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## Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches — Manufactured tolerances on the threaded portion AMENDMENT 2

*Tarauts 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*

### AMENDEMENT 2

Amendment 2 to ISO 2857-1973 was prepared by Technical Committee ISO/TC 29, *Small tools*.

Page 6

Delete sub-clause 4.5 and substitute the following :

#### 4.5 Tolerance on pitch

The limits of tolerance on the pitch shall be as shown in table 4, which also shows the length over which the measurement shall be made, expressed in number of pitches.

Table 4 — Tolerance on pitch

Pitch mm	Measuring length in number of of pitches	Limits of tolerance $\mu\text{m}$
0,25 0,3 0,35 0,4 0,45 0,5 0,6	12	$\pm 8$
0,7 0,75 0,8 1 1,25	9	$\pm 8$
1,5	7	$\pm 8$
1,75		$\pm 9$
2		$\pm 10$
2,5		$\pm 12$
3		$\pm 13$
3,5		$\pm 14$
4		$\pm 15$
4,5		$\pm 16$
5		$\pm 17$
5,5		$\pm 18$
6		$\pm 18$

UDC 621.993

Ref. No. ISO 2857-1973/A2-1986 (E)

Descriptors : tools, cutting tools, taps, screw threads, dimensional tolerances.

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NOTE — The tolerance on pitch is based on the diametral equivalent of the pitch error, so that, in general, it shall not exceed 10 % of the 5H nut thread pitch diameter tolerance. The measuring length is based on seven pitches which falls within the “normal” length of thread engagement as detailed in ISO 965/1. However, for pitches finer than 1,5 mm, the measuring length has been increased to approximately 50 % of the standard tap thread length to bring it within the scope of practical measurement.

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Clause 6

Last line of the table, delete “Cumulative pitch error  $T_p$  over any number of threads” and insert

“Tolerance on pitch”

Pages 8, 10 and 12

Annexes A and B

Delete three times :

“Cumulative pitch error  $T_p$  over any number of threads

This error is fixed at  $\pm 0,05$  % of the considered measuring length with a minimum of  $\pm 0,008$  mm.”

and insert three times :

“Tolerance on pitch

See 4.5.”