
**Aerospace — Drivers, ribbed, for internal
cruciform ribbed or unribbed drives —
Metric series**

*Aéronautique et espace — Embouts de tournevis, avec saillies
antidérapantes pour empreintes cruciformes avec ou sans saillies
antidérapantes — Série métrique*

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ISO 14280:2002

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Printed in Switzerland

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.

The main task of technical committees is to prepare International Standards. 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.

ISO 14280 was prepared by Technical Committee ISO/TC 20, *Aircraft and space vehicles*, Subcommittee SC 4, *Aerospace fastener systems*.

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Introduction

The International Organization for Standardization (ISO) draws attention to the fact that it is claimed that compliance with this International Standard may involve the use of a patent concerning ribbed drivers specified in this International Standard.

Patent rights are held by the Phillips Screw Company worldwide. These drivers are also produced and marketed under the designation of ACR® Multi-Ribbed Phillips.

ISO takes no position concerning the evidence, validity and scope of this patent right.

The holder of this patent right has assured the ISO that he is willing to negotiate licences under reasonable and non-discriminatory terms and conditions with applicants throughout the world. In this respect, the statement of the holder of this patent right is registered with the ISO. Information may be obtained from:

Phillips Screw Company
508 Edgewater Drive
Wakefield, MA 01880
USA

Attention is drawn to the possibility that some of the elements of this International Standard may be the subject of patent rights other than those identified above. ISO shall not be held responsible for identifying any or all such patent rights.

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1 Scope

This International Standard specifies the dimensions of metric ribbed drivers which are inserted into internal cruciform ribbed or unribbed drives used in metric screws in the nominal thread diameter range of 1,6 mm to 20 mm.

The internal cruciform drives, ribbed and unribbed, are defined respectively in ISO 12256 and ISO 14279.

2 Configuration and dimensions

See Figure 1 and Table 1.

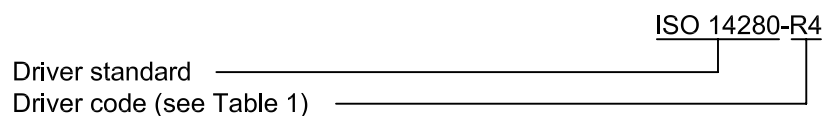
Dimensions and tolerances are expressed in millimetres.

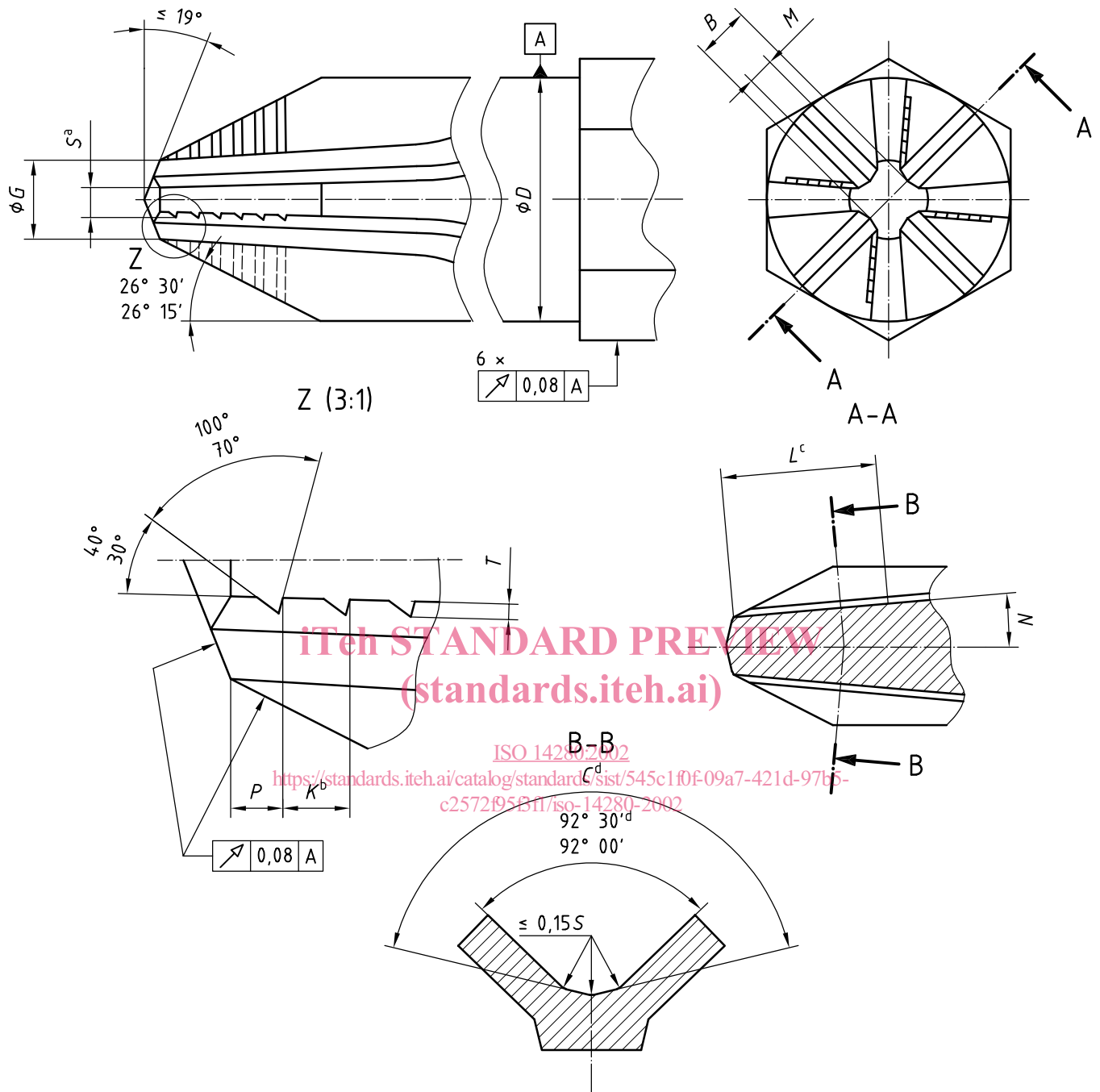
The presentation of the run-out tolerances conforms to ISO 1101.

3 Designation

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The driver designation shall be as follows:





Drivers shall be made from tool steel and heat-treated to hardness 56 HRC to 62 HRC in the tip area (L min. dimension)

Drivers shall be used only in drives having the same coding.

- a Measured over first rib at distance P .
- b Rib to rib.
- c Minimum length of straight surface at angle N . Thereafter, the form of run-out is optional.
- d Angle measured normal to surface established by angle N .

Figure 1 — Configuration — Driver

Table 1 — Dimensions — Driver

Driver code	<i>B</i>	<i>C</i>	<i>D</i>	<i>G</i>	<i>K</i>	<i>L</i>	<i>M</i>		<i>N</i>	<i>P</i>	<i>S</i>		<i>T</i>		Ribs	Driver code
	± 0,025	+ 0° 30' 0°	⁰ -0,25	± 0,03	⁰ -0,18	min.	nom.	tol.	^{0°} 0° 30'	max.	nom.	tol.	nom.	tol.	min.	inches ^b
R0	0,584	a	3,18	0,81	0,43	3,2	0,337	± 0,047	7°	0,38	0,3	0,05	⁰ -0,02	3	0	
R1	1,001	138°	4,78	1,27	0,56		0,513	± 0,025		5° 45'	0,64		0,53			0,1
R2	1,539	140°	6,35	2,29		4,8	1,102		0,64		0,64					
R3	2,497	146°	7,92	3,81		7,2	2,098		1,14		0,79					
R4	3,574	153°	12,7	5,08		8,8	2,738		1,27		1,12					
R5	5,867	162° 46'	15,88	7,9		0,84	13,5				4,394	1,6	⁰ -0,08	0,15	12	

^a Radius: 0,28 max.; 0,21 min.
^b For information and comparison purposes only.

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Bibliography

- [1] ISO 1101:—¹, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*
- [2] ISO 12256:—², *Aerospace — Drives, internal, cruciform, ribbed — Metric series*
- [3] ISO 14279:2002, *Aerospace — Drives, internal, cruciform — Metric series*

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1) To be published. (Revision of ISO 1101:1983)
2) To be published.

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