

**ISO meeterkeerme põhikeermepuuride  
tolerantsiväljad 4H-8H ning 4G-6G hõreda ja  
tiheda keermesammu kohta. Keermestatud osa  
valmistustolerantsid**

Ground thread taps for ISO metric threads of  
tolerances 4H to 8H and 4G to 6G coarse and fine  
itches - Manufacturing tolerances on the threaded  
portion

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 22857:1999 sisaldab Euroopa standardi EN 22857:1989 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 12.12.1999 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN 22857:1999 consists of the English text of the European standard EN 22857:1989.

This standard is ratified with the order of Estonian Centre for Standardisation dated 12.12.1999 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

The standard is available from Estonian standardisation organisation.

ICS 25.100.50

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## English version

Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches; Manufacturing tolerances on the threaded portion (ISO 2857:1973 encl. Amd 1:1984 and Amd 2:1986)

Tarauds à filets rectifiés pour filetages métriques ISO de tolérance 4H à 8H et 4G à 6G à pas gros et à pas fins; Tolérances d'exécution de la partie taillée (ISO 2857:1973, Amd 1:1984 et Amd 2:1986 inclus)

Geschliffene Gewindebohrer für metrische ISO-Gewinde mit Toleranzfeld 4H bis 8H und 4G bis 6G für Regel- und Feingewinde; Festigungstoleranzen des Gewindeteiles (ISO 2857:1973 mit Amd 1:1984 und Amd 2:1986)

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

CEN members are bound to comply with the requirements of the CEN/CENELEC Common Rules 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 CEN 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 CEN Central Secretariat has the same status as the official versions.

CEN members are the national standards organizations of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, 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 Bréderode 2, B-1000 Brussels

### Brief History

Following consideration of the results of a Primary Questionnaire among members, the CEN Technical Board decided in March 1988 to submit the International Standard

ISO 2857:1973 including Amendment 1:1984 and Amendment 2:1986

Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches; Manufacturing tolerances on the threaded portion

to the Formal Vote. This vote was positive.

### Statement

The text of the International Standard ISO 2857:1973 including Amendment 1:1984 and Amendment 2:1986 having been approved by CEN as a European Standard without any modification according to the Common CEN/CENELEC Rules, the following countries are bound to implement this standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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# INTERNATIONAL STANDARD



# 2857

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**Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches — Manufacturing tolerances on the threaded portion**

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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 2857 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and circulated to the Member Bodies in August 1972.

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

|                     |             |                       |
|---------------------|-------------|-----------------------|
| Austria             | India       | Romania               |
| Belgium             | Ireland     | South Africa, Rep. of |
| Chile               | Israel      | Switzerland           |
| Czechoslovakia      | Italy       | Thailand              |
| Egypt, Arab Rep. of | Netherlands | Turkey                |
| France              | New Zealand | United Kingdom        |
| Germany             | Poland      |                       |

The Member Bodies of the following countries expressed disapproval of the document on technical grounds :

Japan  
Sweden

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# Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches — Manufacturing tolerances on the threaded portion

## 1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the manufacturing tolerances on the threaded portion of taps for producing the ISO metric threads of tolerance classes 4H to 8H and 4G to 6G as defined in ISO/R 965/I to III (excluding, consequently, classes 7G and 8G considered as usually produced with ground thread taps).

It is valid for the short taps specified in ISO/R 529 as well as for any other kind of ground thread taps with the same diameters and pitches.

The internal threads produced with those taps are conventionally designated by the simplified denomination of "nut" in agreement with the word used in ISO/R 965 for the general designation of all internal threads.

Annexes A and B give, for all threads with coarse and fine pitches, the manufacturing tolerances on the threaded portion of taps for the following classes of nuts :

4H and 5H — 6H — 7H and 8H

and

4G and 5G — 6G

## 2 REFERENCES

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

ISO/R 724, *ISO general purpose metric screw threads — Basic dimensions.*

ISO/R 965/I, *ISO general purpose metric screw threads — Tolerances — Principles and basic data.*

ISO/R 965/II, *ISO general purpose metric screw threads — Tolerances — Limits of sizes for commercial bolt and nut threads — Medium quality.*

ISO/R 965/III, *ISO general purpose metric screw threads — Tolerances — Deviations for constructional threads.*

## 3 BASIC DATA

3.1 Thread profile of nuts : see figure 1.

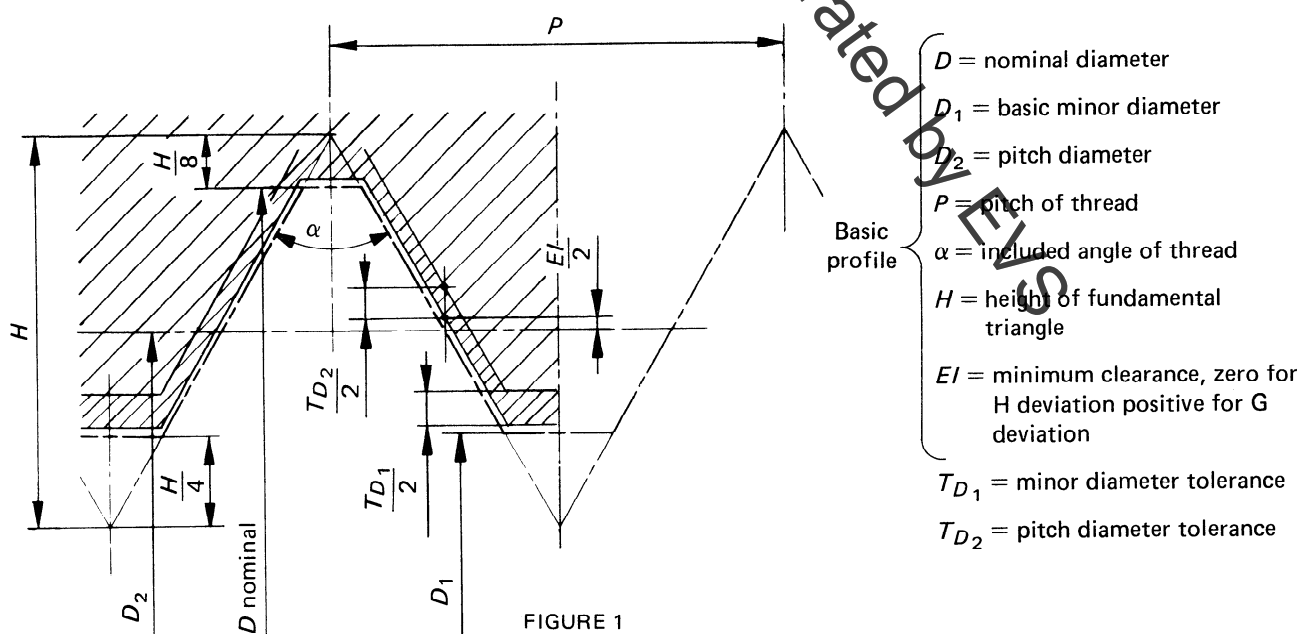


FIGURE 1