

# INTERNATIONAL STANDARD

ISO  
4230

Second edition  
1987-11-15



---

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION  
ORGANISATION INTERNATIONALE DE NORMALISATION  
МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ

---

## Hand- and machine-operated circular screwing dies for taper pipe threads — R series

*Filières rondes de filetage, à main et à machine, pour filetages coniques de tuyauterie —  
Série R*

**(standards.iteh.ai)**

ISO 4230:1987

<https://standards.iteh.ai/catalog/standards/sist/be70cfbe-953b-46f2-a9b0-23815722b09a/iso-4230-1987>

Reference number  
ISO 4230 : 1987 (E)

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 4230 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 4230 : 1977), of which it constitutes a minor revision.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

# Hand- and machine-operated circular screwing dies for taper pipe threads — R series

iTeh STANDARD PREVIEW  
(standards.iteh.ai)

## 1 Scope and field of application

This International Standard is a supplement to ISO 2568 and ISO 4231 and lays down the dimensions of hand- and machine-operated circular screwing dies intended for production of taper pipe threads, R series, in accordance with ISO 7-1.

With the exception of the die 1/16, the general dimensions of these dies (diameter, thickness and fixing dimensions) are in accordance with ISO 2568 so as to permit the driving of hand-operated dies with the aid of the die stocks defined in that document.

## 2 References

ISO 7-1, *Pipe threads where pressure-tight joints are made on the threads — Part 1 : Designation, dimensions and tolerances.*

ISO 2568, *Hand- and machine-operated circular screwing dies and hand-operated die stocks.*

ISO 4231, *Hand- and machine-operated circular screwing dies for parallel pipe threads — G series.*

## 3 Dimensions

ISO 4230:1987

The general dimensions are given in the table overleaf.

## 4 Marking

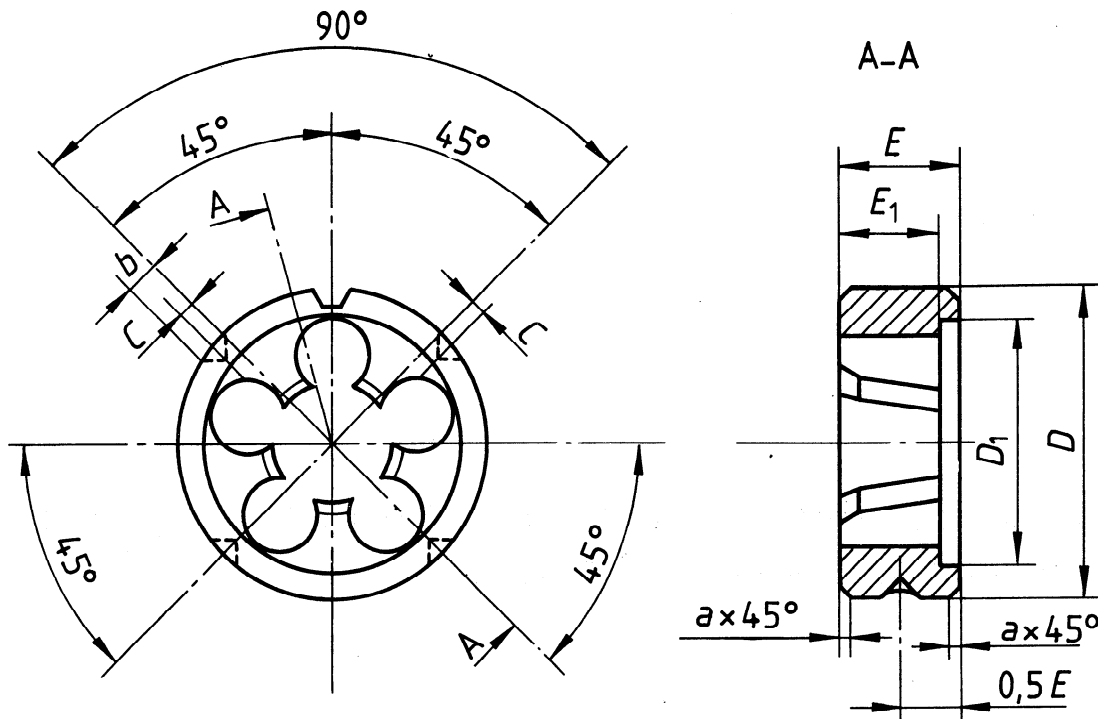
Dies in accordance with this International Standard shall be marked with the letter R immediately followed by the designation of the thread.

*Example :*

An R series taper thread screwing die with designation 3/4 shall be marked as follows :

**R 3/4**

NOTE — Where tools comply in all respects with the relevant International Standards, the symbol ISO may be appended to the mark at the discretion of the manufacturer.



Dimensions in millimetres

Thread designation	Basic diameter	Pitch	$D$	$E$	$E_1$	$C$	$b$	$a$	Minimum number of full threads	Minimum full form thread length
1/16	7,723	0,907	30*	11*	10	1	5	1	6 1/8	5,6
1/8	9,728	0,907	30	11	10	1	5	1	6 1/8	5,6
1/4	13,157	1,337	38	14	12	1,2	6	1	6 1/4	8,4
3/8	16,662	1,337	45	18	15	1,2	6	1	6 1/2	8,8
1/2	20,955	1,814	55	22	19	1,5	8	2	6 1/4	11,4
3/4	26,441	1,814	55	22	20	1,5	8	2	7	12,7
1	33,249	2,309	65	25	24	1,8	8	2	6 1/4	14,5
1 1/4	41,91	2,309	75	30	26	1,8	8	2	7 1/4	16,8
1 1/2	47,803	2,309	90	36	26	2	8	2	7 1/4	16,8
2	59,614	2,309	105	36	31	2,5	10	2	9 1/8	21,1

\* Exception to the general table given in ISO 2568.

NOTES

- 1 The V-groove, diameter  $D_1$  and clearance holes are left to the manufacturer's discretion.
- 2 The thread lead of the screwing die will be calculated on the basis of two threads.
- 3 Tolerances :
  - for precision screwing dies :
    - on  $D$  : f10
    - on  $E$  : js12
  - for non-precision screwing dies :
    - on  $D$  and  $E$  : the tolerances are left to the manufacturer's discretion

UDC 621.992.3 : 621.882.082.22

Descriptors : tools, hand tools, power-operated tools, cutting tools, threading tools, threading dies, dimensions.

Price based on 2 pages