

Australian Standard[®]

**Assembly tools for bolts and
screws—Hexagon drive ends for
hand-operated and machine-
operated screwdriver bits**

This Australian Standard was prepared by Committee ME/10, Small Tools. It was approved on behalf of the Council of Standards Australia on 24 May 1989 and published on 13 October 1989.

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Australian Automobile Association
Australian British Chamber of Commerce
Confederation of Australian Industry
CSIRO, Division of Manufacturing Technology
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Department of Industrial Relations and Employment, New South Wales
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PREFACE

This Standard was prepared by the Standards Australia Committee on Small Tools. It is identical with and has been reproduced from ISO 1173:1988, *Assembly tools for bolts and screws—Hexagon drive ends for hand- and machine-operated screwdriver bits*.

For the purposes of this Australian Standard, the ISO text should be modified as follows:

- (a) Substitute a point (.) for a comma (,) as a decimal marker.
- (b) Substitute 'external' for 'male'.
- (c) Substitute 'internal' for 'female'.
- (d) The references to other publications should be replaced by references to Australian Standards:

<i>Reference to International Standard</i>	<i>Australian Standard</i>
ISO	AS
286 ISO system of limits and fits	1654 Limits and fits for engineering

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Assembly tools for bolts and screws— Hexagon drive ends for hand-operated and machine-operated screwdriver bits

1 Scope and field of application

This International Standard, relating to assembly tools for bolts and screws, specifies the dimensions, the separation force and minimum test torques of male and female parts for hexagon drive ends.

This International Standard applies to hand- and machine-operated screwdriver bits.

2 Reference

ISO 286, *ISO system of limits and fits*.

3 Interchangeability

Hexagon maximum and minimum dimensions have been selected to allow for interchangeability between metric and inch products.

Deviations between the maximum and minimum widths across flats of s_1 and s_2 correspond to tolerances of grade IT10 (see ISO 286).

Sizes e have been calculated by using the formula $e = 1,13 s$.