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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 678

MODULES AND DIAMETRAL PITCHES OF STRAIGHT BEVEL GEARS FOR GENERAL ENGINEERING AND HEAVY ENGINEERING

1st EDITION

March 1968

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Also issued in French and Russian. Copies to be obtained through the national standards organizations.

BRIEF HISTORY

The ISO Recommendation R 678, *Modules and diametral pitches of straight bevel gears for general engineering and heavy engineering,* was drawn up by Technical Committee ISO/TC 60, *Gears,* the Secretariat of which is held by the Institut Belge de Normalisation (IBN).

Work on this question by the Technical Committee began in 1962 and led, in 1965, to the adoption of a Draft ISO Recommendation.

In December 1965, this Draft ISO Recommendation (No. 884) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Argentina	India	Sweden
Australia	Israel	Switzerland
Austria	Italy	Turkey
Belgium	Japan	United Kingdom
Brazil	Netherlands	U.S.S.R.
Bulgaria	New Zealand	Yugoslavia
Chile	Poland	
Czechoslovakia	Portugal	
France	South Africa, Rep. of	
Germany		
Hungary	Spain	

No Member Body opposed the approval of the Draft.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in March 1968, to accept it as an ISO RECOMMENDATION.

ISO Recommendation R 678 March 1968

MODULES AND DIAMETRAL PITCHES OF STRAIGHT BEVEL GEARS FOR GENERAL ENGINEERING AND HEAVY ENGINEERING

INTRODUCTION

This ISO Recommendation, intended essentially to facilitate the establishment of series of cutting tools, is not intended to prevent the use of any unstandardized module or diametral pitch, which can always be obtained by using the tool for the module or diametral pitch corresponding to the next smaller size given in the Table.

MODULES AND DIAMETRAL PITCHES

Preference should be given to the use of the modules and diametral pitches stated in column I. The three modules shown in brackets in column III should be avoided wherever possible.

Modules m

I	II	III
1		
	1.125	
1.25		
	1.375	
1.5		
	1.75	
2		
	2.25	
2.5		
	2.75	
3		(3.25)
	3.5	
4		(3.75)
	4.5	
5		
	5.5	
6		(6.5)
	7	
8		
	9	
10		
	11	
12		
	14	
16		
	18	
20		
	22	
25		
	28	
32		
	36	
40		
	45	
50		

Diametral pitches P

I	II
20	
	18
16	
	14
12	
	11
10	
	9
8	
	7
6	
	5.5
5	
	4.5
4	
	3.5
3	
	2.75
2.5	
	2.25
2	
	1.75
1.5	
	0.875
1.25	
1	
0.75	
0.625	
0.50	