
Hand- and machine-operated circular screwing dies for parallel pipe threads - G series (ISO 2431:1987)

Hand- and machine-operated circular screwing dies for parallel pipe threads - G series (ISO 2431:1987)

Runde Hand- und Maschinen-Schneideisen für zylindrisches Rohrgewinde - Reihe G (ISO 2431:1987)

Filieres rondes de filetage, a main et a machine, pour filetages cylindriques de tuyauterie - Série G (ISO 2431:1987)

[SIST EN 24231:2000](https://standards.iteh.ai/catalog/standards/sist/3dbab96-7c40-42cb-a94c-93cf3d3e6b86/sist-en-24231-2000)

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Ta slovenski standard je istoveten z: EN 24231:1989

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Navojna rezalna orodja

Taps and threading dies

SIST EN 24231:2000

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EUROPEAN STANDARD

EN 24 231

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EUROPAISCHE NORM

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Key words: Power-operated tools, hand tools, threading dies, cylindrical threads, dimensions

English version

Hand- and machine-operated circular screwing dies
for parallel pipe threads; G series
(ISO 2431:1987)

Filières rondes de filetage, à main et
à machine, pour filetages cylindriques
de tuyauterie; Série G
(ISO 2431:1987)

Runde Hand- und Maschinen-
Schneideisen für zylindrisches
Rohrgewinde; Reihe G
(ISO 2431:1987)

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.

<https://standards.iteh.ai/catalog/standards/sist/3dbab96-7c40-42cb-a94c-37c6c846/sist/24231-2000>

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

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Ref. No. EN 24 231:1989 E

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 4231:1987 Hand and machine-operated circular screwing dies for
parallel pipe threads; G series

to the Formal Vote. This vote was positive.

Statement

The text of the International Standard ISO 4231:1987 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, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.



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INTERNATIONAL STANDARD

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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*

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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/3dbabf96-7c40-42cb-a94c-93cf3d3e6b86/sist-en-24231-2000>

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

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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, 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.

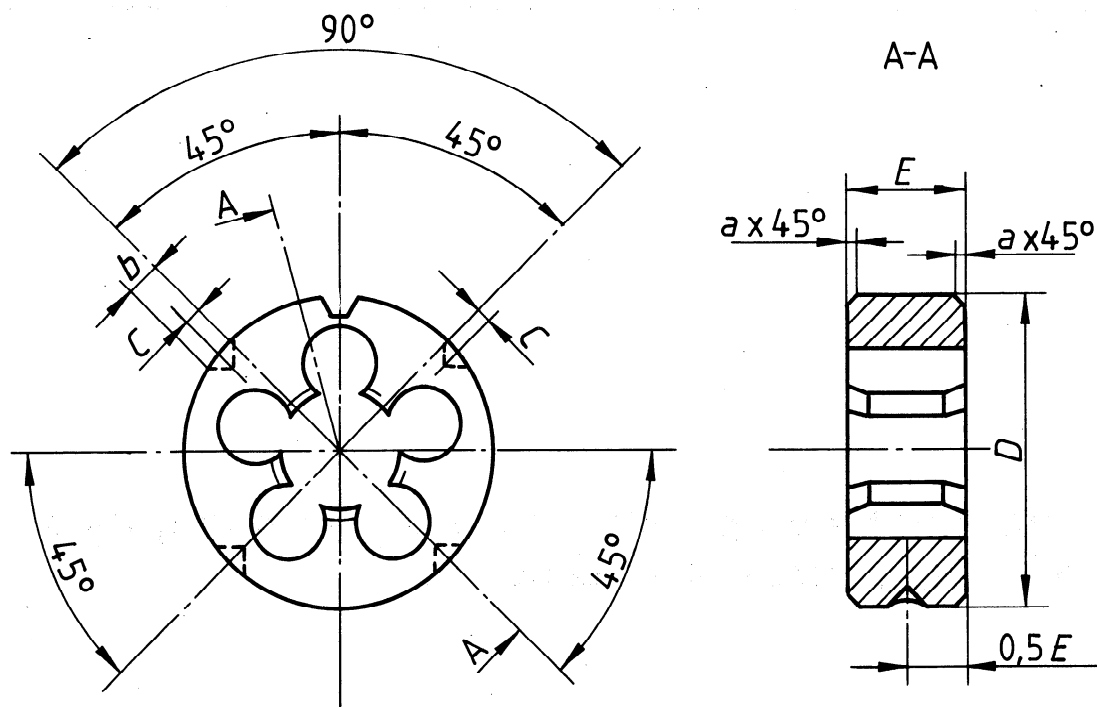
Example :

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.

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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	1,181	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