



National Standards Authority of Ireland

IRISH STANDARD

I.S. EN 22857 : 1990

ICS 25.100.50

**GROUND THREAD TAPS FOR ISO METRIC  
THREADS OF TOLERANCES 4H TO 8H AND  
4G TO 6G COARSE AND FINE PITCHES -  
MANUFACTURING TOLERANCES ON THE  
THREADED PORTION (ISO 2857)**

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Údarás um Chaighdeáin Náisiúnta na hÉireann



## DECLARATION

OF

SPECIFICATION

ENTITLED

GROUND THREAD TAPS FOR ISO METRIC THREADS OF TOLERANCES 4H TO 8H

AND 4G TO 6G COARSE AND FINE PITCHES

MANUFACTURING TOLERANCES ON THE THREADED PORTION

AS

THE IRISH STANDARD SPECIFICATION FOR

GROUND THREAD TAPS FOR ISO METRIC THREADS OF TOLERANCES 4H TO 8H

AND 4G TO 6G COARSE AND FINE PITCHES

MANUFACTURING TOLERANCES ON THE THREADED PORTION

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EOLAS - The Irish Science and Technology Agency in exercise of the power conferred by section 20 (3) of the Industrial Research and Standards Act, 1961 ( No. 20 of 1961 ) and the Science and Technology Act, 1987 (No. 30 of 1987), and with the consent of the Minister for Industry and Commerce, hereby declares as follows:

1. This instrument may be cited as the Standard Specification ( Ground Thread Taps for ISO Metric Threads of Tolerances 4H to 8H and 4G to 6G and Fine Pitches; Manufacturing Tolerances on the Threaded Portion ) Declaration, 1990.

2. (1) The Specification set forth in the Schedule to this declaration is hereby declared to be the standard specification for Ground Thread Taps for ISO Metric Threads of Tolerances 4H to 8H and 4G to 6G and Fine Pitches; Manufacturing Tolerances on the Threaded Portion . The schedule comprises the text of EN 22857 : 1989.

(2) The said standard specification may be cited as Irish Standard/EN 22857 : 1990 or as I.S./EN 22857 : 1990.



EUROPEAN STANDARD

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Key words: Power operated tools, taps, ISO metric threads, dimensional tolerances

English version

Ground thread taps for ISO metric threads of tolerances 4H to 8H and 4G to 6G coarse and fine pitches; Manufacturing tolerances on the threaded portion (ISO 2857:1973 encl. Amd 1:1984 and Amd 2:1986)

Tarauds à filets rectifiés pour filetages métriques ISO de tolérance 4H à 8H et 4G à 6G à pas gros et à pas fins; Tolérances d'exécution de la partie taillée (ISO 2857:1973, Amd 1:1984 et Amd 2:1986 inclus)

Geschliffene Gewindebohrer für metrische ISO-Gewinde mit Toleranzfeld 4H bis 8H und 4G bis 6G für Regel- und Feingewinde; Festigungstoleranzen des Gewindeteiles (ISO 2857:1973 mit Amd 1:1984 und Amd 2:1986)

This European Standard was accepted by CEN on 1989-06-09 and is identical to the ISO standard as referred to.

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