AMERICAN STANDARD

Microscope Objective Thread

ASA B1.11-1958

UDC 621.882.082:535.822:681.42

Sponsors

Society of Automotive Engineers
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Published by

THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS

29 West 39th Street, New York 18, N. Y.

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ERRATA

ANSI B1.11 – 1958 (R1972)
MICROSCOPE OBJECTIVE THREAD (JULY 1972)

Page 5, Section 7 should read, American National Standard ANSI B1.7-1965 (R1972)

Page 6, Section 14 should read, Angle Deviation.

Foreword

The standardization of the microscope objective thread is one of the projects toward unification of screw thread standards among inch-using countries. In Great Britain, the Royal Microscopical Society had established standards for microscope objectives in 1858, based on the Whitworth screw thread system, which were subsequently used throughout the world. The history of this standard is in the *Transactions* of the Society: 1858, p. 39; 1859, p. 92; 1896, pp. 389, 487; 1911, p. 175; 1915, p. 230; 1924, p. 266; and 1936, p. 377.

In practice, American manufacturers of this thread have always employed modifications of the Whitworth form because of their preference for flat crests, such modified threads being completely interchangeable with the RMS threads. At the Conference on Unification of Engineering Standards held in Ottawa, 1945, the American Delegation presented ASA Paper B1/57 and A.O. Drawing ED-95 giving limits of size for a truncated Whitworth thread. Since a thread form with rounded crest is preferred in Great Britain for optical instruments, it was recommended that the title of this document be amended to read, "Proposed Permitted Truncation and Tolerances for RMS Thread."

On the basis of this proposal a draft of a proposed American Standard, dated April, 1948, was circulated to the B1 Sectional Committee membership for comment. In conformity with comments received, a revised draft, dated October, 1954, was approved by Subcommittee No. 4 on Instrument Screw Threads and subsequently submitted to the Sectional Committee for approval. Final approval as an American Standard was given on January 7, 1958, by ASA.

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American Standard

MICROSCOPE OBJECTIVE THREAD

GENERAL AND HISTORICAL

1 This standard covers the screw thread used for mounting the objective assembly to the body or lens turret of microscopes. It is based on, and intended to be interchangeable with, the screw thread introduced and adopted many years ago by the Royal Microscopical Society of Great Britain, generally known as the "RMS thread" and now almost universally accepted as the basic standard for microscope objective mountings. Formal recognition, however, has been extremely limited.

2 Because of its British origin, the basic thread possesses the British Standard Whitworth form, having an included angle of 55° and rounded crests and roots. This same full Whitworth form is also employed as the design, or maximum material, form by the British. The present (American) standard, however, the design thread form established in ASA B1.6-1944, American War Standard for Truncated Whitworth Threads, has been adopted.

3 The pitch diameter allowance and tolerances promulgated in June, 1924, for the RMS thread were subsequently applied by most American manufacturers to their truncated versions and found to be acceptable. Uniformity of practice with regard to the allowances and tolerances for the other diameters never materialized.

4 Experience has established that the principal attributes of a good fit for microscope objective threads are:

(**a**) Adequate clearance to afford protection against binding due to the presence of foreign particles or minor thread crest damage.

(**b**) Sufficient depth of thread engagement to assure security in the short lengths of engagement commonly encountered.

(**c**) Allowances for limited eccentricities so that centralization and squareness of the objective are not influenced by such errors in manufacture.

5 The need for the above characteristics stems principally from the inherent longevity of optical equipment and the repeated use to which objective threads are subjected. The measures necessary to provide these properties precluded adoption of the allowances and tolerances recommended for threads of this pitch in the American War Standard for Truncated Whitworth Threads, ASA B1.6-1944 (withdrawn, 1951). The more significant departures from that standard are:

(**a**) A larger allowance on the pitch diameter of the external thread.

(**b**) Smaller tolerances on the major diameter of the external thread and the minor diameter of the internal thread.

(**c**) The provision of allowances on the major and minor diameters of the external thread.

The values established and further details regarding them are given under Specifications.

6 Though utilized principally for microscope objective mountings, this screw thread is recommended also for other optical assemblies of microscopes and associated apparatus, such as photomicrographic equipment.

TERMINOLOGY

7 The nomenclature, definitions, and letter symbols used in this standard are in conformance with American Standard ASA B1.7-1949, Nomenclature, Definitions, and Letter Symbols for Screw Threads.

SPECIFICATIONS

8 Basic Form of Thread. The basic form of the thread for this standard is the British Standard Whitworth form. Basic dimensions are given in Table 1.

9 Design Form of Thread. The design, or maximum material, forms of both the external and internal threads conform to the American War Standard for Truncated Whitworth Threads, ASA B1.6-1944 (withdrawn, 1951). The design dimensions are given in Table 1.

TABLE 1 DEFINITIONS, FORMULAS, BASIC AND DESIGN DIMENSIONS

Property	Symbol	Formula	Dimension
Basic Thread Form			
Half angle of thread[a]	α	...	27°30′
Included angle of thread[a]	2α	...	55°00′
Number of threads per inch[a]	n	...	36
Pitch	p	$1/n$	0.027778
Height of fundamental triangle	H	$0.960491p$	0.026680
Height of basic thread	h_b	$0.640327p$	0.0178
Radius at crest and root of British Standard Whitworth basic thread (not used)	r	$0.137329p$	0.0038
Design Thread Form			
Height of truncated Whitworth thread	k	$h_b - U = 0.566410p$	0.0157
Width of flat at crest	F_c	$0.243624p$	0.0068
Width of flat at root	F_r	$0.166667p$	0.0046
Basic truncation of crest from basic Whitworth form	U	$0.073917p$	0.00205
Basic and Design Sizes			
Major diameter, nominal and basic	D	...	0.800
Major diameter of internal thread	D_n	D	0.800
Major diameter of external thread[b]	D_s	$D - 2U - G$	0.7941
Pitch (effective) diameter, basic	E	$D - h_b$	0.7822
Pitch (effective) diameter of internal thread	E_n	$D - h_b$	0.7822
Pitch (effective) diameter of external thread[c]	E_s	$D - h_b - G$	0.7804
Minor diameter, basic	K	$D - 2h_b$	0.7644
Minor diameter of internal thread	K_n	$D - 2k$	0.7685
Minor diameter of external thread[b]	K_s	$D - 2h_b - G$	0.7626
Allowance at pitch (effective) diameter[b,c]	G	...	0.0018

[a] All other dimensions are given in inches.
[b] An allowance equal to that on the pitch diameter is also provided on the major and minor diameters of the external thread for additional clearance and centralizing.
[c] Allowance (minimum clearance) on pitch (effective) diameter is the same as on British RMS thread.

10 Lead of Thread. The thread is of the single (single-start) type.

11 Classification. There is established herein only one class of thread which experience has proved to be adequate to meet the demands of the applications.

12 Nominal Sizes. There is only one nominal size having a basic major diameter of 0.800 inch and a pitch of 0.027778 inch (36 threads per inch).

13 Allowances. Positive allowances (minimum clearances) are provided on the pitch, major, and minor diameters of the external thread. The allowance on the pitch diameter is 0.0018 inch, the value established by the British Royal Microscopical Society in 1924 and now widely regarded as a basic requirement. The same allowance is also applied on both the major and minor diameters.

Where interchangeability with product having full-form Whitworth threads is not required, the allowances on the major and minor diameters of the external thread are not necessary, since the forms at the root and crest of the truncated internal thread provide the desired clearances. In such cases, either both limits or only the maximum limit of the major and minor diameters may be increased by the amount of the allowance. Benefits are derived principally from changes in the major diameter where increasing both limits improves the depth of thread engagement, and increasing only the maximum limit grants a larger manufacturing tolerance. However, unless such deviations are specifically covered in purchase negotiations, it is to be assumed that the threads will be supplied in accordance with the tables in this standard.

14 Tolerances. In accordance with standard practice, tolerances on the internal thread are applied in a plus direction from the basic (also design) size and tolerances on the external thread are applied in a minus direction from its design (maximum material) size.

The pitch diameter tolerances for the external and internal thread are the same and include both lead and angle errors. They are derived from the RMS "standard" of 1924 and are the same as for the current British RMS thread.

The tolerance on the major diameter of the external thread and the tolerance on the minor diameter of the internal thread are the minimum values which experience has demonstrated to be

practicable. Adequate depth of thread engagement is thereby assured.

All tolerances are given in Table 2.

15 Lengths of Engagement. The tolerances specified herein are applicable to lengths of engagement ranging from 1/8 inch to 3/8 inch (approximately 15 to 50 per cent of the basic diameter). Lengths of engagement exceeding these limits are seldom employed and, consequently, are not provided for in this standard.

For microscope objective assemblies the length of engagement most generally employed is 1/8 inch.

16 Limits of Size. The limits of size for both the external and internal thread are given in Table 2. Their application is illustrated in Fig. 1.

17 Thread Designation. This screw thread shall be designated on engineering drawings, in specifications, and on tools and gages by the symbol "AMO" preceded by the basic major diameter in inches and the number of threads per inch, as given below:

0.800—36 AMO

TABLE 2 LIMITS OF SIZE AND TOLERANCES[a]

0.800—36 AMO

Element	Major Diameter			Pitch Diameter			Minor Diameter		
	Max	Min	Tol	Max	Min	Tol	Max	Min	Tol
External thread	0.7941	0.7911	0.0030	0.7804	0.7774	0.0030	0.7626	0.7552[b]	
Internal thread	0.8092[c]	0.8000		0.7852	0.7822	0.0030	0.7715	0.7685	0.0030

[a] All dimensions are given in inches.

[b] Extreme minimum minor diameter produced by a new threading tool having a minimum flat of $p/12$ (= 0.0023 inch). This minimum diameter is not controlled by gages but by the form of the threading tool.

[c] Extreme maximum major diameter produced by a new threading tool having a minimum flat of $p/20$ (= 0.0014 inch). This maximum diameter is not controlled by gages but by the form of the threading tool.