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

GB/T 4440-2022

Replacing GB/T 4440-2008

Adjustable wrenches

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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 4440-2008 "Adjustable Wrench". Compared with GB/T 4440-2008, except for structural adjustment and editorial changes,

The main technical changes are as follows.

- Added terms and definitions (see Chapter 3);
- Increased product classification (see 4.2);
- Changed the material requirements (see 5.1, 4.1 of the.2008 edition);
- Added products with specifications of 750mm and 900mm and related dimensions (see 5.2);
- Changed the torque requirements (see 5.4, 4.3 of the.2008 edition);
- Changed the surface quality requirements (see 5.7.4, 4.6.4 of the.2008 edition)
- Added test methods for materials (see 6.1);
- Changed the torque test method (see 6.4, 5.3 of the.2008 edition);
- Changed the small shoulder gap test method (see 6.5.2, 5.4.2 of the.2008 edition);
- Changed the test method of electroplating layer thickness in surface treatment (see 6.6, 5.5.1 of the.2008 edition);
- Changed the inspection rules (see Chapter 7, Chapter 6 of the.2008 edition).

This document is modified to adopt ISO 6787.2018 "Adjustable wrenches for screw and nut assembly tools".

Compared with ISO 6787.2018, this document has more structural adjustments.

Comparison list of structure number changes between two files

See Appendix A.

Compared with ISO 6787.2018, this document has more technical differences, and vertical single

Lines (|) are marked. See Appendix B for a list of these technical differences and their causes.

The following editorial changes have been made to this document.

--- Change the file name to "Live Wrench";

--- Removed references.

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 product classification and marking, requirements, test methods, inspection rules and signs, packaging, transportation and storage of adjustable wrenches.

This document applies to adjustable wrenches for turning bolts and nuts or other fasteners.

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.

GB/T 230.1 Rockwell hardness test for metallic materials - Part 1. Test method (GB/T 230.1-2018, ISO 6508-1.

2016, MOD)

GB/T 699 High Quality Carbon Structural Steel

GB/T 2828.1 Count sampling inspection procedure Part 1. Batch-by-batch inspection sampling plan retrieved by acceptance quality limit (AQL)

(GB/T 2828.1-2012, ISO 2859-1.1999, IDT)

GB/T 4955 Metal coating coating thickness measurement - anodic dissolution coulometric

method (GB/T 4955-2005, ISO 2177.

2003, IDT)

GB/T 5305 Packaging, marking, transportation and storage of hand tools

GB/T 6060.2 Surface roughness comparison samples Grinding, turning, boring, milling, inserting and planing surfaces (GB/T 6060.2-2006,

ISO 2632-1.1985, MOD)

GB/T 6462 Microscopic method for measuring the thickness of metal and oxide coatings (GB/T 6462-2005, ISO 1463.2003,

IDT)

3 Terms and Definitions

3.1

opening dimensionopeningdimension

By adjusting the worm, the movable wrench is moved to the maximum distance from the vertical surface of the wrench body, the size between the two vertical mouth surfaces.

Note. The unit is millimeter (mm).

3.2

Small shoulder clearance

The gap between the small shoulder plane of the movable wrench and the guide rail surface of the wrench body.

Note. The unit is millimeter (mm).