

ICS 25.140.30

CCS J 47



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

GB/T 4390-2008

Replacing GB/T 4390-1995

Wrench openings -- Tolerances for general use

扳手开口和扳手孔 常用公差

(English Translation)

Issued on: December 30, 2008

Implemented on: September 1, 2009

Issued by: Standardization Administration of China

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Foreword

This revised standard adopts ISO 691:2005 "Assembly tools for screws and nuts wrench and socket openings - tolerances" (in English).

This standard is based on ISO 691:2005 redrafted. It lists the control of the standard terms and provisions of international standards in Appendix A a Lanbiao.

Taking into account China's national conditions, in the use of ISO 691:2005, the standard of this made some changes. About the technical differences have been incorporated into the text, and in terms of their margins involved are identified by a single vertical line. It gives a list of the technical differences and their reasons in Appendix B

Table for reference.

This standard and ISO 691:2005 The main differences are as follows.

- Some of the statements apply to international standards to apply to our standard formulation;
- Wrench opening dimension refers to the national standard GB/T 3103.1 (ISO 4759-1:2000, IDT) prescribed tolerance;
- Deletion of the section on the sleeve, this section has been defined in GB/T 3390.1 "Manual socket wrench sleeve" in;
- Deletion of the section on the ISO 691 mark.

This standard replaces GB/T 4390-1995 "metric spanner wrench openings and holes common tolerance." this standard and GB/T 4390-1995 compared to the main changes are as follows.

- The standard name be changed to "spanner wrench holes open and common tolerance" (1995 version of the cover, the cover of this edition);
- Increased Normative references GB/T 3103.1 "Tolerances for fasteners - Bolts, screws, studs and nuts" (2nd edition chapter);

--- The "spanner wrench hole openings and the maximum tolerance" to "spanner wrench holes open and common tolerance" (1995 edition Chapter 2, Excerpts of chapter 3);

--- The "machined wrench holes and openings" with "Tolerance Series 1", the "non machined wrench hole" to "tolerance system Column 2 "and in accordance with ISO 691. Provisions of the 2005 value was modified and adjusted (1995 Edition Chapter 2, 3rd edition chapter).

Appendix A of this standard and Appendix B is an informative annex.

The standard proposed by China National Light Industry Council.

This standard by the National Standardization Technical Committee, hardware tools, hardware sub-technical committee.

This standard by the Shanghai Industrial Tool Research Institute, Zhejiang billion foreign Tool Manufacturing Co., Ltd. is responsible for drafting, Jiangsu Sainty International Group Jiangdu Engineering Co., Ltd, Hangzhou Qianjiang Hardware Tools Co., Ltd., Shanghai Star labor Tools Co., Ltd., Shanghai field Tool (Group) Co., the company, Deng Wei, Li tool Group Co., Ltd., Shanghai Shen Yu Hardware Tools Co., Ltd., Taizhou far Thailand Forging Tools Co., Ltd., Hebei Park Safety Tool Group Co., Ltd. participated in the drafting.

Drafters of this standard. Wu teachings of our forefathers, Chenchang Qi, Weng Hang built Zoujia Ping, Chen Miao, Xu Shuguang, Panyu Jie, Liu Yuxin, Li Ruoci, Chi Yan can, Yang Dongjiang, Gu Qing.

This standard replaces the standards previously issued as follows.

--- GB 4390-1984; GB/T 4390-1995.

Spanner wrench openings and holes tolerances for

1 Scope

This standard specifies the tolerances for metric spanner wrench openings and holes shown in Figure 1.

This standard applies to wrenching on the side dimension metric bolts, screws and nuts (or similar parts) of wrenches and wrenches.

a) wrench b) wrenches

Figure 1 wrenches and wrenches

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including

errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 3103.1 Tolerances for fasteners - Bolts, screws, studs and nuts (GB/T 3103.1-2002, ISO 4759-1:2000, IDT)

3 Common tolerance

Common Table tolerance wrenches open wrenches and wrench holes shown in Table 1 is based on GB/T 3103.1 provided for bolts, screws and Nuts on the side and the development of tolerance.

Table 1 spanner wrench openings and holes in millimeters - tolerances

Edge dimension

Tolerance Tolerance Series 1 Series 2a on the lower deviation lower deviation $2 \leq S$