

SERRATED SHAFT ENDS—SAE J500

SAE Recommended Practice

Report of Parts and Fittings Division approved 1922 and last revised by Parts and Fittings Committee June 1955.

This Recommended Practice is intended for service only. Use SAE Standard, Involute Splines, Serrations, and Inspection—SAE J498 for new applications.

STRAIGHT SHAFTS

N = Number of serrations.
b = Included angle of the space in the hole, and the tooth on the shaft.

The pitch diameter (PD) and hole are basic.
The pitch line is midway between the inner and outer sharp points.
The minimum hole with maximum shaft as measured across wires in Table 1, produce basic (no clearance) fit.
The wire diameter in Table 1 is the diameter that will bear on the pitch line.

Tolerance for diameter across wires = -0.001 on tooth thickness of hole and shaft sizes from 1/8 to 1 3/4 in., and -0.0015 on sizes from 2 to 3 in., inclusive.

Tooth thickness on the shaft may be varied from the tolerance given, to secure desired fit.

Wc = Constant to be added to measurement across wires for shaft, subtracted for hole, for each 0.001-in. increase in wire diameter used over wire size in Table 1.

When serrations are hobbled, the sides of teeth are involute. This departure from flat sides is slight and is ignored.

FORMULAS

1. Diameter over sharp points

$$(OD) = 1.0476479 \text{ PD for 36 serrations.}$$

$$= 1.0349592 \text{ PD for 48 serrations.}$$

2. Diameter under sharp points

$$(RD) = 0.9523521 \text{ PD for 36 serrations.}$$

$$= 0.9650408 \text{ PD for 48 serrations.}$$

3. Diameter of wire that will bear on pitch line of hole

$$(Wh) = 0.05309792 \text{ PD for 36 serrations.}$$

$$= 0.04133332 \text{ PD for 48 serrations.}$$

Diameter of wire that will bear on pitch line of shaft

$$(Ws) = 0.06585005 \text{ PD for 36 serrations.}$$

$$= 0.0485955 \text{ PD for 48 serrations.}$$

4. Measurement across wires

for hole = 0.9119441 PD for 36 serrations.
= 0.9309375 PD for 48 serrations.

Measurement across wires

for shaft = 1.1113285 PD for 36 serrations.
= 1.0823601 PD for 48 serrations.

5. Tolerance constant for measurement across wires per 0.001-in. tooth

$$\text{thickness for hole} = 0.001 \frac{\sin 45}{\sin \left(45 - \frac{180}{N} \right)}$$

$$\text{for shaft} = 0.001 \frac{\sin \left(45 - \frac{180}{N} \right)}{\sin 45}$$

6. Wire diameter constant for use of other diameter wire than that which bears on pitch line, (Wc)

$$= 0.001 + \frac{0.001}{\sin \left(45 - \frac{180}{N} \right)} \text{ for hole.}$$

$$= 0.001 + \frac{0.001}{\cos 45} \text{ for shaft.}$$

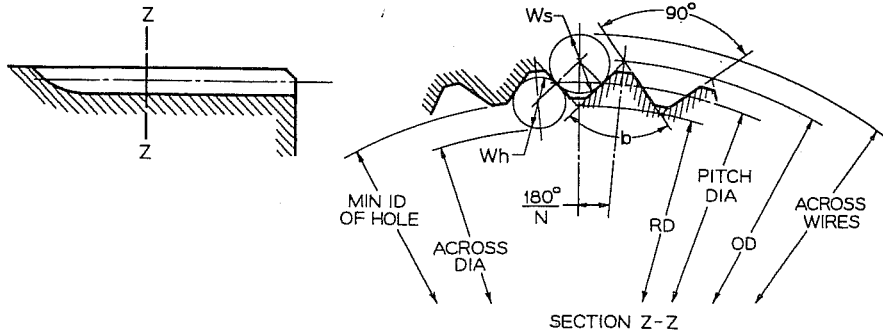


TABLE 1—DIMENSIONS OF HOLES AND SHAFTS, IN.

Hole and Shaft				Hole								Shaft							
Nominal Dia	Pitch Dia	N	b, Deg	Theoretical Dia of Points		Large Dia, min	Small Dia		Dia Across Wires		Wire Size, Wh	Wc	Root Dia, max	Outside Dia		Dia Across Wires		Wire Size, Ws	Wc
				OD	RD		Max	Min	Min	Max				Max	Min	Max	Min		
1/8	0.122	36	80	0.1278	0.1162	0.125	0.118	0.117	0.1113	0.1124	0.0065	0.0026	0.116	0.124	0.123	0.1356	0.1347	0.0080	0.0024
3/16	0.182	36	80	0.1907	0.1733	0.187	0.176	0.175	0.1650	0.1671	0.0097	0.0026	0.174	0.186	0.185	0.2023	0.2014	0.0120	0.0024
1/4	0.243	36	80	0.2546	0.2314	0.250	0.235	0.234	0.2216	0.2227	0.0129	0.0026	0.233	0.249	0.248	0.2701	0.2692	0.0160	0.0024
3/8	0.303	36	80	0.3174	0.2886	0.312	0.293	0.292	0.2763	0.2774	0.0161	0.0026	0.291	0.311	0.310	0.3367	0.3358	0.0200	0.0024
3/8	0.363	36	80	0.3803	0.3457	0.375	0.352	0.351	0.3310	0.3321	0.0193	0.0026	0.350	0.374	0.373	0.4034	0.4025	0.0239	0.0024
1/2	0.485	36	80	0.5081	0.4619	0.500	0.469	0.468	0.4423	0.4434	0.0258	0.0026	0.467	0.499	0.498	0.5390	0.5381	0.0319	0.0024
3/8	0.605	36	80	0.6338	0.5762	0.625	0.584	0.583	0.5517	0.5528	0.0321	0.0026	0.582	0.624	0.623	0.6724	0.6715	0.0398	0.0024
3/4	0.733	48	82-1/2	0.7586	0.7074	0.750	0.716	0.714	0.6824	0.6835	0.0303	0.0025	0.713	0.749	0.747	0.7934	0.7925	0.0356	0.0024
1	0.855	48	82-1/2	0.8849	0.8251	0.875	0.835	0.833	0.7960	0.7971	0.0353	0.0025	0.832	0.874	0.872	0.9254	0.9245	0.0415	0.0024
1	0.977	48	82-1/2	1.0112	0.9428	1.000	0.954	0.952	0.9095	0.9106	0.0404	0.0025	0.951	0.999	0.997	1.0575	1.0566	0.0475	0.0024
1-1/8	1.098	48	82-1/2	1.1364	1.0596	1.125	1.071	1.069	1.0222	1.0233	0.0454	0.0025	1.068	1.124	1.122	1.1884	1.1875	0.0534	0.0024
1-1/4	1.220	48	82-1/2	1.2626	1.1773	1.250	1.190	1.188	1.1357	1.1368	0.0504	0.0025	1.187	1.249	1.247	1.3205	1.3196	0.0593	0.0024
1-3/8	1.342	48	82-1/2	1.3889	1.2951	1.375	1.309	1.307	1.2493	1.2504	0.0555	0.0025	1.306	1.374	1.372	1.4525	1.4516	0.0652	0.0024
1-1/2	1.464	48	82-1/2	1.5152	1.4128	1.500	1.428	1.426	1.3629	1.3640	0.0605	0.0025	1.425	1.499	1.497	1.5846	1.5837	0.0711	0.0024
1-3/4	1.708	48	82-1/2	1.7677	1.6483	1.750	1.666	1.664	1.5900	1.5911	0.0706	0.0025	1.663	1.749	1.747	1.8487	1.8478	0.0830	0.0024
2	1.952	48	82-1/2	2.0202	1.8838	2.000	1.904	1.902	1.8172	1.8188	0.0807	0.0025	1.901	1.999	1.997	2.1128	2.1114	0.0949	0.0024
2-1/4	2.196	48	82-1/2	2.2728	2.1192	2.250	2.142	2.140	2.0443	2.0459	0.0908	0.0025	2.139	2.249	2.247	2.3769	2.3755	0.1067	0.0024
2-1/2	2.440	48	82-1/2	2.5253	2.3547	2.500	2.380	2.378	2.2715	2.2731	0.1009	0.0025	2.377	2.499	2.497	2.6410	2.6396	0.1180	0.0024
2-3/4	2.684	48	82-1/2	2.7778	2.5902	2.750	2.618	2.616	2.4986	2.5002	0.1109	0.0025	2.615	2.749	2.747	2.9051	2.9037	0.1304	0.0024
3	2.928	48	82-1/2	3.0304	2.8256	3.000	2.856	2.854	2.7258	2.7274	0.1210	0.0025	2.853	2.999	2.997	3.1692	3.1678	0.1423	0.0024

