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EN 25968:
1989
ISO 5968:1981

Screwing dies and dienuts —

Part 4: Terminology for circular screwing dies

This European Standard EN 25968 has the status of a
British Standard

UDC 621.992.3:001.4

Cooperating organizations

The European Committee for Standardization, under whose supervision this European Standard was prepared, comprises the national standards organizations of the following Western European countries.

Austria	Oesterreichisches Normungsinstitut
Belgium	Institut belge de normalisation
Denmark	Dansk Standardiseringsraad
Finland	Suomen Standardisoimisiitto, r.y.
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Germany	Deutsches Institut für Normung e.V.
Greece	Hellenic Organization for Standardization
Iceland	Technological Institute of Iceland
Ireland	National Standards Authority of Ireland
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Switzerland	Association suisse de normalisation
United Kingdom	British Standards Institution

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Amendments issued since publication

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National foreword

This Part of BS 1127 has been prepared under the direction of the Machine, Engineers and Hand Tools Standards Policy Committee and is the English language version of EN 25968 “*Circular screwing dies; Terminology*”, published by the European Committee for Standardization (CEN). It is identical with ISO 5968, published by the International Organization for Standardization (ISO).

This Part of BS 1127 together with Parts 1, 2, 3 and 5 supersedes BS 1127:1974 which is withdrawn. BS 1127 comprises the following Parts.

— *Part 1: Specification for hand- and machine-operated circular screwing dies and hand-operated die stocks;*

— *Part 2: Specification for hand- and machine-operated circular screwing dies for taper pipe threads; R series;*

— *Part 3: Specification for hand- and machine-operated circular screwing dies for parallel pipe threads; G series;*

— *Part 4: Terminology for circular screwing dies;*

— *Part 5: Specification for dimensions of hexagonal die nuts.*

BS 1127 was first published in 1943 as a war emergency standard and revised in 1950 to include hexagonal die nuts and again in 1974 to incorporate the change from inch to metric dimensions. The purpose of this present revision is to take account of changes made to related ISO standards since 1974 and the requirement of the United Kingdom as a CEN member to give European Standard EN 25968:1989 the status of a national standard without alteration and withdraw any conflicting standards.

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.

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Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, the EN title page, pages 2 to 6, 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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Key words: Power-operated tools, drawing dies, vocabulary, nomenclature

English version

Circular screwing dies: Terminology

(ISO 5968:1981)

Filières rondes de filetage; Nomenclature et terminologie (ISO 5968:1981)

Runde Schneideisen; Begriffe und Benennungen (ISO 5968:1981)

This European Standard was accepted by CEN on 6 September 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 de Stassart 36, B-1050 Brussels

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 5968:1981, *Circular screwing dies; Terminology to the Formal Vote*. This vote was positive.

Statement

The text of the International Standard ISO 5968:1981 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.

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Circular screwing dies — Terminology

Filières rondes de filetage — Nomenclature et terminologie

Круглые резьбонарезные плашки — Терминология и номенклатура

1 Scope and field of application

This International Standard lays down the terminology of circular screwing dies intended for production of threads to ISO Standards, and gives the corresponding terms in the three official ISO languages.

NOTE — In addition to terms used in the three official ISO languages (English, French and Russian), this International Standard gives the equivalent terms in the German, Italian and Dutch languages; these terms are included at the request of Technical Committee ISO/TC 29, and are published under the responsibility of the member bodies for Germany, F.R. (DIN), Italy (UNI) and the Netherlands (NNI). However, only the terms given in the official languages can be considered as ISO terms.

1 Objet et domaine d'application

La présente Norme internationale établit la nomenclature et la terminologie des filières rondes de filetage destinées à l'exécution de filetages conformes aux normes ISO, et donne la correspondance des termes dans les trois langues ISO.

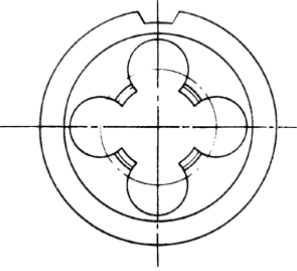
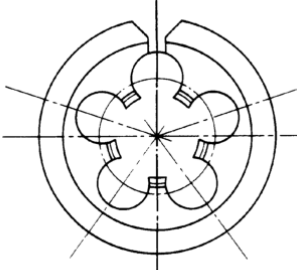
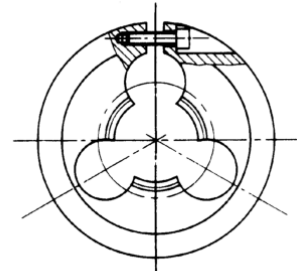
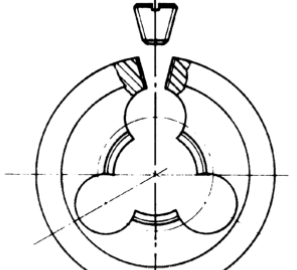
NOTE — En supplément aux termes donnés dans les trois langues officielles de l'ISO (anglais, français, russe), la présente Norme internationale donne les termes équivalents en allemand, italien et néerlandais; ces termes ont été inclus à la demande du comité technique ISO/TC 29, et sont publiés sous la responsabilité des comités membres de l'Allemagne, R.F. (DIN), de l'Italie (UNI) et des Pays-Bas (NNI). Toutefois, seuls les termes et définitions donnés dans les langues officielles peuvent être considérés comme termes et définitions ISO.

1 Объект и область применения

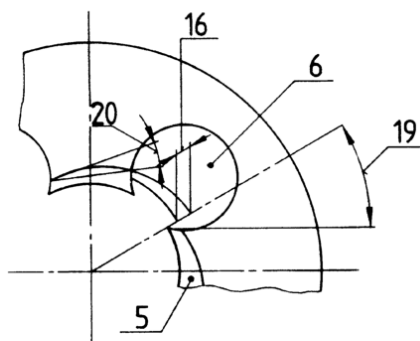
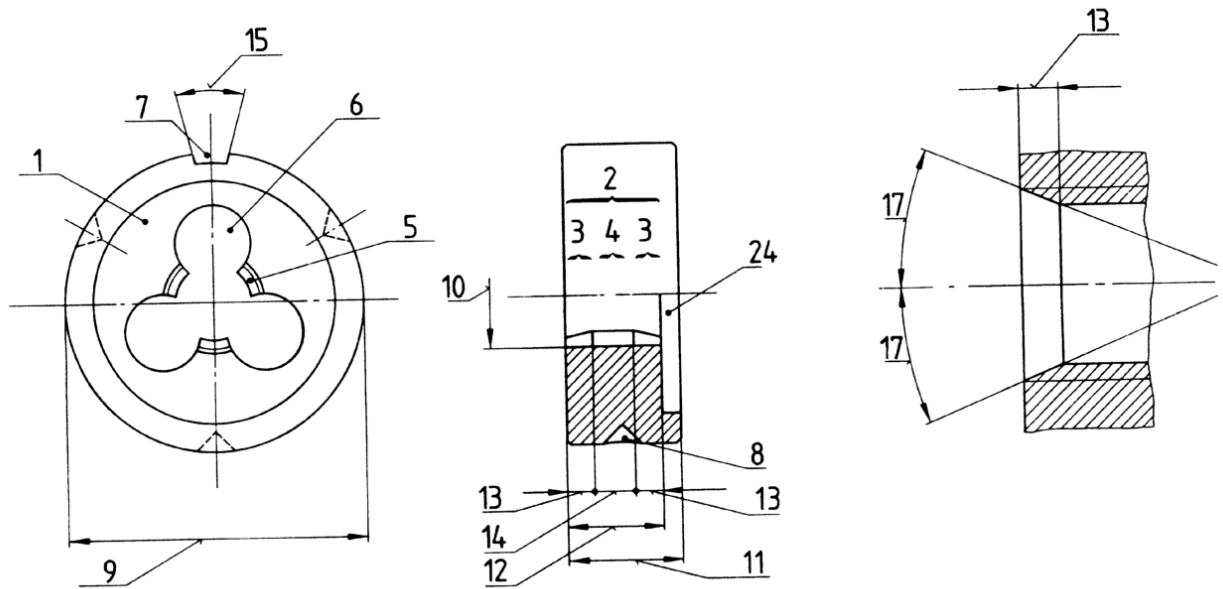
Настоящий Международный Стандарт устанавливает терминологию и номенклатуру круглых резьбонарезных плашек применяемых для нарезки резьб по стандартам ИСО и дает соответствующие термины на трех официальных языках ИСО.

ПРИМЕЧАНИЕ — В дополнение к терминам применяемым на трех официальных языках ИСО (русском, английском и французском) настоящий Международный Стандарт дает эквивалентные термины на немецком, итальянском и голландском языках. Эти термины включены по просьбе Технического Комитета ИСО/ТК 29 и публикуются под ответственность членов-комитетов ДИН (Федеративная Республика Германия), УНИ (Италия), и ННИ (Голландия). Однако, только термины на официальных языках могут считаться как термины ИСО.

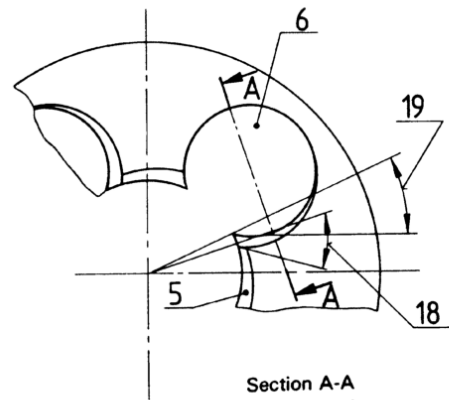
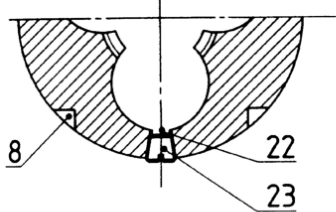
2 Form of circular screwing dies
Nomenclature des types de filières
Виды круглых плашек

No. N° Nº	Diagram Schéma Рисунок	Designation Désignation Обозначение
1		<p>solid circular screwing die</p> <p>filière ronde fixe</p> <p>Плашка круглая жесткая</p> <p>Nichtverstellbares Schneideisen</p> <p>filiera tonda fissa</p> <p>gesloten ronde snijplaat</p>
2		<p>adjustable circular screwing die (without adjusting screw)</p> <p>filière ronde extensible (sans vis de réglage)</p> <p>Плашка круглая раздвижная (без регулировочного винта)</p> <p>Verstellbares Schneideisen (ohne Verstellschraube)</p> <p>filiera tonda regolabile (senza vite di registrazione)</p> <p>open ronde snijplaat (zonder stelschroef)</p>
3		<p>adjustable circular screwing die with tangential adjusting screw</p> <p>filière ronde extensible à vis de réglage tangentielle</p> <p>Плашка круглая раздвижная с тангенциальным регулировочным винтом</p> <p>Verstellbares Schneideisen mit tangentialer Verstellschraube</p> <p>filiera tonda regolabile (con vite di registrazione tangenziale)</p> <p>open ronde snijplaat met tangentiale stelschroef</p>
4		<p>adjustable circular screwing die with radial adjusting screw</p> <p>filière ronde extensible à vis de réglage radiale</p> <p>Плашка круглая раздвижная с радиальным регулировочным винтом</p> <p>Verstellbares Schneideisen mit radialer Verstellschraube</p> <p>filiera tonda regolabile con vite di registrazione radiale</p> <p>open ronde snijplaat met radiale stelschroef</p>

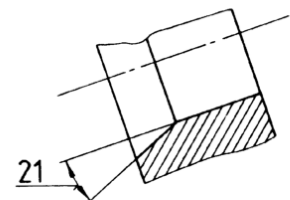
3 Features of screwing dies
Terminologie des caractéristiques des filières
Наименования частей плашек



Normal face
 Entrée normale
 Нормальный угол



Section A-A
 Сечение A-A



Spiral face
 Entrée inclinée (ou spirale)
 Наклонный угол

Index Repère Номер н/п	English/Anglais/Английский	French/Français/Французский	Russian/Russe/Русский
1	body of the screwing die	corps de la filière	корпус резьбонарезной плашки
2	thread	partie filetée	рабочая часть
3	cutting part — chamfer lead	partie taillante — chanfrein d'entrée	режущая часть
4	full thread	filets complets	калибрующая часть
5	land	peigne	перо
6	clearance hole	trous de dégagement	стружечное отверстие
7	V-groove for adjusting purposes if the die is subsequently split	entaille en V pour vis de réglage (cas des filières fendues)	У-образный паз
8	spot hole or dimple	empreinte du pointeau de fixation	фиксирующее гнездо
9	outside diameter	diamètre extérieur	наружный диаметр плашки
10	nominal diameter	diamètre nominal	диаметр резьбы
11	thickness	épaisseur	толщина плашки
12	total length of thread	longueur totale du filetage	длина рабочей части
13	length of chamfer lead	longueur du chanfrein d'entrée	длина режущей части
14	length of full thread	longueur des filets complets	длина калибрующей части
15	angle of V-groove	angle de l'entaille en V	угол У-образного паза
16	radial thread relief	détalonnage radial	падение затылка
17	chamfer lead angle	angle d'entrée	угол заборного конуса
18	rake angle on spiral face	angle de coupe sur l'entrée inclinée (partie saillante)	передний угол режущей части
19	rake angle on full thread	angle de coupe (filets complets)	передний угол калибрующей части
20	radial relief on chamfer lead	détalonnage radial sur le chanfrein d'entrée	задний угол режущей части
21	spiral face inclination	angle de l'entrée inclinée (par rapport à l'axe de la filière)	угол наклона режущей кромки
22	adjusting screw slot	fente d'extensibilité	паз под регулировочный винт
23	adjusting screw (the illustration on page 3 shows an adjustable screwing die with radial adjusting screw)	vis de réglage (l'illustration page 3 montre une filière extensible à vis de réglage radiale)	регулировочный винт
24	recess	chambrage	проточка

Index Repère Номер н/п	German/Allemand/ Немецкий/Deutsch	Italian/Italiano Итальянский/Italiano	Dutch/Néerlandais Голландский/Nederlands
1	Schneideisenkörper	corpo della filiera	lichaam van de snijplaat
2	Gewindeteil	parte filettata	schroefdraadgedeelte
3	Anschnitt	parte tagliente — smusso d'imbocco	snijdend gedeelte — aansnijding
4	Gewindeteil mit vollem Profil	filetti completi	volle schroefdraad
5	Gewindesteg	pettine	tandbreedte
6	Spanloch	foro di scarico	vrijloopgat
7	V-Nut	intaglio a V per vite di registrazione	V-groef voor stelschroef
8	Bohrung für Halteschraube	sede di fissaggio	bevestigingsgat
9	Außendurchmesser des Schneideisens	diametro esterno	buitendiameter
10	Gewinde-Nenndurchmesser	diametro nominale	nominale diameter
11	Gesamtbreite (Höhe) des Schneideisens	spessore	dikte
12	Gewinde-Gesamtlänge	lunghezza totale della parte filettata	totale schroefdraadlengte
13	Anschnittlänge	lunghezza dello smusso d'imbocco	lengte van de aansnijding
14	Gewindelänge mit vollem Profil	lunghezza dei filetti completi	lengte van de volle schroefdraad
15	V-Nut-Winkel	angolo dell'intaglio a V	hoek van de V-groef
16	Radialer Freischliff	spoglia radiale (del fianco)	radiale vrijloop
17	Anschnittwinkel	angolo d'imbocco	hoek van de aansnijding
18	Spanwinkel am Anschnitt	angolo di spoglia sullo smusso d'imbocco (della faccia di taglio)	spaanhoek van de aansnijding
19	Spanwinkel am vollen Gewinde	angoli di spoglia sui filetti completi (della faccia di taglio)	spaanhoek van de volle schroefdraad
20	Anschnitt-Freiwinkel	spoglia radiale sullo smusso d'imbocco (del fianco)	radiale vrijloophoek van de aansnijding
21	Schälanschnittwinkel	angolo dell'imbocco inclinato (in rapporto all'asse della filiera)	hellingshoek van de aansnijding (t.o.v. de as van de snijplaat)
22	Schlitz für Spreizschraube	intaglio di regolazione	gleuf van de stelschroef
23	Spreizschraube	vite di registrazione (l'illustrazione a pagina 3 mostra una filiera regolabile con vite di registrazione radiale)	stelschroef (fig. 3 toont een open ronde snijplaat met radiale stelschroef)
24	Aussparung	camera	kamer

National appendix W

The United Kingdom participation in the preparation of this European Standard was entrusted by the Machine, Engineers and Hand Tools Standards Policy Committee (MTE/-) to Technical Committee MTE/4, upon which the following bodies were represented:

Advanced Manufacturing Technology Research Institute
British Electrical Systems Association (BEAMA Ltd.)
Federation of British Engineers' Tool Manufacturers
Gauge and Tool Makers' Association
Institution of Production Engineers
Screw Thread Tool Manufacturers' Association
Society of British Aerospace Companies Limited
Twist Drill and Reamer Association

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