
INTERNATIONAL STANDARD



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

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up 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.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 2284 was drawn up by Technical Committee ISO/TC 29, *Small tools*.

It was approved in August 1971 by the Member Bodies of the following countries :

Australia	Israel	Sweden
Austria	Italy	Switzerland
Belgium	Japan	Thailand
Czechoslovakia	Korea, Rep. of	Turkey
Egypt, Arab Rep. of	Netherlands	United Kingdom
France	Poland	U.S.A.
Hungary	Romania	U.S.S.R.
India	South Africa, Rep. of	
Ireland	Spain	

No Member Body expressed disapproval of the document.

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

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the general dimensions and marking of hand taps for pipe threads intended for the hand screwing of pipes and tubes.

It is applicable to the two following types of tap :

- taps for cylindrical threads (see Table 1),
- taps for taper threads (see Table 2), threads in accordance with ISO/R 7 and ISO/R 228.

Furthermore it includes in an Annex the bases used for calculation of the dimensions.

2 REFERENCES

ISO/R 7, *Pipe threads for gas list tubes and screwed fittings where pressure-tight joints are made on the threads (1/8 inch to 6 inches)*.¹⁾

ISO/R 228, *Pipe threads where pressure-tight joints are not made on the threads (1/8 inch to 6 inches)*.²⁾

ISO/R 237, *Diameters of shanks and sizes of driving squares for rotating tools with parallel shanks*.

ISO/R 529, *Short machine taps and hand taps*.

3 GENERAL DIMENSIONS

The general dimensions are given in Tables 1 and 2.

Shank diameters and driving squares shall conform to the specifications in ISO/R 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).

4 MARKING

Marking shall be in accordance with the specifications of ISO/R 529 and of its addenda.

1) 1st Edition 1955.

2) 1st Edition 1961.