INTERNATIONAL STANDARD

ISO 4231

Third edition
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Hand- and machine-operated circular screwing dies for parallel pipe threads — G series

Filières rondes de filetage, à main et à machine, pour filetages cylindriques de tuyauterie — Série G

Reference number
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Foreword

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This third edition cancels and replaces the second edition (ISO 4231:1987), of which it constitutes a minor revision with the following changes:

— Annex A has been added;

— a Bibliography has been added.

Hand- and machine-operated circular screwing dies for parallel pipe threads — G series

1 Scope

This International Standard is a supplement to ISO 2568 and ISO 4230 and specifies the dimensions of hand- and machine-operated circular screwing dies intended for production of parallel pipe threads, G series, in accordance with ISO 228-1.

The general dimensions of these dies (diameter, thickness and fixing dimensions) are in accordance with ISO 2568 so as to permit the driving of hand-operated dies with the aid of the die stocks defined in that document.

2 Dimensions

The general dimensions are shown in Figure 1 and given in Table 1.

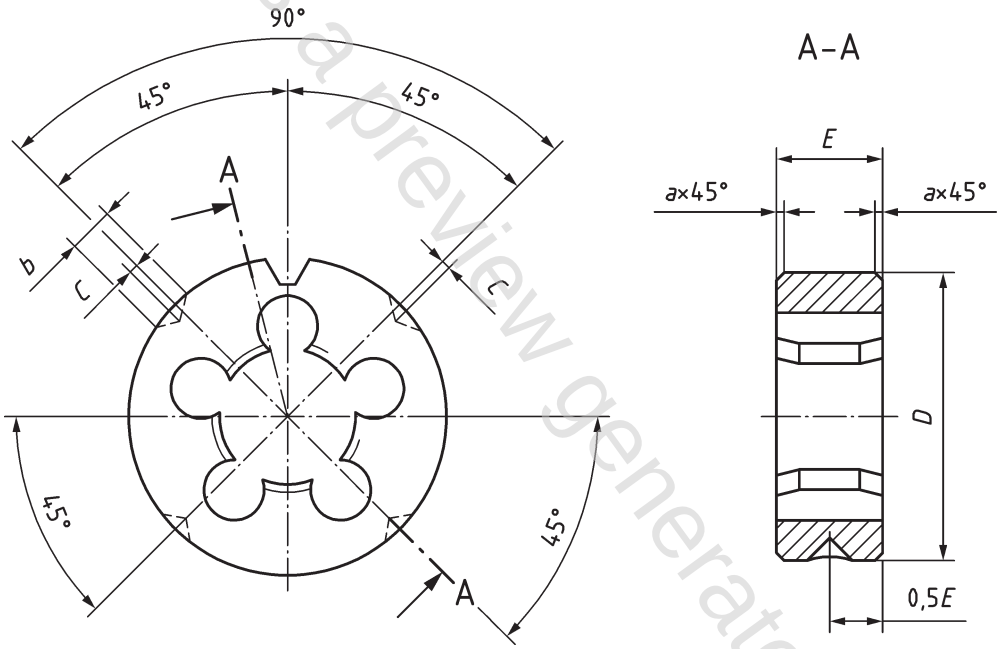

Figure 1

Table 1

Dimensions in millimetres

Thread designation	Basic diameter	Pitch ≈	*D*	*E*	*C*	*b*	*a*
1/16	7,723	0,907	25	9	0,8	5	0,5
1/8	9,728	0,907	30	11	1	5	1
1/4	13,157	1,337	38	10	1,2	6	1
3/8	16,662	1,337	45	14	1,2	6	1
1/2	20,955	1,814	45	14	1,2	6	1
5/8	22,911	1,814	55	16	1,5	8	1