
**Assembly tools for screws and nuts —
Screwdrivers for slotted-head screws —**

Part 2:

**General requirements, lengths of blades
and marking of hand-operated screwdrivers**

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*Outils de manœuvre pour vis et écrous — Tournevis pour vis à tête
ferdne*

*Partie 2: Spécifications générales, longueurs des lames et marquage des
tournevis à main*

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Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.ch
Web www.iso.ch

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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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 2380 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 2380-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 10, *Assembly tools for screws and nuts, pliers and nippers*.

This second edition cancels and replaces the first edition (ISO 2380-2:1992), which has been technically revised.

ISO 2380 consists of the following parts, under the general title *Assembly tools for screws and nuts — Screwdrivers for slotted-head screws*:

- *Part 1: Tips for hand- and machine-operated screwdrivers*
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- *Part 2: General requirements, lengths of blades and marking of hand-operated screwdrivers*

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Assembly tools for screws and nuts — Screwdrivers for slotted-head screws —

Part 2:

General requirements, lengths of blades and marking of hand-operated screwdrivers

1 Scope

This part of ISO 2380 specifies the general requirements, lengths of blades and marking of hand-operated screwdrivers for slotted-head screws as specified in ISO 4759-1.

Requirements for the blade tips are given in ISO 2380-1.

NOTE Screwdrivers for slotted-head screws are listed under number 101 in ISO 1703:1983 [1].

2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 2380. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 2380 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 272, *Fasteners — Hexagon products — Widths across flats.*

ISO 2380-1, *Assembly tools for screws and nuts — Screwdrivers for slotted-head screws — Part 1: Tips for hand- and machine-operated screwdrivers.*

ISO 4759-1, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C.*

3 General requirements

The material, shape and finish of the handle shall be suitable for the normal conditions of use.

The handle and the blade shall not be rough nor have faults which could cause accidents during use of the screwdriver.

The torque requirements of the blade-to-handle connection shall be as specified in ISO 2380-1.

4 Blade lengths

The blade lengths are specified in Table 1 in relation to the tip dimensions of the screwdrivers (see Figure 1). Four series of lengths are provided.

NOTE Figures 1 and 2 are given as examples and are not intended to influence the manufacturer's design.

For tips of nominal dimensions 1 mm × 5,5 mm and above, the screwdriver may have a hexagonal drive near the handle (see Figure 2): the width across flats s and the respective tolerances shall be in accordance with ISO 272 and ISO 4759-1. The dimension h_{min} is determined using the formula

$$h_{min} = 0,5s$$

Table 1 — Screwdriver blades for slotted-head screws

Dimensions in millimetres

Nominal dimensions of the tip in accordance with ISO 2380-1		l $+5$ 0 Series			
a	b	A	B	C	D
0,4	2		40		
	2,5		50	75	100
0,5	3		50	75	100
0,6	3		75	100	125
	3,5	25 (35)	75	100	125
0,8	4	25 (35)	75	100	125
1	4,5	25 (35)	100	125	150
	5,5	25 (35)	100	125	150
1,2	6,5	25 (35)	100	125	150
	8	25 (35)	125	150	175
1,6	8		125	150	175
	10		150	175	200
2	12		150	200	250
2,5	14		200	250	300

NOTE Dimensions in parentheses are non-preferred.

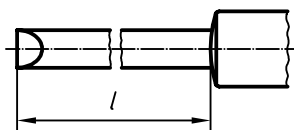


Figure 1

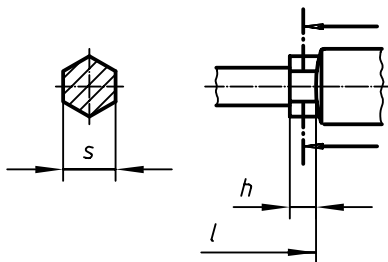


Figure 2

5 Marking

The marking of dimensions a and b and the trademark shall be legible and indelible under normal conditions of use. Indication of the blade length is optional, but when given it shall be the nominal dimension given in Table 1.

6 Designation

A screwdriver conforming to this part of ISO 2380 shall be designated by

- a) "Screwdriver";
- b) reference to this part of ISO 2380, i.e. ISO 2380-2;
- c) series of screwdriver (A, B, C or D);
- d) screwdriver tip in accordance with ISO 2380-1;
- e) capital letter H in the case of a hexagonal drive near the handle.

EXAMPLE 1 A screwdriver series A, with tip dimensions 1,2 mm × 8 mm and no hexagonal drive is designated as follows:

Screwdriver ISO 2380-2 A 1,2 × 8

EXAMPLE 2 A screwdriver series A, with tip dimensions 1,2 mm × 8 mm and a hexagonal drive is designated as follows:

Screwdriver ISO 2380-2 A 1,2 × 8-H

Bibliography

- [1] ISO 1703:1983, *Assembly tools for screws and nuts — Nomenclature*.

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