

Annulé

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 524

HARD METAL WIRE DRAWING DIES INTERCHANGEABILITY DIMENSIONS OF PELLETS AND CASES

1st EDITION
November 1966

COPYRIGHT RESERVED

The copyright of ISO Recommendations and ISO Standards belongs to ISO Member Bodies. Reproduction of these documents, in any country, may be authorized therefore only by the national standards organization of that country, being a member of ISO.

For each individual country the only valid standard is the national standard of that country.

Printed in Switzerland

Also issued in French and Russian. Copies to be obtained through the national standards organizations.

STANDARDSISO.COM : Click to view the full PDF of ISO/R 524:1966

BRIEF HISTORY

The ISO Recommendation R 524, *Hard Metal Wire Drawing Dies – Interchangeability Dimensions of Pellets and Cases*, 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 by the Technical Committee began in 1950 and led, in 1963, to the adoption of a Draft ISO Recommendation.

In April 1964, this Draft ISO Recommendation (No. 670) was circulated to all the ISO Member Bodies for enquiry. It was approved by the following Member Bodies:

Australia	France	Poland
Austria	Germany	Portugal
Belgium	Greece	Spain
Brazil	Hungary	Sweden
Canada	India	Switzerland
Chile	Italy	Turkey
Colombia	Korea, Rep. of	United Kingdom
Czechoslovakia	Netherlands	U.S.S.R.
Denmark	New Zealand	Yugoslavia

Two Member Bodies opposed the approval of the Draft:

Japan
U.S.A.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in November 1966, to accept it as an ISO RECOMMENDATION.

STANDARDSISO.COM : Click to view the full PDF of ISO/R 524:1966

HARD METAL WIRE DRAWING DIES

INTERCHANGEABILITY DIMENSIONS OF PELLETS AND CASES

1. SCOPE

This ISO Recommendation relates to hard metal wire drawing dies and gives the main dimensions for interchangeability of pellets and cases, together with details of marking. It may be supplemented later by standardization of the internal dimensions of the pellets, establishment of the bearing diameter d_1 in relation to the material to be drawn and the drawing conditions, and a uniform method of designation.

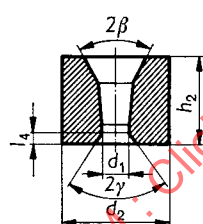
This ISO Recommendation includes an Appendix Z giving the terminology for characteristic elements of pellets and cases in several languages.

2. INTERCHANGEABILITY

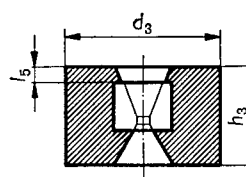
The dimensions given in this ISO Recommendation have been determined by taking as much account as possible of existing practice and of the increasingly widespread use of multiple wire drawing machines.

Although these dimensions are expressed only in millimetres, their adoption by all countries, including those in which the inch system of measurement is most widely used, should ensure world-wide interchangeability.

Interchangeability dimensions of pellets and cases, in millimetres



Pellet (see Note 1)



Case (see Note 2)

Pellets					Cases		
d_2	h_2	2β	2γ	l_4 max.	d_3	h_3	l_5
8	4	90°	90°	1	28	12	3
10	8			2		16	
12	10			2.5		20	
14	12	60°	75°	3	28 or 43	22	4
16	13			3.5	43	25	
20	17			4.5		32	
25	20		60°	5	53 or 75	35	5
30	24			6	75	40	6

NOTES

1. *Internal dimensions of pellets.* Dimension l_4 has been fixed internationally, but the determination of the other internal dimensions of the pellet, and, in particular, of the diameter of the bearing d_1 , in relation to the material to be drawn and the drawing conditions, is left to each National Standards Organization.
2. *Cases.* The case may be cylindrical or tapered; for the latter, the dimension d_3 corresponds to the large end of the taper.

3. MARKING

Wire drawing dies conforming to this ISO Recommendation should carry the following details on their cases:

(1) on the entry side:

manufacturer's trade mark,
diameter of bearing d_1 ;

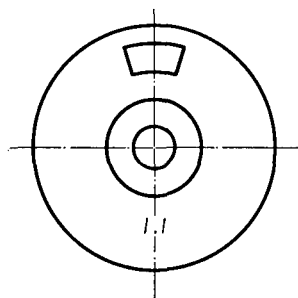
(2) on the exit side:

the mark "ISO",
the diameter of the pellet d_2 , supplemented possibly by the case diameter d_3 .

EXAMPLE:

Entry side

for $d_1 = 1.1$ mm



Exit side

for $d_2 = 14$ mm

