

# Screwing taps —

## Part 5: Nomenclature and terminology

This European Standard EN 25 967 has the status of a British Standard

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## National foreword

This Part of BS 949 has been prepared under the direction of the Machine, Engineers and Hand Tools Standards Policy Committee and supersedes those clauses relating to nomenclature and terminology of BS 949-1:1976 (including amendment No. 1), BS 949-2:1979 and BS 949-3:1982 which are currently being revised to take this and other requirements into account. It is identical with ISO 5967:1981 “*Taps and thread cutting — Nomenclature of the main types and terminology*” prepared by Technical Committee ISO/TC 29 of the International Organization for Standardization (ISO) on which the United Kingdom was represented.

In 1989 the European Committee for Standardization (CEN) endorsed ISO 5967 as the European Standard EN 25 967:1989. The publication of this Part 5 of BS 949 fulfils the United Kingdom obligations as a member of CEN to give EN 25 967 the status of a national standard, without modification.

The existing BS 949-1:1976; BS 949-2:1979 and BS 949-3:1982 are currently being revised to withdraw any conflicting requirements with EN 25 967 and EN 22 857:1989 (which is identical to BS 949-4), again as an United Kingdom obligation as a member of CEN, and to update them taking account of ISO 529:1975 including amendments No. 1 and No. 2, ISO 2283:1972, ISO 2284:1987 and ISO 5969:1979 which have not been adopted by CEN.

It is envisaged that after the completion of these revisions BS 949 will consist of the following Parts:

- *Part 1: Specification of general dimensions for ISO metric thread taps;*
- *Part 2: Specification for unified thread taps manufacturing tolerances;*
- *Part 3: Specification for pipe thread taps;*
- *Part 4<sup>1)</sup>: Specification for metric ground thread taps: manufacturing tolerances;*
- *Part 5: Nomenclature and terminology.*

NOTE *Typographical errors.* It should be noted that there is no page 20 in the original text of ISO 5967:1981.

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, the EN title page, pages 2 to 24, 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.

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<sup>1)</sup> Published.

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English version

## Taps and thread cutting: Nomenclature of the main types and terminology

(ISO 5967:1981)

Tarauds; Nomenclature des principaux types et terminologie  
(ISO 5967:1981)

Gewindebohrer; Benennungen der wichtigsten Formen und Begriffe  
(ISO 5967:1981)

This European Standard was accepted by CEN on 9 June 1989 and is identical to the ISO standard as referred to.

CEN members are bound to comply with the requirements of the CEN/CENELEC Common Rules which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to CEN Central Secretariat has the same status as the official versions.

CEN members are the national standards organizations of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

# CEN

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

**Central Secretariat: Rue Bréderode 2, B-1000 Brussels**

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## Brief history

Following consideration of the results of a Primary Questionnaire among members, the CEN Technical Board decided in March 1988 to submit the International Standard

ISO 5967:1981, *Taps and thread cutting — Nomenclature of the main types and terminology.*

to the Formal Vote. This vote was positive.

## Statement

The text of the International Standard ISO 5967:1981 having been approved by CEN as a European Standard without any modification according to the Common CEN/CENELEC Rules, the following countries are bound to implement this standard: Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxemburg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

## 1 Scope and field of application

This International Standard on taps for ISO thread making shows the main types of taps and their dimensional characteristics. It also gives equivalent terms in the three official languages of ISO.

The purpose of this International Standard is to serve as a reference for tap users and manufacturers. The diagrams given, however, are only to illustrate the terminology as tap design can vary according to the manufacturer.

This International Standard includes

- nomenclature of the main types of taps (clause 3);
- styles of threaded portion of taps (clause 4);
- sets of taps (clause 5);
- dimensional characteristics of taps (clause 6);
- thread profile of taps (clause 7).

In addition, numbered symbols are given opposite certain terms to identify the dimensional characteristics.

NOTE — In addition to terms used in the three official ISO languages (English, French and Russian), this International Standard gives the equivalent terms in German and Italian, these have been included at the request of ISO Technical Committee TC 29

## 1 Objet et domaine d'application

La présente Norme internationale relative aux tarauds destinés à l'exécution des filetages ISO, en montre les principaux types et leurs caractéristiques dimensionnelles. Elle donne également l'équivalence des termes dans les trois langues officielles de l'ISO.

La présente Norme internationale a pour but de servir de référence pour les utilisateurs et les fabricants de ces outils. Néanmoins, les schémas représentés ne servent qu'à illustrer cette terminologie et la conception des tarauds peut varier suivant les fabricants.

La présente Norme internationale comprend

- nomenclature des principaux types de tarauds (chapitre 3);
- styles de la partie taillée des tarauds (chapitre 4);
- jeux de tarauds (chapitre 5);
- caractéristiques dimensionnelles des tarauds (chapitre 6);
- profil du filet des tarauds (chapitre 7).

De plus, sont indiqués en face de certains termes les symboles identifiant les caractéristiques dimensionnelles.

NOTE — En supplément aux termes donnés dans les trois langues officielles de l'ISO (anglais, français, russe), la présente Norme internatio-

## 1 Содержание и область применения

В этом международном стандарте по метчикам для выполнения резьб согласно стандартам ИСО показаны основные типы метчиков и их размерные характеристики. В нем также даны эквивалентные термины на трех официальных языках ИСО.

Цель этого стандарта служить справочным материалом для потребителей и изготовителей. Однако, представленные в тексте рисунки даны только для иллюстрации терминологии, так как конструкция метчика может изменяться по усмотрению изготовителей.

Этот международный стандарт состоит из следующих пяти частей:

- номенклатура основных типов метчиков (раздел 3);
- типы рабочей части метчиков (раздел 4);
- комплекты метчиков (раздел 5);
- размерные характеристики метчиков (раздел 6);
- профиль резьбы метчиков (раздел 7).

Кроме того, против определенных терминов указаны цифровые обозначения, которые определяют основные размеры.

ПРИМЕЧАНИЕ — В дополнение к терминам на трех официальных языках (английском, фран-

and are published under the responsibility of the Member Bodies for Germany, F.R. (DIN) and Italy (UNI). However, only the terms given in the official languages can be considered as ISO terms.

nale donne en annexe les termes équivalents en allemand et italien; ces termes ont été inclus à la demande du comité technique ISO/TC 29 et sont publiés sous la responsabilité des comités membres de l'Allemagne, R.F. (DIN), et de l'Italie (UNI). Toutefois, seuls les termes donnés dans les langues officielles peuvent être considérés comme termes ISO.

цузском и русском), настоящий международный стандарт дает в приложении эквивалентные термины на немецком и итальянском языках: эти термины были введены по просьбе технического комитета ИСО/ТК 29 и публикуются под ответственность комитетов-членов ФРГ и Италии. Тем не менее, только термины на официальных языках могут рассматриваться как термины ИСО.

2 References

- ISO 529, *Short machine taps and hand taps.*
- ISO 2283, *Long shank machine taps with nominal diameters from 3 to 24 mm and 1/8 to 1 in.*
- ISO 2284, *Hand taps for pipe threads for parallel and taper threads — General dimensions and marking.*
- ISO 2857, *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 3002/1, *Geometry of the active part of cutting tools — Part 1 : General terms, reference systems, tool and working angles.*

2 Références

- ISO 529, *Tarauds courts à machine et à main.*
- ISO 2283, *Tarauds à machine, à queue longue, de diamètre nominal 3 à 24 mm et 1/8 à 1 in.*
- ISO 2284, *Tarauds à main au pas du gaz pour filetages cylindrique et conique — Dimensions générales et marquage.*
- ISO 2857, *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.*
- ISO 3002/1, *Géométrie de la partie active des outils coupants — Partie 1 : Notions générales, système de référence, angles de l'outil et angles en travail.*

2 Ссылки

- ИСО 529, *Короткие машинные и ручные метчики.*
- ИСО 2283, *Машинные метчики с удлиненным хвостовиком, номинального диаметра от 3 до 24 мм и от 1/8 до 1 дюйма.*
- ИСО 2284, *Ручные метчики для трубных резьб цилиндрических и конических — Общие размеры и маркировка.*
- ИСО 2857, *Метчики со шлифованной резьбой для метрических резьб, соответствующих стандартам ИСО с допуском от 4H до 8H с крупным и мелким шагом от 4G до 6G — Размерные допуски на рабочую часть.*
- ИСО 3002/1, *Геометрия режущей части инструмента — Часть 1 : Общие термины, система ссылок, углы резания и углы режущего инструмента.*

3 Nomenclature of the main types of taps

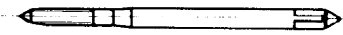
3.1 Short machine taps and hand taps

3 Nomenclature des principaux types de tarauds

3.1 Tarauds courts à machine et à main

3 Номенклатура основных типов метчиков

3.1 Короткие машинные метчики и ручные метчики

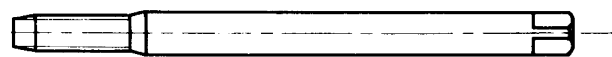
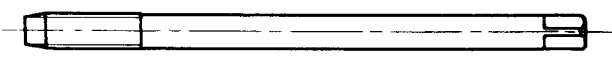
| No.<br>N°<br>N° | Diagram<br>Schéma<br>Чертеж                                                         | Designation<br>Désignation<br>Обозначение                                                                                                                                                                                                                                                                       |
|-----------------|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 110             |  | <p>Short tap with full diameter shank and a tapered connecting portion between shank and thread — ISO 529</p> <p>Taraud court à queue pleine à raccordement (conique) — ISO 529</p> <p>Короткий метчик с утолщенным хвостовиком и конической переходной частью между хвостовиком и рабочей частью — ИСО 529</p> |

| No.<br>N°<br>N° | Diagram<br>Schéma<br>Чертеж                                                         | Designation<br>Désignation<br>Обозначение                                                                                                                                                                                                                                                                                               |
|-----------------|-------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 111             |    | <p>Short tap with shank diameter approximately equal to nominal diameter</p> <p>Taraud court à queue pleine de diamètre approximativement égal au diamètre nominal</p> <p>Короткий метчик с хвостовиком, диаметр которого приблизительно равен номинальному диаметру резьбы</p>                                                         |
| 112             |    | <p>Short tap with shank diameter greater than or equal to nominal diameter and neck between shank and thread — ISO 529</p> <p>Taraud court à queue pleine à gorge — ISO 529</p> <p>Короткий метчик с хвостовиком, диаметр которого превышает или равен номинальному диаметру, с шейкой между хвостовиком и рабочей частью — ИСО 529</p> |
| 113             |  | <p>Short tap with reduced shank diameter — ISO 529</p> <p>Taraud court à queue dégagée — ISO 529</p> <p>Короткий метчик с уменьшенным диаметром хвостовика — ИСО 529</p>                                                                                                                                                                |

## 3.2 Long shank machine taps

## 3.2 Tarauds machine à queue longue

## 3.2 Машинные метчики с удлиненным хвостовиком

| No.<br>N°<br>N° | Diagram<br>Schéma<br>Чертеж                                                         | Designation<br>Désignation<br>Обозначение                                                                                                                                                                                                                                                                                                      |
|-----------------|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 120             |  | <p>Long shank machine taps with reinforced shank diameter and tapered connecting portion between shank and thread</p> <p>Taraud machine à queue longue — taraud à queue pleine à raccordement (conique)</p> <p>Машинные метчики с удлиненным и утолщенным хвостовиком и с конической переходной частью между хвостовиком и рабочей частью.</p> |
| 121             |  | <p>Long shank machine tap with shank diameter approximately equal to nominal diameter</p> <p>Taraud machine à queue longue — taraud à queue pleine de diamètre approximativement égal au diamètre nominal</p> <p>Машинный метчик с удлиненным хвостовиком, диаметр которого приблизительно равен номинальному диаметру резьбы.</p>             |