + 0.0115 | 0.0030 | + 0.0340 | + 0.0310 | 0.0030 |                                  |
| 40      | 50  |             |             |                   |          |        |          |          |        |                                  |
| 50      | 65  | + 0.040     | + 0.010     | + 0.0164          | + 0.0128 | 0.0036 | + 0.0400 | + 0.0364 | 0.0036 |                                  |
| 65      | 80  |             |             |                   |          |        |          |          |        |                                  |
| 80      | 100 | + 0.047     | + 0.012     | + 0.0195          | + 0.0153 | 0.0042 | + 0.0470 | + 0.0428 | 0.0042 |                                  |
| 100     | 120 |             |             |                   |          |        |          |          |        |                                  |
| 120     | 140 | + 0.054     | + 0.014     | + 0.0224          | + 0.0176 | 0.0048 | + 0.0540 | + 0.0492 | 0.0048 |                                  |
| 140     | 160 |             |             |                   |          |        |          |          |        |                                  |
| 160     | 180 | + 0.061     | + 0.015     | + 0.0247          | + 0.0193 | 0.0054 | + 0.0610 | + 0.0556 | 0.0054 |                                  |
| 180     | 200 |             |             |                   |          |        |          |          |        |                                  |
| 200     | 225 | + 0.069     | + 0.017     | + 0.0280          | + 0.0220 | 0.0060 | + 0.0690 | + 0.0630 | 0.0060 |                                  |
| 225     | 250 |             |             |                   |          |        |          |          |        |                                  |
| 250     | 280 | + 0.075     | + 0.018     | + 0.0305          | + 0.0235 | 0.0070 | + 0.0750 | + 0.0680 | 0.0070 |                                  |
| 280     | 315 |             |             |                   |          |        |          |          |        |                                  |
| 315     | 355 | + 0.083     | + 0.020     | + 0.0340          | + 0.0260 | 0.0080 | + 0.0830 | + 0.0750 | 0.0080 |                                  |
| 355     | 400 |             |             |                   |          |        |          |          |        |                                  |
| 400     | 450 | + 0.083     | + 0.020     | + 0.0340          | + 0.0260 | 0.0080 | + 0.0830 | + 0.0750 | 0.0080 |                                  |
| 450     | 500 |             |             |                   |          |        |          |          |        |                                  |

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表25 J 7孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限                     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|------------------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                                    |
| 大 于     | 至   |             |             |                   |          |        |          |          |        | 为最大<br>实体尺寸<br>「即孔的<br>最小极限<br>尺寸」 |
| —       | 3   | + 0.004     | - 0.006     | - 0.0038          | - 0.0050 | 0.0012 | + 0.0040 | + 0.0028 | 0.0012 |                                    |
| 3       | 6   | —           | —           | —                 | —        | —      | —        | —        | —      |                                    |
| 6       | 10  | + 0.008     | - 0.007     | - 0.0037          | - 0.0055 | 0.0018 | + 0.0080 | + 0.0062 | 0.0018 |                                    |
| 10      | 14  | + 0.010     | - 0.008     | 0.0042            | 0.0062   | 0.0020 | + 0.0100 | + 0.0080 | 0.0020 |                                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                    |
| 18      | 24  | + 0.012     | - 0.009     | - 0.0044          | - 0.0068 | 0.0024 | + 0.0120 | + 0.0096 | 0.0024 |                                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                    |
| 30      | 40  | + 0.014     | - 0.011     | - 0.0055          | - 0.0085 | 0.0030 | + 0.0140 | + 0.0110 | 0.0030 |                                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                                    |
| 50      | 65  | + 0.018     | - 0.012     | - 0.0056          | - 0.0092 | 0.0036 | + 0.0180 | + 0.0144 | 0.0036 |                                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                                    |
| 80      | 100 | + 0.022     | - 0.013     | - 0.0055          | - 0.0097 | 0.0042 | + 0.0220 | + 0.0178 | 0.0042 |                                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                                    |
| 120     | 140 | + 0.026     | - 0.014     | - 0.0056          | - 0.0104 | 0.0048 | + 0.0260 | + 0.0212 | 0.0048 |                                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                                    |
| 160     | 180 |             |             |                   |          |        |          |          |        |                                    |
| 180     | 200 | + 0.030     | - 0.016     | - 0.0063          | - 0.0117 | 0.0054 | + 0.0300 | + 0.0246 | 0.0054 |                                    |
| 200     | 225 |             |             |                   |          |        |          |          |        |                                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                                    |
| 250     | 280 | + 0.036     | - 0.016     | + 0.0050          | - 0.0110 | 0.0060 | + 0.0360 | + 0.0300 | 0.0060 |                                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                                    |
| 315     | 355 | + 0.039     | - 0.018     | - 0.0055          | - 0.0125 | 0.0070 | + 0.0390 | + 0.0320 | 0.0070 |                                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                                    |
| 400     | 450 | + 0.043     | - 0.020     | - 0.0060          | - 0.0140 | 0.0080 | + 0.0430 | + 0.0350 | 0.0080 |                                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                                    |

表26 J 8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限                     |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|------------------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                    |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                                    |
| —       | 3   | + 0.006     | - 0.008     | - 0.0052          | - 0.0068 | 0.0016 | + 0.0060 | + 0.0044 | 0.0016 | 为最大<br>实体尺寸<br>（即孔的<br>最小极限<br>尺寸） |
| 3       | 6   | + 0.010     | - 0.008     | 0.0044            | 0.0064   | 0.0020 | + 0.0100 | + 0.0080 | 0.0020 |                                    |
| 6       | 10  | + 0.012     | - 0.010     | - 0.0056          | - 0.0080 | 0.0024 | + 0.0120 | + 0.0096 | 0.0024 |                                    |
| 10      | 14  | + 0.015     | - 0.012     | - 0.0066          | - 0.0094 | 0.0028 | + 0.0150 | + 0.0122 | 0.0028 |                                    |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                    |
| 18      | 24  | + 0.020     | - 0.013     | - 0.0063          | - 0.0097 | 0.0034 | + 0.0200 | + 0.0166 | 0.0034 |                                    |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                    |
| 30      | 40  | + 0.024     | - 0.015     | - 0.0070          | - 0.0110 | 0.0040 | + 0.0240 | + 0.0200 | 0.0040 |                                    |
| 40      | 50  |             |             |                   |          |        |          |          |        |                                    |
| 50      | 65  | + 0.028     | - 0.018     | - 0.0087          | - 0.0133 | 0.0046 | + 0.0280 | + 0.0234 | 0.0046 |                                    |
| 65      | 80  |             |             |                   |          |        |          |          |        |                                    |
| 80      | 100 | + 0.034     | - 0.020     | - 0.0093          | - 0.0147 | 0.0054 | + 0.0340 | + 0.0286 | 0.0054 |                                    |
| 100     | 120 |             |             |                   |          |        |          |          |        |                                    |
| 120     | 140 | + 0.041     | - 0.022     | - 0.0100          | - 0.0160 | 0.0060 | + 0.0410 | + 0.0350 | 0.0060 |                                    |
| 140     | 160 |             |             |                   |          |        |          |          |        |                                    |
| 160     | 180 |             |             |                   |          |        |          |          |        |                                    |
| 180     | 200 | + 0.047     | - 0.025     | - 0.0115          | - 0.0185 | 0.0070 | + 0.0470 | + 0.0400 | 0.0070 |                                    |
| 200     | 225 |             |             |                   |          |        |          |          |        |                                    |
| 225     | 250 |             |             |                   |          |        |          |          |        |                                    |
| 250     | 280 | + 0.055     | - 0.026     | - 0.0110          | - 0.0190 | 0.0080 | + 0.0550 | + 0.0470 | 0.0080 |                                    |
| 280     | 315 |             |             |                   |          |        |          |          |        |                                    |
| 315     | 355 | + 0.060     | - 0.029     | - 0.0125          | - 0.0215 | 0.0090 | + 0.0600 | + 0.0510 | 0.0090 |                                    |
| 355     | 400 |             |             |                   |          |        |          |          |        |                                    |
| 400     | 450 | + 0.066     | - 0.031     | - 0.0120          | - 0.0220 | 0.0100 | + 0.0660 | + 0.0560 | 0.0100 |                                    |
| 450     | 500 |             |             |                   |          |        |          |          |        |                                    |

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表27 Js 6孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                            |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                            |
| —       | 3   | + 0.003     | - 0.003     | - 0.0015          | - 0.0025 | 0.0010 | + 0.0030 | + 0.0020 | 0.0010 | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| 3       | 6   | + 0.004     | - 0.004     | - 0.0020          | - 0.0032 | 0.0012 | + 0.0040 | + 0.0028 | 0.0012 |                            |
| 6       | 10  | + 0.0045    | - 0.0045    | - 0.0022          | - 0.0036 | 0.0014 | + 0.0045 | + 0.0031 | 0.0014 |                            |
| 10      | 14  | + 0.0055    | - 0.0055    | - 0.0027          | - 0.0043 | 0.0016 | + 0.0055 | + 0.0039 | 0.0016 |                            |
| 14      | 18  |             |             |                   |          |        |          |          |        |                            |
| 18      | 24  | + 0.0065    | - 0.0065    | - 0.0031          | - 0.0051 | 0.0020 | + 0.0065 | + 0.0045 | 0.0020 |                            |
| 24      | 30  |             |             |                   |          |        |          |          |        |                            |
| 30      | 40  | + 0.008     | - 0.008     | - 0.0040          | - 0.0064 | 0.0024 | + 0.0080 | + 0.0056 | 0.0024 |                            |
| 40      | 50  |             |             |                   |          |        |          |          |        |                            |
| 50      | 65  | + 0.0095    | - 0.0095    | - 0.0047          | - 0.0075 | 0.0028 | + 0.0095 | + 0.0067 | 0.0028 |                            |
| 65      | 80  |             |             |                   |          |        |          |          |        |                            |
| 80      | 100 | + 0.011     | - 0.011     | - 0.0056          | - 0.0088 | 0.0032 | + 0.0110 | + 0.0078 | 0.0032 |                            |
| 100     | 120 |             |             |                   |          |        |          |          |        |                            |
| 120     | 140 | + 0.0125    | - 0.0125    | - 0.0062          | - 0.0100 | 0.0038 | + 0.0125 | + 0.0087 | 0.0038 |                            |
| 140     | 160 |             |             |                   |          |        |          |          |        |                            |
| 160     | 180 |             |             |                   |          |        |          |          |        |                            |
| 180     | 200 | + 0.0145    | - 0.0145    | - 0.0073          | - 0.0117 | 0.0044 | + 0.0145 | + 0.0101 | 0.0044 |                            |
| 200     | 225 |             |             |                   |          |        |          |          |        |                            |
| 225     | 250 |             |             |                   |          |        |          |          |        |                            |
| 250     | 280 | + 0.016     | - 0.016     | - 0.0080          | - 0.0128 | 0.0048 | + 0.0160 | + 0.0112 | 0.0048 |                            |
| 280     | 315 |             |             |                   |          |        |          |          |        |                            |
| 315     | 355 | + 0.018     | - 0.018     | - 0.0091          | - 0.0145 | 0.0054 | + 0.0180 | + 0.0126 | 0.0054 |                            |
| 355     | 400 |             |             |                   |          |        |          |          |        |                            |
| 400     | 450 | + 0.020     | - 0.020     | - 0.0100          | - 0.0160 | 0.0060 | + 0.0200 | + 0.0140 | 0.0060 |                            |
| 450     | 500 |             |             |                   |          |        |          |          |        |                            |

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表28 Js 7孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                            |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                            |
| —       | 3   | + 0.005     | - 0.005     | - 0.0028          | - 0.0040 | 0.0012 | + 0.0050 | + 0.0038 | 0.0012 | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| 3       | 6   | + 0.006     | - 0.006     | - 0.0033          | - 0.0047 | 0.0014 | + 0.0060 | + 0.0046 | 0.0014 |                            |
| 6       | 10  | + 0.007     | - 0.007     | - 0.0037          | - 0.0055 | 0.0018 | + 0.0070 | + 0.0052 | 0.0018 |                            |
| 10      | 14  | + 0.009     | - 0.009     | - 0.0052          | - 0.0072 | 0.0020 | + 0.0090 | + 0.0070 | 0.0020 |                            |
| 14      | 18  |             |             |                   |          |        |          |          |        |                            |
| 18      | 24  | + 0.010     | - 0.010     | - 0.0054          | - 0.0078 | 0.0024 | + 0.0100 | + 0.0076 | 0.0024 |                            |
| 24      | 30  |             |             |                   |          |        |          |          |        |                            |
| 30      | 40  | + 0.012     | - 0.012     | 0.0065            | 0.0095   | 0.0030 | + 0.0120 | + 0.0090 | 0.0030 |                            |
| 40      | 50  |             |             |                   |          |        |          |          |        |                            |
| 50      | 65  | + 0.015     | - 0.015     | - 0.0086          | - 0.0122 | 0.0036 | + 0.0150 | + 0.0114 | 0.0036 |                            |
| 65      | 80  |             |             |                   |          |        |          |          |        |                            |
| 80      | 100 | + 0.017     | - 0.017     | - 0.0095          | - 0.0137 | 0.0042 | + 0.0170 | + 0.0128 | 0.0042 |                            |
| 100     | 120 |             |             |                   |          |        |          |          |        |                            |
| 120     | 140 | + 0.020     | - 0.020     | - 0.0116          | - 0.0164 | 0.0048 | + 0.0200 | + 0.0152 | 0.0048 |                            |
| 140     | 160 |             |             |                   |          |        |          |          |        |                            |
| 160     | 180 |             |             |                   |          |        |          |          |        |                            |
| 180     | 200 | + 0.023     | - 0.023     | - 0.0133          | - 0.0187 | 0.0054 | + 0.0230 | + 0.0176 | 0.0054 |                            |
| 200     | 225 |             |             |                   |          |        |          |          |        |                            |
| 225     | 250 |             |             |                   |          |        |          |          |        |                            |
| 250     | 280 | + 0.026     | 0.026       | 0.0150            | 0.0210   | 0.0060 | + 0.0260 | + 0.0200 | 0.0060 |                            |
| 280     | 315 |             |             |                   |          |        |          |          |        |                            |
| 315     | 355 | + 0.028     | - 0.028     | - 0.0155          | - 0.0225 | 0.0070 | + 0.0280 | + 0.0210 | 0.0070 |                            |
| 355     | 400 |             |             |                   |          |        |          |          |        |                            |
| 400     | 450 | + 0.031     | 0.031       | - 0.0170          | - 0.0250 | 0.0080 | + 0.0310 | + 0.0230 | 0.0080 |                            |
| 450     | 450 |             |             |                   |          |        |          |          |        |                            |

表29 K6孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限       |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                      |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                      |
| 大 户     | 至   | ES          | EI          | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    | 为最大实体尺寸「即孔的最小极限偏差」尺寸 |
|         | 3   | 0           | - 0.006     | - 0.0045          | - 0.0055 | 0.0010 | 0        | - 0.0010 | 0.0010 |                      |
| 3       | 6   | + 0.002     | - 0.006     | - 0.0040          | - 0.0052 | 0.0012 | + 0.0020 | + 0.0008 | 0.0012 |                      |
| 6       | 10  | + 0.002     | - 0.007     | - 0.0047          | - 0.0061 | 0.0014 | + 0.0020 | + 0.0006 | 0.0014 |                      |
| 10      | 14  | + 0.002     | - 0.009     | - 0.0062          | - 0.0078 | 0.0016 | + 0.0020 | + 0.0004 | 0.0016 |                      |
| 14      | 18  |             |             |                   |          |        |          |          |        |                      |
| 18      | 24  | + 0.002     | - 0.011     | - 0.0076          | - 0.0096 | 0.0020 | + 0.0020 | 0        | 0.0020 |                      |
| 24      | 30  |             |             |                   |          |        |          |          |        |                      |
| 30      | 40  | + 0.003     | - 0.013     | - 0.0090          | - 0.0114 | 0.0024 | + 0.0030 | + 0.0006 | 0.0024 |                      |
| 40      | 50  |             |             |                   |          |        |          |          |        |                      |
| 50      | 65  | + 0.004     | 0.015       | 0.0102            | 0.0130   | 0.0028 | + 0.0040 | + 0.0012 | 0.0028 |                      |
| 65      | 80  |             |             |                   |          |        |          |          |        |                      |
| 80      | 100 | + 0.004     | - 0.018     | - 0.0126          | - 0.0158 | 0.0032 | + 0.0040 | + 0.0008 | 0.0032 |                      |
| 100     | 120 |             |             |                   |          |        |          |          |        |                      |
| 120     | 140 | + 0.004     | - 0.021     | - 0.0147          | - 0.0185 | 0.0038 | + 0.0040 | + 0.0002 | 0.0038 |                      |
| 140     | 160 |             |             |                   |          |        |          |          |        |                      |
| 160     | 180 | + 0.005     | - 0.024     | - 0.0168          | - 0.0212 | 0.0044 | + 0.0050 | + 0.0006 | 0.0044 |                      |
| 180     | 200 |             |             |                   |          |        |          |          |        |                      |
| 200     | 225 |             |             |                   |          |        |          |          |        |                      |
| 225     | 250 |             |             |                   |          |        |          |          |        |                      |
| 250     | 280 | + 0.005     | - 0.027     | - 0.0190          | - 0.0238 | 0.0048 | + 0.0050 | + 0.0002 | 0.0048 |                      |
| 280     | 315 |             |             |                   |          |        |          |          |        |                      |
| 315     | 355 | + 0.007     | - 0.029     | - 0.0201          | - 0.0255 | 0.0054 | + 0.0070 | + 0.0016 | 0.0054 |                      |
| 355     | 400 |             |             |                   |          |        |          |          |        |                      |
| 400     | 450 | + 0.008     | - 0.032     | - 0.0220          | - 0.0280 | 0.0060 | + 0.0080 | + 0.0020 | 0.0060 |                      |
| 450     | 500 |             |             |                   |          |        |          |          |        |                      |

表30 K7孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差 |        | 量 规 极 限 偏 差 及 公 差 |         |        |         |         |        | 通规<br>磨损<br>极限 |
|---------|-----|-----------|--------|-------------------|---------|--------|---------|---------|--------|----------------|
|         |     | 上 偏 差     | 下 偏 差  | 通 规               |         |        | 止 规     |         |        |                |
| 大 于     | 至   | ES        | EI     | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    |                |
| —       | 3   | 0         | -0.010 | -0.0078           | -0.0090 | 0.0012 | 0       | -0.0012 | 0.0012 |                |
| 3       | 6   | +0.003    | -0.009 | -0.0063           | -0.0077 | 0.0014 | +0.0030 | +0.0016 | 0.0014 |                |
| 6       | 10  | +0.005    | -0.010 | -0.0067           | -0.0085 | 0.0018 | +0.0050 | +0.0032 | 0.0018 |                |
| 10      | 14  | +0.006    | -0.012 | -0.0082           | -0.0102 | 0.0020 | +0.0060 | +0.0040 | 0.0020 |                |
| 14      | 18  |           |        |                   |         |        |         |         |        |                |
| 18      | 24  | +0.006    | -0.015 | -0.0104           | -0.0128 | 0.0024 | +0.0060 | +0.0036 | 0.0024 |                |
| 24      | 30  |           |        |                   |         |        |         |         |        |                |
| 30      | 40  | +0.007    | -0.018 | -0.0125           | -0.0155 | 0.0030 | +0.0070 | +0.0040 | 0.0030 |                |
| 40      | 50  |           |        |                   |         |        |         |         |        |                |
| 50      | 65  | +0.009    | -0.021 | -0.0146           | -0.0182 | 0.0036 | +0.0090 | +0.0054 | 0.0036 |                |
| 65      | 80  |           |        |                   |         |        |         |         |        |                |
| 80      | 100 | +0.010    | -0.025 | -0.0175           | -0.0217 | 0.0042 | +0.0100 | +0.0058 | 0.0042 |                |
| 100     | 120 |           |        |                   |         |        |         |         |        |                |
| 120     | 140 | +0.012    | -0.028 | -0.0196           | -0.0244 | 0.0048 | +0.0120 | +0.0072 | 0.0048 |                |
| 140     | 160 |           |        |                   |         |        |         |         |        |                |
| 160     | 180 | +0.013    | -0.033 | -0.0233           | -0.0287 | 0.0054 | +0.0130 | +0.0076 | 0.0054 |                |
| 180     | 200 |           |        |                   |         |        |         |         |        |                |
| 200     | 225 | +0.016    | -0.036 | -0.0250           | -0.0310 | 0.0060 | +0.0160 | +0.0100 | 0.0060 |                |
| 225     | 250 |           |        |                   |         |        |         |         |        |                |
| 250     | 280 | +0.017    | -0.040 | -0.0275           | -0.0345 | 0.0070 | +0.0170 | +0.0100 | 0.0070 |                |
| 280     | 315 |           |        |                   |         |        |         |         |        |                |
| 315     | 355 | +0.018    | -0.045 | -0.0310           | -0.0390 | 0.0080 | +0.0180 | +0.0100 | 0.0080 |                |
| 355     | 400 |           |        |                   |         |        |         |         |        |                |
| 400     | 450 | +0.018    | -0.045 | -0.0310           | -0.0390 | 0.0080 | +0.0180 | +0.0100 | 0.0080 |                |
| 450     | 500 |           |        |                   |         |        |         |         |        |                |

为最大实体尺寸「即孔的最小极限尺寸」

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表31 M 6 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |         |        |         |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|---------|--------|---------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |         |        | 止 规     |          |        |                            |
|         |     |             |             | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差      | 公 差    |                            |
| 大 于     | 至   |             |             |                   |         |        |         |          |        | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | -0.002      | -0.008      | -0.0065           | -0.0075 | 0.0010 | -0.0020 | -0.00030 | 0.0010 |                            |
| 3       | 6   | -0.001      | -0.009      | -0.0070           | -0.0082 | 0.0012 | -0.0010 | -0.00020 | 0.0012 |                            |
| 6       | 10  | -0.003      | -0.012      | -0.0097           | -0.0111 | 0.0014 | -0.0030 | -0.00044 | 0.0014 |                            |
| 10      | 14  | -0.004      | -0.015      | -0.0122           | -0.0138 | 0.0016 | -0.0040 | -0.0056  | 0.0016 |                            |
| 14      | 18  |             |             |                   |         |        |         |          |        |                            |
| 18      | 24  | -0.004      | -0.017      | -0.0136           | -0.0156 | 0.0020 | -0.0040 | -0.0060  | 0.0020 |                            |
| 24      | 30  | -0.004      | -0.020      | -0.0160           | -0.0184 | 0.0024 | -0.0040 | -0.0064  | 0.0024 |                            |
| 30      | 40  |             |             |                   |         |        |         |          |        |                            |
| 40      | 50  | -0.005      | -0.024      | -0.0192           | -0.0220 | 0.0028 | -0.0050 | -0.0078  | 0.0028 |                            |
| 50      | 65  |             |             |                   |         |        |         |          |        |                            |
| 65      | 80  | -0.006      | -0.028      | -0.0226           | -0.0258 | 0.0032 | -0.0060 | -0.0092  | 0.0032 |                            |
| 80      | 100 |             |             |                   |         |        |         |          |        |                            |
| 100     | 120 | -0.008      | -0.033      | -0.0267           | -0.0305 | 0.0038 | -0.0080 | -0.0118  | 0.0038 |                            |
| 120     | 140 |             |             |                   |         |        |         |          |        |                            |
| 140     | 160 |             |             |                   |         |        |         |          |        |                            |
| 160     | 180 | -0.008      | -0.037      | -0.0298           | -0.0342 | 0.0044 | -0.0080 | -0.0124  | 0.0044 |                            |
| 180     | 200 |             |             |                   |         |        |         |          |        |                            |
| 200     | 225 |             |             |                   |         |        |         |          |        |                            |
| 225     | 250 |             |             |                   |         |        |         |          |        |                            |
| 250     | 280 | -0.009      | -0.041      | -0.0330           | -0.0378 | 0.0048 | -0.0090 | -0.0138  | 0.0048 |                            |
| 280     | 315 |             |             |                   |         |        |         |          |        |                            |
| 315     | 355 | -0.010      | -0.044      | -0.0371           | -0.0425 | 0.0054 | -0.0100 | -0.0154  | 0.0054 |                            |
| 355     | 400 |             |             |                   |         |        |         |          |        |                            |
| 400     | 450 | -0.010      | -0.050      | -0.0400           | -0.0460 | 0.0060 | -0.0100 | -0.0160  | 0.0060 |                            |
| 450     | 500 |             |             |                   |         |        |         |          |        |                            |

表32 M 7孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |         |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|---------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规     |          |        |                            |
| 大 于     | 至   |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差     | 下偏差      | 公 差    | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | - 0.002     | - 0.012     | - 0.0098          | - 0.0110 | 0.0012 | - 0.002 | - 0.0032 | 0.0012 |                            |
| 3       | 6   | 0           | - 0.012     | - 0.0093          | - 0.0107 | 0.0014 | 0       | - 0.0014 | 0.0014 |                            |
| 6       | 10  | 0           | - 0.015     | - 0.0117          | - 0.0135 | 0.0018 | 0       | - 0.0018 | 0.0018 |                            |
| 10      | 14  | 0           | - 0.018     | - 0.0142          | - 0.0102 | 0.0020 | 0       | - 0.0020 | 0.0020 |                            |
| 14      | 18  |             |             |                   |          |        |         |          |        |                            |
| 18      | 24  | 0           | - 0.021     | - 0.0164          | - 0.0188 | 0.0024 | 0       | - 0.0024 | 0.0024 |                            |
| 24      | 30  |             |             |                   |          |        |         |          |        |                            |
| 30      | 40  | 0           | - 0.025     | - 0.0195          | - 0.0225 | 0.0030 | 0       | - 0.0030 | 0.0030 |                            |
| 40      | 50  |             |             |                   |          |        |         |          |        |                            |
| 50      | 65  | 0           | - 0.030     | - 0.0236          | - 0.0272 | 0.0036 | 0       | - 0.0036 | 0.0036 |                            |
| 65      | 80  |             |             |                   |          |        |         |          |        |                            |
| 80      | 100 | 0           | - 0.035     | - 0.0275          | - 0.0317 | 0.0042 | 0       | - 0.0042 | 0.0042 |                            |
| 100     | 120 |             |             |                   |          |        |         |          |        |                            |
| 120     | 140 | 0           | - 0.040     | - 0.0316          | - 0.0364 | 0.0043 | 0       | 0.0048   | 0.0048 |                            |
| 140     | 160 |             |             |                   |          |        |         |          |        |                            |
| 160     | 180 | 0           | - 0.046     | - 0.0363          | - 0.0417 | 0.0054 | 0       | 0.0054   | 0.0054 |                            |
| 180     | 200 |             |             |                   |          |        |         |          |        |                            |
| 200     | 225 | 0           | 0.052       | 0.0410            | 0.0470   | 0.0060 | 0       | 0.0060   | 0.0060 |                            |
| 225     | 250 |             |             |                   |          |        |         |          |        |                            |
| 250     | 280 | 0           | - 0.057     | - 0.0445          | - 0.0515 | 0.0070 | 0       | - 0.0070 | 0.0070 |                            |
| 280     | 315 |             |             |                   |          |        |         |          |        |                            |
| 315     | 355 | 0           | - 0.063     | - 0.0490          | - 0.0570 | 0.0080 | 0       | - 0.0080 | 0.0080 |                            |
| 355     | 400 |             |             |                   |          |        |         |          |        |                            |
| 400     | 450 | 0           |             |                   |          |        |         |          |        |                            |
| 450     | 500 |             |             |                   |          |        |         |          |        |                            |

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表33 M 8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差 量 规 极 限 偏 差 及 公 差 |             |          |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-----------------------------|-------------|----------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES                 | 下 偏 差<br>EI | 通 规      |          |        | 止 规      |          |        |                            |
|         |     |                             |             | 上偏差      | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                            |
| 大 于     | 至   |                             |             |          |          |        |          |          |        |                            |
| --      | 3   | - 0.002                     | - 0.016     | - 0.0132 | - 0.0148 | 0.0016 | - 0.0020 | - 0.0036 | 0.0016 | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| 3       | 6   | + 0.002                     | - 0.016     | - 0.0124 | - 0.0144 | 0.0020 | + 0.0020 | 0        | 0.0020 |                            |
| 6       | 10  | + 0.001                     | - 0.021     | - 0.0166 | - 0.0190 | 0.0024 | + 0.0010 | - 0.0014 | 0.0024 |                            |
| 10      | 14  | + 0.002                     | - 0.025     | - 0.0196 | - 0.0224 | 0.0028 | + 0.0020 | - 0.0008 | 0.0028 |                            |
| 14      | 18  |                             |             |          |          |        |          |          |        |                            |
| 18      | 24  | + 0.004                     | - 0.029     | - 0.0223 | - 0.0257 | 0.0034 | + 0.0040 | + 0.0006 | 0.0034 |                            |
| 24      | 30  |                             |             |          |          |        |          |          |        |                            |
| 30      | 40  | + 0.005                     | - 0.034     | - 0.0260 | - 0.0300 | 0.0040 | + 0.0050 | + 0.0010 | 0.0040 |                            |
| 40      | 50  |                             |             |          |          |        |          |          |        |                            |
| 50      | 65  | + 0.005                     | - 0.041     | - 0.0317 | - 0.0363 | 0.0046 | + 0.0050 | + 0.0004 | 0.0046 |                            |
| 65      | 80  |                             |             |          |          |        |          |          |        |                            |
| 80      | 100 | + 0.006                     | - 0.048     | - 0.0373 | - 0.0427 | 0.0054 | + 0.0060 | + 0.0006 | 0.0054 |                            |
| 100     | 120 |                             |             |          |          |        |          |          |        |                            |
| 120     | 140 | + 0.008                     | - 0.055     | - 0.0430 | - 0.0490 | 0.0060 | + 0.0080 | + 0.0020 | 0.0060 |                            |
| 140     | 160 |                             |             |          |          |        |          |          |        |                            |
| 160     | 180 | + 0.009                     | - 0.063     | - 0.0495 | - 0.0565 | 0.0070 | + 0.0090 | + 0.0020 | 0.0070 |                            |
| 180     | 200 |                             |             |          |          |        |          |          |        |                            |
| 200     | 225 | + 0.009                     | - 0.072     | - 0.0570 | - 0.0650 | 0.0080 | + 0.0090 | + 0.0010 | 0.0080 |                            |
| 225     | 255 |                             |             |          |          |        |          |          |        |                            |
| 250     | 280 | + 0.011                     | - 0.078     | - 0.0615 | - 0.0705 | 0.0090 | + 0.0110 | + 0.0020 | 0.0090 |                            |
| 280     | 310 |                             |             |          |          |        |          |          |        |                            |
| 315     | 355 | + 0.011                     | - 0.086     | - 0.0670 | - 0.0770 | 0.0100 | + 0.0110 | + 0.0010 | 0.0100 |                            |
| 355     | 400 |                             |             |          |          |        |          |          |        |                            |
| 400     | 450 | + 0.011                     | - 0.086     | - 0.0670 | - 0.0770 | 0.0100 | + 0.0110 | + 0.0010 | 0.0100 |                            |
| 450     | 500 |                             |             |          |          |        |          |          |        |                            |

表34 N 6 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |         |        |         |         |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|---------|--------|---------|---------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |         |        | 止 规     |         |        |                            |
|         |     |             |             | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    |                            |
| 大 于     | 至   |             |             |                   |         |        |         |         |        | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | -0.004      | -0.010      | -0.0085           | -0.0095 | 0.0010 | -0.0040 | -0.0050 | 0.0010 |                            |
| 3       | 6   | -0.005      | -0.013      | -0.0110           | -0.0122 | 0.0012 | -0.0050 | -0.0062 | 0.0012 |                            |
| 6       | 10  | -0.007      | -0.016      | -0.0137           | -0.0151 | 0.0014 | -0.0070 | -0.0084 | 0.0014 |                            |
| 10      | 14  | -0.009      | -0.020      | -0.0172           | -0.0188 | 0.0016 | -0.0090 | -0.0106 | 0.0016 |                            |
| 14      | 18  |             |             |                   |         |        |         |         |        |                            |
| 18      | 24  | -0.011      | -0.024      | 0.0206            | 0.0226  | 0.0020 | -0.0110 | -0.0130 | 0.0020 |                            |
| 24      | 30  |             |             |                   |         |        |         |         |        |                            |
| 30      | 40  | -0.012      | -0.028      | -0.0240           | -0.0264 | 0.0024 | -0.0120 | -0.0144 | 0.0024 |                            |
| 40      | 50  |             |             |                   |         |        |         |         |        |                            |
| 50      | 65  | 0.014       | 0.033       | 0.0282            | 0.0310  | 0.0028 | 0.0140  | 0.0168  | 0.0028 |                            |
| 65      | 80  |             |             |                   |         |        |         |         |        |                            |
| 80      | 100 | 0.016       | 0.038       | -0.0326           | -0.0358 | 0.0032 | 0.0160  | -0.0192 | 0.0032 |                            |
| 100     | 120 |             |             |                   |         |        |         |         |        |                            |
| 120     | 140 | -0.020      | 0.045       | -0.0387           | -0.0425 | 0.0038 | -0.0200 | -0.0238 | 0.0038 |                            |
| 140     | 160 |             |             |                   |         |        |         |         |        |                            |
| 160     | 180 | 0.022       | -0.051      | -0.0438           | 0.0482  | 0.0044 | -0.0220 | -0.0264 | 0.0044 |                            |
| 180     | 200 |             |             |                   |         |        |         |         |        |                            |
| 200     | 225 |             |             |                   |         |        |         |         |        |                            |
| 225     | 250 |             |             |                   |         |        |         |         |        |                            |
| 250     | 280 | -0.025      | -0.057      | -0.0490           | -0.0538 | 0.0048 | -0.0250 | -0.0298 | 0.0048 |                            |
| 280     | 315 |             |             |                   |         |        |         |         |        |                            |
| 315     | 355 | -0.026      | -0.062      | -0.0531           | -0.0585 | 0.0054 | -0.0260 | -0.0314 | 0.0054 |                            |
| 355     | 400 |             |             |                   |         |        |         |         |        |                            |
| 400     | 450 | -0.027      | -0.067      | -0.0570           | -0.0630 | 0.0060 | -0.0270 | -0.0330 | 0.0060 |                            |
| 450     | 500 |             |             |                   |         |        |         |         |        |                            |

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表35 N7孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                            |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                            |
| —       | 3   | - 0.004     | - 0.014     | - 0.0118          | - 0.0130 | 0.0012 | - 0.0040 | - 0.0052 | 0.0012 | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| 3       | 6   | - 0.004     | - 0.016     | - 0.0133          | - 0.0147 | 0.0014 | - 0.0040 | - 0.0054 | 0.0014 |                            |
| 6       | 10  | - 0.004     | - 0.019     | - 0.0157          | - 0.0175 | 0.0018 | - 0.0040 | - 0.0058 | 0.0018 |                            |
| 10      | 14  | - 0.005     | - 0.023     | - 0.0192          | - 0.0212 | 0.0020 | - 0.0050 | - 0.0070 | 0.0020 |                            |
| 14      | 18  |             |             |                   |          |        |          |          |        |                            |
| 18      | 24  | - 0.007     | - 0.028     | - 0.0234          | - 0.0258 | 0.0024 | - 0.0070 | - 0.0094 | 0.0024 |                            |
| 24      | 30  |             |             |                   |          |        |          |          |        |                            |
| 30      | 40  | - 0.008     | - 0.033     | - 0.0275          | - 0.0305 | 0.0030 | - 0.0080 | - 0.0110 | 0.0030 |                            |
| 40      | 50  |             |             |                   |          |        |          |          |        |                            |
| 50      | 65  | - 0.009     | - 0.039     | - 0.0326          | - 0.0362 | 0.0036 | - 0.0090 | - 0.0126 | 0.0036 |                            |
| 65      | 80  |             |             |                   |          |        |          |          |        |                            |
| 80      | 100 | - 0.010     | - 0.045     | - 0.0375          | - 0.0417 | 0.0042 | - 0.0100 | - 0.0142 | 0.0042 |                            |
| 100     | 120 |             |             |                   |          |        |          |          |        |                            |
| 120     | 140 | - 0.012     | - 0.052     | - 0.0436          | - 0.0484 | 0.0048 | - 0.0120 | - 0.0668 | 0.0048 |                            |
| 140     | 160 |             |             |                   |          |        |          |          |        |                            |
| 160     | 180 |             |             |                   |          |        |          |          |        |                            |
| 180     | 200 | - 0.014     | - 0.060     | - 0.0503          | - 0.0557 | 0.0054 | - 0.0140 | - 0.0194 | 0.0054 |                            |
| 200     | 225 |             |             |                   |          |        |          |          |        |                            |
| 225     | 250 |             |             |                   |          |        |          |          |        |                            |
| 250     | 280 | - 0.014     | - 0.066     | - 0.0550          | - 0.0610 | 0.0060 | - 0.0140 | - 0.0200 | 0.0060 |                            |
| 280     | 315 |             |             |                   |          |        |          |          |        |                            |
| 315     | 355 | - 0.016     | - 0.073     | - 0.0605          | - 0.0675 | 0.0070 | - 0.0160 | - 0.0230 | 0.0070 |                            |
| 355     | 400 |             |             |                   |          |        |          |          |        |                            |
| 400     | 450 | - 0.017     | - 0.080     | - 0.0660          | - 0.0740 | 0.0080 | - 0.0170 | - 0.0250 | 0.0080 |                            |
| 450     | 500 |             |             |                   |          |        |          |          |        |                            |

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表36 N 8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差 |         | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限                     |
|---------|-----|-----------|---------|-------------------|----------|--------|----------|----------|--------|------------------------------------|
|         |     | 上 偏 差     | 下 偏 差   | 通 规               |          |        | 止 规      |          |        |                                    |
| 大 于     | 至   | ES        | EI      | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    | 为最大<br>实体尺寸<br>〔即孔的<br>最小极限<br>尺寸〕 |
| —       | 3   | - 0.004   | - 0.018 | - 0.0152          | - 0.0168 | 0.0016 | - 0.0040 | - 0.0056 | 0.0016 |                                    |
| 3       | 6   | - 0.002   | - 0.020 | - 0.0164          | - 0.0184 | 0.0020 | - 0.0020 | - 0.0040 | 0.0020 |                                    |
| 6       | 10  | - 0.003   | - 0.025 | - 0.0206          | - 0.0230 | 0.0024 | - 0.0030 | - 0.0054 | 0.0024 |                                    |
| 10      | 14  | - 0.003   | - 0.030 | - 0.0246          | - 0.0274 | 0.0028 | - 0.0030 | - 0.0058 | 0.0028 |                                    |
| 14      | 18  |           |         |                   |          |        |          |          |        |                                    |
| 18      | 24  | - 0.003   | - 0.036 | - 0.0293          | - 0.0327 | 0.0034 | - 0.0030 | - 0.0064 | 0.0034 |                                    |
| 24      | 30  |           |         |                   |          |        |          |          |        |                                    |
| 30      | 40  | - 0.003   | - 0.042 | - 0.0340          | - 0.0380 | 0.0040 | - 0.0030 | - 0.0070 | 0.0040 |                                    |
| 40      | 50  |           |         |                   |          |        |          |          |        |                                    |
| 50      | 65  | - 0.004   | - 0.050 | - 0.0407          | - 0.0453 | 0.0046 | - 0.0040 | - 0.0086 | 0.0046 |                                    |
| 65      | 80  |           |         |                   |          |        |          |          |        |                                    |
| 80      | 100 | - 0.004   | - 0.058 | - 0.0473          | - 0.0527 | 0.0054 | - 0.0040 | - 0.0094 | 0.0054 |                                    |
| 100     | 120 |           |         |                   |          |        |          |          |        |                                    |
| 120     | 140 | - 0.004   | - 0.067 | - 0.0550          | - 0.0610 | 0.0060 | - 0.0040 | - 0.0100 | 0.0060 |                                    |
| 140     | 160 |           |         |                   |          |        |          |          |        |                                    |
| 160     | 180 |           |         |                   |          |        |          |          |        |                                    |
| 180     | 200 | - 0.005   | - 0.077 | - 0.0635          | - 0.0705 | 0.0070 | - 0.0050 | - 0.0120 | 0.0070 |                                    |
| 200     | 225 |           |         |                   |          |        |          |          |        |                                    |
| 225     | 250 |           |         |                   |          |        |          |          |        |                                    |
| 250     | 280 | 0.005     | 0.086   | 0.0710            | 0.0790   | 0.0080 | 0.0050   | 0.0130   | 0.0080 |                                    |
| 280     | 315 |           |         |                   |          |        |          |          |        |                                    |
| 315     | 355 | - 0.005   | - 0.094 | - 0.0775          | - 0.0865 | 0.0090 | - 0.0050 | - 0.0140 | 0.0090 |                                    |
| 355     | 400 |           |         |                   |          |        |          |          |        |                                    |
| 400     | 450 | - 0.006   | - 0.103 | - 0.0840          | - 0.0940 | 0.0100 | - 0.0060 | - 0.0160 | 0.0100 |                                    |
| 450     | 500 |           |         |                   |          |        |          |          |        |                                    |

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表37 P 7 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |         |        |         |         |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|---------|--------|---------|---------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 量 规               |         |        | 止 规     |         |        |                            |
|         |     |             |             | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    |                            |
| 大 于     | 至   |             |             |                   |         |        |         |         |        | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | -0.006      | -0.016      | -0.0138           | -0.0150 | 0.0012 | -0.0060 | -0.0072 | 0.0012 |                            |
| 3       | 6   | -0.008      | -0.020      | -0.0173           | -0.0187 | 0.0014 | -0.0080 | -0.0094 | 0.0014 |                            |
| 6       | 10  | -0.009      | -0.024      | -0.0207           | -0.0225 | 0.0018 | -0.0090 | -0.0108 | 0.0018 |                            |
| 10      | 14  | -0.011      | -0.029      | -0.0252           | -0.0272 | 0.0020 | -0.0110 | -0.0130 | 0.0020 |                            |
| 14      | 18  |             |             |                   |         |        |         |         |        |                            |
| 18      | 24  | -0.014      | -0.035      | -0.0304           | -0.0328 | 0.0024 | -0.0140 | -0.0164 | 0.0024 |                            |
| 24      | 30  |             |             |                   |         |        |         |         |        |                            |
| 30      | 40  | -0.017      | -0.042      | -0.0365           | -0.0395 | 0.0030 | -0.0170 | -0.0200 | 0.0030 |                            |
| 40      | 50  |             |             |                   |         |        |         |         |        |                            |
| 50      | 65  | -0.021      | -0.051      | -0.0446           | -0.0482 | 0.0036 | -0.0210 | -0.0246 | 0.0036 |                            |
| 65      | 80  |             |             |                   |         |        |         |         |        |                            |
| 80      | 100 | -0.024      | -0.059      | -0.0515           | -0.0557 | 0.0042 | -0.0240 | -0.0282 | 0.0042 |                            |
| 100     | 120 |             |             |                   |         |        |         |         |        |                            |
| 120     | 140 | -0.028      | -0.068      | -0.0596           | -0.0644 | 0.0048 | -0.0280 | -0.0328 | 0.0038 |                            |
| 140     | 160 |             |             |                   |         |        |         |         |        |                            |
| 160     | 180 | -0.033      | -0.079      | -0.0693           | -0.0747 | 0.0054 | -0.0330 | -0.0384 | 0.0054 |                            |
| 180     | 200 |             |             |                   |         |        |         |         |        |                            |
| 200     | 225 |             |             |                   |         |        |         |         |        |                            |
| 225     | 250 |             |             |                   |         |        |         |         |        |                            |
| 250     | 280 | -0.036      | -0.088      | -0.0770           | -0.0830 | 0.0060 | -0.0360 | -0.0420 | 0.0060 |                            |
| 280     | 315 |             |             |                   |         |        |         |         |        |                            |
| 315     | 355 | -0.041      | -0.098      | -0.0855           | -0.0925 | 0.0070 | -0.0410 | -0.0480 | 0.0070 |                            |
| 355     | 400 |             |             |                   |         |        |         |         |        |                            |
| 400     | 450 | -0.045      | -0.108      | -0.0940           | -0.1020 | 0.0080 | -0.0450 | -0.0530 | 0.0080 |                            |
| 450     | 500 |             |             |                   |         |        |         |         |        |                            |

表38 R 7 孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |         |        |         |         |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|---------|--------|---------|---------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |         |        | 止 规     |         |        |                            |
|         |     |             |             | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    |                            |
| 大 于     | 至   |             |             |                   |         |        |         |         |        | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | -0.010      | -0.020      | -0.0178           | -0.0190 | 0.0012 | -0.0100 | -0.0112 | 0.0012 |                            |
| 3       | 6   | -0.011      | -0.023      | -0.0203           | -0.0217 | 0.0014 | -0.0110 | -0.0124 | 0.0014 |                            |
| 6       | 10  | -0.013      | -0.028      | -0.0247           | -0.0265 | 0.0018 | -0.0130 | -0.0148 | 0.0018 |                            |
| 10      | 14  | -0.016      | -0.034      | -0.0302           | -0.0322 | 0.0020 | -0.0160 | -0.0180 | 0.0020 |                            |
| 14      | 18  |             |             |                   |         |        |         |         |        |                            |
| 18      | 24  | -0.020      | -0.041      | -0.0364           | -0.0388 | 0.0024 | -0.0200 | -0.0224 | 0.0024 |                            |
| 24      | 30  |             |             |                   |         |        |         |         |        |                            |
| 30      | 40  | -0.025      | -0.050      | -0.0445           | -0.0475 | 0.0030 | -0.0250 | -0.0280 | 0.0030 |                            |
| 40      | 50  |             |             |                   |         |        |         |         |        |                            |
| 50      | 65  | -0.030      | -0.060      | -0.0536           | -0.0572 | 0.0036 | -0.0300 | -0.0336 | 0.0036 |                            |
| 65      | 80  | 0.032       | 0.062       | 0.0556            | 0.0592  | 0.0036 | 0.0320  | 0.0356  | 0.0036 |                            |
| 80      | 100 | -0.038      | -0.073      | -0.0655           | -0.0697 | 0.0042 | -0.0380 | -0.0422 | 0.0042 |                            |
| 100     | 120 | -0.041      | -0.076      | -0.0685           | -0.0727 | 0.0042 | -0.0410 | -0.0452 | 0.0042 |                            |
| 120     | 140 | -0.048      | -0.088      | -0.0796           | -0.0844 | 0.0048 | -0.0480 | -0.0528 | 0.0048 |                            |
| 140     | 160 | -0.050      | -0.090      | -0.0816           | -0.0864 | 0.0048 | -0.0500 | -0.0548 | 0.0048 |                            |
| 160     | 180 | -0.053      | -0.093      | -0.0846           | -0.0894 | 0.0048 | -0.0530 | -0.0578 | 0.0048 |                            |
| 180     | 200 | -0.060      | -0.106      | -0.0963           | -0.1017 | 0.0054 | -0.0600 | -0.0654 | 0.0054 |                            |
| 200     | 225 | -0.063      | -0.109      | -0.0993           | -0.1047 | 0.0054 | -0.0630 | -0.0684 | 0.0054 |                            |
| 225     | 250 | 0.067       | -0.113      | -0.1033           | -0.1087 | 0.0054 | 0.0670  | -0.0724 | 0.0054 |                            |
| 250     | 280 | 0.071       | 0.126       | 0.1150            | 0.1210  | 0.0060 | 0.0710  | 0.0800  | 0.0060 |                            |
| 280     | 315 | -0.078      | 0.130       | 0.1190            | 0.1250  | 0.0060 | -0.0780 | 0.0840  | 0.0060 |                            |
| 315     | 355 | -0.087      | -0.144      | -0.1315           | -0.1385 | 0.0070 | -0.0870 | -0.0940 | 0.0070 |                            |
| 355     | 400 | -0.093      | -0.150      | -0.1375           | -0.1445 | 0.0070 | -0.0930 | -0.1000 | 0.0070 |                            |
| 400     | 450 | -0.103      | -0.166      | -0.1520           | -0.1600 | 0.0080 | -0.1030 | -0.1110 | 0.0080 |                            |
| 450     | 500 | -0.109      | -0.172      | -0.1580           | -0.1660 | 0.0080 | -0.1090 | -0.1170 | 0.0080 |                            |

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表39 R 8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |         |        |         |         |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|---------|--------|---------|---------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |         |        | 止 规     |         |        |                            |
|         |     |             |             | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    |                            |
| 大 于     | 至   | ES          | EI          | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | -0.010      | -0.024      | -0.0212           | -0.0228 | 0.0016 | -0.0100 | -0.0116 | 0.0016 |                            |
| 3       | 6   | -0.015      | -0.033      | -0.0394           | -0.0314 | 0.0020 | -0.0150 | -0.0170 | 0.0020 |                            |
| 6       | 10  | -0.019      | -0.041      | -0.0366           | -0.0390 | 0.0024 | -0.0190 | -0.0214 | 0.0024 |                            |
| 10      | 14  | -0.023      | -0.050      | 0.0446            | 0.0474  | 0.0028 | 0.0230  | -0.0258 | 0.0028 |                            |
| 14      | 18  |             |             |                   |         |        |         |         |        |                            |
| 18      | 24  | -0.028      | -0.061      | -0.0543           | -0.0577 | 0.0034 | -0.0280 | -0.0314 | 0.0034 |                            |
| 24      | 30  |             |             |                   |         |        |         |         |        |                            |
| 30      | 40  | -0.034      | -0.073      | -0.0650           | -0.0690 | 0.0040 | -0.0340 | -0.0380 | 0.0040 |                            |
| 40      | 50  |             |             |                   |         |        |         |         |        |                            |
| 50      | 65  | -0.041      | -0.087      | -0.0777           | -0.0823 | 0.0046 | -0.0410 | -0.0456 | 0.0046 |                            |
| 65      | 80  | -0.043      | -0.089      | -0.0797           | -0.0843 | 0.0046 | -0.0430 | -0.0476 | 0.0046 |                            |
| 80      | 100 | -0.051      | -0.105      | -0.0943           | -0.0997 | 0.0054 | -0.0510 | -0.0564 | 0.0054 |                            |
| 100     | 120 | -0.054      | -0.108      | -0.0973           | -0.1027 | 0.0054 | -0.0540 | -0.0594 | 0.0054 |                            |
| 120     | 140 | -0.063      | -0.126      | -0.1140           | -0.1200 | 0.0060 | -0.0630 | -0.0690 | 0.0060 |                            |
| 140     | 160 | -0.065      | -0.128      | -0.1160           | -0.1220 | 0.0060 | -0.0650 | -0.0710 | 0.0060 |                            |
| 160     | 180 | -0.068      | -0.131      | -0.1190           | -0.1250 | 0.0060 | -0.0680 | -0.0740 | 0.0060 |                            |
| 180     | 200 | -0.077      | -0.149      | -0.1355           | -0.1425 | 0.0070 | -0.0770 | -0.0840 | 0.0070 |                            |
| 200     | 225 | -0.080      | -0.152      | -0.1385           | -0.1455 | 0.0070 | -0.0800 | -0.0870 | 0.0070 |                            |
| 225     | 250 | -0.084      | -0.156      | -0.1425           | -0.1495 | 0.0070 | -0.0840 | -0.0910 | 0.0070 |                            |
| 250     | 280 | -0.094      | -0.175      | -0.1600           | -0.1680 | 0.0080 | -0.0940 | -0.1020 | 0.0080 |                            |
| 280     | 315 | -0.098      | -0.179      | -0.1640           | -0.1720 | 0.0080 | -0.0980 | -0.1060 | 0.0080 |                            |
| 315     | 355 | -0.108      | -0.197      | -0.1805           | -0.1895 | 0.0090 | -0.1080 | -0.1170 | 0.0090 |                            |
| 355     | 400 | -0.114      | -0.203      | -0.1865           | -0.1955 | 0.0090 | -0.1140 | -0.1230 | 0.0090 |                            |
| 400     | 450 | -0.126      | -0.223      | -0.2040           | -0.2040 | 0.0100 | -0.1260 | -0.1360 | 0.0100 |                            |
| 450     | 500 | -0.132      | -0.229      | -0.2100           | -0.2200 | 0.0100 | -0.1320 | -0.1420 | 0.0100 |                            |

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表 7 孔用量规应用尺寸

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通 规<br>磨 损 极 限                      |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|-------------------------------------|
|         |     | 上 偏 差<br>ES | 上 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                                     |
|         |     |             |             | 上 偏 差             | 下 偏 差    | 公 差    | 上 偏 差    | 下 偏 差    | 公 差    |                                     |
| 大 于     | 至   |             |             |                   |          |        |          |          |        |                                     |
| —       | 3   | - 0.014     | - 0.024     | - 0.0218          | - 0.0230 | 0.0012 | - 0.0140 | - 0.0152 | 0.0012 | 为 最 大 实 体 尺 寸 「 即 孔 的 最 小 极 限 尺 寸 」 |
| 3       | 6   | - 0.015     | - 0.027     | - 0.0243          | - 0.0257 | 0.0014 | - 0.0150 | - 0.0164 | 0.0014 |                                     |
| 6       | 10  | - 0.017     | - 0.032     | - 0.0287          | - 0.0305 | 0.0018 | - 0.0170 | - 0.0188 | 0.0018 |                                     |
| 10      | 14  | - 0.021     | - 0.039     | - 0.0352          | - 0.0372 | 0.0020 | - 0.0210 | - 0.0230 | 0.0020 |                                     |
| 14      | 18  |             |             |                   |          |        |          |          |        |                                     |
| 18      | 24  | - 0.027     | - 0.048     | - 0.0434          | - 0.0458 | 0.0024 | - 0.0270 | - 0.0294 | 0.0024 |                                     |
| 24      | 30  |             |             |                   |          |        |          |          |        |                                     |
| 30      | 40  | - 0.034     | - 0.059     | - 0.0535          | - 0.0565 | 0.0030 | - 0.0340 | - 0.0370 | 0.0030 |                                     |
| 40      | 50  |             |             |                   |          |        |          |          |        |                                     |
| 50      | 65  | - 0.042     | - 0.072     | - 0.0656          | - 0.0692 | 0.0036 | - 0.0420 | - 0.0456 | 0.0036 |                                     |
| 65      | 80  | - 0.048     | - 0.078     | - 0.0716          | - 0.0752 | 0.0036 | - 0.0480 | - 0.0516 | 0.0036 |                                     |
| 80      | 100 | - 0.058     | - 0.093     | - 0.0855          | - 0.0897 | 0.0042 | - 0.0580 | - 0.0622 | 0.0042 |                                     |
| 100     | 120 | - 0.066     | - 0.101     | - 0.0935          | - 0.0977 | 0.0042 | - 0.0660 | - 0.0702 | 0.0042 |                                     |
| 120     | 140 | - 0.077     | - 0.117     | - 0.1086          | - 0.1134 | 0.0048 | - 0.0770 | - 0.0818 | 0.0048 |                                     |
| 140     | 160 | - 0.085     | - 0.125     | - 0.1146          | - 0.1214 | 0.0048 | - 0.0850 | - 0.0898 | 0.0048 |                                     |
| 160     | 180 | - 0.093     | - 0.133     | - 0.1246          | - 0.1294 | 0.0048 | - 0.0930 | - 0.0978 | 0.0048 |                                     |
| 180     | 200 | - 0.105     | - 0.151     | - 0.1413          | - 0.1467 | 0.0054 | - 0.1050 | - 0.1104 | 0.0054 |                                     |
| 200     | 225 | - 0.113     | - 0.159     | - 0.1493          | - 0.1547 | 0.0054 | - 0.1130 | - 0.1184 | 0.0054 |                                     |
| 225     | 250 | - 0.123     | - 0.169     | - 0.1593          | - 0.1647 | 0.0054 | - 0.1230 | - 0.1284 | 0.0054 |                                     |
| 250     | 280 | 0.138       | 0.190       | 0.1790            | 0.1850   | 0.0060 | 0.1380   | 0.1440   | 0.0060 |                                     |
| 280     | 315 | 0.150       | 0.202       | 0.1910            | 0.1970   | 0.0060 | 0.1500   | 0.1560   | 0.0060 |                                     |
| 315     | 355 | - 0.169     | - 0.226     | - 0.2135          | - 0.2205 | 0.0070 | - 0.1690 | - 0.1760 | 0.0070 |                                     |
| 355     | 400 | - 0.187     | - 0.244     | - 0.2315          | - 0.2385 | 0.0070 | - 0.1870 | - 0.1940 | 0.0070 |                                     |
| 400     | 450 | - 0.209     | - 0.272     | - 0.2580          | - 0.2660 | 0.0080 | - 0.2090 | - 0.2170 | 0.0080 |                                     |
| 450     | 500 | - 0.229     | - 0.292     | - 0.2780          | - 0.2880 | 0.0080 | - 0.2290 | - 0.2370 | 0.0080 |                                     |

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表41 U7孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |         |        |         |         |        | 通规<br>磨损<br>极限   |
|---------|-----|-------------|-------------|-------------------|---------|--------|---------|---------|--------|--|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |         |        | 止 规     |         |        |  |
| 大 于     | 至   |             |             | 上偏差               | 下偏差     | 公 差    | 上偏差     | 下偏差     | 公 差    | 为<br>最<br>大<br>实<br>体<br>尺<br>寸<br>「<br>即<br>孔<br>的<br>最<br>小<br>极<br>限<br>尺<br>寸<br>」 |
| —       | 3   | -0.018      | -0.028      | -0.0258           | -0.0270 | 0.0012 | -0.0180 | -0.0192 | 0.0012 |  |
| 3       | 6   | -0.019      | -0.031      | -0.0283           | -0.0297 | 0.0014 | -0.0190 | -0.0204 | 0.0014 |  |
| 6       | 10  | -0.022      | -0.037      | -0.0337           | -0.0355 | 0.0018 | -0.0220 | -0.0238 | 0.0018 |  |
| 10      | 14  | -0.026      | -0.044      | -0.0402           | -0.0422 | 0.0020 | -0.0260 | -0.0280 | 0.0020 |  |
| 14      | 18  |             |             |                   |         |        |         |         |        |  |
| 18      | 24  | -0.033      | -0.054      | -0.0494           | -0.0518 | 0.0024 | -0.0330 | -0.0354 | 0.0024 |  |
| 24      | 30  | -0.040      | -0.061      | -0.0564           | -0.0588 | 0.0024 | -0.0400 | -0.0424 | 0.0024 |  |
| 30      | 40  | -0.051      | -0.076      | -0.0705           | -0.0735 | 0.0030 | -0.0510 | -0.0540 | 0.0030 |  |
| 40      | 50  | -0.061      | -0.086      | -0.0805           | -0.0835 | 0.0030 | -0.0610 | -0.0640 | 0.0030 |  |
| 50      | 65  | -0.076      | -0.106      | -0.0996           | -0.1032 | 0.0036 | -0.0760 | -0.0796 | 0.0036 |  |
| 65      | 80  | -0.091      | -0.121      | -0.1146           | -0.1182 | 0.0036 | -0.0910 | -0.0946 | 0.0036 |  |
| 80      | 100 | -0.111      | -0.146      | -0.1385           | -0.1427 | 0.0042 | -0.1110 | -0.1152 | 0.0042 |  |
| 100     | 120 | -0.131      | -0.166      | -0.1585           | -0.1627 | 0.0042 | -0.1310 | -0.1352 | 0.0042 |  |
| 120     | 140 | -0.155      | -0.195      | -0.1866           | -0.1914 | 0.0048 | -0.1550 | -0.1598 | 0.0048 |  |
| 140     | 160 | -0.175      | -0.215      | -0.2066           | -0.2114 | 0.0048 | -0.1750 | -0.1798 | 0.0048 |  |
| 160     | 180 | -0.195      | -0.235      | -0.2266           | -0.2314 | 0.0048 | -0.1950 | -0.1998 | 0.0048 |  |
| 180     | 200 | -0.219      | -0.265      | -0.2553           | -0.2607 | 0.0054 | -0.2190 | -0.2244 | 0.0054 |  |
| 200     | 225 | -0.241      | -0.287      | -0.2773           | -0.2827 | 0.0054 | -0.2410 | -0.2464 | 0.0054 |  |
| 225     | 250 | -0.267      | -0.313      | -0.3033           | -0.3087 | 0.0054 | -0.2670 | -0.2724 | 0.0054 |  |
| 250     | 280 | -0.295      | -0.347      | -0.3360           | -0.3420 | 0.0060 | -0.2950 | -0.3010 | 0.0060 |  |
| 280     | 315 | -0.330      | -0.382      | -0.3710           | -0.3770 | 0.0060 | -0.3300 | -0.3360 | 0.0060 |  |
| 315     | 355 | -0.369      | -0.428      | -0.4185           | -0.4205 | 0.0070 | -0.3690 | -0.3760 | 0.0070 |  |
| 355     | 400 | -0.414      | -0.471      | -0.4585           | -0.4655 | 0.0070 | -0.4140 | -0.4210 | 0.0070 |  |
| 400     | 450 | -0.467      | -0.530      | -0.5160           | -0.5240 | 0.0080 | -0.4670 | -0.4750 | 0.0080 |  |
| 450     | 500 | -0.517      | -0.580      | -0.5660           | -0.5740 | 0.0080 | -0.5170 | -0.5250 | 0.0080 |  |

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表42 U8孔用量规应用尺寸

mm

| 基 本 尺 寸 |     | 孔 极 限 偏 差   |             | 量 规 极 限 偏 差 及 公 差 |          |        |          |          |        | 通规<br>磨损<br>极限             |
|---------|-----|-------------|-------------|-------------------|----------|--------|----------|----------|--------|----------------------------|
|         |     | 上 偏 差<br>ES | 下 偏 差<br>EI | 通 规               |          |        | 止 规      |          |        |                            |
|         |     |             |             | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    |                            |
| 大 于     | 至   | ES          | EI          | 上偏差               | 下偏差      | 公 差    | 上偏差      | 下偏差      | 公 差    | 为最大<br>实体尺寸「即孔的<br>最小极限尺寸」 |
| —       | 3   | - 0.018     | - 0.032     | - 0.0292          | - 0.0308 | 0.0016 | - 0.0180 | - 0.0196 | 0.0016 |                            |
| 3       | 6   | - 0.023     | - 0.041     | - 0.0374          | - 0.0394 | 0.0020 | - 0.0230 | - 0.0250 | 0.0020 |                            |
| 6       | 10  | - 0.028     | - 0.050     | - 0.0456          | - 0.0480 | 0.0024 | - 0.0280 | - 0.0304 | 0.0024 |                            |
| 10      | 14  | - 0.033     | - 0.060     | - 0.0546          | - 0.0574 | 0.0028 | - 0.0330 | - 0.0358 | 0.0028 |                            |
| 14      | 18  |             |             |                   |          |        |          |          |        |                            |
| 18      | 24  | - 0.041     | - 0.074     | - 0.0673          | - 0.0707 | 0.0034 | - 0.0410 | - 0.0444 | 0.0034 |                            |
| 24      | 30  | - 0.048     | - 0.081     | - 0.0743          | - 0.0777 | 0.0034 | - 0.0480 | - 0.0514 | 0.0034 |                            |
| 30      | 40  | - 0.060     | - 0.099     | - 0.0910          | - 0.0950 | 0.0040 | - 0.0600 | - 0.0640 | 0.0040 |                            |
| 40      | 50  | - 0.070     | - 0.109     | - 0.1010          | - 0.1050 | 0.0040 | - 0.0700 | - 0.0740 | 0.0040 |                            |
| 50      | 65  | - 0.087     | - 0.133     | - 0.1237          | - 0.1283 | 0.0046 | - 0.0870 | - 0.0916 | 0.0046 |                            |
| 65      | 80  | 0.102       | 0.148       | 0.1387            | 0.1433   | 0.0046 | 0.1020   | - 0.1066 | 0.0046 |                            |
| 80      | 100 | - 0.124     | - 0.178     | - 0.1673          | - 0.1727 | 0.0054 | - 0.1240 | - 0.1294 | 0.0054 |                            |
| 100     | 120 | - 0.144     | - 0.198     | - 0.1873          | - 0.1927 | 0.0054 | - 0.1440 | - 0.1494 | 0.0054 |                            |
| 120     | 140 | - 0.170     | - 0.233     | - 0.2210          | - 0.2270 | 0.0060 | - 0.1700 | - 0.1760 | 0.0060 |                            |
| 140     | 160 | - 0.190     | - 0.253     | - 0.2410          | - 0.2470 | 0.0060 | - 0.1900 | - 0.1960 | 0.0060 |                            |
| 160     | 180 | - 0.210     | - 0.273     | - 0.2610          | - 0.2670 | 0.0060 | - 0.2100 | - 0.2160 | 0.0060 |                            |
| 180     | 200 | - 0.236     | - 0.308     | - 0.2945          | - 0.3015 | 0.0070 | - 0.2360 | - 0.2430 | 0.0070 |                            |
| 200     | 225 | - 0.258     | - 0.330     | - 0.3165          | - 0.3235 | 0.0070 | - 0.2580 | - 0.2650 | 0.0070 |                            |
| 225     | 250 | - 0.284     | - 0.356     | - 0.3425          | - 0.3495 | 0.0070 | - 0.2840 | - 0.2910 | 0.0070 |                            |
| 250     | 280 | 0.315       | 0.396       | 0.3810            | 0.3890   | 0.0080 | 0.3150   | 0.3230   | 0.0080 |                            |
| 280     | 315 | - 0.350     | - 0.431     | - 0.4160          | - 0.4240 | 0.0080 | - 0.3500 | - 0.3580 | 0.0080 |                            |
| 315     | 355 | - 0.390     | - 0.479     | - 0.4625          | - 0.4715 | 0.0090 | - 0.3900 | - 0.3990 | 0.0090 |                            |
| 355     | 400 | - 0.435     | - 0.524     | - 0.5075          | - 0.5165 | 0.0090 | - 0.4350 | - 0.4440 | 0.0090 |                            |
| 400     | 450 | - 0.490     | - 0.587     | - 0.5680          | - 0.5780 | 0.0100 | - 0.4900 | - 0.5000 | 0.0100 |                            |
| 450     | 500 | - 0.540     | - 0.637     | - 0.6180          | - 0.6280 | 0.0100 | - 0.5400 | - 0.5500 | 0.0100 |                            |

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## 附 录 A

### 孔用光滑极限量规应用尺寸计算

(参考件)

#### A.1 孔用量规应用尺寸计算公式

$$\begin{aligned} \text{通规尺寸: } d_T &= D \begin{matrix} EI + Z + \frac{T}{2} \\ EI + Z - \frac{T}{2} \end{matrix} \\ \text{磨损极限尺寸: } d_s &= D + EI \end{aligned}$$

$$\text{止规尺寸: } d_z = D \begin{matrix} ES \\ ES - T \end{matrix}$$

式中:  $D$ ——孔的基本尺寸

$d_T$ ——通规尺寸

$d_s$ ——通规磨损极限尺寸

$d_z$ ——止规尺寸

A.2 量规尺寸公差 $T$ 和通规尺寸公差带的中心到工件最大实体尺寸的距离 $Z$ ,应按GB 1957-81表1(表A1)的规定。

#### A.3 孔用量规计算实例

a、孔用量规的基本尺寸与工件孔的基本尺寸相同即 $\phi 10$

b、由GB 1801-79表2查得:

$$ES = -13\mu\text{m} = -0.013\text{mm}$$

$$EI = -28\mu\text{m} = -0.028\text{mm}$$

c、由附表查得:

$$T = 1.8\mu\text{m} = 0.0018\text{mm}$$

$$Z = 2.4\mu\text{m} = 0.0024\text{mm}$$

$$\begin{aligned} \text{通规尺寸: } d_T &= D \begin{matrix} EI + Z + \frac{T}{2} \\ EI + Z - \frac{T}{2} \end{matrix} \\ &= \phi 10 \begin{matrix} -0.028 + 0.0024 + \frac{0.0018}{2} \\ -0.028 + 0.0024 - \frac{0.0018}{2} \end{matrix} \\ &= \phi 10 \begin{matrix} -0.0247 \\ -0.0265 \end{matrix} \end{aligned}$$

$$\text{通规磨损极限尺寸: } d_s = D + EI$$

$$= \phi 10 + (-0.028)$$

$$= \phi 9.972$$

止規尺寸:

$$d_z = D_{ES}^{ES} - T$$

$$= \phi 10_{-0.013}^{-0.0130} - 0.0018$$

$$= \phi 10_{-0.0148}^{-0.0130}$$

| 工件基本尺寸       |     | 表 A 1 |     |     |      |     |     |      |     |     |      |    |      |       |    |      |       |    |      |       |    |      |       |    |      | 0.001 毫米 |     |      |       |     |      |       |     |  |  |  |  |
|--------------|-----|-------|-----|-----|------|-----|-----|------|-----|-----|------|----|------|-------|----|------|-------|----|------|-------|----|------|-------|----|------|----------|-----|------|-------|-----|------|-------|-----|--|--|--|--|
|              |     | IT 6  |     |     | IT 7 |     |     | IT 8 |     |     | IT 9 |    |      | IT 10 |    |      | IT 11 |    |      | IT 12 |    |      | IT 13 |    |      | IT 14    |     |      | IT 15 |     |      | IT 16 |     |  |  |  |  |
| 尺寸 (毫米)      | IT6 | T     | μm  | IT7 | T    | μm  | IT8 | T    | μm  | IT9 | T    | μm | IT10 | T     | μm | IT11 | T     | μm | IT12 | T     | μm | IT13 | T     | μm | IT14 | T        | μm  | IT15 | T     | μm  | IT16 | T     | μm  |  |  |  |  |
| 至 3          | 6   | 1     | 1   | 10  | 1.2  | 1.6 | 14  | 1.6  | 2   | 25  | 2    | 3  | 40   | 2.4   | 4  | 60   | 3     | 8  | 100  | 4     | 9  | 140  | 6     | 14 | 250  | 9        | 20  | 400  | 14    | 30  | 600  | 20    | 40  |  |  |  |  |
| 大于 3 至 6     | 8   | 1.2   | 1.4 | 12  | 1.4  | 2   | 18  | 2    | 2.6 | 30  | 2.4  | 4  | 48   | 3     | 5  | 75   | 4     | 8  | 120  | 5     | 11 | 180  | 7     | 16 | 300  | 11       | 25  | 480  | 16    | 35  | 750  | 25    | 50  |  |  |  |  |
| 大于 6 至 10    | 9   | 1.4   | 1.6 | 15  | 1.8  | 2.4 | 22  | 2.4  | 3.2 | 36  | 2.8  | 5  | 58   | 3.6   | 6  | 90   | 5     | 9  | 150  | 6     | 13 | 220  | 8     | 20 | 360  | 13       | 30  | 580  | 20    | 40  | 900  | 30    | 60  |  |  |  |  |
| 大于 10 至 18   | 11  | 1.6   | 2   | 18  | 2    | 2.8 | 27  | 2.8  | 4   | 43  | 3.4  | 6  | 70   | 4     | 8  | 110  | 6     | 11 | 180  | 7     | 15 | 270  | 10    | 24 | 430  | 15       | 35  | 700  | 24    | 50  | 1100 | 35    | 75  |  |  |  |  |
| 大于 18 至 30   | 13  | 2     | 2.4 | 21  | 2.4  | 3.4 | 33  | 3.4  | 5   | 52  | 4    | 7  | 84   | 5     | 9  | 130  | 7     | 13 | 210  | 8     | 18 | 330  | 12    | 28 | 520  | 18       | 40  | 840  | 28    | 60  | 1300 | 40    | 90  |  |  |  |  |
| 大于 30 至 50   | 16  | 2.4   | 2.8 | 25  | 3    | 4   | 39  | 4    | 6   | 62  | 5    | 8  | 100  | 6     | 11 | 160  | 8     | 16 | 250  | 10    | 22 | 390  | 14    | 34 | 620  | 22       | 50  | 1000 | 34    | 75  | 1600 | 50    | 110 |  |  |  |  |
| 大于 50 至 80   | 18  | 2.8   | 3.4 | 30  | 3.6  | 4.8 | 46  | 4.8  | 7   | 74  | 6    | 9  | 120  | 7     | 13 | 190  | 9     | 19 | 300  | 12    | 26 | 460  | 16    | 40 | 740  | 26       | 60  | 1200 | 40    | 90  | 1900 | 60    | 130 |  |  |  |  |
| 大于 80 至 120  | 22  | 3.2   | 3.8 | 36  | 4.2  | 5.4 | 54  | 5.4  | 8   | 87  | 7    | 10 | 140  | 8     | 15 | 230  | 10    | 23 | 350  | 14    | 30 | 540  | 20    | 44 | 870  | 30       | 70  | 1400 | 44    | 100 | 2300 | 70    | 150 |  |  |  |  |
| 大于 120 至 180 | 25  | 3.8   | 4.4 | 40  | 4.8  | 6   | 63  | 6    | 9   | 100 | 8    | 12 | 160  | 9     | 18 | 250  | 12    | 25 | 400  | 16    | 35 | 630  | 22    | 52 | 1000 | 35       | 80  | 1600 | 52    | 120 | 2500 | 80    | 180 |  |  |  |  |
| 大于 180 至 250 | 29  | 4.4   | 5   | 48  | 5.4  | 7   | 72  | 7    | 10  | 115 | 9    | 14 | 185  | 10    | 20 | 290  | 14    | 29 | 480  | 18    | 40 | 720  | 26    | 60 | 1150 | 40       | 90  | 1850 | 60    | 130 | 2900 | 90    | 200 |  |  |  |  |
| 大于 250 至 315 | 32  | 4.8   | 5.6 | 52  | 6    | 8   | 81  | 8    | 11  | 130 | 10   | 16 | 210  | 12    | 22 | 320  | 16    | 32 | 520  | 20    | 45 | 810  | 28    | 66 | 1300 | 45       | 100 | 2100 | 66    | 150 | 3200 | 100   | 220 |  |  |  |  |
| 大于 315 至 400 | 36  | 5.4   | 6.2 | 57  | 7    | 9   | 89  | 9    | 12  | 140 | 11   | 18 | 230  | 14    | 25 | 360  | 18    | 36 | 570  | 22    | 50 | 890  | 32    | 74 | 1400 | 50       | 110 | 2300 | 74    | 170 | 3600 | 110   | 250 |  |  |  |  |
| 大于 400 至 500 | 40  | 6     | 7   | 63  | 8    | 10  | 97  | 10   | 14  | 155 | 12   | 20 | 250  | 16    | 28 | 400  | 20    | 40 | 630  | 24    | 55 | 970  | 36    | 80 | 1550 | 55       | 120 | 2500 | 80    | 190 | 4000 | 120   | 280 |  |  |  |  |

附加说明:

本标准由第七〇八所起草。

本标准由第七〇八所提出。

自本标准实施之日起: 原QJ 443-444-78作废。