

SLOVENSKI STANDARD

SIST EN 22568:2000

01-december-2000

Hand- and machine-operated circular screwing dies and hand-operated die stocks (ISO 2568:1988)

Hand- and machine-operated circular screwing dies and hand-operated die stocks (ISO 2568:1988)

Runde Hand- und Maschinenschneideisen und Schneideisenhalter (ISO 2568:1988)

Filières rondes de filetage, à main et à machine, et porte-filière à main (ISO 2568:1988)

Ta slovenski standard je istoveten z: EN 22568:1989

SIST EN 22568:2000
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ICS:

25.100.50

Navojna rezalna orodja

Taps and threading dies

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en

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EUROPEAN STANDARD

EN 22 568

NORME EUROPEENNE

EUROPAISCHE NORM

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English version

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à machine, et porte-filière à main
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Schneideisen und Schneideisen-
halter (ISO 2568:1988)

This European Standard was accepted by CEN on 1989-06-09 and is identical to the ISO standard as referred to.
CEN members are bound to comply with the requirements of the CEN/CENELEC Common Rules which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to CEN Central Secretariat has the same status as the official versions.

CEN members are the national standards organizations of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue Bréderode 2, B-1000 Brussels

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Ref. No. EN 22 568:1989 E

Brief History

Following consideration of the results of a Primary Questionnaire among members, the CEN Technical Board decided in March 1988 to submit the International Standard

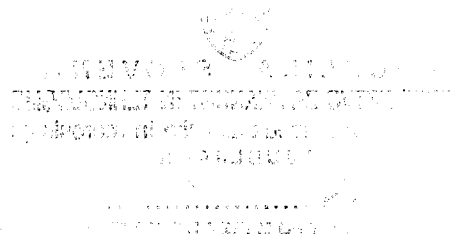
ISO 2568:1988 Hand- and machine-operated circular screwing dies and hand-operated die stocks

to the Formal Vote. This vote was positive.

Statement

The text of the International Standard ISO 2568:1988 having been approved by CEN as a European Standard without any modification according to the Common CEN/CENELEC Rules, the following countries are bound to implement this standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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INTERNATIONAL STANDARD

ISO
2568

Second edition
1988-12-01



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

Hand- and machine-operated circular screwing dies and hand-operated die stocks

Filières rondes de filetage, à main et à machine, et porte-filière à main

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ISO 2568 : 1988 (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 2568 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 2568 : 1973), of which it constitutes a minor revision. It incorporates amendments 1 and 2, published in 1977 and 1983 respectively, and a new clause 5 "Marking" has been added.

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 and hand-operated die stocks

1 Scope and field of application

This International Standard specifies the general dimensions of hand-operated and machine-operated screwing dies. These dimensions, established as a function of the thread diameter and pitch, are the following:

- outside diameter;
 - thickness;
 - cutting portion length;
 - general dimensions of attachment.
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It also gives the interchangeability dimensions of hand-operated die stocks.

This International Standard is applicable to screwing dies intended for the manufacture of the following threads:

- ISO metric threads:
 - coarse thread, from M1 to M68;
 - fine thread, from M1 to M56.
- ISO inch threads:
 - “Unified coarse” series (UNC), from No. 1 — 64 to 2 3/4 — 4;
 - “Unified fine” series (UNF), from No. 0 — 80 to 1 1/2 — 12.

The dimensional characteristics of circular screwing dies, as a function of thread diameters and pitches, are given in annex A.

The general dimensions of screwing dies for threads which are not dealt with in this International Standard, and therefore are not recommended, are given for guidance only in annex B. Annex B is applicable to screwing dies for inch threads of the following types:

- B.1 — “British Standard Whitworth” (BSW).
- B.2 — “British Standard Fine” (BSF).
- B.3 — “British Association” (BA).

All screwing dies are available in two classes, namely

- non-precision screwing dies;
- precision screwing dies.

ISO 2568 : 1988 (E)

2 ISO metric threads

Screwing dies with:

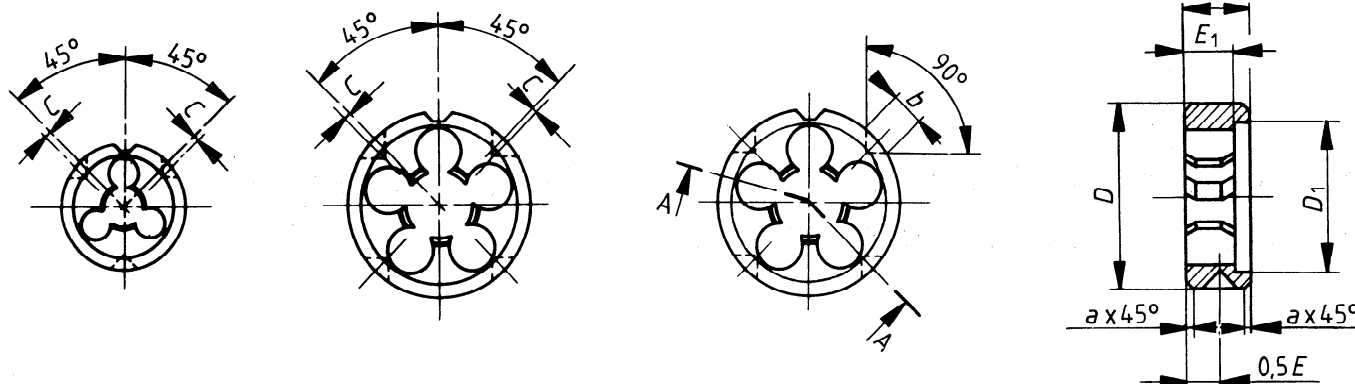
 $D = 16$ and 20 mm $D > 25$ mm

Figure 1 — Metric screwing dies

2.1 Coarse thread

Table 1

Dimensions in millimetres

Designation	d nom.	Pitch	D	D_1	E	E_1	C	b	a
M1	1	0,25	16	11	5	2,5	0,5	3	0,2
M1,1	1,1								
M1,2	1,2								
M1.4	1,4	0,3							
M1.6	1,6	0,35							
M1,8	1,8								
M2	2	0,4	20	14	7	3	0,6	4	0,5
M2,2	2,2	0,45							
M2,5	2,5								
M3	3	0,5							
M3,5	3,5	0,6							
M4	4	0,7							
M4,5	4,5	0,75	25	17	9	4	0,8	5	1
M5	5	0,8							
M6	6	1							
M7	7								
M8	8								
M9	9	1,25							
M10	10	1,5							
M11	11		30	21	11	5	1	1	

Designation	d nom.	Pitch	D	E	C	b	a
M12	12	1,75	38	14	1,2	6	1
M14	14	2					
M16	16						
M18	18	2,5	45	18*	1,5	8	2
M20	20						
M22	22						
M24	24	3	55	22	1,8	10	2
M27	27						
M30	30	3,5	65	25	2	10	2
M33	33						
M36	36	4	75	30	2,5	10	2
M39	39						
M42	42	4,5	90	36	2,5	10	2
M45	45						
M48	48	5	105	36	2,5	10	2
M52	52						
M56	56	5,5	120	36	2,5	10	2
M60	60						
M64	64	6	120	36	2,5	10	2
M68	68						

* For an M16 die, this dimension is an exception to the general table (table 6) given in annex A.

NOTES

1 The shape of the V-groove is left to the discretion of the manufacturer. Screwing dies are generally supplied with two chamfers at the thread entrance, according to the material to be threaded and at the discretion of the manufacturer.

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 discretion of the manufacturer.