

INTERNATIONAL STANDARD



3296

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

Textile machinery and accessories — Tubes for ring-spinning, doubling and twisting spindles, taper 1 : 64

Matériel pour l'industrie textile — Tubes pour broches de continus à filer et à retordre à anneaux, conicité 1 : 64

First edition — 1975-05-01

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UDC 677.052

Ref. No. ISO 3296-1975 (E)

Descriptors : textile machinery, spinning frames, ring twisters, spinning (extruding), pipes (tube), specifications, dimensions, taper.

Price based on 4 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 3296 was drawn up by Technical Committee ISO/TC 72, *Textile machinery and accessories*, and circulated to the Member Bodies in December 1973.

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

Belgium	India	Thailand
Czechoslovakia	Ireland	Turkey
Egypt, Arab Rep. of	Mexico	United Kingdom
Germany	Poland	U.S.S.R.
France	Switzerland	Yugoslavia

No Member Body expressed disapproval of the document.

Textile machinery and accessories — Tubes for ring-spinning, doubling and twisting spindles, taper 1 : 64

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions and tolerances (length and diameter) of tubes with taper 1 : 64 for ring-spinning, doubling and twisting spindles.

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2 DIMENSIONS AND TOLERANCES

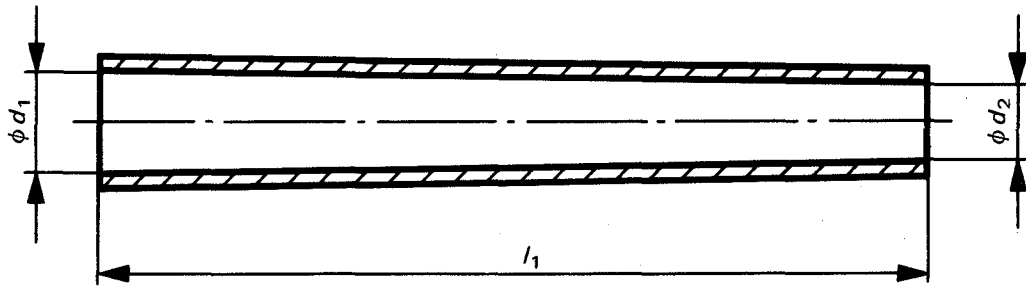


FIGURE 1a) — Tube type A with plain top

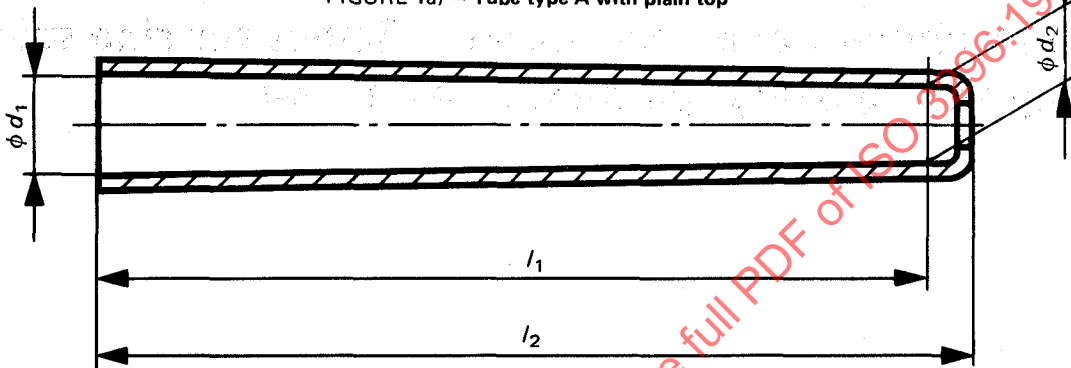


FIGURE 1b) — Tube type B with rolled-in top

TABLE 1 — Dimensions and tolerances for tubes

Values in millimetres

Length		Tolerance l_1 and l_2	Row 0		Row 1		Row 2		Row 3	
l_1	l_2		d_1	d_2	d_1	d_2	d_1	d_2	d_1	d_2
220	230	$\pm 1,5$	24	20,56	22	18,56	20	16,56	18	14,56
(230)	(240)		24	20,41	22	18,41	20	16,41	18	14,41
240	250		27	23,25	24	20,25	22	18,25	20	16,25
(250)	(260)		27	23,09	24	20,09	22	18,09	20	16,09
260	270	$\pm 2,0$	30	25,94	27	22,94	24	19,94	22	17,94
(270)	(280)		30	25,78	27	22,78	24	19,78	22	17,78
280	290		33	28,62	30	25,62	27	22,62	24	19,62
(290)	(300)		33	28,47	30	25,47	27	22,47	24	19,47
300	320	$\pm 2,5$	36	31,31	33	28,31	30	25,31	27	22,31
320	340		39	34,00	33	28,00	30	25,00	27	22,00
340	360		42	36,69	36	30,69	33	27,69	30	24,69
360	380		45	39,38	39	33,38	36	30,38	33	27,38
380	400	$\pm 3,0$	48	42,06	42	36,06	39	33,06	36	30,06
400	420		51	44,75	45	38,75	42	35,75	39	32,75
450	470		60	52,97	54	46,97	49	41,97	—	—
500	520		70	62,19	62	54,19	56	48,19	—	—
550	570	$\pm 4,0$	80	71,41	70	61,41	64	55,41	—	—
600	620		90	80,63	80	70,63	70	60,63	—	—
650	670		—	—	90	79,84	80	69,84	—	—
700	720		—	—	100	89,06	90	79,06	—	—
750	770	$\pm 5,0$	—	—	110	98,28	100	88,28	—	—
800	820		—	—	120	107,50	110	97,50	—	—

The values framed in bold are preferred. The values in brackets should be avoided wherever possible, in both the preferred and non-preferred areas.

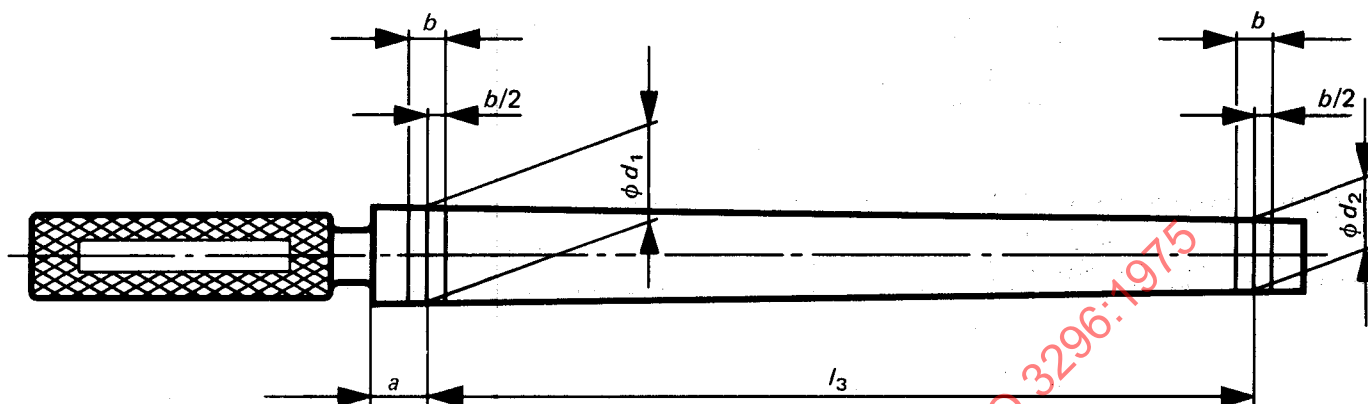


FIGURE 2a) — Gauge for tubes type A

TABLE 2 a) — Dimensions and tolerances for gauges for tubes type A

Values in millimetres

Length $l_3 \pm 0,2$	Row 0		Row 1		Row 2		Row 3		Distance $a \pm 1$	Distance $b \pm 0,1$
	d_1	d_2	d_1	d_2	d_1	d_2	d_1	d_2		
220	24	20,56	22	18,56	20	16,56	18	14,56	20	10
230	24	20,41	22	18,41	20	16,41	18	14,41		12
240	27	23,25	24	20,25	22	18,25	20	16,25		
250	27	23,09	24	20,09	22	18,09	20	16,09		
260	30	25,94	27	22,94	24	19,94	22	17,94		
270	30	25,78	27	22,78	24	19,78	22	17,78		
280	33	28,62	30	25,62	27	22,62	24	19,62		16
290	33	28,47	30	25,47	27	22,47	24	19,47		
300	36	31,31	33	28,31	30	25,31	27	22,31		
320	39	34,00	33	28,00	30	25,00	27	22,00		19
340	42	36,69	36	30,69	33	27,69	30	24,69		
360	45	39,38	39	33,38	36	30,38	33	27,38	40	22
380	48	42,06	42	36,06	39	33,06	36	30,06		26
400	51	44,75	45	38,75	42	35,75	39	32,75		
450	60	52,97	54	46,97	49	41,97	—	—		
500	70	62,19	62	54,19	56	48,19	—	—		30
550	80	71,41	70	61,41	64	55,41	—	—		
600	90	80,63	80	70,63	70	60,63	—	—		
650	—	—	90	79,84	80	69,84	—	—		33
700	—	—	100	89,06	90	79,06	—	—		
750	—	—	110	98,28	100	88,28	—	—		42
800	—	—	120	107,50	110	97,50	—	—		

The marks $\pm b/2$ at the small end of the gauge are used only for checking the internal diameter at the top of the tube. For checking the internal diameter at the base of the tube by means of the corresponding marks on the gauge, the tube must be cut into parts.

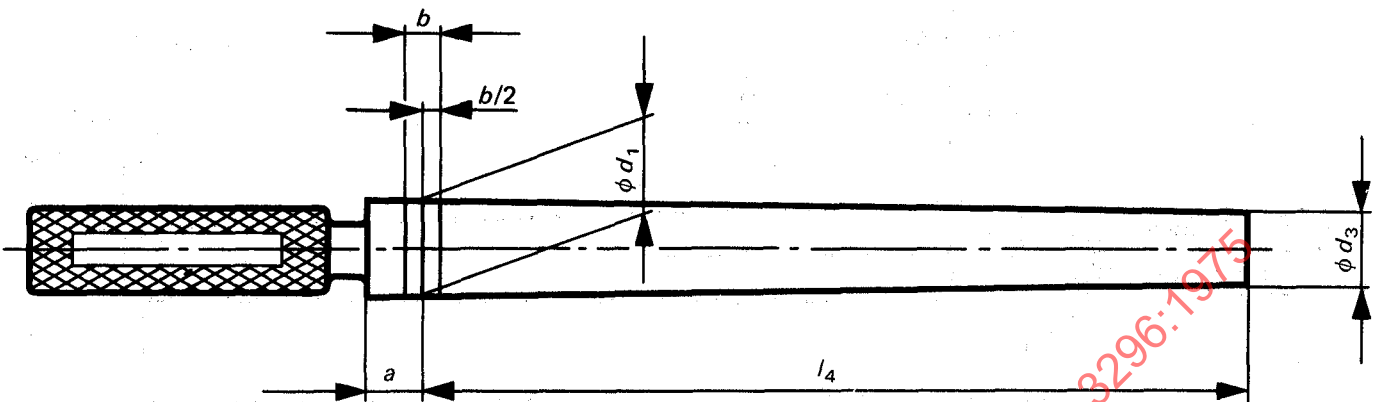


FIGURE 2b) – Gauge for tubes type B

TABLE 2b) – Dimensions and tolerances for gauges for tubes type B

Values in millimetres

Length $l_4 \pm 0,2$	Row 0		Row 1		Row 2		Row 3		Distance $a \pm 1$	Distance $b \pm 0,1$
	d_1	d_3	d_1	d_3	d_1	d_3	d_1	d_3		
215	24	20,64	22	18,64	20	16,64	18	14,64	20	10
225	24	20,48	22	18,48	20	16,48	18	14,48		12
230	27	23,41	24	20,41	22	18,41	20	16,41		
240	27	23,25	24	20,25	22	18,25	20	16,25		
250	30	26,09	27	23,09	24	20,09	22	18,09		
260	30	25,94	27	22,94	24	19,94	22	17,94		16
270	33	28,78	30	25,78	27	22,78	24	19,78		
280	33	28,62	30	25,62	27	22,62	24	19,62		
300	36	31,31	33	28,31	30	25,31	27	22,31		
320	39	34,00	33	28,00	30	25,00	27	22,00		
330	42	36,84	36	30,84	33	27,84	30	24,84		
350	45	39,53	39	33,53	36	30,53	33	27,53	22	
370	48	42,22	42	36,22	39	33,22	36	30,22		
390	51	44,91	45	38,91	42	35,91	39	32,91	40	26
440	60	53,12	54	47,12	49	42,12	—	—		30
485	70	62,42	62	54,42	56	48,42	—	—		
535	80	71,64	70	61,64	64	55,64	—	—		
585	90	80,86	80	70,86	70	60,86	—	—		
635	—	—	90	80,08	80	70,08	—	—		
685	—	—	100	89,30	90	79,30	—	—		
730	—	—	110	98,59	100	88,59	—	—		42
780	—	—	120	107,81	110	97,81	—	—		

For checking the internal diameter at the base of the tube by means of the corresponding marks on the gauge, the tube must be cut into parts.

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INTERNATIONAL STANDARD



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Extra long parallel shank twist drills

Forets extra-longs à queue cylindrique

First edition — 1975-04-01

STANDARDSISO.COM : Click to view the full PDF of ISO 3292:1975

UDC 621.951.45

Ref. No. ISO 3292-1975 (E)

Descriptors : tools, twist drills, parallel shanks, dimensions.

Price based on 2 pages