

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 844-3 (1979): Screw Drivers, Part III: Dimensions for Screw Drivers for Recessed Head Screws [PGD 5: Assembly 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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Indian Standard

REAFFIRMED

SPECIFICATION FOR SCREW DRIVERS

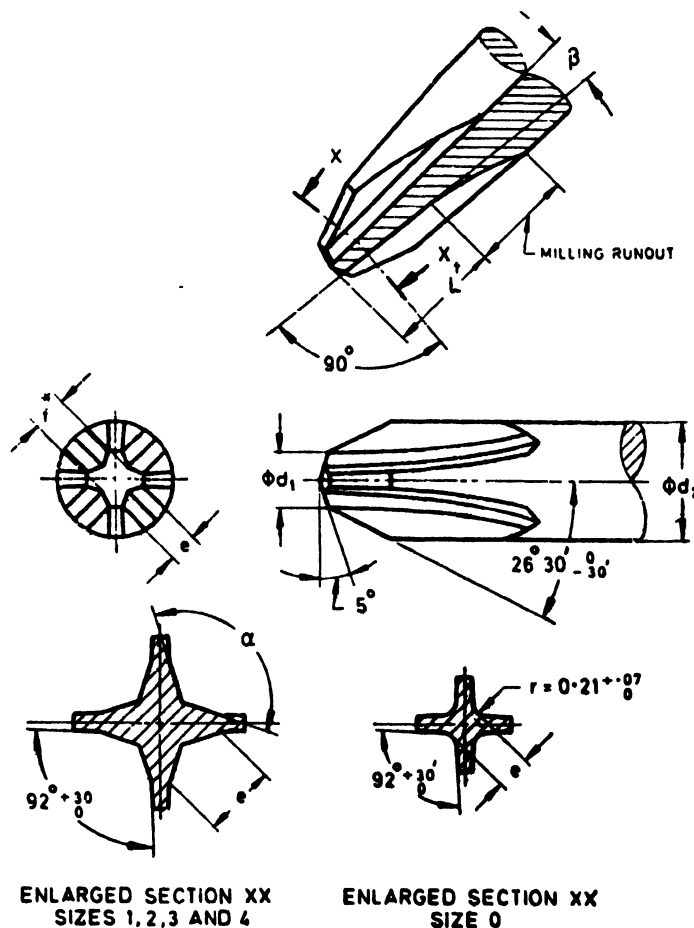
PART III DIMENSIONS FOR SCREW DRIVERS FOR
RECESSED HEAD SCREWS

(Second Revision)

1. **Scope** — Covers dimensional and other requirements for screw drivers intended for recessed head screws.

2. Dimensions

2.1 Screw Driver Points

ENLARGED SECTION XX
SIZES 1, 2, 3 AND 4ENLARGED SECTION XX
SIZE 0

*Measured in a plane perpendicular to the axis of the screw driver and passing through the point of intersection of the vertical line inclined at an angle β with the enveloping surface of the taper of angle $2 (90^\circ - 5^\circ)$.

†Length of the portion milled at an angle β .

Adopted 27 June 1979

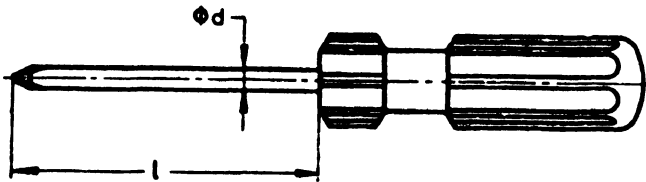
November 1979, BIS

Gr 2

All dimensions in millimetres.

Nominal Size	d_1 -0.075 +0.025	d_2 h11	e		f +0.075 -0.025	l Min	α +30' 0	β 0 -30'
			Dimension	Tolerance				
0	0.838	3	.290	+0.090 -0	0.559	2.5	—	7°
1	1.295	5	0.488	+0.075 -0	0.975	3.0	138°	7°
2	2.311	6	1.077	+0.075 -0	1.514	4.5	140°	5°45'
3	3.635	8	2.073	+0.075 -0	2.471	7.0	146°	5°45'
4	5.105	10	2.713	+0.075 -0	3.548	8.5	153°	7°

2.2 Type A (Ordinary Type with Long Handle)

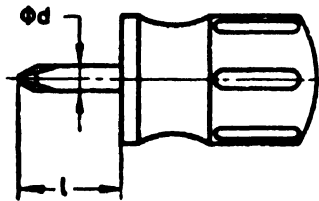


All dimensions in millimetres.

Nominal Size	d h11	$l \pm 5$	Plastic Handle Sizes*
0	3	60	L80
1	5	75	L90
2	6	100	L100
3	8	150	L120
4	10	200	L120

*According to IS : 844 (Part I)-1979 'Specification for screw drivers : Part I Technical supply conditions (second revision) '.

2.3 Type B (Stubby Type)



All dimensions in millimetres.

Nominal Size	d h11	$l \pm 5$	Plastic Handle Sizes*
1	5	25	S50
2	6	25	S50

*See IS : 844 (Part I)-1979.

AMENDMENT NO. 1 OCTOBER 1993
TO
IS 844 (Part 3) : 1979 SPECIFICATION FOR SCREW
DRIVERS
PART 3 DIMENSIONS FOR SCREW DRIVERS FOR RECESSED
HEAD SCREWS
(Second Revision)

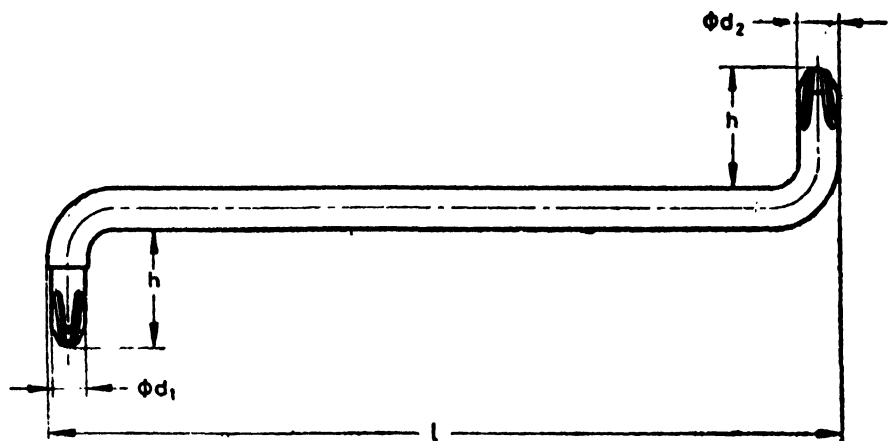
(*Page 2, clause 2.1, Table*) - Existing tolerance under ' d_1 ' shall be read
as:

d_1
 $+0.075$
 -0.025

(PE 06)

Reprography Unit, BIS, New Delhi, India

2.4 Type C (Double Off Set Type)



All dimensions in millimetres.

Nominal Size	d_1 Min	d_2 Min	$l \pm 5$	h Min
1×2	5	6	100	20
3×4	8	10	200	30

3. Material, Finish, Preservation and Packing, Sampling and Marking — According to IS : 844 (Part I)-1979.

4. Hardness — The blades shall be heat treated throughout their length. The hardness when measured as close as possible to the working end shall be within the range of 545 to 655 HV (\approx 52 to 58 HRC).

5. Designation — A screw driver of Type A and nominal size 2 shall be designated as:

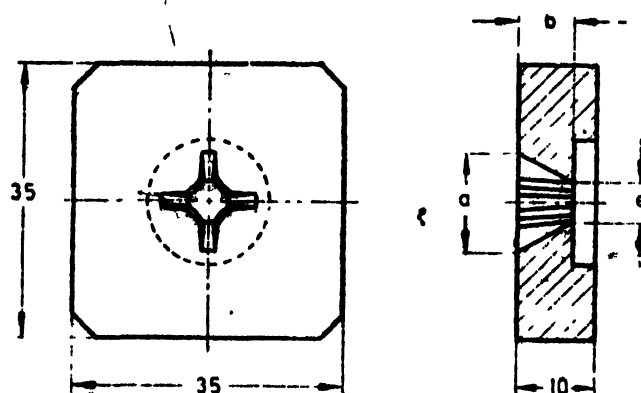
Screw Driver A-2, IS : 844 (Part III)

6. Tests — The screw drivers shall be subjected to the testing torque indicated in Table 1. The dimensions for a suitable torque applying test plate is indicated in Table 2. The screw driver point shall be made to sit in the test plate and the testing torque shall be applied without any jerks or impact and shall be gradually increased till the specified testing torque is reached. At the end of the test there shall be no permanent deformation or other defects, such as cracks, breaks, etc.

TABLE 1 TESTING TORQUE FOR SCREW DRIVERS

Nominal Size	Testing Torque N.m. Min
0	1.4
1	3.8
2	10.4
3	38.0
4	58.0

TABLE 2 : DIMENSIONS FOR TEST PLATE



All dimensions in millimetres.

Nominal Size	a		b	e
	Max	Min		
0	2.34	2.24	1.47	0.81
1	3.66	3.56	2.34	1.27
2	5.97	5.87	3.63	2.29
3	9.85	9.75	5.99	3.81
4	12.39	12.29	7.26	5.08

Note—The recess shall be cold-stamped with a master punch. Hardness of the plate shall be 655 HV, Min (=58 HRC, Min).

7. Marking — The screw drivers shall be marked with the type, nominal size, manufacturer's name and/or the recognized trade-mark.

7.1 ISI Certification Marking — Details available with the Indian Standards Institution.

EXPLANATORY NOTE

This standard covers the requirements for screw drivers for recessed head screws conforming to relevant Indian Standards.

This standard was first published in 1974. In the present revision the wooden handles have been replaced by the plastic handles and Grades 1 and 2 have been rationalized to a single grade.