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Transformed

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 722

ROCK DRILLING

HOLLOW HEXAGONAL DRILL STEELS IN BAR FORM

1st EDITION

May 1968

For each individual country the only valid standard is the national standard of that country.

Printed in Switzerland

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

BRIEF HISTORY

The ISO Recommendation R 722, *Rock drilling — Hollow hexagonal drill steels in bar form*, was drawn up by Technical Committee ISO/TC 82, *Mining*, the Secretariat of which is held by the Deutscher Normenausschuss (DNA).

Work on this question by the Technical Committee began in 1960 and led, in 1964, to the adoption of a Draft ISO Recommendation.

In April 1965, this Draft ISO Recommendation (No. 801) 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:

Australia	Japan	Sweden
Belgium	Korea, Rep. of	Turkey
Brazil	Netherlands	U.A.R.
Chile	New Zealand	United Kingdom
Czechoslovakia	Poland	
France	Portugal	
Germany	South Africa, Rep. of	
Hungary	Spain	
India		

Three Member Bodies opposed the approval of the Draft:

Canada
U.S.S.R.
Yugoslavia

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

ISO Recommendation R 722 May 1968

ROCK DRILLING

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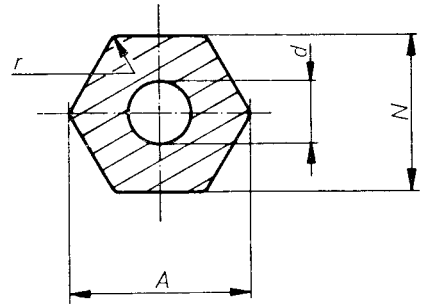

TABLE 1 — Dimensions in millimetres

Hexagonal size mm	N Basic size	N Tolerance	A ≈	d	r	Eccentricity: distance between the centre of the hexagon and the centre of the hole max.	Section ≈ mm²	Mass ≈ kg/m
19	19.2	+ 0.1 − 0.4	21.4	6 ± 0.5	1.5 $^{+1}_{0}$	0.75	285	2.2
22	22.4		24.8	6.7 ± 0.6	2 $^{+1}_{0}$	0.75	390	3.1
25	25.6	0 − 0.6	28.5	7.6 ± 0.75	2 $^{+1}_{0}$	0.75	510	4

TABLE 2 — Dimensions in inches

Hexagonal size in	N Basic size	N Tolerance	A ≈	d	r	Eccentricity: distance between the centre of the hexagon and the centre of the hole max.	Section ≈ in²	Mass ≈ lb/ft
3/4	0.756	+ 0.004 − 0.016	0.843	0.236 ± 0.020	0.059 $^{+0.039}_{0}$	0.030	0.442	1.48
7/8	0.882		0.976	0.264 ± 0.024	0.079 $^{+0.039}_{0}$	0.030	0.605	2.08
1	1.008	0 − 0.024	1.122	0.299 ± 0.030	0.079 $^{+0.039}_{0}$	0.030	0.791	2.69

Relative density 7.85.