

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 1651

TUBE DRAWING MANDRELS

1st EDITION

July 1970

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Printed in Switzerland

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BRIEF HISTORY

The ISO Recommendation R 1651, *Tube drawing mandrels*, was drawn up by Technical Committee ISO/TC 29, *Small tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question led to the adoption of Draft ISO Recommendation No. 1561 which was circulated to all the ISO Member Bodies for enquiry in August 1968. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Belgium
Czechoslovakia
France
Greece
Hungary
India
Ireland

Israel
Italy
Netherlands
Poland
Portugal
South Africa, Rep. of
Spain

Switzerland
Thailand
Turkey
U.A.R.
United Kingdom
Yugoslavia

The following Member Bodies opposed the approval of the Draft :

Finland
Sweden

This Draft ISO Recommendation was then submitted by correspondence to the ISO Council which decided to accept it as an ISO RECOMMENDATION.

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TUBE DRAWING MANDRELS

1. SCOPE

This ISO Recommendation relates to tube drawing mandrels and gives their general dimensions with respect to diameter d_1 .

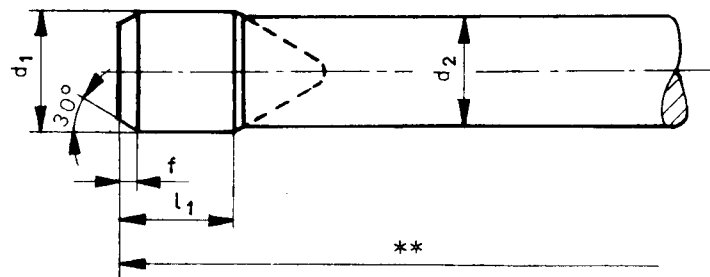
It applies to brazed drawing mandrels and sleeved drawing mandrels.

The dimensions given in this ISO Recommendation have been determined taking existing practice into account as far as possible.

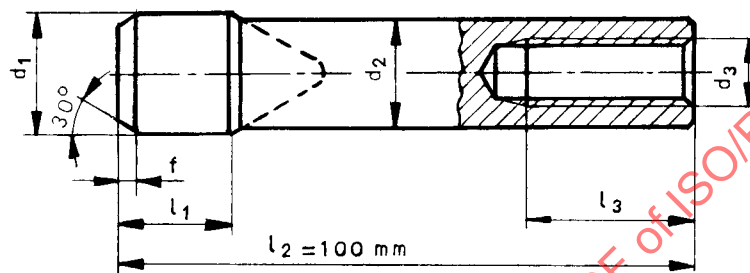
Threads are given in both measurement systems (metric and in inches) so as to allow the use of these mandrels in any country and on any machine.

2. BRAZED DRAWING MANDRELS

Form A — Welded on rod



Form B — With female thread



Form C — With male thread

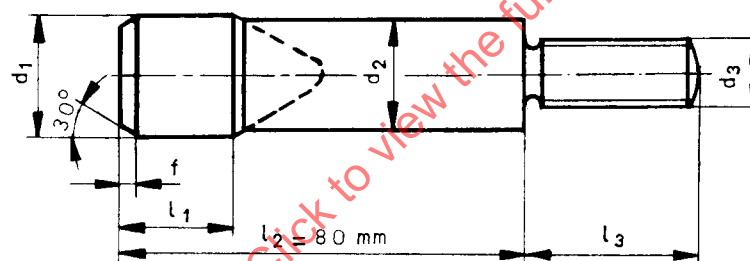


FIG. 1

TABLE 1

Dimensions in millimetres

Form	d_1			d_2	l_1	f^* max.	Form B			Form C		
	above	up to	Tolerance				d_3		l_3	d_3		l_3
							Metric thread	Inch thread		Metric thread	Inch thread	
A	3	6	$+0.01$ 0	$d_2 = d_1$	10	2	—	—	—	—	—	—
	6	8			12							
B,C	8	10	$+0.01$ 0	$d_2 = d_1 \begin{smallmatrix} -0.2 \\ -0.06 \end{smallmatrix}$	15	2	M 5	Na10—32 UNF	10	M 6	$\frac{1}{4}$ — 20 UNC	12
	10	12.5			18		M 6	$\frac{1}{4}$ — 20 UNC	12	M 8	$\frac{5}{16}$ — 18 UNC	16
	12.5	16			20		M 8	$\frac{5}{16}$ — 18 UNC	16	M10	$\frac{3}{8}$ — 16 UNC	20
	16	20	$+0.02$ 0		22		M10	$\frac{3}{8}$ — 16 UNC	20	M12	$\frac{1}{2}$ — 13 UNC	24
	20	25			25		M12	$\frac{1}{2}$ — 13 UNC	24	M16	$\frac{5}{8}$ — 11 UNC	32

* A radius can be provided in place of a chamfer if required.

** The total length should be subject to agreement between manufacturer and purchaser.

NOTE. — Details not stated are left to the discretion of the manufacturer.