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**INTERNATIONAL STANDARD**



**2857**

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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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**

First edition – 1973-12-01

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**UDC 621.993**

**Ref. No. ISO 2857-1973 (E)**

**Descriptors :** tools, taps, screw threads, dimensional tolerances

Price based on 13 pages

## FOREWORD

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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 :

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Chile	Israel	Switzerland
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Germany	Poland	

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

Japan  
Sweden

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Printed in Switzerland

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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.

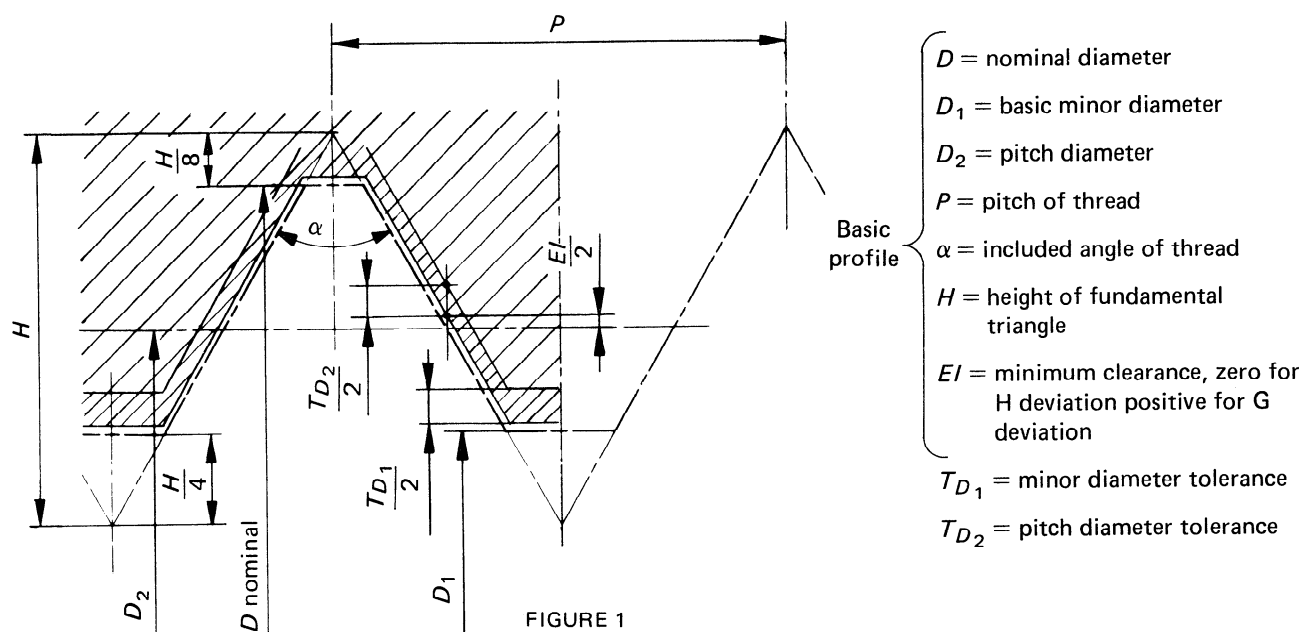


FIGURE 1



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