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

GB/T 969-2007

Replacing GB/T 969-1994

Technical specification for taps

丝锥技术条件

(English Translation)

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Foreword

This revised standard adopts ISO 8830:1991 "high-speed steel teeth Machine Taps technical conditions" (in English).

This standard is based on ISO 8830:1991 re-drafted.

This standard and ISO 8830:1991 compared to the following technical differences and editorial changes.

- Remove the foreword to international standards;
- Used instead of using decimal comma " , " ;
- "This International Standard" by "this standard";
- Normative documents column items, ISO 237 with the standard of GB/T 4267 in place, ISO 2857 standard with our GB/T 968 in place;
- Increase the surface roughness requirements;
- Increasing the high-performance machine taps, hand taps and nut taps requirements;
- Increased Grinding requirements tap the thread type;
- Increased taps threaded portion length tolerance;
- Increased packaging requirements;
- Deleted the Chapter 4, "cutting geometry." this standard replaces GB/T 969-1994 "Taps technical conditions." this standard and GB/T 969-1994 compared to the following changes.
- Increasing the foreword;
- 3.5 "circular checks among the top threaded portion and a shank taps beating" to "Taps round a common axis of the beating";
- 3.11b) "on the length of twice the square head" to "within two square head length";
- 3.5 "cutting portion" to "Cone";

--- Canceled a Chapter 4, "Performance Test";

--- Original 5.1e) "cobalt high speed steel manufactured standard 'HSS-Co'" to "high speed steel manufactured with standard 'HSS-E'".

The standard proposed by China Machinery Industry Federation.

This standard tool by the National Standardization Technical Committee (SAC/TC91) centralized.

This standard was drafted. Chengdu Tool Institute.

1 Scope

This standard specifies the machine tap (high performance level and ordinary level), hand taps and nut taps the technical requirements, the basic logo and packaging Claim.

This standard applies to the processing of common screw (GB/T 192, GB/T 193, GB/T 196, GB/T 197) with a tap.

High-performance machine taps mainly applicable to CNC machine tools, machining centers or other automated machines.

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 192 ordinary screw threads - Basic model (GB/T 192-2003, ISO 68-1:1998, MOD)
GB/T 193 series ordinary thread diameter and pitch (GB/T 193-2003, ISO 261:1998, MOD)
GB/T 196 common thread basic size (GB/T 196-2003, ISO 724:1993, MOD) GB/T 197
common thread tolerance (GB/T 197-2003, ISO 965-1:1998, MOD) GB/T 968 tap thread
tolerance (GB/T 968-2007, ISO 2857. 1973, MOD) GB/T 4267 straight shank rotating tool
shank diameters and sizes of driving squares of (GB/T 4267-2004, ISO 237. 1975, IDT)

3 Technical requirements

3.1

Taps surface without cracks, nicks, rust and grinding burns and other defects affecting performance.

3.2

Taps surface roughness of the maximum permissible values specified in Table 1.

Table 1 in microns

project

Taps Name

Machine Taps

High performance grade Ordinary level Nut taps Hand taps H4 nut Taps Threaded surface
 R z 3.2 R z 3.2 R z 3.2 R z 12.5 Front R z 3.2 R 6.3 R z z z 6.3 6.3 R Behind R z 3.2 R 3.2
 R z z z 3.2 R 6.3 Rao shank R 1.6 R 0.8 R Rao Rao Rao 1.6 R 3.2

Note 1: The front edge of the groove and connecting the tap should be smooth.

Note 2: The adapters M2 ~ M30 of H4 nut tap shank surface roughness may not be specified.

3.3

tap thread tolerance shall comply with GB/T 968's. The diameter of the examination site provides as follows.

Hand taps, Machine taps and nut taps. starting point in the calibration part inspection. Hand from the tap calibration part of the front end is less than 4 tooth pitch when checking in diameter from the front end 4 of the tooth.