

Transformed
ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 722

ROCK DRILLING
HOLLOW HEXAGONAL DRILL STEELS IN BAR FORM

1st EDITION

May 1968

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BRIEF HISTORY

The ISO Recommendation R 722, *Rock drilling — Hollow hexagonal drill steels in bar form*, was drawn up by Technical Committee ISO/TC 82, *Mining*, the Secretariat of which is held by the Deutscher Normenausschuss (DNA).

Work on this question by the Technical Committee began in 1960 and led, in 1964, to the adoption of a Draft ISO Recommendation.

In April 1965, this Draft ISO Recommendation (No. 801) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies:

Australia	Japan	Sweden
Belgium	Korea, Rep. of	Turkey
Brazil	Netherlands	U.A.R.
Chile	New Zealand	United Kingdom
Czechoslovakia	Poland	
France	Portugal	
Germany	South Africa	
Hungary	Rep. of	
India	Spain	

Three Member Bodies opposed the approval of the Draft:

Canada
U.S.S.R.
Yugoslavia

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in May 1968, to accept it as an ISO RECOMMENDATION.

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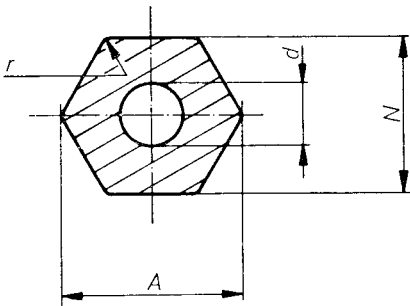


TABLE 1 — Dimensions in millimetres

Hexagonal size mm	N		A ≈	d	r	Eccentricity: distance between the centre of the hexagon and the centre of the hole max.	Section ≈ mm ²	Mass ≈ kg/m
	Basic size	Tolerance						
19	19.2	+ 0.1 — 0.4	21.4	6 ± 0.5	1.5 ^{+ 1} ₀	0.75	285	2.2
22	22.4		24.8	6.7 ± 0.6	2 ^{+ 1} ₀	0.75	390	3.1
25	25.6	0 — 0.6	28.5	7.6 ± 0.75	2 ^{+ 1} ₀	0.75	510	4

TABLE 2 — Dimensions in inches

Hexagonal size in	N		A ≈	d	r	Eccentricity: distance between the centre of the hexagon and the centre of the hole max.	Section ≈ in ²	Mass ≈ lb/ft
	Basic size	Tolerance						
3/4	0.756	+ 0.004 — 0.016	0.843	0.236 ± 0.020	0.059 ^{+ 0.039} ₀	0.030	0.442	1.48
7/8	0.882		0.976	0.264 ± 0.024	0.079 ^{+ 0.039} ₀	0.030	0.605	2.08
1	1.008	0 — 0.024	1.122	0.299 ± 0.030	0.079 ^{+ 0.039} ₀	0.030	0.791	2.69

Relative density 7.85.