
**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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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).

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The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This third edition cancels and replaces the second edition (ISO 4231:1987), of which it constitutes a minor revision with the following changes:

- [Annex A](#) has been added;
- a Bibliography has been added.

Hand- and machine-operated circular screwing dies for parallel pipe threads — G series

1 Scope

This International Standard is a supplement to ISO 2568 and ISO 4230 and specifies 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 Dimensions

The general dimensions are shown in Figure 1 and given in Table 1.

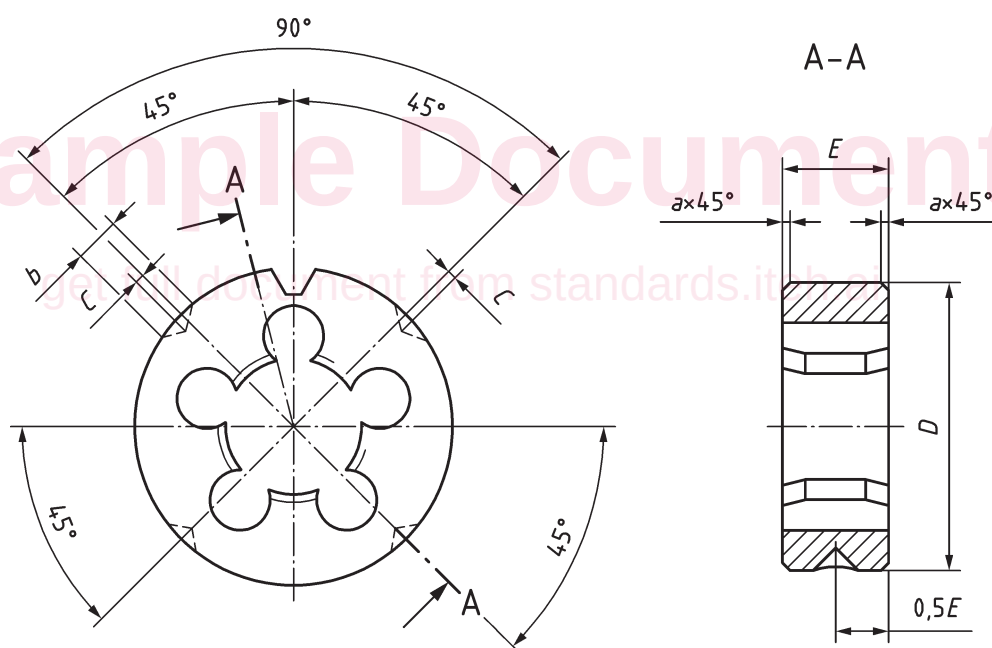


Figure 1

Table 1

Dimensions in millimetres

Thread designation	Basic diameter	Pitch $\approx$	D	E	C	b	a
1/16	7,723	0,907	25	9	0,8	5	0,5
1/8	9,728	0,907	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