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**Hand taps for parallel and taper pipe  
threads — General dimensions and  
marking**

*Tarauds à main pour filetages cylindrique et conique de tuyauterie —  
Dimensions générales et marquage*

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html)

This document was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This fourth edition cancels and replaces the third edition (ISO 2284:1987), of which it constitutes a minor revision with the following changes: [ISO 2284:2017](http://www.iso.org/iso/foreword.html#ISO 2284:2017)

- added [Annex B](#) giving the relationship between the symbols of this document and the symbols according to the ISO 13399 series.

# Hand taps for parallel and taper pipe threads — General dimensions and marking

## 1 Scope

This document specifies the general dimensions and marking of hand taps for pipe threads.

It is applicable to the two following types of tap:

- taps for parallel threads (see [Figure 1](#) and [Table 1](#)),
- taps for taper threads (see [Figure 2](#) and [Table 2](#)),

having threads in accordance with ISO 7-1 and ISO 228-1.

Furthermore, it gives in [Annex A](#) the bases used for calculation of the dimensions, and in Annex B the relationship between designations in this document and the ISO 13399 series.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 237, *Rotating tools with parallel shanks — Diameters of shanks and sizes of driving squares*

ISO 5969, *Ground thread taps for pipe threads G series and Rp series — Tolerances on the threaded portion*

[ISO 2284:2017](#)

## 3 Terms and definitions

<https://standards.iec.ch/standard/iso/iso-2284-17>

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

## 4 General dimensions

The general dimensions are given in [Table 1](#) and [Table 2](#).

Shank diameters and driving squares shall conform to the specifications given in ISO 237, the tolerances being as follows:

- on diameter,  $d_1$ :
  - h9 for precision shanks;
  - h11 for other shanks;
- on width across flats,  $a$ :
  - h11;
  - h12 (including errors of form of the square and of its position in relation to the shank).

## 5 Marking

Taps in accordance with this document and with the requirements of ISO 5969 shall be marked, on the shank, with the following indications:

- a) the letter designating the thread series;
- b) the designation of the thread.

A G series parallel thread tap with designation 3/4 shall be marked as follows:

**G 3/4**

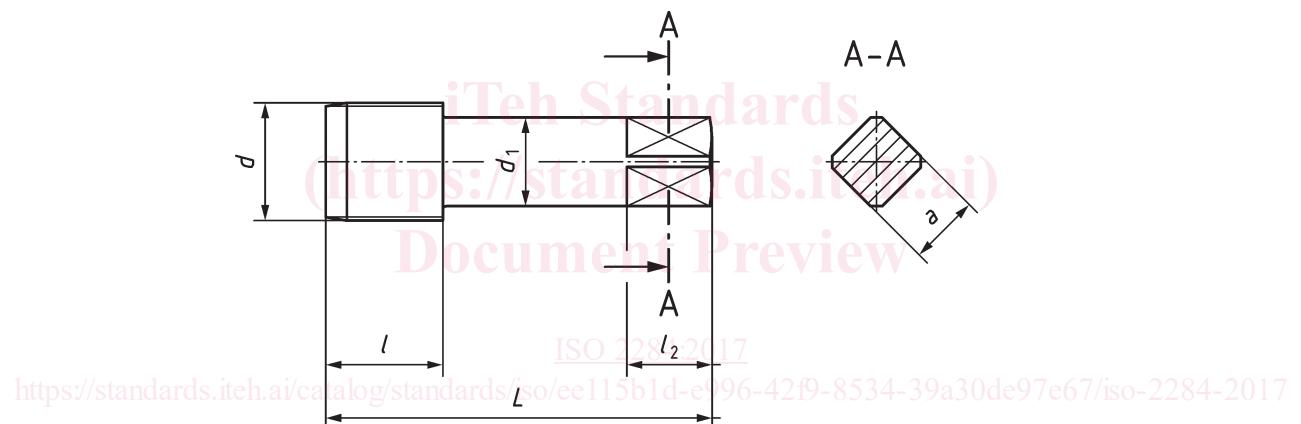
An Rp series parallel thread tap with designation 1/4 shall be marked as follows:

**Rp 1/4**

An Rc series taper thread tap with designation 1 shall be marked as follows:

**Rc 1**

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.



**Figure 1 — Tap for parallel threads — G series and Rp series**