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Third edition
2016-11-15

Assembly tools for screws and nuts — Technical specifications —

Part 2: Machine-operated sockets (impact)

*Outils de manoeuvre pour vis et écrous — Spécifications techniques —
Partie 2: Douilles à machine (impact)*



Reference number
ISO 1711-2:2016(E)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 10, *Assembly tools for screws and nuts, pliers and nippers*.

This third edition cancels and replaces the second edition (ISO 1711-2:2015), which has been technically revised with the following changes:

- [Clause 4](#) has been added, giving empiric formulae for minimum test torsion torques as a function of width across flats;
- in [7.1](#) the angle chamfer α of the test mandrel in [Figure 1](#) has been changed from 30° max to $15^\circ \leq \alpha \leq 30^\circ$;
- revision of sizes for width across flats covered in [Table 3](#); Sizes 3,5, 4,5, 26 and 28 have been deleted;
- revision of minimum test torque values in [Table 3](#).

A list of all parts in the ISO 1711 series can be found on the ISO website.

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Introduction

When testing machine-operated impact sockets, there are three types of testing that could be relevant:

- torsional testing;
- impact testing;
- endurance testing.

This document covers only torsional testing of machine-operated sockets. Presently, the torsional test and hardness values given in this document ensure sockets will last a reasonable impact life if the appropriate tool is used.

An impact test or endurance test is desired, but at present, there is no procedure suitable for standardization available. This will be an issue for a future revision of this document.