INTERNATIONAL STANDARD 368

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Textile machinery and accessories — Tubes for ring-spinning, doubling and twisting spindles, taper 1 : 38 and 1 : 40

Matériel pour l'industrie textile — Tubes pour broches de continus à filer et à retordre à anneaux, conicité 1 : 38 et 1 : 40

First edition — 1975-05-01

UDC 677.052 **Ref. No. ISO 368-1975 (E)**

Descriptors : textile machinery, spinning frames, ring twisters, spinning (extruding), ring doubling, pipes (tube), specifications, dimensions, taper.

Price based on 6 pages

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 368 was drawn up by Technical Committee ISO/TC 72, *Textile machinery and accessories,* and circulated to the Member Bodies in November 1973.

It has been approved by the Member Bodies of the following countries :

Belgium	Germany	Spain
Bulgaria	India	Switzerland
Czechoslovakia	Ireland	Thailand
Denmark	Mexico	Turkey
Egypt, Arab Rep. of	Poland	U.S.S.R.
France	Romania	Yugoslavia

No Member Body expressed disapproval of the document.

This International Standard cancels and replaces ISO Recommendation R 368-1964, of which it constitutes a technical revision.

Printed in Switzerland

Textile machinery and accessories — Tubes for ring-spinning, doubling and twisting spindles, taper 1 : 38 and 1 : 40

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions and tolerances (length and diameter) of tubes with taper 1 : 38 and 1 : 40 for ring-spinning, doubling and twisting spindles.

2 DIMENSIONS AND TOLERANCES

2.1 Taper 1 : 38

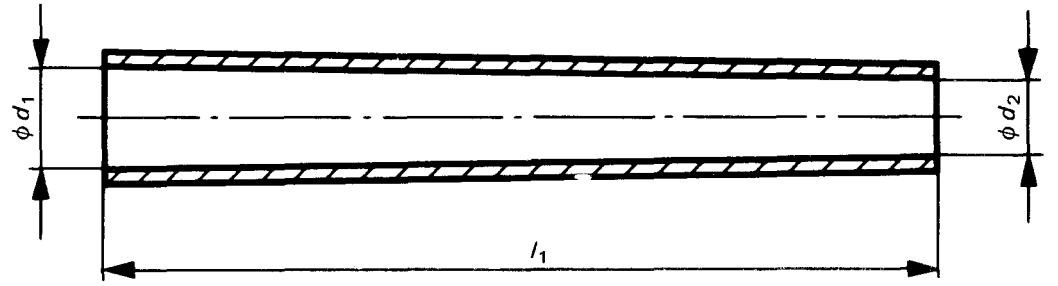

FIGURE 1a) – **Tube type A with plain top**

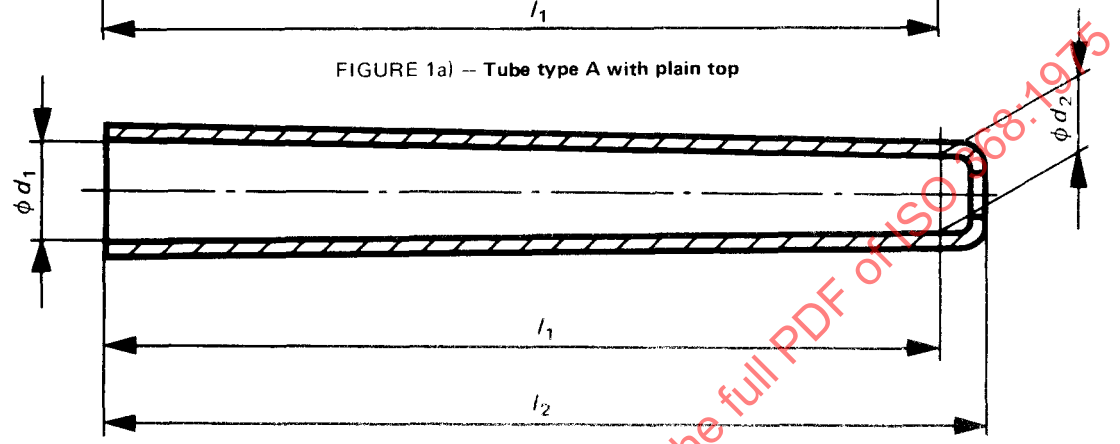

FIGURE 1b) – **Tube type B with rolled-in top**

TABLE 1 – **Dimensions and tolerances for tubes**

Values in millimetres

Length		**Tolerance**	**Row 0**		**Row 1**		**Row 2**		**Row 3**	
l_1	l_2	l_1 and l_2	d_1	d_2	d_1	d_2	d_1	d_2	d_1	d_2
200	210	± 1,5	22,26	17,00	20,26	15,00	18,76	13,50	–	–
(210)	(220)		22,27	16,75	20,27	14,75	18,77	13,25	–	–
220	230		24,28	18,50	22,28	16,50	20,28	14,50	18,78	13,00
(230)	(240)		24,30	18,25	22,30	16,25	20,30	14,25	18,80	12,75
240	250	± 2,0	27,31	21,00	24,31	18,00	22,31	16,00	20,31	14,00
(250)	(260)		27,32	20,75	24,32	17,75	22,32	15,75	20,32	13,75
260	270		30,34	23,50	27,34	20,50	24,34	17,50	22,34	15,50
(270)	(280)		30,35	23,25	27,35	20,25	24,35	17,25	22,35	15,25
280	290		33,36	26,00	30,36	23,00	27,36	20,00	24,36	17,00
(290)	(300)		33,37	25,75	30,37	22,75	27,37	19,75	24,37	16,75
300	310	± 2,5	36,39	28,50	33,39	25,50	30,39	22,50	27,39	19,50
320	330		39,42	31,00	33,42	25,00	30,42	22,00	–	–
340	350	± 3,0	42,44	33,50	36,44	27,50	33,44	24,50	–	–
360	370		45,47	36,00	39,47	30,00	36,47	27,00	–	–
380	390		48,50	38,50	42,50	32,50	39,50	29,50	–	–
400	410		51,52	41,00	45,52	35,00	42,52	32,00	–	–
450	460		60,59	48,75	54,59	42,75	49,59	37,75	–	–
500	510	± 4,0	70,65	57,50	62,65	49,50	56,65	43,50	–	–
550	560		80,72	66,25	70,72	56,25	64,72	50,25	–	–
600	610		90,79	75,00	80,79	65,00	70,79	55,00	–	–
650	660		–	–	90,85	73,75	80,85	63,75	–	–
700	710		–	–	100,92	82,50	90,92	72,50	–	–
750	760	± 5,0	–	–	110,99	91,25	100,99	81,25	–	–
800	810		–	–	121,05	100,00	111,05	90,00	–	–

The values framed in bold are preferred. The values in brackets should be avoided wherever possible, in both the preferred and non-preferred areas.

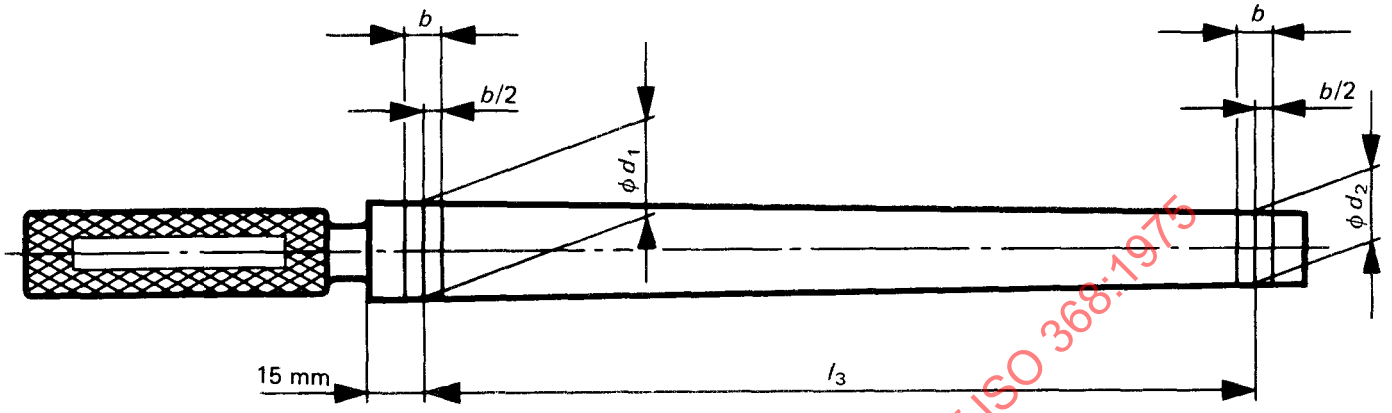

FIGURE 2a) – **Gauge for tubes type A**

TABLE 2a) – **Dimensions and tolerances for gauges for tubes type A**

Values in millimetres

Length $l_3 \pm 0,2$	**Row 0**		**Row 1**		**Row 2**		**Row 3**		**Distance** $b \pm 0,1$
	d_1	d_2	d_1	d_2	d_1	d_2	d_1	d_2	
200	22,26	17,00	20,26	15,00	18,76	13,50	–	–	6
210	22,27	16,75	20,27	14,75	18,77	13,25	–	–	
220	24,28	18,50	22,28	16,50	20,28	14,50	18,78	13,00	
230	24,30	18,25	22,30	16,25	20,30	14,25	18,80	12,75	
240	27,31	21,00	24,31	18,00	22,31	16,00	20,31	14,00	8
250	27,32	20,75	24,32	17,75	22,32	15,75	20,32	13,75	
260	30,34	23,50	27,34	20,50	24,34	17,50	22,34	15,50	
270	30,35	23,25	27,35	20,25	24,35	17,25	22,35	15,25	
280	33,36	26,00	30,36	23,00	27,36	20,00	24,36	17,00	
290	33,37	25,75	30,37	22,75	27,37	19,75	24,37	16,75	
300	36,39	28,50	33,39	25,50	30,39	22,50	27,39	19,50	10
320	39,42	31,00	33,42	25,00	30,42	22,00	–	–	
340	42,44	33,50	36,44	27,50	33,44	24,50	–	–	12
360	45,47	36,00	39,47	30,00	36,47	27,00	–	–	
380	48,50	38,50	42,50	32,50	39,50	29,50	–	–	14
400	51,52	41,00	45,52	35,00	42,52	32,00	–	–	
450	60,59	48,75	54,59	42,75	49,59	37,75	–	–	16
500	70,65	57,50	62,65	49,50	56,65	43,50	–	–	18
550	80,72	66,25	70,72	56,25	64,72	50,25	–	–	
600	90,79	75,00	80,79	65,00	70,79	55,00	–	–	
650	–	–	90,85	73,75	80,85	63,75	–	–	20
700	–	–	100,92	82,50	90,92	72,50	–	–	
750	–	–	110,99	91,25	100,99	81,25	–	–	25
800	–	–	121,05	100,00	111,05	90,00	–	–	

The marks $\pm b/2$ at the small end of the gauge are used only for checking the internal diameter at the top of the tube. For checking the internal diameter at the base of the tube by means of the corresponding marks on the gauge, the tube must be cut into parts.

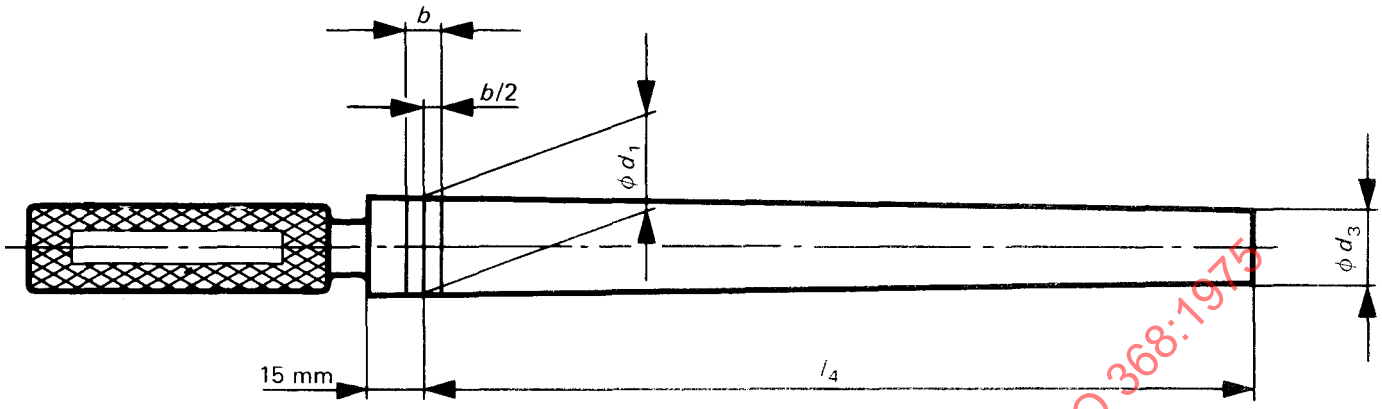

FIGURE 2b) — **Gauge for tubes type B**

TABLE 2b) — **Dimensions and tolerances for gauges for tubes type B**

Values in millimetres

Length $l_4 \pm 0,2$	Row 0		Row 1		Row 2		Row 3		Distance $b \pm 0,1$
	d_1	d_3	d_1	d_3	d_1	d_3	d_1	d_3	
200	22,26	17,00	20,26	15,00	18,76	13,50	–	–	6
210	22,27	16,75	20,27	14,75	18,77	13,25	–	–	
220	24,28	18,50	22,28	16,50	20,28	14,50	18,78	13,00	
230	24,30	18,25	22,30	16,25	20,30	14,25	18,80	12,75	
240	27,31	21,00	24,31	18,00	22,31	16,00	20,31	14,00	8
250	27,32	20,75	24,32	17,75	22,32	15,75	20,32	13,75	
260	30,34	23,50	27,34	20,50	24,34	17,50	22,34	15,50	
270	30,35	23,25	27,35	20,25	24,35	17,25	22,35	15,25	
280	33,36	26,00	30,36	23,00	27,36	20,00	24,36	17,00	
290	33,37	25,75	30,37	22,75	27,37	19,75	24,37	16,75	
295	36,39	28,63	33,39	25,63	30,39	22,63	27,39	19,63	10
315	39,42	31,13	33,42	25,13	30,42	22,13	–	–	
330	42,44	33,76	36,44	27,76	33,44	24,76	–	–	12
350	45,47	36,26	39,47	30,26	36,47	27,26	–	–	
370	48,50	38,76	42,50	32,76	39,50	29,76	–	–	14
390	51,52	41,26	45,52	35,26	42,54	32,26	–	–	
440	60,59	49,01	54,59	43,01	49,59	38,01	–	–	16
485	70,65	57,89	62,65	49,89	56,65	43,89	–	–	18
535	80,72	66,64	70,72	56,64	64,72	50,64	–	–	
585	90,79	75,40	80,79	65,40	70,79	55,40	–	–	
630	–	–	90,85	74,27	80,85	64,27	–	–	20
680	–	–	100,92	83,03	90,92	73,03	–	–	
730	–	–	110,99	91,78	100,99	81,78	–	–	25
780	–	–	121,05	100,52	111,05	90,52	–	–	

For checking the internal diameter at the base of the tube by means of the corresponding marks on the gauge, the tube must be cut into parts.