
**Mechanical pencils and leads
for general use — Classification,
dimensions, quality and test
methods —**

**Part 2:
Black leads**

*Porte-mines et mines pour usage général — Classification,
dimensions, qualité et méthodes d'essai —*

Partie 2: Mines graphite pour porte-mines



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Contents

	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Classification	2
5 Quality	2
5.1 Bending strength	2
5.2 Hardness degree	3
6 Dimensions	3
7 Test methods	4
7.1 Test conditions	4
7.2 Bending strength	4
7.3 Hardness degree	5
7.3.1 General	5
7.3.2 Writing density	5
7.3.3 Writing test	9
7.4 Dimension	9
7.4.1 Diameter	9
7.4.2 Length	9
8 Designation	10
Bibliography	11

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 10, *Technical product documentation*.

A list of all parts in the ISO 20318 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

This document was developed in response to the recent increase in popularity of mechanical pencils and their leads among students who use them for general writing, and where varieties of both hardness degrees and thickness (designated as marking diameter) of leads have been expanding in response to different types of usage. It should be noted that the entire production volume of mechanical pencils has been increasing every year, whereas the production of mechanical pencils for technical drawings has been decreasing.

Despite those recent trends, ISO 9177-1 was revised in 2011 with a scope limited to technical drawing usage only.

Therefore, it is clear that this document is necessary for general use and that it should be independent of technical drawings. The ISO 20318 series consists of two parts: mechanical pencils and black leads.

A set of a mechanical pencil and lead of the same marking diameter should be completely complementary, and should be compatible even with pencils and lead from different manufacturers.

It should also be noted that there are two issues which have not been resolved since the first relevant standard was published. First, on marking of labelling the diameters on mechanical pencils and cases of leads, two designations coexist: 0,35 and 0,3 and 1 and 0,9. This document attempts to clarify this designation issue by defining diameters precisely. Second, a scientific definition of hardness degree of leads is not yet available. Even though this document tried to establish a solely quantitative evaluation method, qualitative evaluation turned out to be inevitable. The issue, therefore, remains unresolved.

The title of the 2016 third edition of ISO 9177-1 was revised to distinguish it clearly from this document with the addition of “for technical drawings”.

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Mechanical pencils and leads for general use — Classification, dimensions, quality and test methods —

Part 2: Black leads

1 Scope

This document specifies classification, dimensions, quality and test methods for black leads used for mechanical pencils for general writing, as specified in ISO 20318-1.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5-3:2009, *Photography and graphic technology — Density measurements — Part 3: Spectral conditions*

ISO 12757-1, *Ball point pens and refills — Part 1: General use*

ISO 14145-1, *Roller ball pens and refills — Part 1: General use*

ISO 20318-1, *Mechanical pencils for general use — Classification, dimensions, quality and testing methods — Part 1: Mechanical pencils*

JIS S 6005, *Leads for mechanical pencils*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 20318-1 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

3.1 black lead

solid writing material for mechanical pencil, which consists of black colour materials (e.g. graphite) and a binding agent, generating lines which are erasable

3.2 hardness degree

combination of two alphanumeric or alphabetical symbols used to indicate the hardness and density (darkness) of the lead when used in writing

Note 1 to entry: See [Table 1](#).

Note 2 to entry: Hardness increases from 6B to 9H, density of line increases from 9H to 6B.

Note 3 to entry: HB represents the median hardness degree.

Note 4 to entry: A scientific definition of hardness degree is not yet available

3.3 marking diameter

numerical symbol used to classify leads by thickness (diameter) of lead

Note 1 to entry: These are used to label or mark lead boxes to indicate a corresponding mechanical pencil specified in ISO 20318-1.

4 Classification

Black leads for mechanical pencils for general use shall be classified according to the hardness degree and the marking diameter as specified in [Table 1](#).

Table 1 — Classification

Dimensions in millimetres

Marking diameter (see 3.3)	Hardness degree (see 3.2)	Informative Nominal diameter (see ISO 9177-2)
0,2	F, HB, B, 2B	—
0,3	4H, 3H, 2H, H, F, HB, B, 2B	0,35
0,4		—
0,5	4H, 3H, 2H, H, F, HB, B, 2B, 3B, 4B	0,5
0,7	4H, 3H, 2H, H, F, HB, B, 2B	0,7
0,9	4H, 3H, 2H, H, F, HB, B, 2B, 3B, 4B	1
1,3	2H, H, F, HB, B, 2B	—
1,4		— ^a
2	9H, 8H, 7H, 6H, 5H, 4H, 3H, 2H, H, F, HB, B, 2B, 3B, 4B, 5B, 6B	2

^a 1,4 is the line width specified in ISO 128-20.

5 Quality

5.1 Bending strength

The bending strength of black leads shall conform to the specifications in [Table 2](#), in which the minimum value is specified for each marking diameter when tested in accordance with [7.2](#).

Table 2 — Bending strength of black lead

Dimensions in MPa

Hardness degree	Bending strength								
	Marking diameter (mm)								
	0,2	0,3	0,4	0,5	0,7	0,9	1,3	1,4	2
9H, 8H, 7H	—	—	—	—	—	—	—	—	80
6H, 5H	—	—	—	—	—	—	—	—	75
4H, 3H	—	265	230	200	180	105	—	—	
2H, H							95	90	
F, HB	300	240	215	190	160	95	85	80	70

Table 2 (continued)

Hardness degree	Bending strength								
	Marking diameter (mm)								
	0,2	0,3	0,4	0,5	0,7	0,9	1,3	1,4	2
B, 2B	230	220	185	150	140	90	80	70	40
3B, 4B	—	—	—	130	—	80	—	—	30
5B, 6B	—	—	—	—	—	—	—	—	20

5.2 Hardness degree

The hardness degree of black leads shall be evaluated quantitatively and qualitatively, because its scientific definition is not yet available (see 3.2).

It shall be specified quantitatively as the writing density by using a line-drawing device. The writing density of HB shall conform to the specification of A (recording type) or B (spiral type) in Table 3, and for the leads of the same brand, the order of writing density shall not reverse or alter in the order of the hardness degree, when tested in accordance with 7.3.2 a) to c).

Furthermore, it shall be confirmed qualitatively in the order of the density and the hardness by handwriting. The order of density and hardness of the same brand leads shall not reverse or alter in the order of the hardness degree, when tested in accordance with 7.3.3.

Table 3 — The writing density of HB

Marking diameter (mm)	Type of line-drawing device	
	A: Recording type	B: Spiral type
0,2	0,15 to 0,30	0,25 to 0,45
0,3		
0,4		
0,5	0,25 to 0,45	0,30 to 0,50
0,7		
0,9		
1,3		
1,4		
2		

6 Dimensions

The actual diameter of black lead shall conform to the specifications in Table 4 when measured in accordance with 7.4.

The length of leads for marking diameter 0,2 mm to 1,4 mm should be (60 ± 1) mm, and that of marking diameter 2 mm should be (130 ± 1) mm, respectively. However, the length may be any dimension as selected upon agreement between the purchaser and the supplier.

Table 4 — Dimensions of black lead

Dimensions in millimetres

Diameter of leads		Length	Informative
Marking diameter	Range of actual diameter of the lead for mechanical pencils	Recommended value	Nominal diameter (see ISO 9177-2)
0,2	0,27 to 0,29	60 ± 1	—
0,3	0,37 to 0,39		0,35
0,4	0,46 to 0,48		—
0,5	0,55 to 0,58		0,5
0,7	0,69 to 0,73		0,7
0,9	0,88 to 0,92		1
1,3	1,25 to 1,32		—
1,4	1,37 to 1,44		— ^a
2	1,95 to 2,05	130 ± 1	2

^a 1,4 is the line width specified in ISO 128-20.

7 Test methods

7.1 Test conditions

Unless otherwise specified, the test shall be carried out at the ordinary temperature (20 ± 15) °C and ordinary relative humidity (65 ± 20) %.

7.2 Bending strength

The sample for the bending strength test shall be 10 leads taken at random from the smallest container. If 10 leads or fewer are contained in the smallest container, all the leads shall be taken for the sample.

The test method is that shown in [Figure 1](#). Apply a load on the lead at the constant rate of 10 mm/min and at a distance halfway between the two supporting anvils as specified in [Table 5](#). Next, measure the load at the time when the lead is broken, and calculate the bending strength using [Formula \(1\)](#).

$$\sigma = \frac{8Fl}{\pi d^3} \quad (1)$$

where

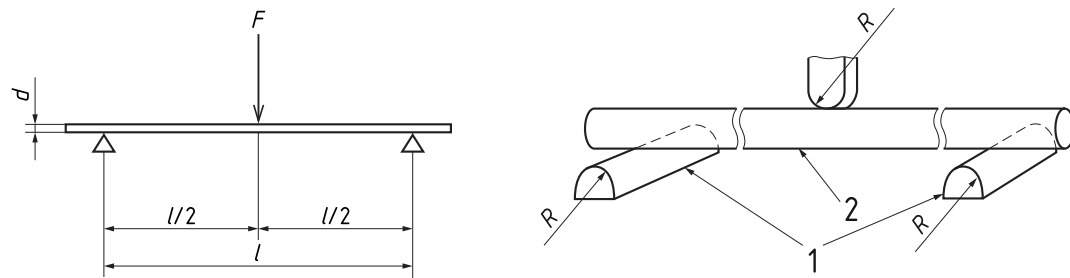
σ is bending strength (MPa);

F is load (N) average of 10 samples or all samples if fewer than 10;

l is distance between supporting anvils (mm) actual performance value based on [Table 4](#);

d is diameter of lead (mm).

The shape of the tops (radius R) for applying load and of the two supporting anvils shall be such that $R = (0,2 \pm 0,02)$ mm.

**Key**

1 supporting anvil

2 lead

 F load (N) d diameter of lead (mm) l distance between supporting anvils (mm) actual performance value based on [Table 4](#) R radius (mm)**Figure 1 — Method for bending strength test****Table 5 — Distance between the supporting anvils**

Dimensions in millimetres

Marking diameter	Distance
0,2; 0,3; 0,4; 0,5; 0,7; 0,9; 1,3; and 1,4	20 to 40
2	40 to 60

7.3 Hardness degree**7.3.1 General**

The sample for the hardness degree test shall use five leads taken at random from the smallest container. If five leads or fewer are contained in the smallest container, all leads shall be taken as samples.

7.3.2 Writing density

The writing density test shall be as follows:

- Using a line-drawing device either of recording type (A method) as shown in [Figure 2](#) and [Figure 3](#), or of spiral type (B method) as shown in [Figure 4](#) and [Figure 5](#), draw a line with the sample on line-drawing paper which has been conditioned in advance at the temperature and the relative humidity specified in [Table 6](#) for 12 h or more.
- Measure the density of the line at the middle of line-drawing width, either at four positions in the case of method A as shown in [Figure 3](#) or at three positions in the case of method B as shown in [Figure 5](#), using a densitometer.

The measuring conditions shall be as shown in [Table 6](#).

Table 6 — Test measuring conditions for writing density

	Type of line-drawing device			
	A: Recording type		B: Spiral type	
1) Line-drawing paper	Specified in ISO 12757-1, ISO 14145-1 and JIS S 6005			
2) Temperature of room	(23 ± 5) °C		(23 ± 2) °C	
3) Relative humidity of room	(65 ± 5) RH %		(50 ± 5) RH %	
4) Load at the time of line-drawing	Marking diameter (mm)	Load	Marking diameter (mm)	Load
	0,2	2 N	0,2	(0,6 ± 0,05) N
	0,3		0,3	(1,1 ± 0,05) N
	0,4		0,4	
	0,5	3 N	0,5	(1,9 ± 0,05) N
	0,7		0,7	
	0,9		0,9	(2,4 ± 0,05) N
	1,3		1,3	
	1,4		1,4	
	2		2	(3,4 ± 0,05) N
5) Speed of line-drawing	50 mm/s (= 3,0 m/min)		75 mm/s (= 4,5 m/min)	
6) Pitch of line-drawing or feed speed of line-drawing paper	Marking diameter (mm)	Pitch	Marking diameter (mm)	Feed speed
	0,2	0,5 mm	0,2	10 mm/min
	0,3		0,3	
	0,4		0,4	
	0,5		0,5	15 mm/min
	0,7		0,7	
	0,9		0,9	20 mm/min
	1,3		1,3	
	1,4		1,4	
	2		2	
7) Distance of line-drawing	6 m ± 1 m		≥ 25 m with 3 mm lead protrusion	
8) Holding angle of lead	0,2 mm	90°	70	
	0,3 to 2 mm	75°		
9) Form of lead top	0,2 to 1,4 mm; use them as they are		0,2 mm to 2 mm; use them as they are	
	2 mm; sharpen lead at an angle of (17 ± 1)° in circular conic shape and make its top diameter (0,6 ± 0,1) mm			
10) Movement of lead	During one rotation of line-drawing, lead also rotates once		0,5 r/min to 1,0 r/min	
11) Density measuring apparatus	The spectrophotometer specified in the apparatus capable of measuring ISO visual density in ISO 5-3:2009, 6.1 [ISO visual density, D_T ($S_H:S_V$), D_R ($S_A:S_V$)] or one equivalent or superior to this in precision			
12) Diameter of spot densitometer	3,4 mm to 4,0 mm		4,5 mm	
13) Example of line-drawing device	PL-1000s (by DEICY) ^a		HST10 (by HUTT) ^a	

^a PL-1000s and HST10 are examples of suitable products available commercially. This information is given for the convenience of users of this document and does not constitute an endorsement by ISO of these products.

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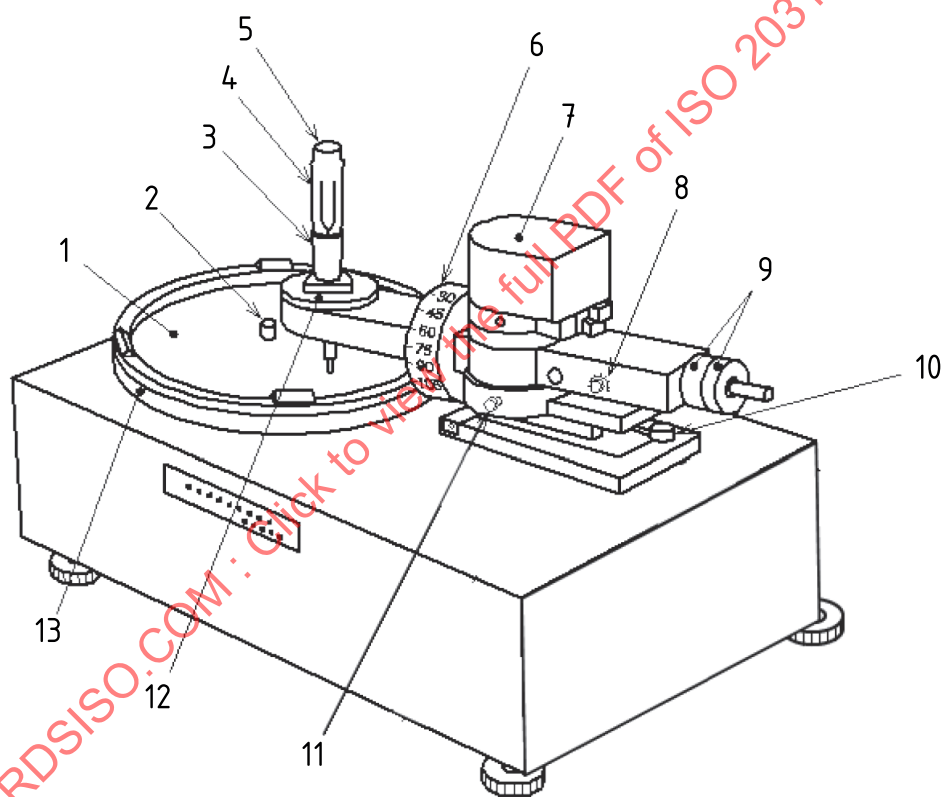
- c) When using the spectrophotometer, the density shall be calculated using [Formula \(2\)](#) and, in the case of apparatus capable of measuring ISO visual density, it shall be D_R (the density of line-drawing paper is 0). The average of measurements at four points (in the case of method A) or at three points (in the case of method B) of individual samples shall be obtained. The averages of all the samples tested shall be further averaged to be recorded as the density of the lead.

$$D = \log \frac{1}{\rho} \quad (2)$$

where

D is density;

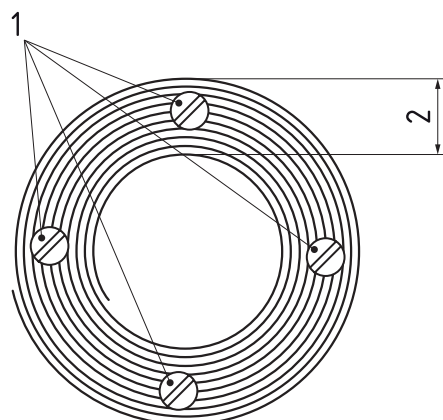
ρ is reflectance (the reflectance of line-drawing paper is 1).



Key

- | | |
|----------------------------------|--|
| 1 line-drawing paper | 8 arm level |
| 2 centre pin | 9 balance weight |
| 3 pen holder | 10 scale clamp for setting equal angle |
| 4 sample | 11 rapid return lever grip |
| 5 pen-clamp cap | 12 load weigh |
| 6 writing angle setting dial | 13 paper clamp disc |
| 7 pen lifting/lowering apparatus | |

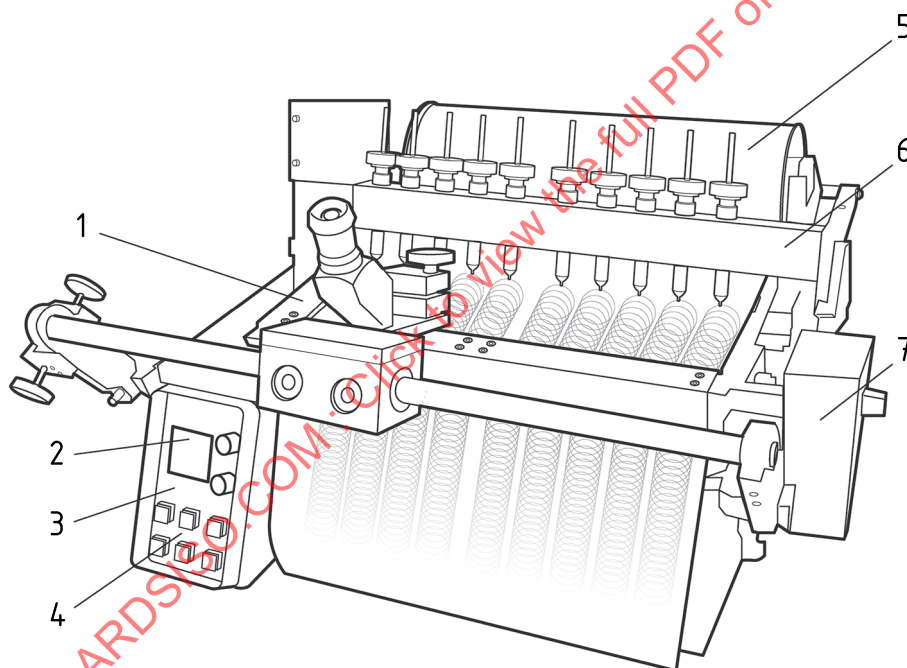
Figure 2 — Example of recording type line-drawing device



Key

- 1 measuring position
- 2 line-drawing width

Figure 3 — Measuring positions of density with recording type device



Key

- 1 stamping plate
- 2 display numbers
- 3 switchboard
- 4 luminous switch – main switch
- 5 test paper roll
- 6 pick-up bar
- 7 motor for paper feed

Figure 4 — Example of spiral type line-drawing device