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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 3228-2022

Replacing GB/T 3228-2009

**Assembly tools for screws and nuts - Dimensions of
machine-operated impact square drive sockets**

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foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1. Structure and Drafting Rules for Standardization Documents" drafting.

This document replaces GB/T 3228-2009 "Dimensions of impact-type motorized square transmission sleeves for assembly tools for bolts and nuts", and is in line with

Compared with GB/T 3228-2009, except for structural adjustment and editorial changes, the main technical changes are as follows.

- a) Added a description not including technical requirements (see Chapter 1);
- b) Changed the expression of scope of application (see Chapter 1, Chapter 1 of the.2009 edition);
- c) Deleted the chapter on technical requirements (see Chapter 5 of the.2009 edition);
- d) Increase the size of Dmax and part s (see Table 1~Table 6);
- e) Changed the size of tmin (see Table 1~Table 6, Table 1~Table 7 of the.2009 edition);
- f) The requirement for the sleeve with a square hole of 16mm is deleted (see Table 4 of the.2009 edition);
- g) Deleted the tolerance requirements for the width across flats of the hexagonal hole of the impact motorized socket (see Appendix A of the.2009 edition).

This document is equivalent to ISO 2725-2:2017 "Assembly tools for bolts and nuts Square

transmission sleeve Part 2.Motorized sleeve (punching Strike)".

The following minimal editorial changes have been made to this document.

--- In order to coordinate with existing standardization documents, the standard name has been modified.

Please note that some contents of this document may refer to patents. The issuing agency of this document assumes no responsibility for identifying patents.

1 Scope

This document specifies the size, identification and signs of the impact type motorized square transmission sleeve with hexagonal or double hexagonal working ends.

The motorized square drive sleeve is in accordance with ISO 1174-2.

Note. The impact motorized square drive socket covered in this document is the square drive hexagonal socket number 2202010 in ISO 1703.

This document does not contain technical requirements for these products, the relevant technical requirements are given in ISO 1711-2.

2 Normative references

The contents of the following documents constitute the essential provisions of this document through normative references in the text. Among them, dated references

For documents, only the version corresponding to the date is applicable to this document; for undated reference documents, the latest version (including all amendments) is applicable to

this document.

Note. GB/T 4390-2008 Common tolerances for spanner openings and spanner holes (ISO 691.2005, MOD)

ISO 1174-2 Assembly tool transmission squares for bolts and nuts - Part 2.Transmission squares for motorized socket tools (Assembly

Note. GB/T 3227-2018 Assembling tools for bolts and nuts, drive squares of motorized socket tools (ISO 1174-2.1996, MOD)

3 Terms and Definitions

This document does not have terms and definitions that need to be defined.

4 Width across flats tolerance

The tolerance of the width s across sides of the hexagonal hole shall be consistent with the tolerance of the sleeve hole specified in ISO 691, and the manufacturer can choose the deviation by himself

sequence.

5 sizes

The sleeves shown in Figures 1 to 3 are sleeves with a square hole size of 6.3 mm to 40 mm, and their dimensions are shown in Tables 1 to 6. The square hole size should

Consistent with ISO 1174-2. See Table 7 and Table 8 for the dimensions of the locating pins and corresponding expansion rings shown in Figure 4.

The diagrams given in this document are examples only. Does not affect the design of the factory.

Note. The width across sides s is mostly taken from ISO 272.

When using the E-type external transmission square specified in ISO 1174-2, the reasonable connection position of the guide groove shall be determined by the manufacturer itself.