

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

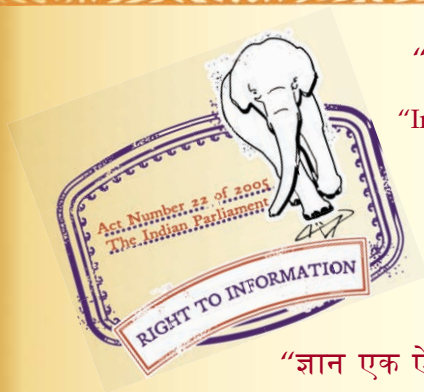
“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6837 (1973): Three Wheel Type Pipe Cutter [PGD 6: Earth, Metal And Wood Working Hand Tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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AMENDMENT NO. 1 JUNE 1981
TO
IS : 6837-1973 SPECIFICATION FOR
THREE WHEEL TYPE PIPE CUTTER

Alterations

(Page 1, clause 2, heading) — Substitute the following for the existing heading:

'2. Typical Shapes, Capacities and Dimensions '

(Page 2, Table 3, reference to clause) — Substitute '(Clause 2.3) ' for '(Clause 2.2) '.

(Page 2, Table 4, reference to clause) — Substitute '(Clause 2.3) ' for '(Clause 2.2) '.

Addendum

(Page 1, clause 2) — Add the following new matter after 2 and renumber the subsequent clauses accordingly:

'2.1 Shapes — As shown in Fig. 1 and 2.

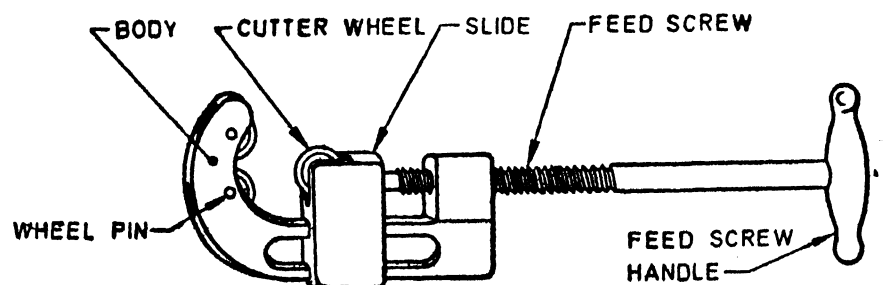


FIG. 1 THREE-WHEEL TYPE PIPE CUTTER FOR CUTTING PIPE 9 TO 60 mm DIAMETER INCLUSIVE, TYPICAL

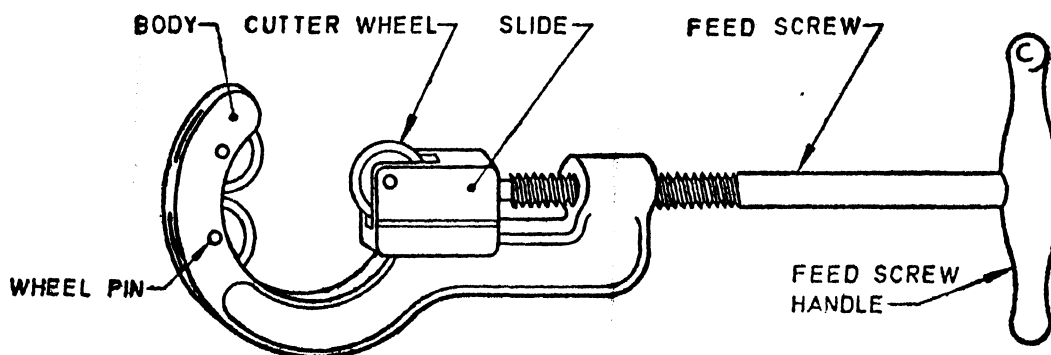


FIG. 2 THREE-WHEEL TYPE PIPE CUTTER FOR CUTTING PIPE 45 TO 315 mm DIAMETER INCLUSIVE, TYPICAL

(EDC 12)



Indian Standard

SPECIFICATION FOR THREE WHEEL TYPE PIPE CUTTER

1. Scope — Lays down the dimensional and other requirements for three wheel type pipe cutter, intended for cutting steel and wrought iron pipes in the range of 9 to 315 mm external diameter.

2. Capacities and Dimensions

2.1 Capacities — Pipe cutter shall be available in the sizes given in Table 1.

TABLE 1 CAPACITIES OF THREE WHEEL TYPE PIPE CUTTERS

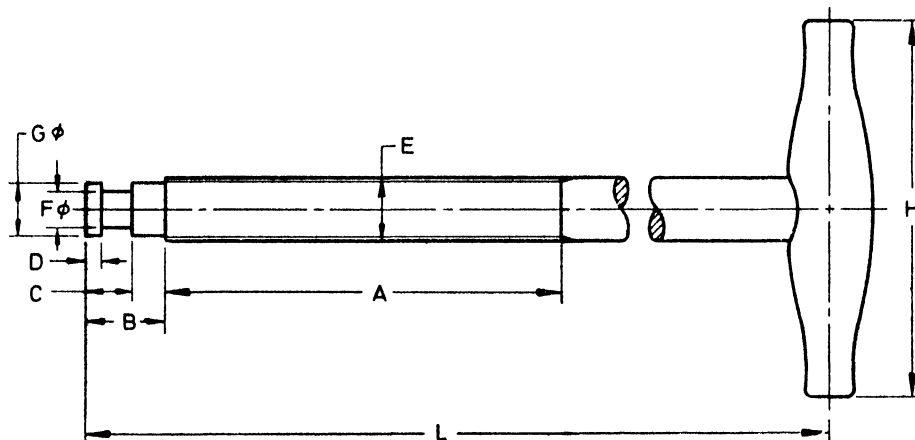
All dimensions in millimetres.

Nominal Size	Suitable for Pipe Diameter Between	Nominal Size	Suitable for Pipe Diameter Between
1	9 to 35.5	5	106 to 170
2	20 " 60	6	160 " 224
3	45 " 90	7	212 " 265
4	75 " 112	8	236 " 315

2.2 Dimensions — The dimensions of component parts of pipe cutters shall be as given in Tables 2 to 4.

TABLE 2 DIMENSIONS FOR FEED SCREW AND HANDLE

All dimensions in millimetres.



Nominal Size	Length of Thread A	Minimum Dimension from Thread to End B	Dimension in Slide C	Width of Nose D	ISO Metric Screw Thread E	Diameter of Recess for Slide F	Diameter of Nose G	Overall Length of Handle H Min	Length from Centre of Handle to End L
1	71	20	11.8	4	M14×2	7.1	11.8	85	250
2	100	20	11.8	4	M16×2	8.5	13.2	95	300
3	112	22.4	11.8	4	M20×2.5	11.2	16	140	355
4	132	28	12.5	5	M22×2.5	13.2	18	200	400
5	160	28	12.5	5	M22×2.5	13.2	18	200	475
6	170	28	12.5	5	M22×2.5	13.2	18	200	530
7	170	31.5	14	6.3	M24×3	15	20	200	630
8	212	31.5	14	6.3	M30×3.5	15	20	265	710

Adopted 15 February 1973

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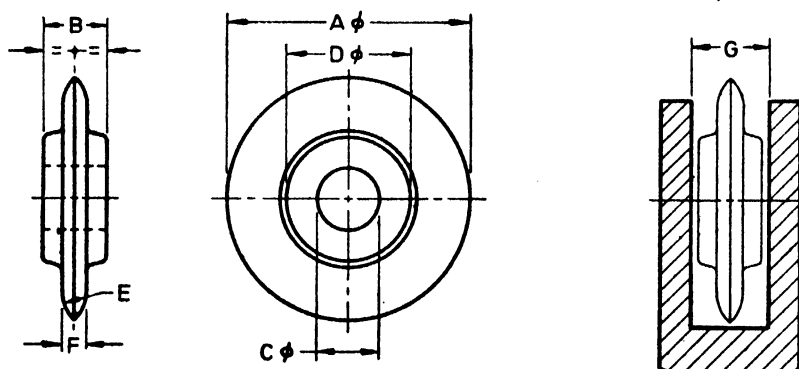
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TABLE 3 DIMENSIONS FOR CUTTER WHEELS AND WHEEL SLOTS

(Clause 2.2)

All dimensions in millimetres.

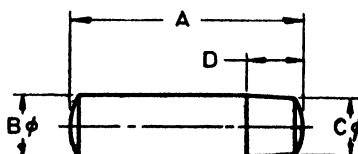


Nominal Size	Nominal Diameter of Wheel A	Width Through Boss B $+0$ -0.125	Diameter of Bore C $+0.075$ -0	Nominal Diameter of Boss D	Nominal Radius of Blade E	Width of Root of Blade F	Width of Wheel Slot G $+0.125$ $+0.050$
1	25	6.3	7.1	14	9.5 or 5	2 or 2.8	6.3
2	31.5	8	8	16	9.5 or 5	2 or 3	8
3	35.5	9.5	9	19	9.5 or 6.3	2.36 or 4	9.5
4	42.5	12.5	11.2	22.4	9.5 or 8	2.36 or 5	12.5
5 and 6	50	12.5	11.2	25	9.5	2.8 or 5.6	12.5
7 and 8	53	12.5	11.2	25	9.5	2.8 or 5.6	12.5

TABLE 4 DIMENSIONS FOR WHEEL PINS

(Clause 2.2)

All dimensions in millimetres.



Nominal Size	Normal Overall Length A	Diameter of Pin B -0.050 -0.125	Nominal Diameter Small End of Taper C	Nominal Length of Taper D
1	26.5	7.1	6.3	6.3
2	30	8	7	7
3	35.5	9	8	8
4 to 8	45	11.2	10	10

2.2.1 General engineering tolerances shall be applicable on untoleranced dimensions.

3. Requirements

3.1 Assembly — The functioning faces of the body and slide shall be machined in a manner that on assembly they are equidistant about and parallel with the centre line of the wheel slots. The centre line of the threaded hole for the feed screw and that of thrust hole in the slide shall be parallel and central with the functioning (sliding) faces of the body and slide in order to ensure accuracy of assembly.

3.2 Requirements regarding material, hardness, manufacture, workmanship and finish, tests, marking, packing and sampling shall conform to IS : 6843-1973 'Technical supply conditions for pipe cutters'.

4. Designation — The pipe cutters shall be designated by the nominal size and the number of this standard.

Example:

A pipe cutter of nominal size 7 and suitable for pipe diameters between 212 to 265 mm (external diameter) shall be designated as:

Pipe Cutter 7 IS : 6837

EXPLANATORY NOTE

While preparing this standard, assistance has been derived from Draft British Standard No. 71/32387 (Revision of BS 1857) 'Pipe cutters' issued by British Standards Institution.