

INTERNATIONAL STANDARD

ISO
4231

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 parallel pipe threads — G series

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

(standards.iteh.ai)

ISO 4231:1987

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feae56e19765/iso-4231-1987](https://standards.iteh.ai/catalog/standards/sist/40c5bc2b-3b58-409e-8bd7-feae56e19765/iso-4231-1987)

Reference number
ISO 4231 : 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 4231 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 4231:1977), of which it constitutes a minor revision. <https://standards.iteh.ai/catalog/standards/sist/40c5bc2b-3b58-409e-8bd7-feae56e19765/iso-4231-1987>

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 parallel pipe threads — G series

iTeh STANDARD PREVIEW (standards.iteh.ai)

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, in accordance with ISO 228-1.

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 228-1, *Pipe threads where pressure-tight joints are not 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 4230, *Hand- and machine-operated circular screwing dies for taper pipe threads — R series.*

3 Dimensions

The general dimensions are given in the table overleaf.

4 Marking

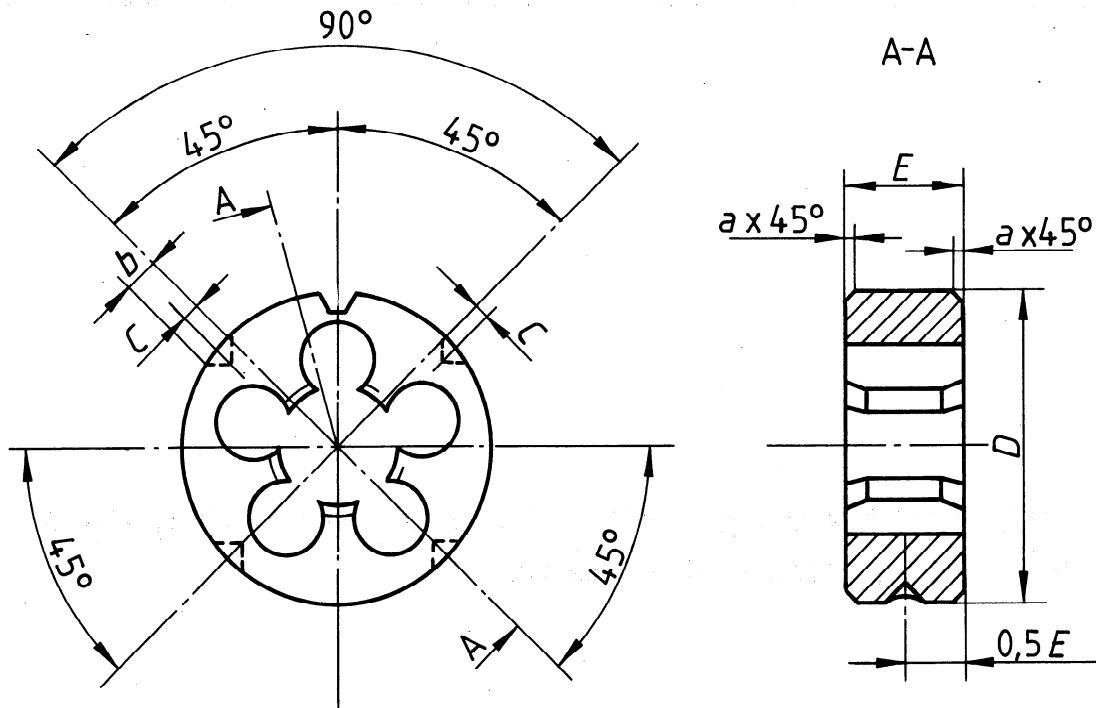
Dies in accordance with this International Standard shall be marked with the letter G immediately followed by the designation of the thread.

Example :

A G series parallel thread screwing die with designation 3/8 shall be marked as follows :

G 3/8

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	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	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	41,91	2,309	75	20	1,8	8	2
1 1/2	47,803	2,309	90	22	2	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	65,71	2,309	120	22	2,5	10	2

NOTES

- 1 The shape of the V-groove and the clearance holes are left to the manufacturer's discretion.
- 2 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