
INTERNATIONAL STANDARD



2725

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Assembly tools for screws and nuts — Power and hand operated square drive sockets — Metric series

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Price based on 3 pages

FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up 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.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 2725 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and circulated to the Member Bodies in April 1972.

It has been approved by the Member Bodies of the following countries:

Belgium	Ireland	South Africa, Rep. of
Czechoslovakia	Israel	Spain
Egypt, Arab Rep. of	Italy	Sweden
France	Japan	Switzerland
Germany	Netherlands	Thailand
Hungary	Portugal	Turkey
India	Romania	United Kingdom

The Member Body of the following country expressed disapproval of the document on technical grounds :

U.S.A.

Assembly tools for screws and nuts — Power and hand operated square drive sockets — Metric series

1 SCOPE AND FIELD OF APPLICATION

This International Standard, relating to assembly tools for screws and nuts, specifies the dimensions of power and hand operated square drive sockets with operating end of hexagon and double hexagon form.

The drive squares are in conformity with ISO/R 1174.

The hand operated sockets should satisfy technical specifications given in ISO/R 1711.

2 REFERENCES

ISO/R 691, *Tolerances on spanner gaps and sockets (Metric values for general use)*.

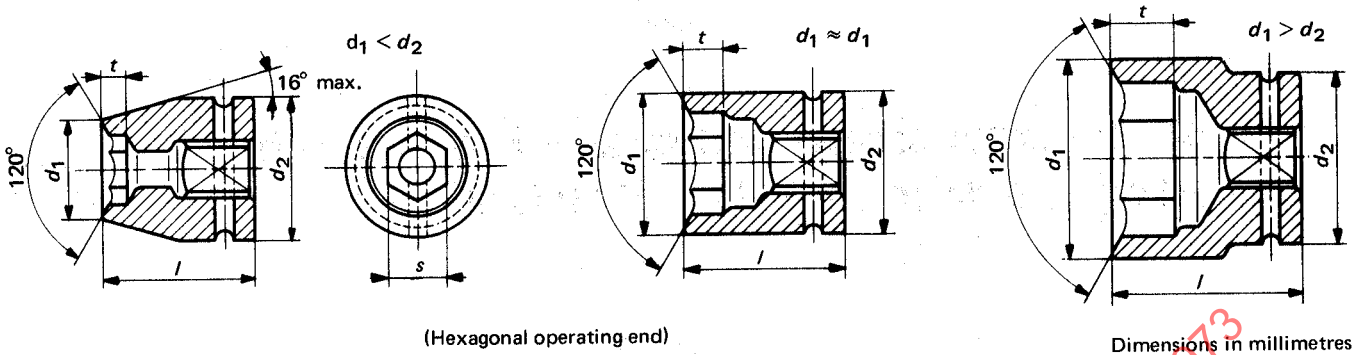
ISO/R 1174, *Assembly tools for bolts and screws — Driving squares for power socket wrenches and hand socket wrenches*.

ISO/R 1711, *Hand operated wrenches and sockets — Technical specifications*.

3 ACROSS FLAT TOLERANCES

Tolerances on *s* shall be in conformity with ISO/R 691. Manufacturers are free to choose the series of deviations.

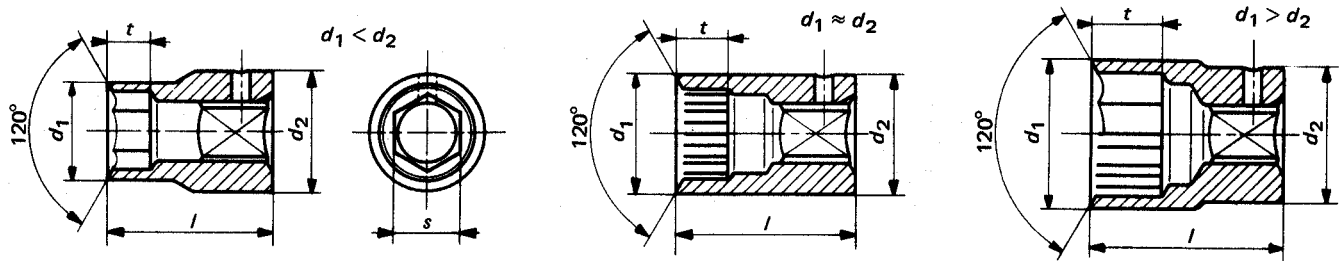
4 POWER SQUARE DRIVE SOCKETS



Across flat		Drive square ¹⁾											
		6,3			10			12,5			16		
s ²⁾	t min.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.
3,2	1,1	6,8	14	25									
4	1,4	7,8											
5	1,7	9,1											
5,5	2,1	9,7											
7	2,8	11,6											
8	3,5	12,8											
10	4,2	15,3	16	25	12,8	20	34	15,3	28	40			
11	4,9	16,6			14,1			17,8					
12	5,6	17,8			16,6			19,0					
13		19,1			17,8			20,3					
14		20,3			21,5								
17	7,0				21,6			22,8					25,0
19	8,4		25,3	26,5			28,8						
22	9,8		27,8	29,0			31,3						
24	11,2						35,0						
27	12,6						32,8	37	45	50	37,5	42	51
30	14,0						35,3				41,3		
32	15,4						39,0				45,0		
36	16,8										47,5	42	55
											52,5		

Across flat		Drive square ¹⁾								
		20			25			40		
s ²⁾	t min.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.
19	8,4	33,6	48	51						
22	9,8	37,4								
24	11,2	39,9								
27	12,6	43,6								
30	14,0	47,4								
32	15,4	49,9	58	54	46,7	58	60			
36	16,8	54,9			50,4		62			
41	18,9	61,1			52,9		63			
46	21,0	67,4			57,9		67	64,2	86	78
50	23,1				58		70	70,4		80
55	25,2		63	76	76,7	84				
60	27,3			75,4	82	81,7	87			
				81,7	87	87,9	90			
				87,9		91	94,2			95

1) According to ISO/R 1174.
2) Tolerances according to ISO/R 691.

5 HAND OPERATED SQUARE DRIVE SOCKETS¹⁾

Dimensions in millimetres

Across flat		Drive square ²⁾														
		6,3			10			12,5			20			25		
s ³⁾	t min.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.	d ₁ max.	d ₂ max.	l max.
3,2	1,6	5,9	12	25												
4	2	6,9														
5	2,5	8,2														
5,5	3	8,8														
7	4	11,0														
8	5	12,2			11,0	20	32									
10	6	14,7	15		12,2			15,5	24	40						
11	7	16,0	16		14,7			16,7								
12	8	17,2	17		16,0			18,0								
13		18,5	19		17,2			19,2								
14	10	19,7	20		18,5			20,5								
17					19,7			24,2	25							
19	12				23,5	24	35	26,7	27	42						
22	14				26,0			29,7	30	44	32,3	40	55			
24	16							33,0	31	46	35,8					
27	18							36,7	34	48	39,6			60		
30	20							40,5	38	50	43,3	43				
32	22							43,0	41		45,8	45	65			
36	24										50,8					
41	27										57,1	48	70			
46	30										63,3	50	75	66,4	55	80
50	33										68,3		80	71,4		85
55	36										74,6	57	85	77,6	57	90
60	39													83,9	61	95
Form of operating end		hexagon			double hexagon									hexagon or double hexagon		

1) According to ISO/R 1711.

2) According to ISO/R 1174.

3) Tolerances according to ISO/R 691.

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