

Revised

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

**ISO RECOMMENDATION
R 65**

**STEEL TUBES
SUITABLE FOR SCREWING
IN ACCORDANCE WITH ISO RECOMMENDATION R 7**

**1st EDITION
April 1958**

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BRIEF HISTORY

The ISO Recommendation R 65, *Steel Tubes, Suitable for Screwing in accordance with ISO Recommendation R 7*, was drawn up by Technical Committee ISO/TC 5, *Pipes and Fittings*, the Secretariat of which is held by the Association Suisse de Normalisation (SNV).

At its first meeting, held in Zurich, in May 1951, the Technical Committee assigned the standardization of steel tubes, suitable for screwing in accordance with ISO Recommendation R 7, to its Sub-Committee ISO/TC 5/SC 1, *Gas List Tubes and other Steel Pipes*. The study was made on parallel lines with ISO Recommendation R 64, *Steel Tubes - Outside Diameters*, and on the basis of ISO Recommendation R 7, *Pipe Threads for Gas List Tubes and Screwed Fittings, where Pressure-Tight Joints are made on the Threads (1/8 inch to 6 inches)*.

At its meetings in Zurich, in May 1952 and November 1953, Sub-Committee 1 considered outside diameters, from 1/8 inch to 6 inches nominal bore, in conjunction with their tolerances. At Dusseldorf, in June 1954, the wall thicknesses, and especially the minimum wall thicknesses, remaining under the thread, were discussed. As a result of the Sub-Committee's meeting in Paris, in November 1954, and that of its working group in London, in February 1955, a first draft proposal was put forward.

After several other meetings, a new document was drafted, which took into account, to a large extent, the wall thicknesses and the light series II tubes, with smaller tolerances, in use in the United Kingdom. This document was adopted by the Sub-Committee, at its meeting in Rigi-Kaltbad, in July 1956, and by the Technical Committee, as a Draft ISO Recommendation.

On 10 April 1957, the Draft was sent out to all ISO Member Bodies and was approved by the following 23 Member Bodies (out of a total of 38):

*Australia	Germany	Norway
Austria	*Greece	*Portugal
Belgium	Hungary	Spain
*Canada	India	Sweden
Czechoslovakia	*Ireland	Switzerland
Denmark	Italy	Union
Finland	Netherlands	of South Africa
France	New Zealand	United Kingdom

No Member Body opposed the approval of the Draft.

In April 1958, the ISO Council decided, by correspondence, to accept the Draft ISO Recommendation as an ISO RECOMMENDATION.

* These Member Bodies stated that they had no objection to the Draft being approved.

STEEL TUBES
SUITABLE FOR SCREWING
IN ACCORDANCE WITH ISO RECOMMENDATION R 7

The present ISO Recommendation establishes the dimensions and the characteristics of seamless and welded steel tubes for four separate series, namely:

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The dimensions in millimetres and in inches, given in the tables, are considered to be "Corresponding values", although some of them are not exact equivalents. In all cases, however, the dimensions ensure practicable interchangeability.

The conventional masses have been determined by taking the arithmetical mean between the theoretical masses calculated with the formulae:

$$m = (D-t) t \times 0.024\,661\,5 \text{ kg/m} \quad \text{for the metric system}$$

$$m = (D-t) t \times 10.681\,42 \text{ lb/ft} \quad \text{for the inch system}$$

where

m = mass by unit of length,
 D = mean outside diameter,
 t = mean wall thickness,

and the conversion factor

$$1 \text{ lb/ft} = 1.488\,16 \text{ kg/m.}$$