



Published 1986-09-15

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

Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches — Manufactured tolerances on the threaded portion AMENDMENT 2

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

AMENDEMENT 2

Amendment 2 to ISO 2857-1973 was prepared by Technical Committee ISO/TC 29, *Small tools*.

Page 6

Delete sub-clause 4.5 and substitute the following :

4.5 Tolerance on pitch

The limits of tolerance on the pitch shall be as shown in table 4, which also shows the length over which the measurement shall be made, expressed in number of pitches.

Table 4 — Tolerance on pitch

Pitch mm	Measuring length in number of of pitches	Limits of tolerance µm
0,25 0,3 0,35 0,4 0,45 0,5 0,6	12	± 8
0,7 0,75 0,8 1 1,25	9	± 8
1,5	7	± 8
1,75		± 9
2		± 10
2,5		
3		± 12
3,5		± 13
4		± 14
4,5		± 15
5		± 16
5,5		± 17
6		± 18

UDC 621.993

Ref. No. ISO 2857-1973/A2-1986 (E)

Descriptors : tools, cutting tools, taps, screw threads, dimensional tolerances.

© International Organization for Standardization, 1986 •

Printed in Switzerland

Price group A