

Screwing taps —

Part 3: Specification for pipe thread taps

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Committees responsible for this British Standard

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- British Electrical Systems Association (BEAMA Ltd.)
- Federation of British Engineers' Tool Manufacturers

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Foreword

This Part of BS 949 has been prepared under the direction of the Machine, Engineers and Hand Tools Standards Policy Committee, and supersedes BS 949-3:1982 which is withdrawn.

In 1989 the European Committee for Standardization (CEN) endorsed ISO 2857:1973 and ISO 5967:1981, published by the International Organization for Standardization (ISO), as EN 22857:1989 and EN 25967:1989 respectively. Both were given the status of national standards without modification, with the publication of BS 949-4:1990 (identical to EN 22857) and Part 5:1990 (identical to EN 25967) which fulfils the United Kingdom obligations as a member of CEN in this respect.

BS 949-3:1982 has been revised to withdraw any requirements conflicting with EN 22857 and EN 25967. However, the general dimensions and thread manufacturing tolerances given in this Part remain unchanged from those given in the 1982 edition.

For the general dimensions of the taps, this Part of BS 949 is technically equivalent to ISO 2284:1987. For the dimensions and manufacturing tolerances on the threaded portion of taps for G and R_p series threads it is related to ISO 5969:1979. There is no ISO standard specifying the tolerances on the threaded portion for R_c series threads.

BS 949 now consists of the following Parts.

- *Part 1: Specification of general dimensions;*
- *Part 2: Specification for Unified ground thread taps: manufacturing tolerances;*
- *Part 3: Specification for pipe thread taps;*
- *Part 4: Specification for metric ground thread taps: manufacturing tolerances;*
- *Part 5: Nomenclature and terminology.*

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 14, 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 Part of BS 949 specifies dimensions and tolerances for screwing taps for the following thread series:

- parallel internal pipe threads for use where pressure-tight joints are not required to be made on the threads, i.e. G series threads, in accordance with BS 2779:1986;
- parallel internal pipe threads for use with taper external pipe threads in making pressure-tight joints on the threads, i.e. R_p series threads, in accordance with BS 21:1985;
- taper internal pipe threads for use with taper external pipe threads in making pressure-tight joints on the threads, i.e. R_c series threads, in accordance with BS 21:1985.

2 References

2.1 Normative references

This Part of BS 949 incorporates, by reference, provisions from specific editions of other publications. These normative references are cited at the appropriate points in the text and the publications are listed on the inside back cover. Subsequent amendments to, or revisions of, any of these publications apply to this Part of BS 949 only when incorporated in it by updating or revision.

2.2 Informative references

This Part of BS 949 refers to other publications that provide information or guidance. Editions of these publications current at the time of issue of this standard are listed on the inside back cover, but reference should be made to the latest editions.

3 Right-hand and left-hand threads

Unless left-hand threads are specified in the order (see 9.2.3), any reference to taps conforming to this Part of BS 949 shall be assumed to be to taps for right-hand threads.

4 Terminology of thread profiles

The internal threads produced with the taps specified in this Part of this British Standard shall be designated by the simplified denomination "nut".

The method of dimensioning and tolerancing the thread profiles of nuts and taps shall be as illustrated in Figure 1 to Figure 6.



