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IS 6379 (1989): Single Ended Ring Wrenches (Spanners) [PGD
5: Assembly Hand Tools]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
**SINGLE ENDED RING WRENCHES
(SPANNERS) — SPECIFICATION**
(First Revision)

भारतीय मानक
एक सिरे वाले रिंग रेंच (पाने) — विशिष्ट
(पहला पुनरीक्षण)

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FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 3 October 1989, after the draft finalized by the Assembly Hand Tools Sectional Committee had been approved by the Production Engineering Division Council.

This standard was first issued in 1971. While revising this standard, nominal sizes 18, 21 and 34 mm have been included because of its popular use in the country. Reference of latest IS 2027 : 1980 'Widths across flats for spanners and sockets (second revision)' and IS 6131 : 1980 'Technical requirements for hand-operated wrenches (spanners) and sockets (first revision)' have also been incorporated.

For double ended ring spanners, reference may be made to IS 2029 : 1981 'Specification for ring wrenches (spanners) (second revision).'

While revising, considerable assistance has been taken from DIN 3111 : 1982 'Box wrenches, single end, test torques Series A', issued by Deutsches Institut für Normung (DIN).

Indian Standard

SINGLE ENDED RING WRENCHES (SPANNERS) — SPECIFICATION

(*First Revision*)

1 SCOPE

1.1 This standard covers the requirements for single ended ring wrenches (spanners), conforming to test torque Series A or Series B as per IS 6131 : 1980 'Technical requirements for hand-operated wrenches (spanners) and sockets (*first revision*)'.

2 REFERENCES

2.1 The following Indian Standards are necessary adjuncts to this standard:

<i>IS No.</i>	<i>Title</i>
IS 1570 (Part 2) : 1979	Schedules for wrought steels : Part 2 Carbon steels (unalloyed steels) (<i>first revision</i>)
IS 2027 : 1980	Widths across flats for spanners and sockets (<i>second revision</i>)
IS 3749 : 1978	Tool and die steels for cold work (<i>first revision</i>)
IS 6131 : 1980	Technical requirements for hand-operated wrenches (spanners) and sockets (<i>first revision</i>)

3 DIMENSIONS

3.1 Dimensions shall be as given in Table 1.

3.2 Tolerances on width across flats shall be in accordance with IS 2027 : 1980.

4 MATERIAL

4.1 The wrenches shall be manufactured from suitable alloyed or unalloyed steels meeting the requirements laid down in 5.

Suitable Examples : Steel designation 45C8 conforming IS 1570 (Part 2) : 1979 and T50Cr4V2 of IS 3749 : 1978.

5 HARDNESS, WORKMANSHIP AND FINISH, PRESERVATION AND PACKING, TESTS, SAMPLING

5.1 These requirements shall be according to IS 6131 : 1980. The torque test shall conform to Series A or Series B of IS 6131 : 1980.

6 DESIGNATION

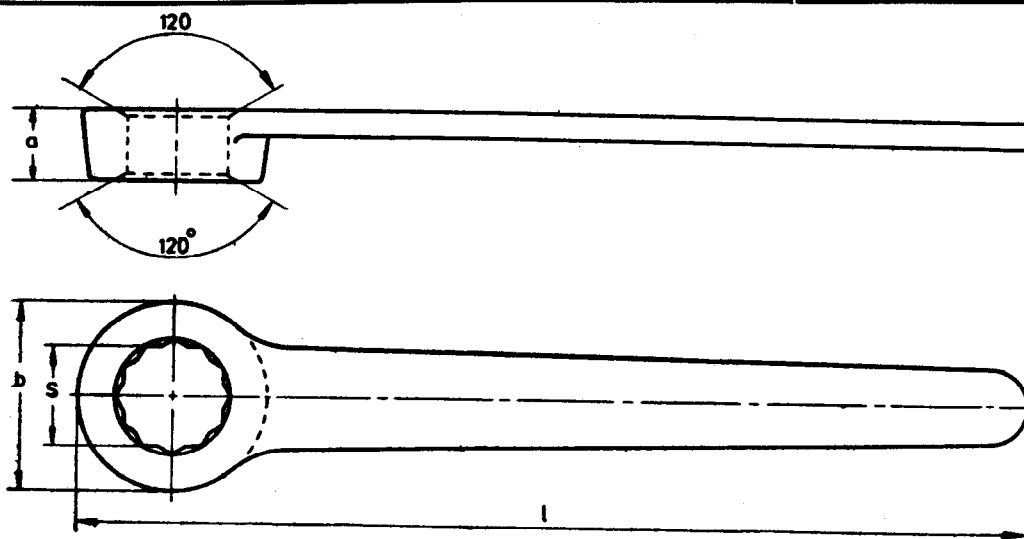
6.1 A single ended ring wrench (spanner) of nominal size 30 mm and torque Series A shall be designated as follows:

Ring Wrench 30A IS 6379

7 MARKING

7.1 Wrenches shall be legibly and indelibly marked with the nominal size and manufacturer's name, initials or recognized trade-mark.

Table 1 Dimensions for Single Ended Ring Wrenches (Spanners)
(Clause 3.1)



All dimensions in millimetres.

Nominal Size* S	a Max	b Min	l	
			Max	Min
18	12	29	175	155
19	12	30	180	160
21	14	33	195	175
22	14	36	200	180
24	16	38	220	200
27	17	42	240	220
30	19	46	260	240
32	20	49	270	250
34	20	53	280	260
36	23	55	300	270
41	26	63	340	310
46	28	71	370	340
50	29	77	420	370
55	30	84	450	410
60	31	92	480	440
65	33	98	520	470
70	36	106	560	510
75	39	114	600	550
80	41	122	630	580
85	44	130	670	620
90	47	136	710	660
95	47	145	710	660

*Nominal size is the width across flats of the ring spanner.

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