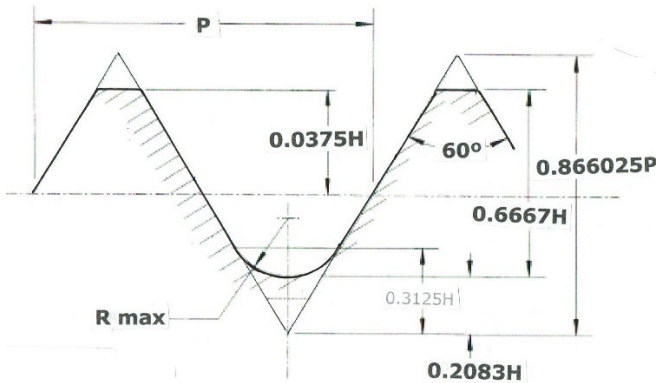


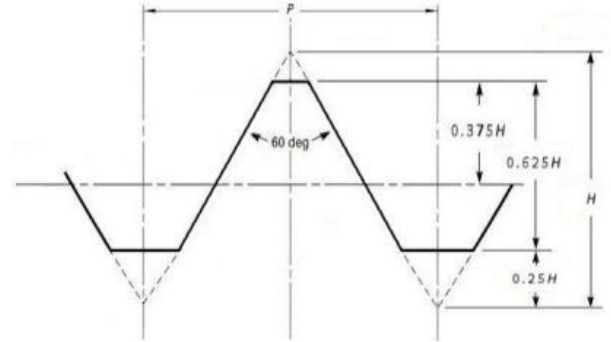
UNJ & MJ THREADS

UNJ threads

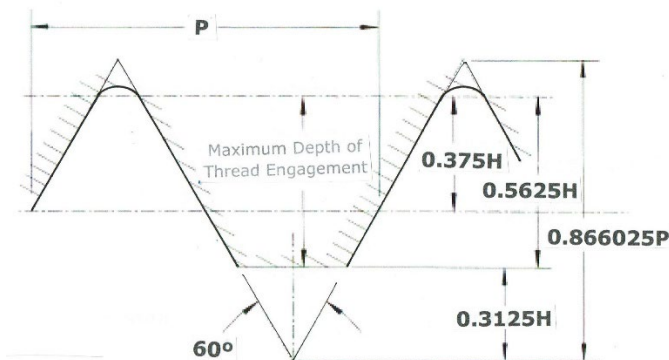
The basic difference between UNJ, UNJC, UNJF and UNJEF threads and UN, UNC, UNF, and UNEF threads is that the external J thread has a larger root radius than the standard UN threads and it's normally required that inspection/measurement must be performed on this radius and thread root diameter of a UNJ. The normal pitch diameter tolerances for UNJ threads are 3A (external) and 3B (internal).



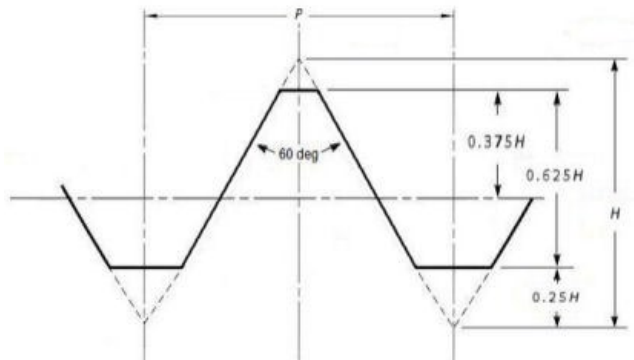
UNJ External Thread
Root radius 0.072P to 0.096P



UN External Thread



UNJ Internal Thread



UN Internal Thread

N.B. The possible modification of adding a large root radius to internal UNJ screw threads subject to fatigue is intended to reduce stress related failures.

MJ threads

As with UNJ threads the root radius on external threads is larger than on standard M threads. The root radius should be between 0.15011P and 0.18042P. The internal minor diameter should be truncated to allow clearance for the maximum external thread root radius.

N.B. When manufacturing these thread types (UNJ and MJ) it is recommended that the relevant standard/standards be used to have all relevant data.

It is can often be possible to combine UNJ threads with UN (as with MJ and M) but certainly not recommended as the larger root radius can cause interference.