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Short machine taps and hand taps

Tarauds courts à machine et à main



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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 529 was prepared by Technical Committee ISO/TC 29, *Small tools*, Sub-Committee SC 4, *Screwing taps and dies*.

This second edition cancels and replaces the first edition (ISO 529:1975), of which it constitutes a technical revision.

Annex A forms an integral part of this International Standard. Annexes B and C are for information only.

Short machine taps and hand taps

Section 1: General

1.1 Scope

This International Standard specifies the general dimensions of short machine taps and hand taps. These dimensions, established as functions of the thread diameter and pitch, are the following:

- length of thread (maximum);
- overall length;
- shank diameter and dimensions of driving square;
- dimensions of the connecting portion between the shank and threaded part.

This International Standard is applicable to taps intended for cutting the following threads:

- a) ISO metric threads
 - coarse pitch;
 - fine pitch.
- b) ISO inch threads
 - “Unified Coarse” series (UNC) and “Unified Fine” series (UNF).
- c) Inch threads, non-recommended
 - “British Standard Whitworth” (BSW) and “British Standard Fine” (BSF);
 - “British Association” (BA).

NOTES

1 The overall length, thread length and diameters of shank for taps whose thread diameter and pitch are not listed in tables are given in table A.1.

2 Annex B gives an abstract from ISO 237 for shank diameters and size of driving squares, for information.

Technical specifications for taps covered by this International Standard (including marking) are given in ISO 8830.

1.2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject

to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 237:1975, *Rotating tools with parallel shanks — Diameters of shanks and sizes of driving squares.*

ISO 2857:1973, *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 8830:1991, *High-speed steel machine taps with ground threads — Technical specifications.*

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