

Käsitsi ja mootoriga käitatavad ümar- keermelõikurid ja käsiajamiga keermelõikurid

Hand- and machine-operated circular screwing dies
and hand-operated die stocks

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 22568:1999 sisaldab Euroopa standardi EN 22568:1989 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 12.12.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 22568:1999 consists of the English text of the European standard EN 22568:1989.</p> <p>This document is endorsed on 12.12.1999 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p>Käsitlusala:</p> <p>Standard määrab kindlaks käsitsi ja mootoriga käitatavate keermelõikurite põhimõtted. Need mõtted on määratud olenevalt keeme läbimõõdust ja sammust ning koosnevad alljärgnevast: välisläbimõõt, paksus, keermestatava osa pikkus, põhilised kinnitamismõtted. Standard esitab samuti ka käsiajamiga keermelõikuri mõtted, mis tagavad vahetatavuse.</p>	<p>Scope:</p>
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ICS 25.100.50

Võtmesõnad: keermelõikurid, lõikeriistad, märgistamine, tööriistad

UDC 621.992.3 : 621.88.082.1

Descriptors: Power-operated tools, threading dies, die stocks, dimensions.

English version

**Hand and machine-operated circular screwing dies
and hand-operated die stocks
(ISO 2568 : 1988)**

Filières rondes de filetage, à main et à
machine, et porte-filière à main
(ISO 2568 : 1988)

Runde Hand- und Maschinen-Schneidei-
sen und Schneideisenhalter
(ISO 2568 : 1988)

This European Standard was approved by CEN on 1989-06-09 and is identical to the ISO Standard as referred to.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization

Comité Européen de Normalisation

Europäisches Komitee für Normung

Central Secretariat: rue de Stassart 36, B-1050 Brussels

Foreword

Following the positive result of the PQ procedure, CEN/BT decided in 1988 to submit International Standard ISO 2568 : 1988 Hand and machine-operated circular screwing dies and hand-operated die stocks to Formal Vote. The result was positive.

In accordance with the CEN/CENELEC Internal Regulations, the following countries are bound to implement this European Standard:

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

Endorsement notice

The text of the International Standard ISO 2568 : 1988 was approved by CEN as a European Standard without any modification.

1 Scope and field of application

This International Standard specifies the general dimensions of hand-operated and machine-operated screwing dies. These dimensions, established as a function of the thread diameter and pitch, are the following:

- outside diameter;
- thickness;
- cutting portion length;
- general dimensions of attachment.

It also gives the interchangeability dimensions of hand-operated die stocks.

This International Standard is applicable to screwing dies intended for the manufacture of the following threads:

- ISO metric threads:
 - coarse thread, from M1 to M68;
 - fine thread, from M1 to M56.
- ISO inch threads:
 - "Unified coarse" series (UNC), from No. 1 — 64 to 2 $\frac{3}{4}$ — 4;
 - "Unified fine" series (UNF), from No. 0 — 80 to 1 $\frac{1}{2}$ — 12.

The dimensional characteristics of circular screwing dies, as a function of thread diameters and pitches, are given in annex A.

The general dimensions of screwing dies for threads which are not dealt with in this International Standard, and therefore are not recommended, are given for guidance only in annex B. Annex B is applicable to screwing dies for inch threads of the following types:

- B.1 — "British Standard Whitworth" (BSW).
- B.2 — "British Standard Fine" (BSF).
- B.3 — "British Association" (BA).

All screwing dies are available in two classes, namely

- non-precision screwing dies;
- precision screwing dies.