

Specification for

Dimensions of conduit dies, diestocks and guides

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The Government department and organization marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this British Standard.

British Electrical Conduit Systems Association	Society of Motor Manufacturers and Traders Ltd.
Electrical Contractors' Association (Incorp.)	
Screw Thread Tool Manufacturers' Association	Individual experts

This British Standard, having been approved by the Mechanical Engineering Industry Standards Committee, was published under the authority of the Executive Board on 17 May 1974

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Foreword

This British Standard has been prepared under the authority of the Mechanical Engineering Industry Standards Committee in response to a request received from the Cut Thread Screwing Tool Manufacturers' Association and the Ground Thread Tap Association.

Originally published in 1951, this British Standard has been revised as part of the metrication programme and in order that provisions may be made for the metric conduit threads dealt with in BS 4568, "*Steel conduits and fittings with metric threads of ISO form for electrical installations*".

The opportunity has also been taken to make provisions for thread diameters of 40, 50 and 63 mm as it is foreseen that there will be a requirement for these additional sizes in the future.

The imperial dimensions of BS conduit dies for threads to BS 31, "*Steel conduit and fittings for electrical wiring*" given in the 1951 edition of this standard are retained in Appendix A for reference, but these should not be used for new designs as it is anticipated that they will be superseded by the end of 1974.

In Appendix B, similar provisions are made for conduit dies for screwing fastening threads of "G" designation to BS 2779, "*Fastening threads of BSP sizes*".

NOTE Attention is drawn to the certification facilities offered by BSI; see the inside back cover of this standard.

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Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 8, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

1 Scope

This British Standard provides for three sizes of dies, i.e. small, medium and large, primarily intended for use with steel conduit tubing as specified in BS 4568.

Principal dimensions are also specified for the corresponding stocks and guides for each type of die.

NOTE The titles of the British Standards referred to in this standard are given on the inside back cover.

2 Designation and screwing ranges

The three sizes of dies (and their associated guides and stocks) shall be designated Type MCS, Type MCM and Type MCL respectively and shall be applicable to the following screwing ranges:

Die	Screwing range
Type MCS	M16 up to and including M25 BS Conduit
Type MCM	M25 up to and including M40 BS Conduit
Type MCL	M50 and M63

3 Marking

Dies conforming with this standard shall be marked with the thread size and BS.CON e.g. M16 BS.CON.

4 Nomenclature

For the purposes of this standard the nomenclature given in Table 1, Table 2 and Table 3 for the principal features of dies, guides and stocks has been adopted.

5 General dimensions

The standard dimensions of dies shall be as given in Table 1. The standard dimensions of guides shall be as given in Table 2. The standard dimensions of stocks shall be as given in Table 3.

6 Finished sizes of guides

When guides are finished by enamelling or other processes, the finished sizes after coating shall not exceed the upper limits specified in Table 2.