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# INTERNATIONAL STANDARD



# 4231

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

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## Hand- and machine-operated circular screwing dies for parallel pipe threads — G series

*Filières rondes de filetage, à main et à machine, pour filetages gaz cylindriques — Série G*

**iTeh STANDARD PREVIEW**  
First edition — 1977-02-15  
**(standards.iteh.ai)**

[ISO 4231:1977](https://standards.iteh.ai/catalog/standards/sist/bf1d4efb-816c-4dc9-bb98-c413189ea8f4/iso-4231-1977)

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UDC 621.992.3

Ref. No. ISO 4231-1977 (E)

**Descriptors** : tools, power-operated tools, hand tools, screwing dies, gas pipe threads, dimensions.

## FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

International Standard ISO 4231 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in November 1975.

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It has been approved by the member bodies of the following countries :

ISO 4231:1977

Australia	Germany	Romania
Austria	Hungary	South Africa, Rep. of
Belgium	India	Sweden
Bulgaria	Israel	Switzerland
Canada	Italy	Turkey
Chile	Korea, Rep. of	United Kingdom
Czechoslovakia	Mexico	U.S.S.R.
Egypt, Arab Rep. of	Netherlands	
France	Poland	

The member body of the following country expressed disapproval of the document on technical grounds :

Japan

# Hand- and machine-operated circular screwing dies for parallel pipe threads – G series

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### 1 SCOPE AND FIELD OF APPLICATION

This International Standard is a supplement to ISO 2568 and ISO 4230 and lays down the dimensions of hand- and machine-operated circular screwing dies intended for production of parallel pipe threads – G series (according to ISO/R 228).

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 International Standard.

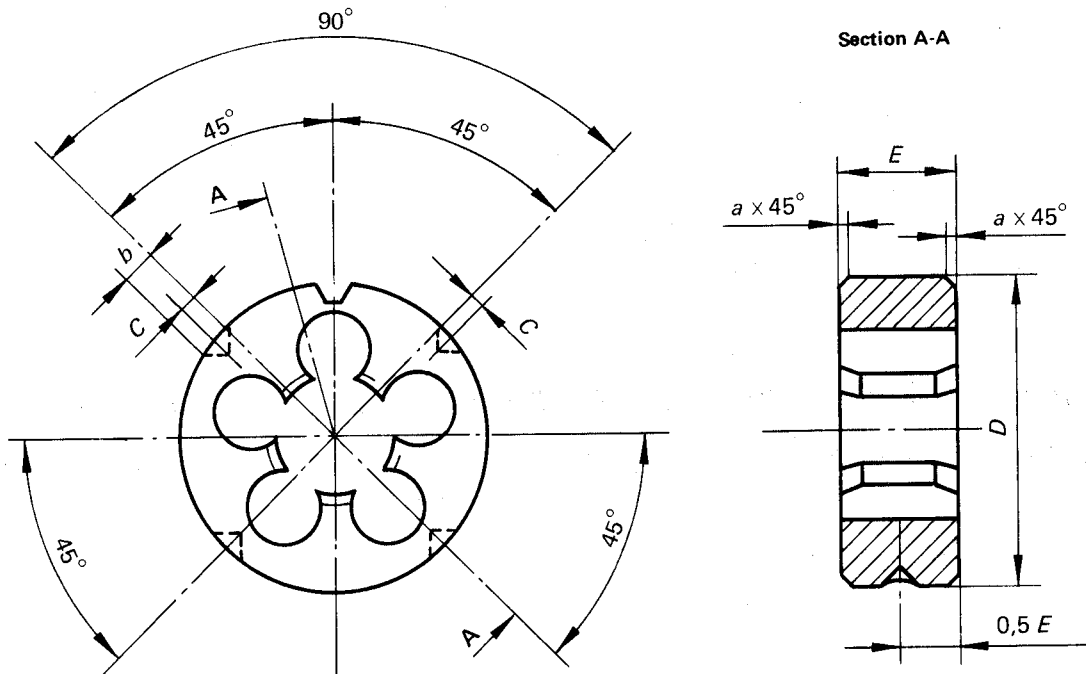
### 2 REFERENCES

ISO 2568, *Hand- and machine-operated circular screwing dies and hand-operated die stocks.*  
ISO 4230, *Hand- and machine-operated circular screwing dies for taper pipe threads – R series.*  
ISO/R 228, *Pipe threads where pressure-tight joints are not made on the threads (1/8 inch to 6 inches).*<sup>1)</sup>

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

ISO 4230, *Hand- and machine-operated circular screwing dies for taper pipe threads – R series.*

1) In course of revision.



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Dimensions in millimetres

Designation	Basic diameter	Approx. pitch	D	E	C	b	a
1/16	7,723	0,907	25	9	0,8	5	0,5
1/8	9,728	0,907	30	11	1,0	5	1
1/4	13,157	1,337	38	10	1,2	6	1
3/8	16,662	1,337	45	14	1,2	6	1
1/2	20,955	1,814	45	14	1,2	6	1
5/8	22,911	1,814	55	16	1,5	8	1
3/4	26,441	1,814	55	16	1,5	8	1
7/8	30,201	1,814	65	18	1,8	8	1
1	33,249	2,309	65	18	1,8	8	1
1 1/4	41,910	2,309	75	20	1,8	8	2
1 1/2	47,803	2,309	90	22	2,0	8	2
1 3/4	53,746	2,309	105	22	2,5	10	2
2	59,614	2,309	105	22	2,5	10	2
2 1/4	65,710	2,309	120	22	2,5	10	2

NOTES

1 The shape of the V-groove and clearance holes are left to the manufacturer's discretion.

2 Tolerances :

— for precision screwing dies :

- on D : f10
- on E : j<sub>8</sub>12

— for non-precision screwing dies :

- on D and E : the tolerances are left to the manufacturer's discretion.