

**ASME B107.4-2019**

**[Revision of ASME B107.4-2005 (R2011)]**

# **Driving and Spindle Ends for Portable Hand, Impact, Air, and Electric Tools (Percussion Tools Excluded)**

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**AN AMERICAN NATIONAL STANDARD**



**The American Society of  
Mechanical Engineers**

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**The American Society of  
Mechanical Engineers**

Two Park Avenue • New York, NY • 10016 USA



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# FOREWORD

The American National Standards Committee B107, Socket Wrenches and Drives, under sponsorship of the American Society of Mechanical Engineers (ASME), held its organizational meeting on June 28, 1967. Subcommittee 1 on Driving Ends for Portable Hand, Air, and Electric Tools and Subcommittee 3 on Spindle Ends for Portable Air and Electric Tools were subsequently organized. These two subcommittees took over the work that was originally handled by Technical Committee 28 of Standards Committee B5. The Standard produced by the subcommittees was designated ASME B107.4-1982. This document was reaffirmed in 1988.

The Committee subsequently undertook a revision of the 1982 standard. The revised standard was approved as an American National Standard on October 16, 1995.

The ASME Standards Committee title was changed to Hand Tools and Accessories, and in 1996 its scope was expanded to include safety considerations. Following review by the Committee, a revision, ASME B107.4-2005, was approved as an American National Standard on March 14, 2005. It was reaffirmed in 2011.

Principal changes in this edition are changes to Tables 7, 7M, 9, 9M, 10, 13, and 13M, which were subsequently renumbered as described below. Tolerances and dimensions in some SI unit tables were adjusted to align significant digits properly. Tables and figures in the B107 series were renumbered in 2017 in a manner consistent with the numbering system used in other ASME standards. The former and current table and figure numbers for ASME B107.4 are listed below.

Before 2017	After 2017	Before 2017	After 2017
Tables		Tables (Cont'd)	
1, 1M	6-1	14, 14M	9-2
2, 2M	6-2	15, 15M	9-3
3, 3M	6-3	16, 16M	9-4
4, 4M	6-4	17	10-1
5, 5M	7-1	18	10-2
6, 6M	7-2	19, 20	10-3
7, 7M	8-1	21	10-4
8, 8M	8-2	22	11-1
9, 9M	8-3	Figures	
10, 10M	8-4	1	8-1
11A, 11AM	8-5	2	8-2
11B, 11BM	8-6	3	8-3
12, 12M	8-7		
13, 13M	9-1		

This Standard may be used as a guide by state authorities or other regulatory bodies in the formulation of laws or regulations. It is also intended for voluntary use by establishments that use or manufacture the tools covered.

This Foreword is not a part of ASME B107.4 and is included for information purposes only.

Members of the Hand Tools Institute Wrench Standards Committee, through their knowledge and hard work, have been major contributors to the development of the B107 wrench standards. Their active efforts in the promotion of these standards is acknowledged and appreciated.

ASME B107.4-2019 was approved by the B107 Standards Committee on January 18, 2019 and by the Board on Standards and Testing on March 12, 2019. It was approved as an American National Standard on April 23, 2019. The requirements of the Standard take effect on the date of issue.



# ASME B107 STANDARDS COMMITTEE

## Hand Tools and Accessories

(The following is the roster of the Committee at the time of approval of this Standard.)

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<b>C. Kuznia</b> , General Services Administration	



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**General.** ASME Standards are developed and maintained with the intent to represent the consensus of concerned interests. As such, users of this Standard may interact with the Committee by requesting interpretations, proposing revisions or a case, and attending Committee meetings. Correspondence should be addressed to:

Secretary, B107 Standards Committee  
The American Society of Mechanical Engineers  
Two Park Avenue  
New York, NY 10016-5990  
<http://go.asme.org/Inquiry>

**Proposing Revisions.** Revisions are made periodically to the Standard to incorporate changes that appear necessary or desirable, as demonstrated by the experience gained from the application of the Standard. Approved revisions will be published periodically.

The Committee welcomes proposals for revisions to this Standard. Such proposals should be as specific as possible, citing the paragraph number(s), the proposed wording, and a detailed description of the reasons for the proposal, including any pertinent documentation.

**Proposing a Case.** Cases may be issued to provide alternative rules when justified, to permit early implementation of an approved revision when the need is urgent, or to provide rules not covered by existing provisions. Cases are effective immediately upon ASME approval and shall be posted on the ASME Committee web page.

Requests for Cases shall provide a Statement of Need and Background Information. The request should identify the Standard and the paragraph, figure, or table number(s), and be written as a Question and Reply in the same format as existing Cases. Requests for Cases should also indicate the applicable edition(s) of the Standard to which the proposed Case applies.

**Interpretations.** Upon request, the B107 Standards Committee will render an interpretation of any requirement of the Standard. Interpretations can only be rendered in response to a written request sent to the Secretary of the B107 Standards Committee.

Requests for interpretation should preferably be submitted through the online Interpretation Submittal Form. The form is accessible at <http://go.asme.org/InterpretationRequest>. Upon submittal of the form, the Inquirer will receive an automatic e-mail confirming receipt.

If the Inquirer is unable to use the online form, he/she may mail the request to the Secretary of the B107 Standards Committee at the above address. The request for an interpretation should be clear and unambiguous. It is further recommended that the Inquirer submit his/her request in the following format:

Subject:	Cite the applicable paragraph number(s) and the topic of the inquiry in one or two words.
Edition:	Cite the applicable edition of the Standard for which the interpretation is being requested.
Question:	Phrase the question as a request for an interpretation of a specific requirement suitable for general understanding and use, not as a request for an approval of a proprietary design or situation. Please provide a condensed and precise question, composed in such a way that a "yes" or "no" reply is acceptable.
Proposed Reply(ies):	Provide a proposed reply(ies) in the form of "Yes" or "No," with explanation as needed. If entering replies to more than one question, please number the questions and replies.
Background Information:	Provide the Committee with any background information that will assist the Committee in understanding the inquiry. The Inquirer may also include any plans or drawings that are necessary to explain the question; however, they should not contain proprietary names or information.



Requests that are not in the format described above may be rewritten in the appropriate format by the Committee prior to being answered, which may inadvertently change the intent of the original request.

Moreover, ASME does not act as a consultant for specific engineering problems or for the general application or understanding of the Standard requirements. If, based on the inquiry information submitted, it is the opinion of the Committee that the Inquirer should seek assistance, the inquiry will be returned with the recommendation that such assistance be obtained.

ASME procedures provide for reconsideration of any interpretation when or if additional information that might affect an interpretation is available. Further, persons aggrieved by an interpretation may appeal to the cognizant ASME Committee or Subcommittee. ASME does not “approve,” “certify,” “rate,” or “endorse” any item, construction, proprietary device, or activity.

**Attending Committee Meetings.** The B107 Standards Committee regularly holds meetings and/or telephone conferences that are open to the public. Persons wishing to attend any meeting and/or telephone conference should contact the Secretary of the B107 Standards Committee. Future Committee meeting dates and locations can be found on the Committee Page at <http://go.asme.org/B107committee>.



# DRIVING AND SPINDLE ENDS FOR PORTABLE HAND, IMPACT, AIR, AND ELECTRIC TOOLS (PERCUSSION TOOLS EXCLUDED)

## 1 SCOPE

This Standard applies to portable power tools for drilling, grinding, polishing, sawing, and driving threaded fasteners, and hand tools for driving threaded fasteners. Other tools not classed as percussion tools belong in this category and may be added by revision or addition through the usual procedure.

This Standard includes dimensions and tolerances for both driving and driven elements where such coordination is important and not established by reference to the pertinent American National Standards. All dimensions are in inches and millimeters.

## 2 DEFINITIONS

*percussion tools*: hammers, chisels, scalers, tampers, clay diggers, and rock drills. Percussion tools are excluded from this Standard.

*rounding*: In this Standard, calculated values are rounded off as follows:

- (a) if the next digit after the last digit to be retained is less than 5, the last digit to be retained is not changed
- (b) if the next digit after the last digit to be retained is 5 or greater, the last digit to be retained is increased by one

*tool*: as used in this Standard, a portable device, either hand operated or powered by compressed air or electricity, for performing a mechanical operation.

## 3 REFERENCES

The following is a list of publications referenced in this Standard.

ANSI/ASME B1.1-1989 (R2001), Unified Inch Screw Threads (UN and UNR Thread Form)

ANSI B7.1-2000, Safety Requirements for the Use, Care and Protection of Abrasive Wheels

ANSI B92.1-1996, Involute Splines and Inspection, Inch Version

Publisher: American National Standards Institute (ANSI), 25 West 43rd Street, New York, NY 10036 ([www.ansi.org](http://www.ansi.org))

ISO 1174-1:2011, Assembly tools for screws and nuts — Driving squares — Part 1: Driving squares for hand socket tools

ISO 1174-2:1996, Assembly tools for screws and nuts — Driving squares — Part 2: Driving squares for power socket tools

Publisher: International Organization for Standardization (ISO), Central Secretariat, Chemin de Blandonnet 8, Case Postale 401, 1214 Vernier, Geneva, Switzerland ([www.iso.org](http://www.iso.org))

## 4 ISO COMPATIBILITY

Italicization and bold type indicate ISO compatibility.

EXAMPLE: (**38.214**)

## 5 GAGE USE AND DESIGN

The illustrations shown herein are descriptive, not restrictive, and are not intended to preclude the manufacture of products or gages that are otherwise in accordance with this Standard.

Manufacturers may use gages with tighter dimensions or tolerances than shown herein to ensure product acceptance.

Tolerances on gage dimensions within the Standard represent new manufactured or purchased gage sizes. The extreme size for all limit (GO and NO GO) gages shall not exceed the extreme limits of products specified within the Standard. All variations (manufacturing tolerance, calibration error, wear allowance, etc.) in the gages, whatever their cause or purpose, shall bring these gages within the extreme limits of the gage size specified within this Standard. Thus, a gage that represents a minimum limit may be larger, but never smaller, than the minimum specified for the product standard; likewise, the gage that represents a maximum limit may be smaller, but never larger, than the maximum size specified for the product standard.



## **6 SPINDLES FOR CHUCKS**

See [Tables 6-1](#) through [6-4](#).

## **7 HEXAGONAL DRIVES**

See [Tables 7-1](#) and [7-2](#).

## **8 SQUARE DRIVES**

See [Figures 8-1](#) through [8-3](#) and [Tables 8-1](#) through [8-7](#).

## **9 SPLINE DRIVES**

See [Tables 9-1](#) through [9-4](#).

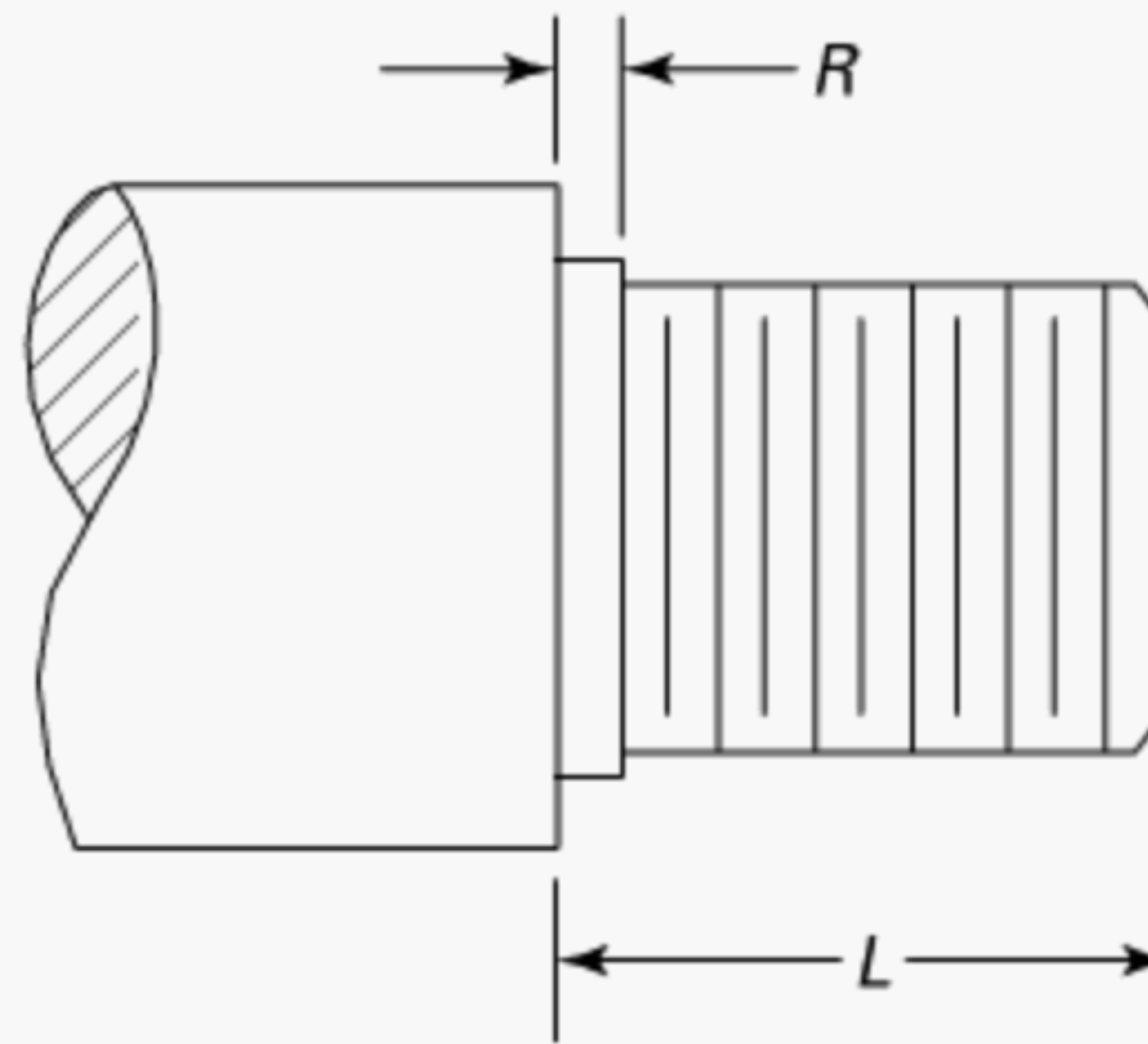
## **10 ABRASION TOOL SPINDLES**

See [Tables 10-1](#) through [10-4](#).

## **11 CIRCULAR SAW ARBORS**

See [Table 11-1](#).



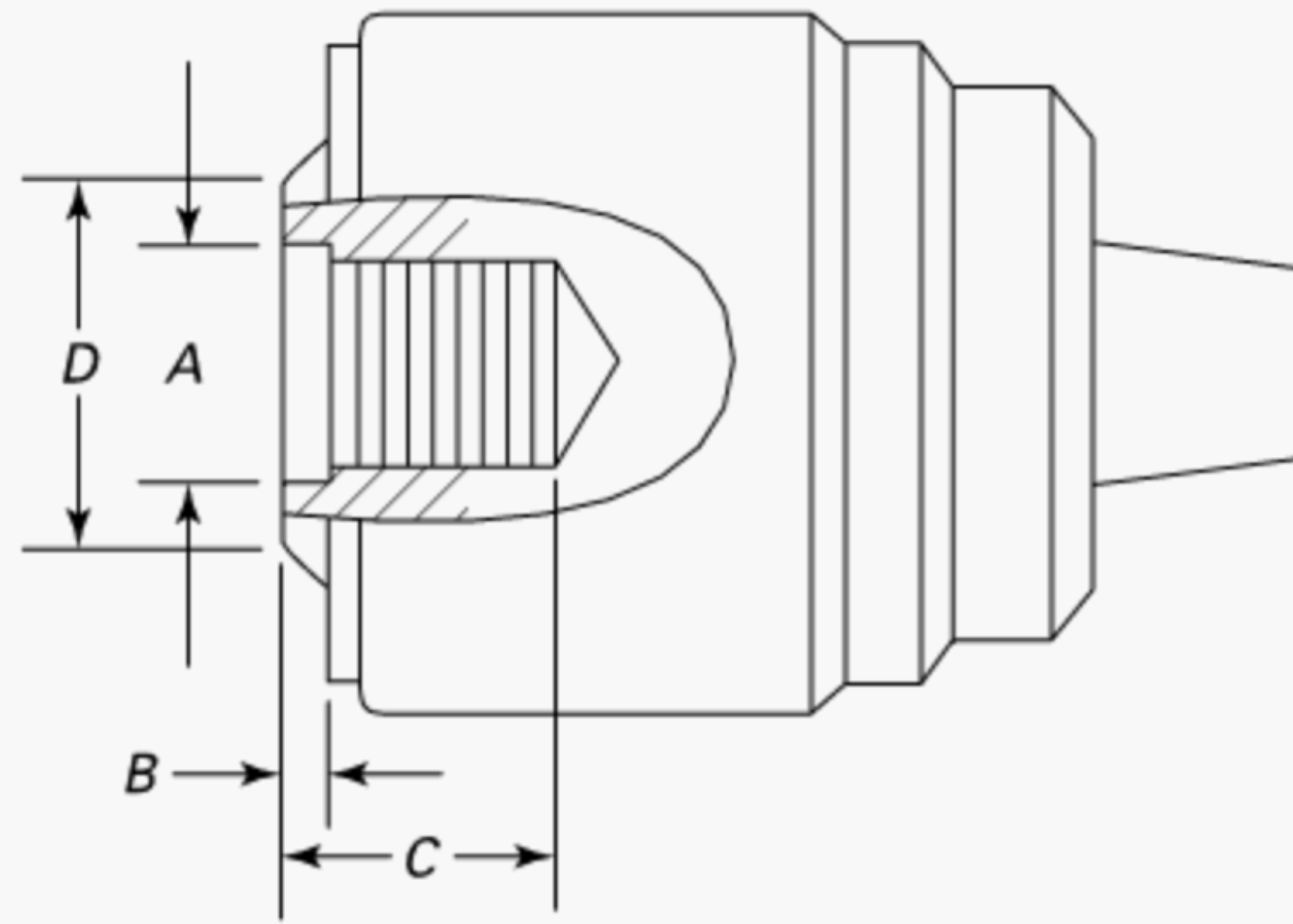
**Table 6-1 Threaded Spindles**

U.S. Customary Units, in.				
Nominal Dia. and Thread, UNF-2A	Pitch Dia.		<i>R</i>	<i>L</i>
	Max.	Min.		
$\frac{3}{8}$ -24	0.3479	0.3455	$\frac{1}{16} \pm \frac{1}{64}$	$\frac{9}{16}$ [Note (1)] +0.000, -0.030
$\frac{1}{2}$ -20	0.4675	0.4649	$\frac{1}{16} \pm \frac{1}{64}$	$\frac{9}{16}$ +0.000, -0.030
$\frac{5}{8}$ -16 UN-2A	0.5844	0.5812	$\frac{3}{32} \pm \frac{1}{64}$	$\frac{11}{16}$ +0.000, -0.030
$\frac{3}{4}$ -16	0.7094	0.7062	$\frac{3}{32} \pm \frac{1}{64}$	$\frac{11}{16}$ +0.000, -0.030
SI Units, mm				
Nominal Dia. and Thread, in., UNF-2A	Pitch Dia.		<i>R</i>	<i>L</i>
	Max.	Min.		
$\frac{3}{8}$ -24	8.836	8.776	$1.59 \pm 0.39$	14.29 [Note (1)] +0.00, -0.76
$\frac{1}{2}$ -20	11.874	11.808	$1.59 \pm 0.39$	14.29 +0.00, -0.76
$\frac{5}{8}$ -16 UN-2A	14.843	14.762	$2.38 \pm 0.39$	17.46 +0.00, -0.76
$\frac{3}{4}$ -16	18.018	17.937	$2.38 \pm 0.39$	17.46 +0.00, -0.76

GENERAL NOTE: Threads right hand.

NOTE: (1) Also  $\frac{7}{16}$  (11.11).

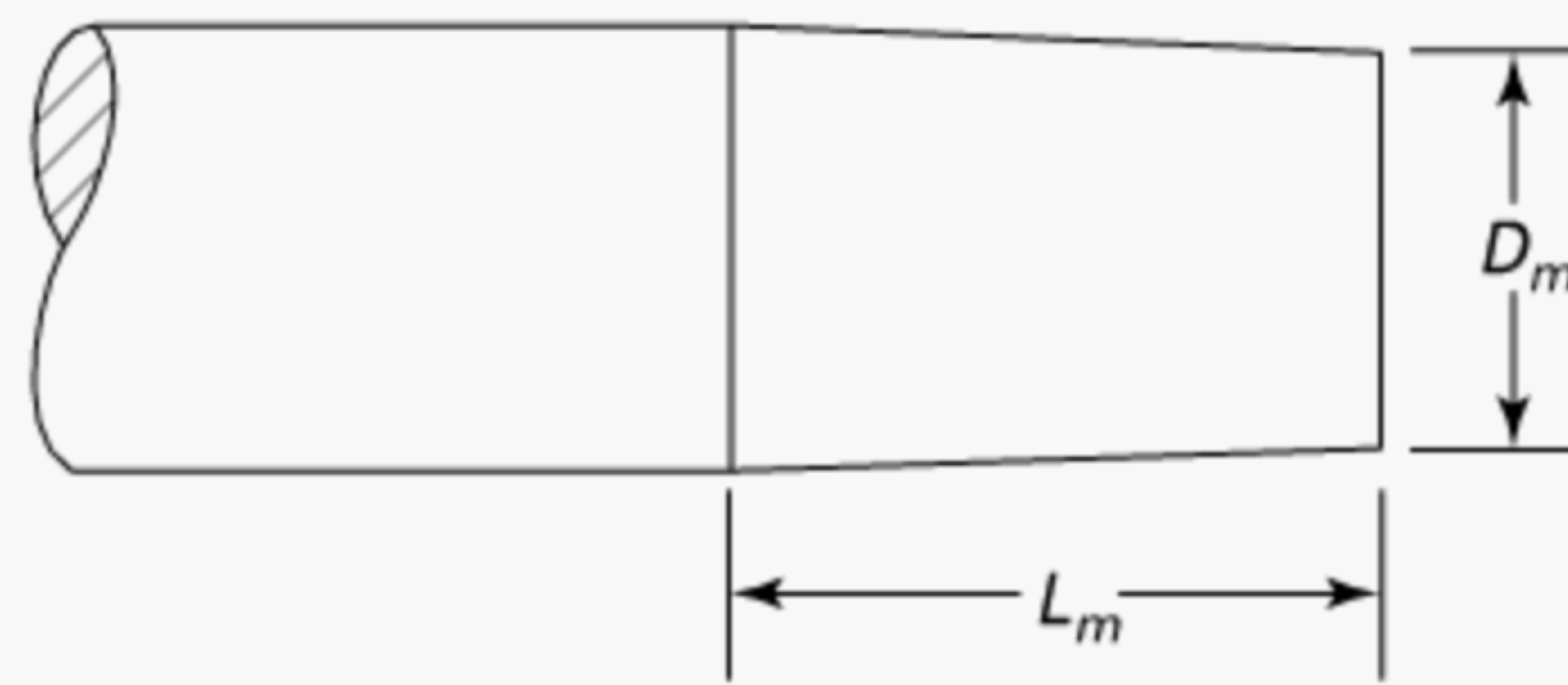


**Table 6-2 Threaded Chucks**

U.S. Customary Units, in.					
Nominal Dia. and Thread, UNF-2B	<i>A</i>		<i>B</i> , Min.	<i>C</i> , Min.	<i>D</i> [Note (1)], Nom.
	Max.	Min.			
$\frac{3}{8}$ -24	0.385	0.380	0.115	$\frac{19}{32}$	$\frac{5}{8}$
$\frac{1}{2}$ -20	0.510	0.503	0.115	$\frac{19}{32}$	$\frac{7}{8}$
$\frac{5}{8}$ -16 UN-2B	0.635	0.629	0.146	$\frac{25}{32}$	$1\frac{1}{8}$
$\frac{3}{4}$ -16	0.760	0.754	0.146	$\frac{13}{16}$	$1\frac{1}{4}$
SI Units, mm					
Nominal Dia. and Thread, in., UNF-2B	<i>A</i>		<i>B</i> , Min.	<i>C</i> , Min.	<i>D</i> [Note (1)], Nom.
	Max.	Min.			
$\frac{3}{8}$ -24	9.77	9.65	2.92	15.09	15.88
$\frac{1}{2}$ -20	12.95	12.78	2.92	15.09	22.23
$\frac{5}{8}$ -16 UN-2B	16.12	15.98	3.71	19.84	28.58
$\frac{3}{4}$ -16	19.30	19.15	3.71	20.64	31.75

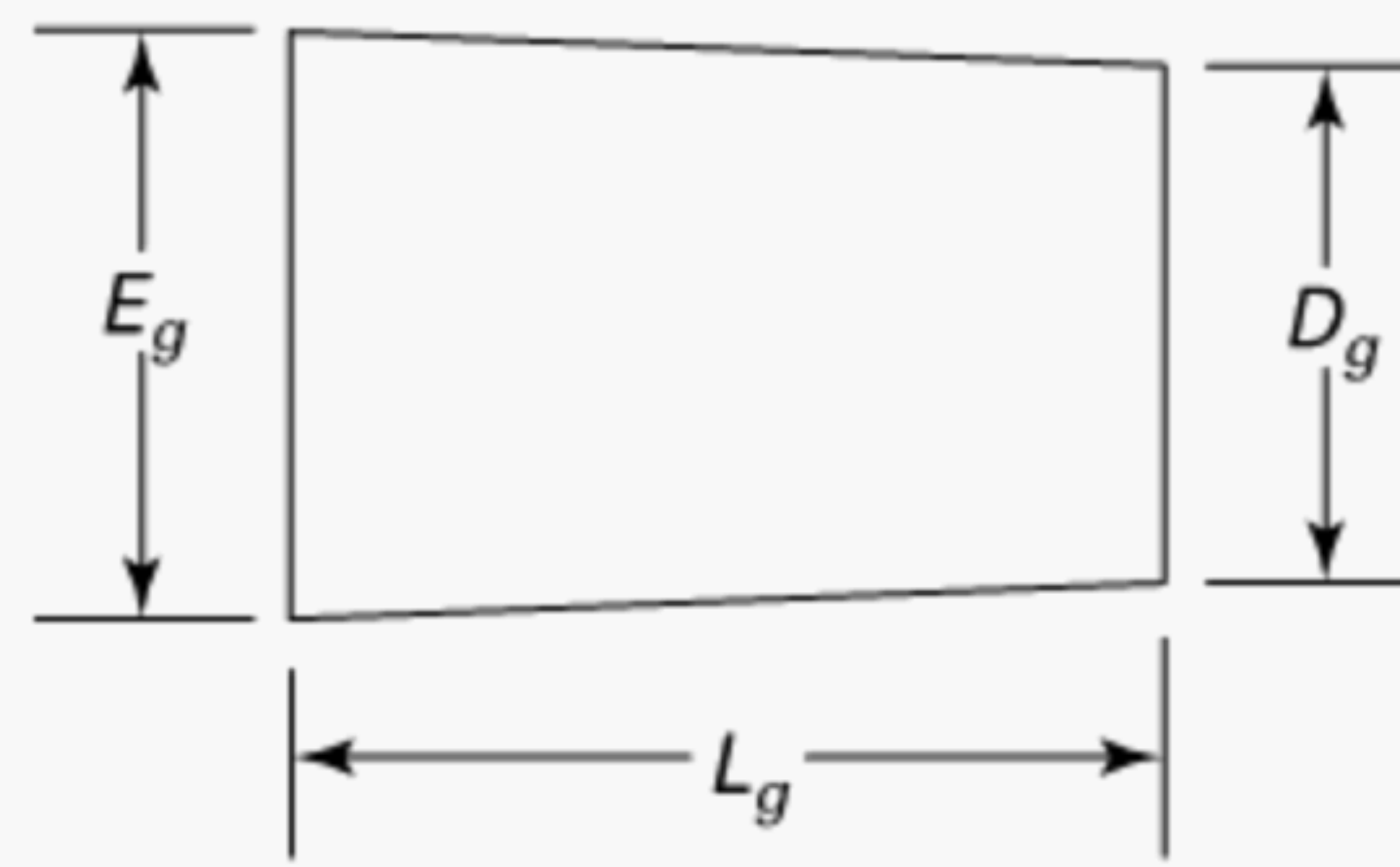
NOTE: (1) Reference Manufacturer's Practice.



**Table 6-3 Tapered Spindles**

U.S. Customary Units, in.			
Number [Note (1)]	$D_m$	$L_m$	Taper, in./ft
1	0.335-0.333	0.656	0.92508
2 short	0.490-0.488	0.750	0.97861
2	0.490-0.488	0.875	0.97861
33	0.563-0.561	1.000	0.76194
6	0.626-0.624	1.000	0.62292
3	0.748-0.746	1.219	0.63898
SI Units, mm			
Number [Note (1)]	$D_m$	$L_m$	Taper, mm/m
1	8.50-8.46	16.66	77.0900
2 short	12.44-12.40	19.05	81.5508
2	12.44-12.40	22.23	81.5508
33	14.30-14.25	25.40	63.4950
6	15.90-15.85	25.40	51.9100
3	18.99-18.95	30.96	53.2483

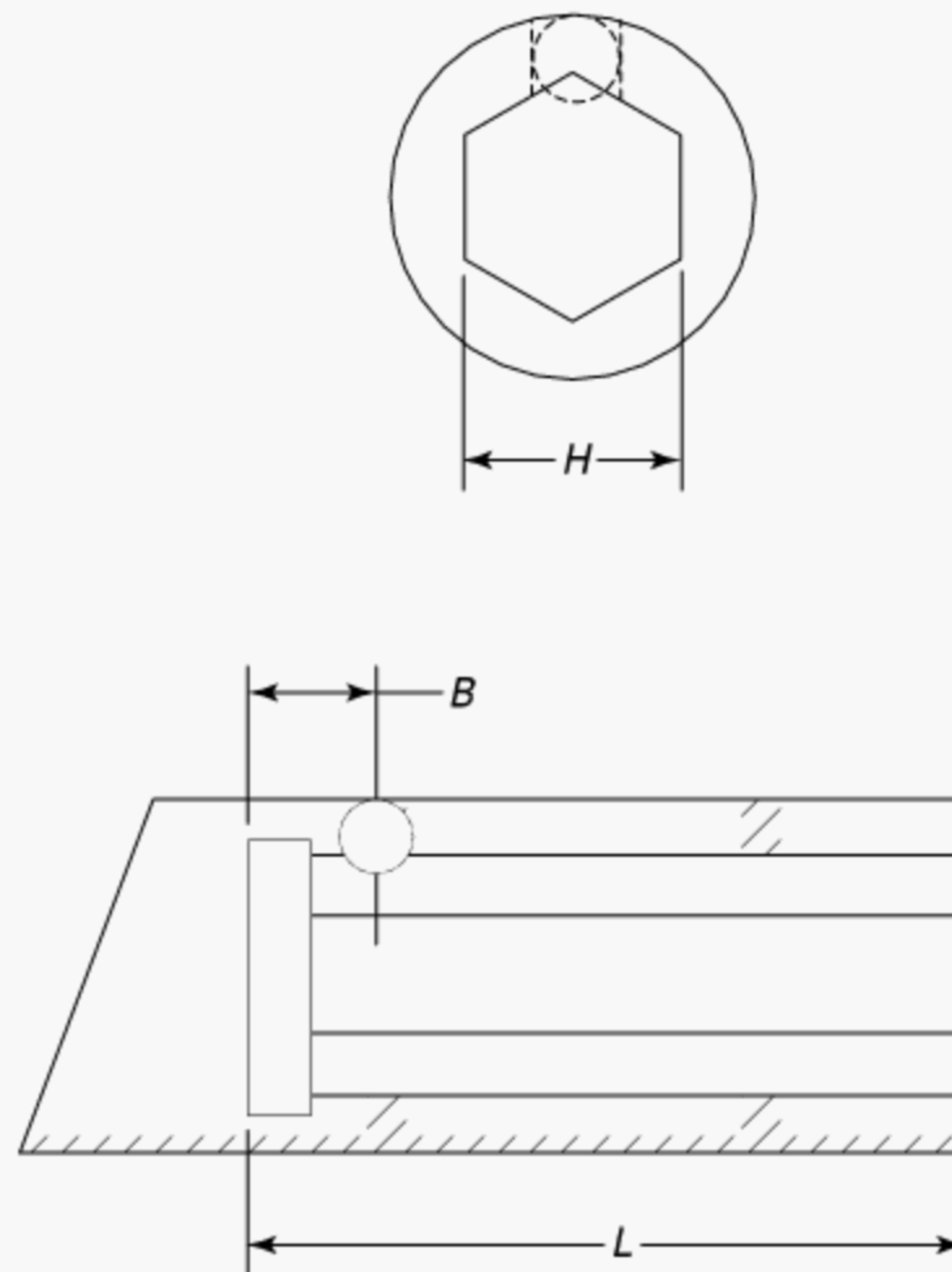
NOTE: (1) Jacobs Taper Number.

**Table 6-4 Master Plug Gage Dimensions — Jacobs Taper**

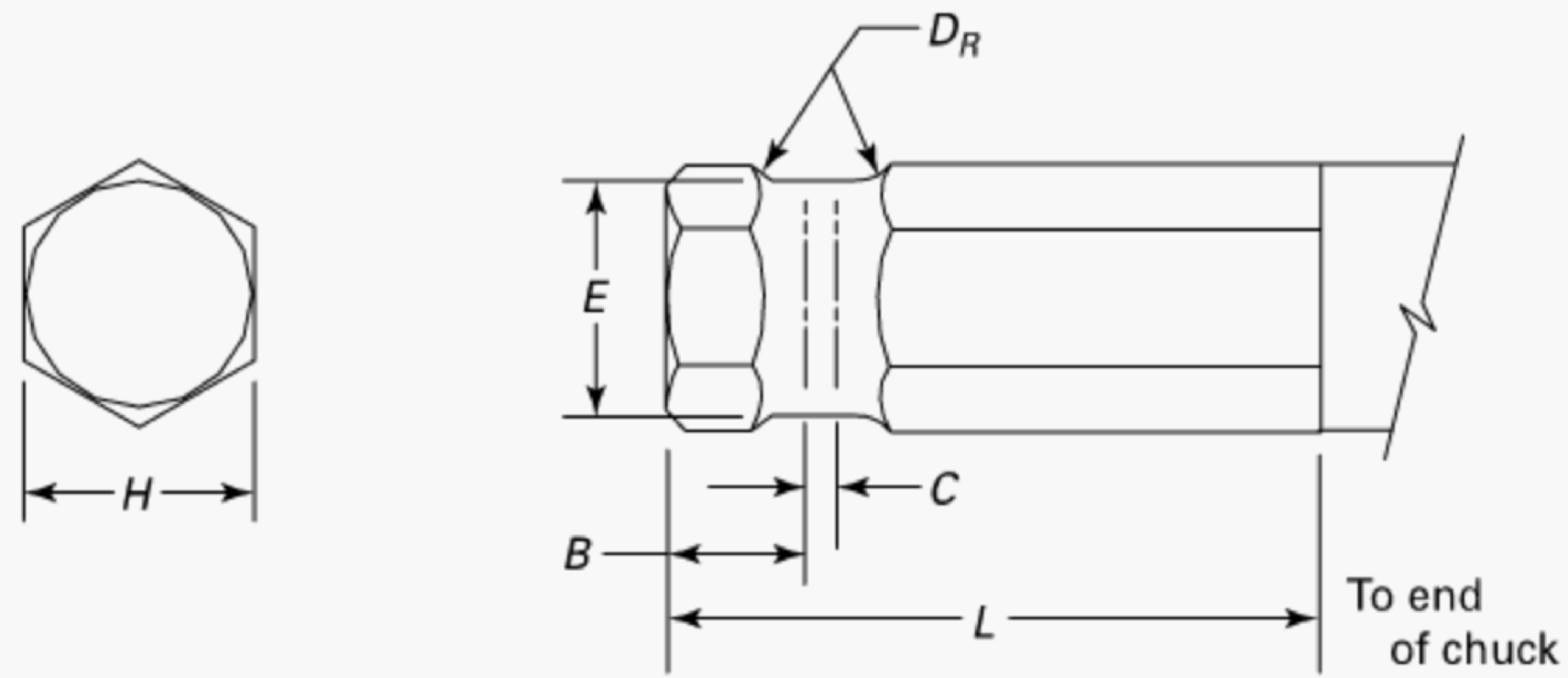
U.S. Customary Units, in.				
Number	$E_g$	$D_g$	$L_g$	Taper, in./ft [Note (1)]
1	0.38400	0.33341	0.65625	0.92508
2 short	0.54880	0.48764	0.75000	0.97861
2	0.55900	0.48764	0.87500	0.97861
33	0.62401	0.56051	1.00000	0.76194
6	0.67600	0.62409	1.00000	0.62292
3	0.81100	0.74610	1.21875	0.63898
SI Units, mm				
Number	$E_g$	$D_g$	$L_g$	Taper, mm/m [Note (1)]
1	9.7536	8.4686	16.6688	77.0900
2 short	13.9395	12.3861	19.0500	81.5508
2	14.1986	12.3861	22.2250	81.5508
33	15.8499	14.2370	25.4000	63.4950
6	17.1704	15.8519	25.4000	51.9100
3	20.5994	18.9509	30.9563	53.2483

NOTE: (1) Calculated from  $E_g$ ,  $D_g$ , and  $L_g$ .



**Table 7-1 Hexagonal Chucks**

U.S. Customary Units, in.					
Nominal Hexagon		$H$		$B$ , $\pm 0.005$	$L$ , Max.
in.	mm	Max.	Min.		
$\frac{1}{4}$	6.35	0.255	0.253	$\frac{3}{8}$	$\frac{15}{16}$
$\frac{5}{16}$	7.94	0.316	0.314	$\frac{13}{64}$	1
$\frac{7}{16}$	11.11	0.444	0.442	$\frac{17}{64}$	$1\frac{1}{8}$
$\frac{5}{8}$	15.88	0.632	0.630	$\frac{11}{32}$	$1\frac{5}{8}$
$\frac{3}{4}$	19.05	0.758	0.755	$\frac{11}{32}$	$1\frac{7}{8}$
SI Units, mm					
Nominal Hexagon		$H$		$B$ , $\pm 0.13$	$L$ , Max.
mm	in.	Max.	Min.		
6.35	$\frac{1}{4}$	6.47	6.43	9.53	23.81
7.94	$\frac{5}{16}$	8.02	7.98	5.16	25.40
11.11	$\frac{7}{16}$	11.27	11.23	6.75	28.57
15.88	$\frac{5}{8}$	16.05	16.00	8.73	41.27
19.05	$\frac{3}{4}$	19.25	19.18	8.73	47.62

**Table 7-2 Hexagonal Shanks****U.S. Customary Units, in.**

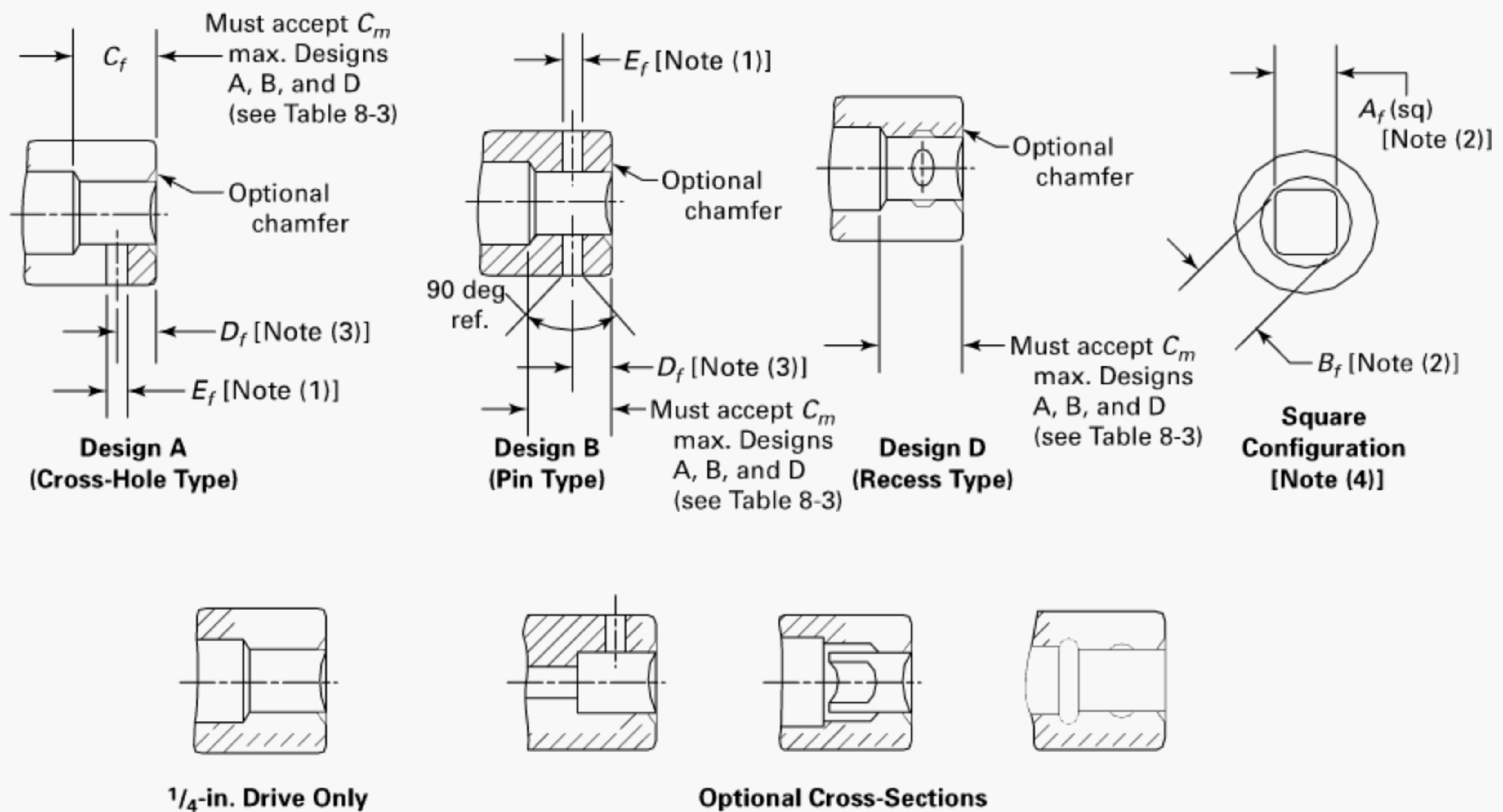
<b>Nominal Hexagon</b>		<b>H</b>		<b>B</b>	<b>C</b>	<b>D<sub>R</sub></b>	<b>E, Dia.</b>	<b>L</b>
<b>in.</b>	<b>mm</b>	<b>Max.</b>	<b>Min.</b>					
1/4	6.35	0.250	0.248	11/32	1/16	3/32	3/16	1
5/16	7.94	0.312	0.310	3/16	3/64	3/32	1/4	1 1/16
7/16	11.11	0.4375	0.435	1/4	1/32	7/64	11/32	1 1/4
5/8	15.88	0.625	0.622	5/16	1/16	5/32	17/32	1 3/4
3/4	19.05	0.750	0.747	5/16	1/16	5/32	21/32	2

**SI Units, mm**

<b>Nominal Hexagon</b>		<b>H</b>		<b>B</b>	<b>C</b>	<b>D<sub>R</sub></b>	<b>E, Dia.</b>	<b>L</b>
<b>mm</b>	<b>in.</b>	<b>Max.</b>	<b>Min.</b>					
6.35	1/4	6.35	6.30	8.73	1.59	2.38	4.76	25.40
7.94	5/16	7.92	7.87	4.76	1.19	2.38	6.35	26.99
11.11	7/16	11.11	11.05	6.35	0.79	2.78	8.73	31.75
15.88	5/8	15.87	15.80	7.94	1.59	3.97	13.49	44.45
19.05	3/4	19.05	18.97	7.94	1.59	3.97	16.67	50.80



**Figure 8-1 Square Drive Specifications for Hand, Power, and Impact Wrenches — Internal End**

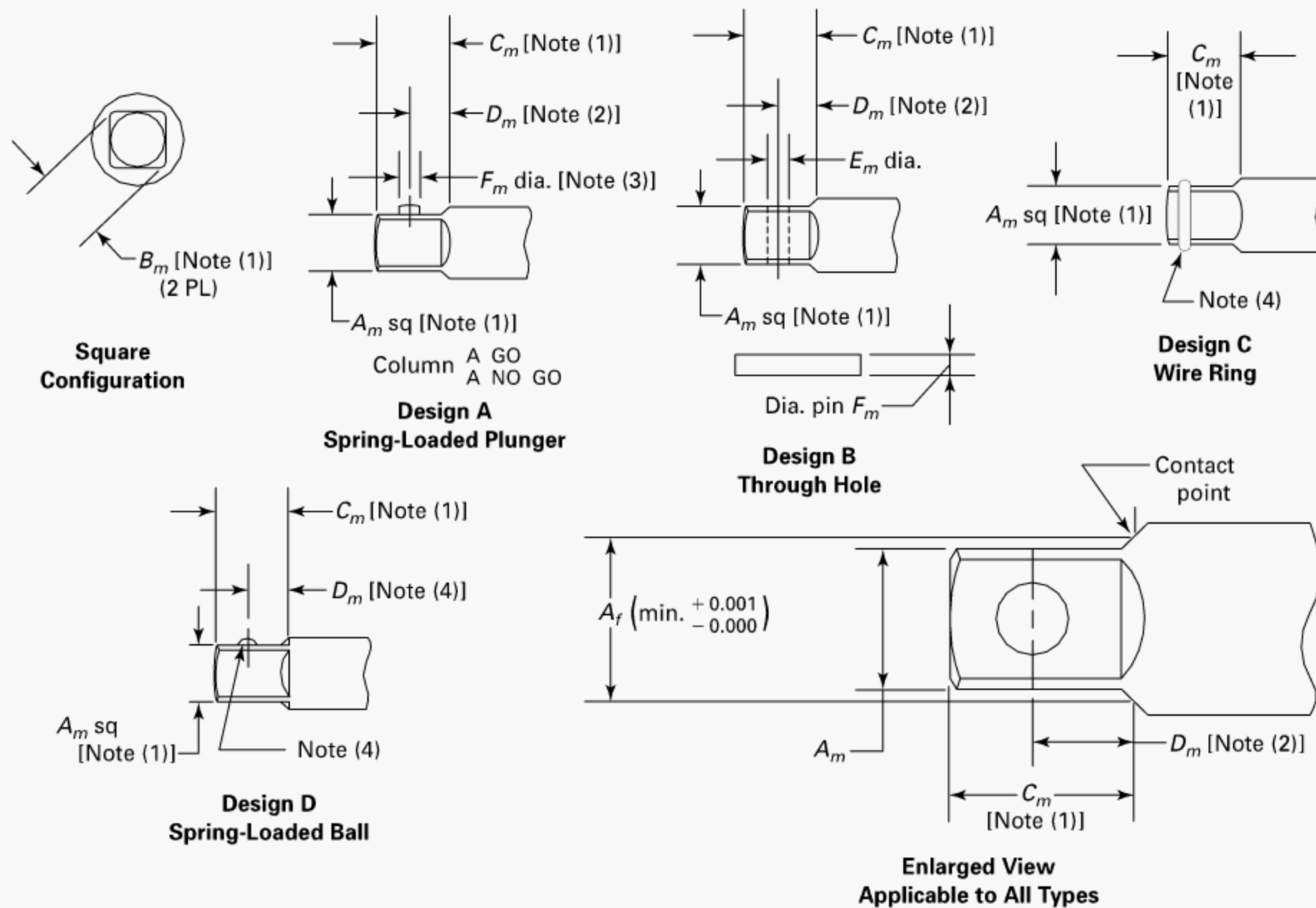


GENERAL NOTE: Design C is not included in Table 8-1 since it only refers to external squares, ring type.

**NOTES:**

- (1) Neither cross-hole Design A nor Design B nor recess Design D is required for 1/4-in. drive internal openings; however, if recessed, Design D must be recessed on four sides.
  - (a) Either recess Design D on four sides or cross-hole Design A on one, two, or four sides is required on 3/8-in., 1/2-in., 3/4-in., and 1-in. sizes.
  - (b) Cross-hole Design B shall be through two opposite sides.
- (2) Square tolerances shall be such as to ensure acceptance when gaged with gages conforming to Table 8-2 and the figure above it.
- (3)  $D_f$  max. does not equal  $D_m$  min. (see Figure 8-2); however, due to edge radius, plunger diameter, and square dimension interactions, no interference or interchangeability problem exists.
- (4) The minimum retention force of recess-type Design D shall be such as to ensure the holding force specified in Table 8-1 when tested with weights conforming to Table 8-6 and this figure.



**Figure 8-2 Square Drive Specifications for Hand, Power, and Impact Wrenches — External End****GENERAL NOTES:**

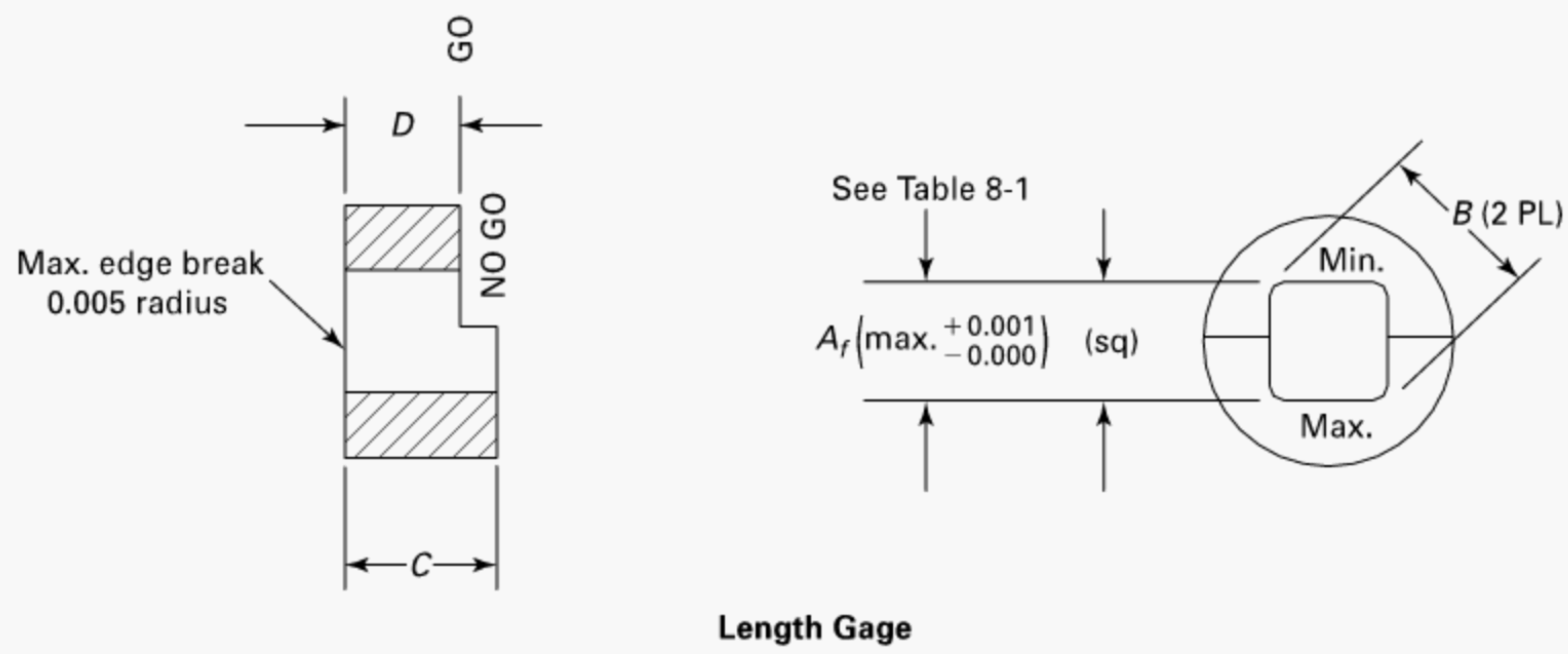
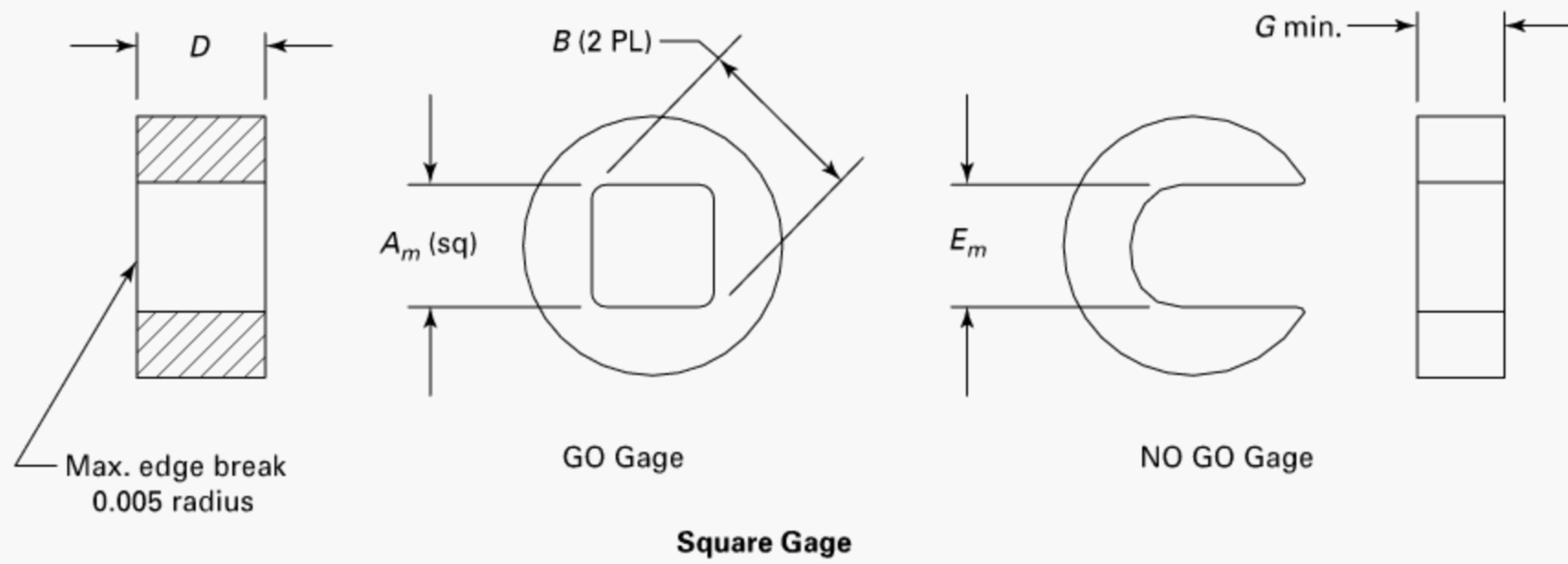
- (a)  $D_m$  min. does not equal  $D_f$  max. (see Figure 8-1); however, due to edge radius, plunger diameter, and square dimension interactions, no interference or interchangeability problem exists.
- (b) For impact wrenches,  $A_m$  should be held as close to maximum as practical.

**NOTES:**

- (1) Square tolerances shall be such as to ensure acceptance when gaged with gages conforming to Table 8-4.
- (2) Dimension  $D_m$  tolerance shall be such as to ensure acceptance when gaged with gages conforming to Table 8-7.
- (3)  $F_m$  is the diameter of a plunger or pin and does not apply to a spring-loaded ball or ball-shaped plunger or wire ring.
- (4) The minimum retention force of the ball or wire ring shall be such as to ensure the holding force of weights conforming to Table 8-5.



**Figure 8-3 Square Drive Gage Specifications for Hand, Power, and Impact Wrenches — External End**



**Table 8-1 Square Drive Specifications for Hand, Power, and Impact Wrenches — Internal End**

U.S. Customary Units, in.									
Drive Size		$A_f$		$B_f$ Min.	$D_f$		$E_f$		Minimum Force to Retain Square, Design D, lbf
in.	mm	Max.	Min.		Max.	Min.	Design A, Min.	Design B, Min.	
$\frac{1}{4}$	6.3	<b>0.2603</b>	<b>0.2527</b>	<b>0.3352</b>	<b>0.161</b>	0.136	0.090	0.118	<b>1.5</b>
$\frac{3}{8}$	10.0	<b>0.3853</b>	<b>0.3777</b>	0.5052	<b>0.224</b>	0.199	0.170	0.204	<b>4.0</b>
$\frac{1}{2}$	12.5	<b>0.5113</b>	<b>0.5027</b>	0.6702	<b>0.318</b>	0.293	0.201	0.220	<b>6.0</b>
$\frac{5}{8}$ [Note (1)]	16.0	0.6333	0.6277	0.8432	0.318	0.290	...	0.250	...
$\frac{3}{4}$	20.0	<b>0.7613</b>	<b>0.7527</b>	1.0052	0.415	<b>0.390</b>	0.216	0.250	...
1	25.0	<b>1.0125</b>	<b>1.0035</b>	1.3502	<b>0.602</b>	0.577	0.234	0.280	...
$1\frac{1}{2}$	40.0	1.5155	<b>1.5045</b>	<b>1.9842</b>	<b>0.645</b>	<b>0.620</b>	...	<b>0.377</b>	...
$2\frac{1}{2}$	63.0	2.5205	<b>2.5045</b>	<b>3.3592</b>	<b>1.505</b>	<b>1.480</b>	...	<b>0.500</b>	...
$3\frac{1}{2}$	...	3.5205	3.5045	4.7022	2.370	2.345	...	0.700	...

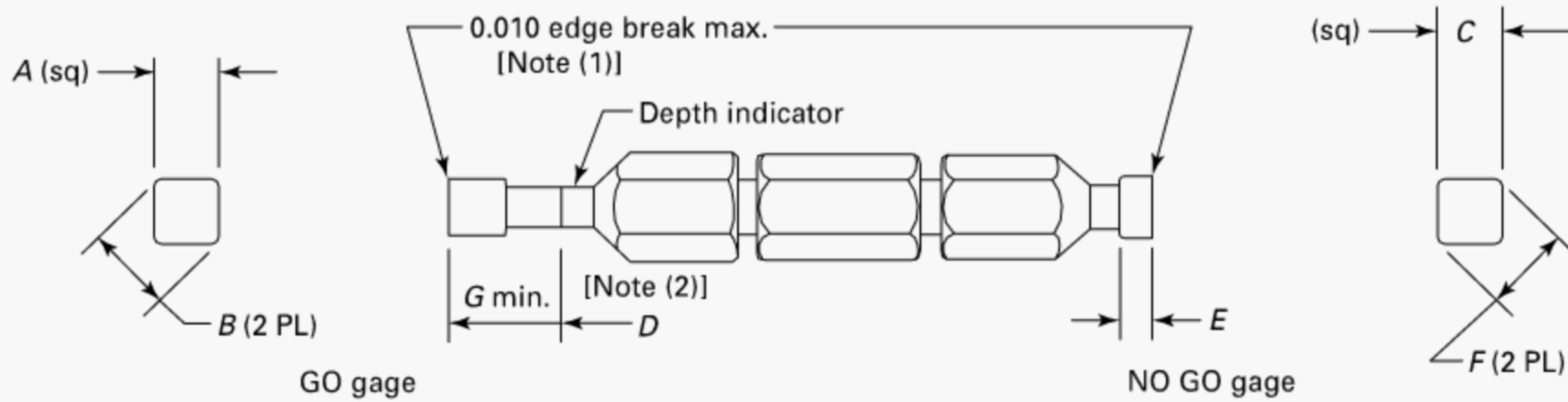
SI Units, mm									
Drive Size		$A_f$		$B_f$ Min.	$D_f$		$E_f$		Minimum Force to Retain Square, Design D, N
mm	in.	Max.	Min.		Max.	Min.	Design A, Min.	Design B, Min.	
6.3	$\frac{1}{4}$	<b>6.612</b>	<b>6.419</b>	<b>8.514</b>	<b>4.09</b>	3.45	2.29	3.00	<b>6.67</b>
10.0	$\frac{3}{8}$	<b>9.787</b>	<b>9.594</b>	12.832	<b>5.69</b>	5.05	4.32	5.18	<b>17.79</b>
12.5	$\frac{1}{2}$	12.987	12.769	17.023	<b>8.08</b>	7.44	5.11	5.59	<b>26.69</b>
16.0 [Note (1)]	$\frac{5}{8}$	16.086	15.944	21.417	8.08	7.37	...	6.35	...
20.0	$\frac{3}{4}$	<b>19.337</b>	<b>19.119</b>	25.532	10.54	<b>9.91</b>	5.49	6.35	...
25.0	1	<b>25.718</b>	<b>25.489</b>	34.295	<b>15.29</b>	14.66	5.94	7.11	...
40.0	$1\frac{1}{2}$	38.494	<b>38.214</b>	50.399	<b>16.38</b>	15.75	...	<b>9.58</b>	...
63.0	$2\frac{1}{2}$	64.021	<b>63.614</b>	<b>85.324</b>	<b>38.23</b>	37.59	...	<b>12.70</b>	...
...	$3\frac{1}{2}$	89.421	89.014	119.436	60.20	59.56	...	17.78	...

## GENERAL NOTES:

- (a) Dimensions set in **boldface italic** type, sizes  $\frac{1}{4}$  in. (6.3 mm) through 1 in. (25 mm), are compatible (will fit) with ISO 1174-1:2011 for hand socket tools.
- (b) Dimensions set in **boldface italic** type, sizes  $1\frac{1}{2}$  in. (40 mm) through  $2\frac{1}{2}$  in. (60 mm), are compatible (will fit) with ISO 1174-2:1996 for power socket tools.

NOTE: (1) Not recommended for new products.



**Table 8-2 Square Drive Gage Specifications for Hand, Power, and Impact Wrenches — Internal End****U.S. Customary Units, in.**

Drive Size		A (GO), +0.0002 -0.0000	B (GO), +0.0002 -0.0002	C (NO GO), +0.0000 -0.0002	D, +0.003 -0.000 [Notes (1) and (3)]	E, Min.	F (NO GO)	
in.	mm						Max.	Min.
1/4	6.3	0.2527	0.3350	0.2603	0.312	0.250	0.3334	0.3301
3/8	10.0	0.3777	0.5050	0.3853	0.438	0.250	0.5039	0.4989
1/2	12.5	0.5027	0.6700	0.5113	0.625	0.250	0.6684	0.6617
5/8	16.0	0.6277	0.8430	0.6333	0.656	0.250	0.8414	0.8330
3/4	20.0	0.7527	1.0050	0.7613	0.938	0.250	1.0034	0.9934
1	25.0	1.0035	1.3500	1.0125	1.125	0.250	1.3484	1.3349
1 1/2	40.0	1.5045	1.9840	1.5155	1.625	0.250	1.9824	1.9626
2 1/2	63.0	2.5045	3.3590	2.5205	2.265	0.250	3.3574	3.3238
3 1/2	...	3.5045	4.7020	3.5205	3.265	0.250	4.7004	4.6534

**SI Units, mm**

Drive Size		A (GO), +0.005 -0.000	B (GO), +0.005 -0.005	C (NO GO), +0.000 -0.005	D, +0.08 -0.00 [Notes (1) and (3)]	E, Min.	F (NO GO)	
mm	in.						Max.	Min.
6.3	1/4	6.419	8.509	6.612	7.92	6.35	8.468	8.385
10.0	3/8	9.594	12.827	9.787	11.13	6.35	12.799	12.672
12.5	1/2	12.769	17.018	12.987	15.88	6.35	16.977	16.807
16.0	5/8	15.944	21.412	16.086	16.66	6.35	21.372	21.158
20.0	3/4	19.119	25.527	19.337	23.83	6.35	25.486	25.232
25.0	1	25.489	34.290	25.718	28.58	6.35	34.249	33.906
40.0	1 1/2	38.214	50.394	38.494	41.28	6.35	50.353	49.850
63.0	2 1/2	63.614	85.319	64.021	57.53	6.35	85.278	84.425
...	3 1/2	89.014	119.431	89.421	82.93	6.35	119.390	118.196

GENERAL NOTE: Gage tolerances are gage manufacturing tolerances.

**NOTES:**

(1) Do not include the length of the chamfer as part of the NO GO gaging procedure. If edge break is more than 0.010 in. (0.254 mm), the difference must be added to D.

(2)

G min. = a minimum dimension  
 = A min. for up to 1 in. or 25 mm.  
 = 1 in. min. or 25 mm min., for A greater than 1 in. or 25 mm

If G min. is made equal to D, then G min. can be used as the depth indicator.

(3) Square drive opening shall accept min. of length D.



Table 8-3 Square Drive Specifications for Hand, Power, and Impact Wrenches — External End

U.S. Customary Units, in.												
Drive Size		$A_m$ , All Designs		Maximum $B_m$ , All Designs	$C_m$				Minimum $D_m$ , Designs A, B, and D	Minimum $E_m$ , Design B	Maximum $F_m$ , Designs A and B	Minimum Force to Remove Square, lbf
					Designs A, B, and D		Design C					
in.	mm	Max.	Min.	Designs	Max.	Min.	Max.	Min.				
$\frac{1}{4}$	6.3	0.2518	<b>0.2467</b>	<b>0.3298</b>	0.312	0.265	...	...	<b>0.156</b>	...	<b>0.078</b>	<b>1.5</b>
$\frac{3}{8}$	10.0	0.3768	<b>0.3717</b>	<b>0.4998</b>	0.438	0.406	0.516	0.482	<b>0.218</b>	...	0.140	<b>4.0</b>
$\frac{1}{2}$	12.5	0.5018	<b>0.4967</b>	<b>0.6648</b>	0.625	0.531	0.665	0.619	<b>0.312</b>	...	0.156	<b>6.0</b>
$\frac{5}{8}$	16.0	0.6268	0.6217	0.8338	0.656	0.594	0.794	0.760	0.322	...	0.156	...
[Note (1)]												
$\frac{3}{4}$	20.0	0.7518	<b>0.7467</b>	<b>0.9998</b>	0.938	0.750	0.938	0.875	<b>0.409</b>	0.250	0.188	10.0
1	25.0	1.0018	<b>0.9965</b>	1.3398	1.125	1.000	1.170	1.130	<b>0.596</b>	0.250	<b>0.188</b>	12.0
$1\frac{1}{2}$	40.0	1.5028	<b>1.4975</b>	<b>1.9678</b>	1.625	1.562	...	...	0.641	<b>0.345</b>	0.250	...
$2\frac{1}{2}$	63.0	<b>2.4998</b>	2.4845	3.3438	2.265	2.234	...	...	<b>1.515</b>	<b>0.430</b>	0.312	...
$3\frac{1}{2}$	...	3.4998	3.4845	4.6868	3.265	3.234	...	...	2.380	0.578	0.500	...
SI Units, mm												
Drive Size		$A_m$ , All Designs		Maximum $B_m$ , All Designs	$C_m$				Minimum $D_m$ , Designs A, B, and D	Minimum $E_m$ , Design B	Maximum $F_m$ , Designs A and B	Minimum Force to Remove Square, N
					Designs A, B, and D		Design C					
mm	in.	Max.	Min.	All Designs	Max.	Min.	Max.	Min.				
6.3	$\frac{1}{4}$	6.396	<b>6.266</b>	<b>8.377</b>	7.92	6.73	...	...	<b>3.96</b>	...	<b>1.98</b>	<b>6.67</b>
10.0	$\frac{3}{8}$	9.571	<b>9.441</b>	<b>12.695</b>	11.13	10.31	13.11	12.24	<b>5.54</b>	...	3.56	<b>17.79</b>
12.5	$\frac{1}{2}$	12.746	<b>12.616</b>	<b>16.886</b>	15.88	13.49	16.89	15.72	<b>7.92</b>	...	3.96	<b>26.69</b>
16.0	$\frac{5}{8}$	15.921	15.791	21.179	16.66	15.09	20.17	19.30	8.18	...	3.96	...
[Note (1)]												
20.0	$\frac{3}{4}$	19.096	<b>18.966</b>	<b>25.395</b>	23.83	19.05	23.83	22.23	<b>10.39</b>	6.35	4.78	44.48
25.0	1	25.446	<b>25.311</b>	34.031	28.58	25.40	29.72	28.70	<b>15.14</b>	6.35	<b>4.78</b>	53.38
40.0	$1\frac{1}{2}$	38.171	<b>38.037</b>	49.982	41.28	39.67	...	...	<b>16.28</b>	<b>8.76</b>	6.35	...
63.0	$2\frac{1}{2}$	<b>63.495</b>	63.106	84.933	57.53	56.74	...	...	<b>38.48</b>	<b>10.92</b>	7.92	...
...	$3\frac{1}{2}$	88.895	88.506	119.045	82.93	82.14	...	...	60.45	14.68	12.70	...

## GENERAL NOTES:

- (a) Dimensions set in **boldface italic** type, sizes  $\frac{1}{4}$  in. (6.3 mm) through 1 in. (25 mm), are compatible (will fit) with ISO 1174-1:2011 for hand socket tools.
- (b) Dimensions set in **boldface italic** type, sizes  $1\frac{1}{2}$  in. (40 mm) through  $2\frac{1}{2}$  in. (60 mm), are compatible (will fit) with ISO 1174-2:1996 for power socket tools.

NOTE: (1) Not recommended for new products.



**Table 8-4 Square Drive Gage Specifications for Hand, Power, and Impact Wrenches — External End**

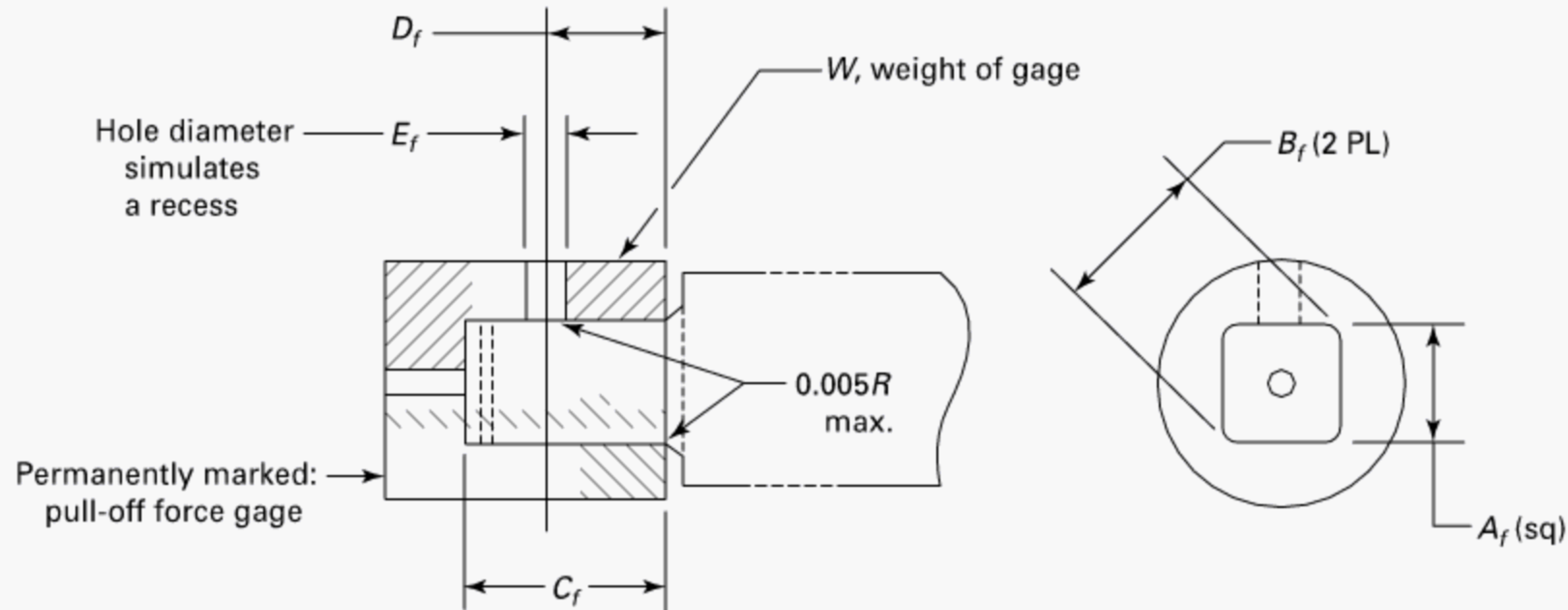
U.S. Customary Units, in.									
Drive Size		$A_m$ , +0.0002 –0.0002, All Designs	$B$ , +0.0002 –0.0002, All Designs	$C$ , +0.000 –0.001		$D$ , +0.001 –0.000		$G$ Min., Designs A, B, and D	$E_m$ , +0.0002 –0.0000, All Designs
				Designs A, B, and D	Design C	Designs A, B, and D	Design C		
mm	in.								
1/4	6.3	0.2520	0.3300	0.312	...	0.265	...	0.312	0.2467
3/8	10.0	0.3770	0.5000	0.438	0.516	0.406	0.482	0.438	0.3717
1/2	12.5	0.5020	0.6650	0.625	0.653	0.531	0.619	0.625	0.4967
5/8	16.0	0.6270	0.8340	0.656	0.794	0.594	0.760	0.656	0.6217
3/4	20.0	0.7520	1.0000	0.938	0.915	0.750	0.875	0.938	0.7467
1	25.0	1.0020	1.3400	1.125	1.170	1.000	1.130	1.125	0.9965
1 1/2	40.0	1.5030	1.9680	1.625	...	1.562	...	1.625	1.4975
2 1/2	63.0	2.5000	3.3440	2.265	...	2.234	...	2.265	2.4845
3 1/2	...	3.5000	4.6870	3.265	...	3.234	...	3.265	3.4845
SI Units, mm									
Drive Size		$A_m$ , +0.000 –0.005, All Designs	$B$ , +0.005 –0.005, All Designs	$C$ , +0.00 –0.03		$D$ , +0.03 –0.00		$G$ Min., Designs A, B, and D	$E_m$ , +0.005 –0.000, All Designs
				Designs A, B, and D	Design C	Designs A, B, and D	Design C		
mm	in.								
6.3	1/4	6.401	8.382	7.92	...	6.73	...	7.92	6.266
10.0	3/8	9.576	12.700	11.13	13.11	10.31	12.24	11.13	9.441
12.5	1/2	12.751	16.891	15.88	16.59	13.49	15.72	15.88	12.616
16.0	5/8	15.926	21.184	16.66	20.17	15.09	19.30	16.66	15.791
20.0	3/4	19.101	25.400	23.83	23.24	19.05	22.23	23.83	18.966
25.0	1	25.451	34.036	28.58	29.72	25.40	28.70	28.58	25.311
40.0	1 1/2	38.176	49.987	41.28	...	39.67	...	41.28	38.037
63.0	2 1/2	63.500	84.938	57.53	...	56.74	...	57.53	63.106
...	3 1/2	88.900	119.050	82.93	...	82.14	...	82.93	88.506

## GENERAL NOTES:

- (a) NO GO gage must be used by rotating gage 90 deg to check both sets of across-flat dimensions.  
 (b) Gage tolerances are tool makers' gage manufacturing tolerances.



**Table 8-5 Square Drive Pull-Off Force Gage Specifications for Designs C and D Hand, Power, and Impact Wrenches — External End**



**U.S. Customary Units, in.**

Drive Size		$A_f$ +0.0010 -0.0000	$B_f$ +0.005 -0.000	$C_f$ +0.025 -0.000	$D_f$ +0.000 -0.002	$E_f$ +0.000 -0.002	Total Weight of Gage, $W$ , lb	
in.	mm						Max.	Min.
1/4	6.3	0.2603	0.335	0.312	...	...	1.58	1.5
3/8	10.0	0.3853	0.505	0.438	0.224	0.076	4.20	4.0
1/2	12.5	0.5113	0.670	0.625	0.318	0.110	6.30	6.0
3/4	20.0	0.7613	1.005	0.938	0.415	0.216	10.50	10.0
1	25.0	1.0125	1.350	1.125	0.602	0.234	12.60	12.0

**SI Units, mm**

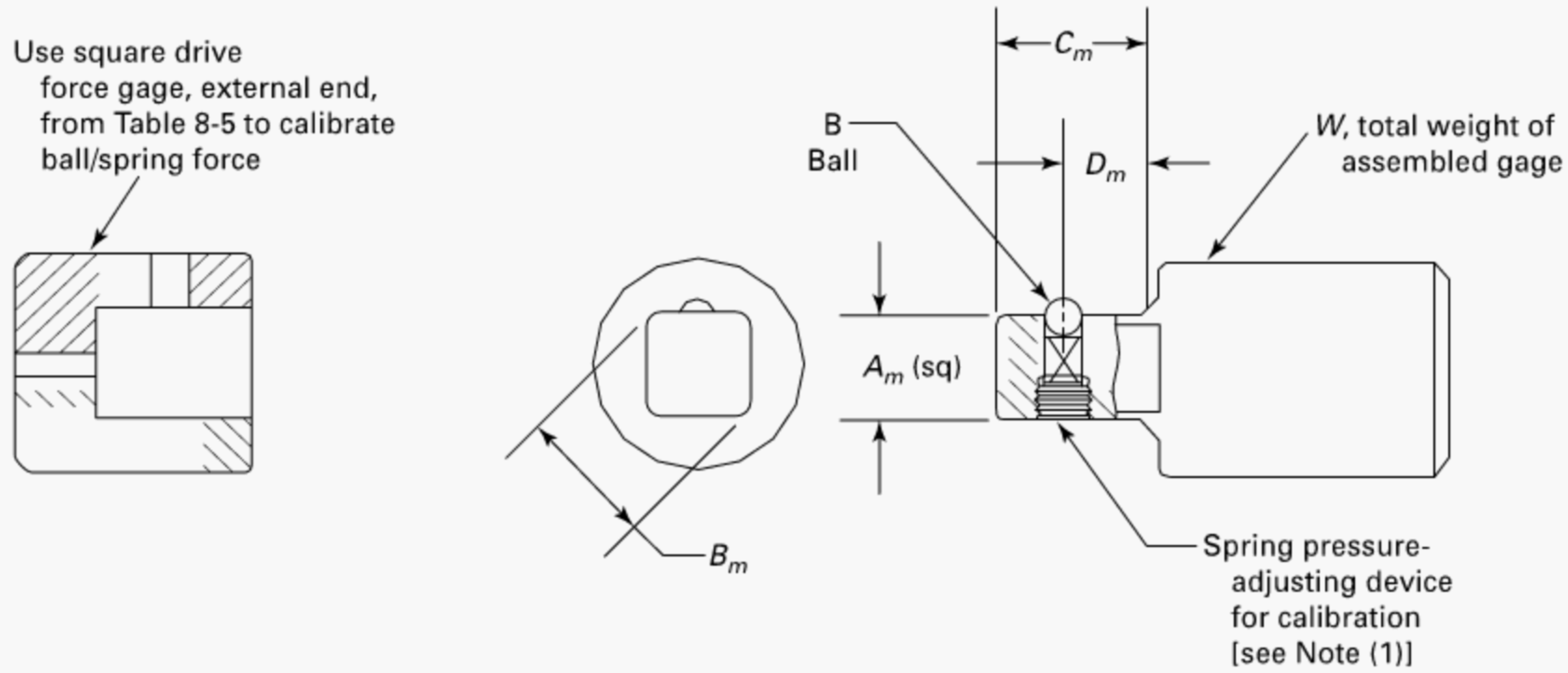
Drive Size		$A_f$ +0.020 -0.000	$B_f$ +0.13 -0.00	$C_f$ +0.64 -0.00	$D_f$ +0.00 -0.05	$E_f$ +0.00 -0.05	Total Weight of Gage, $W$ , kg	
mm	in.						Max.	Min.
6.3	1/4	6.612	8.51	7.92	...	...	0.71	0.68
10.0	3/8	9.787	12.83	11.13	5.68	1.93	1.90	1.81
12.5	1/2	12.987	17.02	15.88	8.07	2.78	2.86	2.72
20.0	3/4	19.337	25.53	23.83	10.54	5.49	4.77	4.54
25.0	1	25.718	34.29	28.58	15.29	5.94	5.71	5.44

**GENERAL NOTES:**

- The  $C_m$  of the product being gaged must pass the [Figure 8-3](#) length gage prior to pull-off force gaging.
- While retaining the gage, the square drive shall be lifted gradually in a vertical manner, avoiding any side loads.
- The above gage simulates the worst-case condition of an internal square to test the pull-off force retention of an external square of Design C (wire) and Design D (ball).



**Table 8-6 Square Drive Retention Force Gage Specifications for Design D (Recess-Type) Hand, Power, and Impact Wrenches — Internal End**



**U.S. Customary Units, in.**

Drive Size		$A_m$		$B_m$ , Max.	$C_m$		$D_m$ , Min.	Ball Size, B $\pm 0.005$	Total Weight of Gage, W, lb	
in.	mm	Max.	Min.		Max.	Min.			Max.	Min.
$\frac{1}{4}$	6.3	0.252	0.2467	0.330	0.312	0.265	0.156	0.125	1.58	1.5
$\frac{3}{8}$	10.0	0.377	0.3717	0.500	0.438	0.406	0.218	0.187	4.20	4.0
$\frac{1}{2}$	12.5	0.502	0.4967	0.663	0.625	0.531	0.312	0.250	6.30	6.0

**SI Units, mm**

Drive Size		$A_m$		$B_m$ , Max.	$C_m$		$D_m$ , Min.	Ball Size, B $\pm 1.27$	Total Weight of Gage, W, kg	
mm	in.	Max.	Min.		Max.	Min.			Max.	Min.
6.3	$\frac{1}{4}$	6.401	6.266	8.38	7.92	6.73	3.96	3.17	0.71	0.68
10.0	$\frac{3}{8}$	9.576	9.441	12.70	11.13	10.31	5.54	4.75	1.90	1.81
12.5	$\frac{1}{2}$	12.751	12.616	16.89	15.88	13.49	7.92	6.35	2.86	2.72

**GENERAL NOTES:**

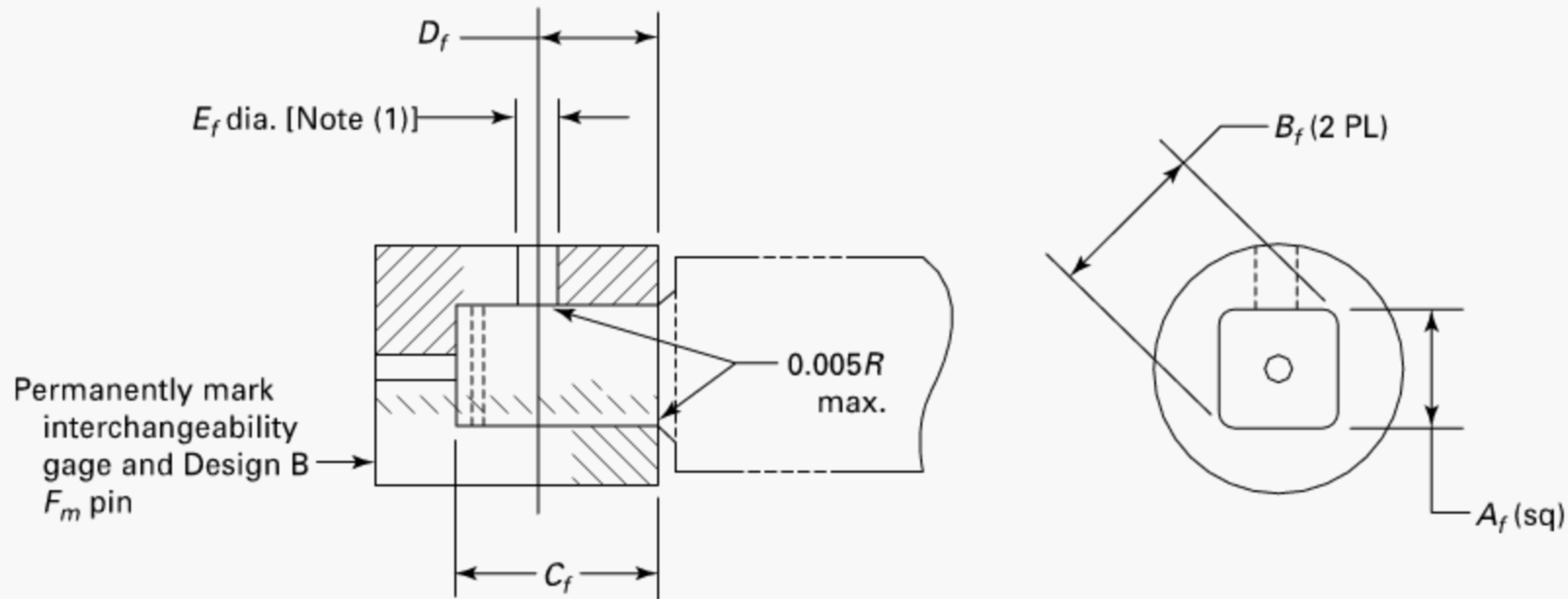
(a) Square drive shall be lifted gradually in a vertical manner, avoiding any side loads, while retaining the gage.

(b) Design D (internal-type recess) is generally not used on drive sizes larger than  $\frac{1}{2}$  in. (12.5 mm).

NOTE: (1) Use the corresponding drive size force gage from Table 8-5 to calibrate the retention force of the ball and spring.



**Table 8-7 Square Drive Interchangeability Gage Specifications for Designs A and B Hand, Power, and Impact Wrenches**  
— External End



## U.S. Customary Units, in.

Drive Size		$A_f$ +0.0010 -0.0000	$B_f$ +0.005 -0.000	$C_f$ +0.025 -0.000	$D_f$ +0.000 -0.002	$E_f$ , +0.000 -0.002		Maximum $F_m$ Pin, +0.0005 -0.0000, Design B
in.	mm					Design A, Min.	Design B, Min.	
1/4	6.3	0.2527	0.335	0.312	0.161	0.090	0.118	0.0780
3/8	10.0	0.3777	0.505	0.438	0.224	0.170	0.204	0.1400
1/2	12.5	0.5027	0.670	0.625	0.318	0.201	0.220	0.1560
5/8	16.0	0.6277	0.843	0.656	0.318	...	0.250	0.1560
3/4	20.0	0.7527	1.005	0.938	0.415	0.216	0.250	0.1880
1	25.0	1.0035	1.350	1.125	0.602	0.234	0.280	0.1880
1 1/2	40.0	1.5045	1.984	1.625	0.645	...	0.337	0.2500
2 1/2	63.0	2.5045	3.359	2.265	1.505	...	0.500	0.3120
3 1/2	89.0	3.5045	4.702	3.265	2.370	...	0.700	0.5000

## SI Units, mm

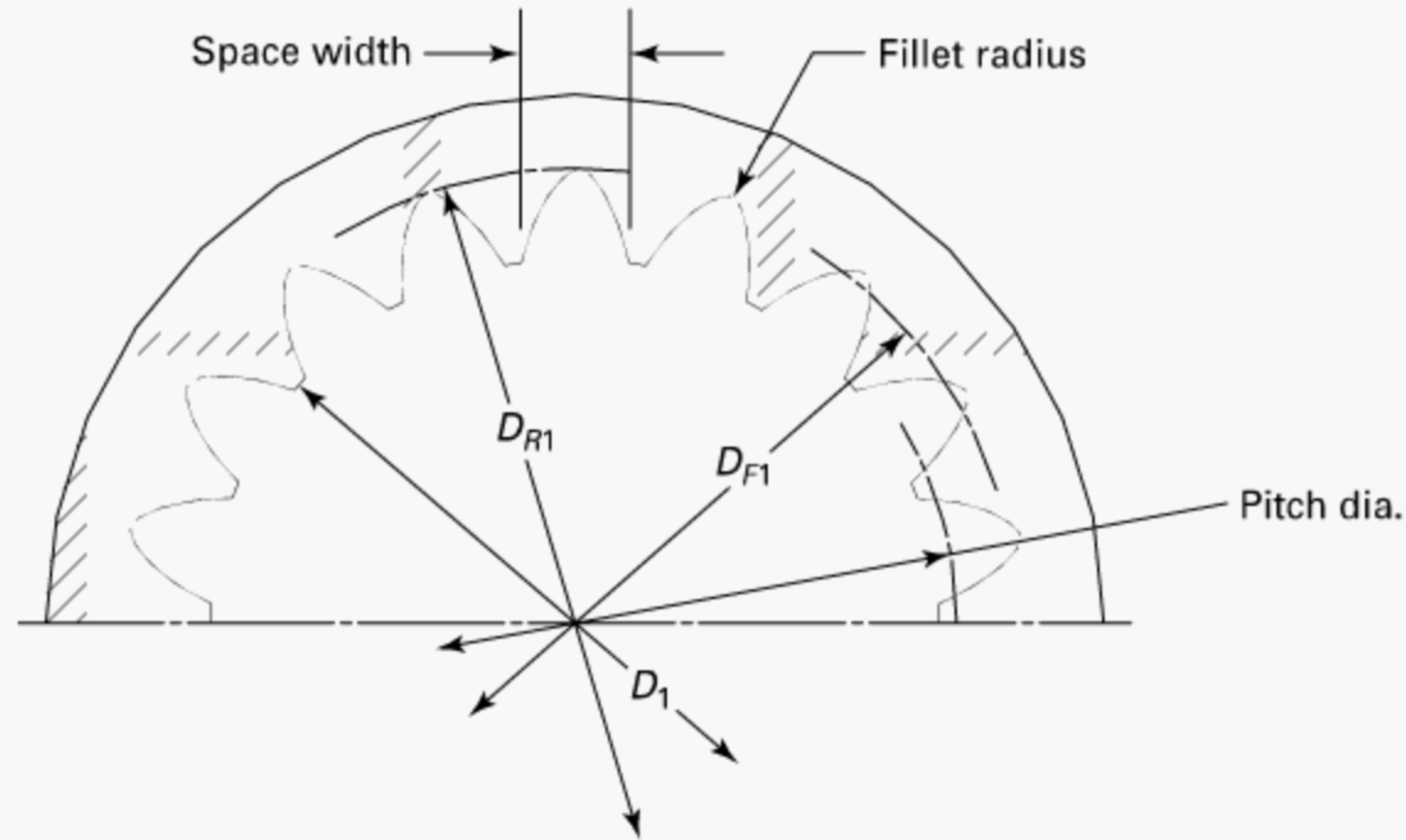
Drive Size		$A_f$ +0.020 -0.000	$B_f$ +0.13 -0.00	$C_f$ +0.64 -0.00	$D_f$ +0.00 -0.05	$E_f$ , +0.00 -0.05		Maximum $F_m$ Pin, +0.013 -0.000, Design B
mm	in.					Design A, Min.	Design B, Min.	
6.3	1/4	6.419	8.51	7.92	4.09	2.29	3.00	1.980
10.0	3/8	9.594	12.83	11.12	5.69	4.32	5.18	3.550
12.5	1/2	12.769	17.02	15.87	8.08	5.11	5.59	3.960
16.0	5/8	15.944	21.41	16.66	8.08	...	6.35	3.960
20.0	3/4	19.119	25.53	23.82	10.54	5.49	6.35	4.770
25.0	1	25.489	34.29	28.57	15.29	5.94	7.11	4.770
40.0	1 1/2	38.214	50.39	41.27	16.38	...	8.56	6.350
63.0	2 1/2	63.614	85.32	57.53	38.23	...	12.70	7.920
89.0	3 1/2	89.014	119.43	82.93	60.20	...	17.78	12.700

## GENERAL NOTES:

- The  $C_m$  of the product being gaged must pass the Figure 8-3 length gage prior to pull-off force gaging.
- The above gage simulates the worst-case condition of an internal square to test the interchangeability of an external square of Design A (plunger) and Design B (pin).
- Product to be oriented to engage plunger or pin into  $E_f$  diameter of gage.

NOTE: (1)  $E_f$  will be through both sides for Design B.



**Table 9-1 Spline Drives — Internal Spline Proportions**

**U.S. Customary Units, in.**

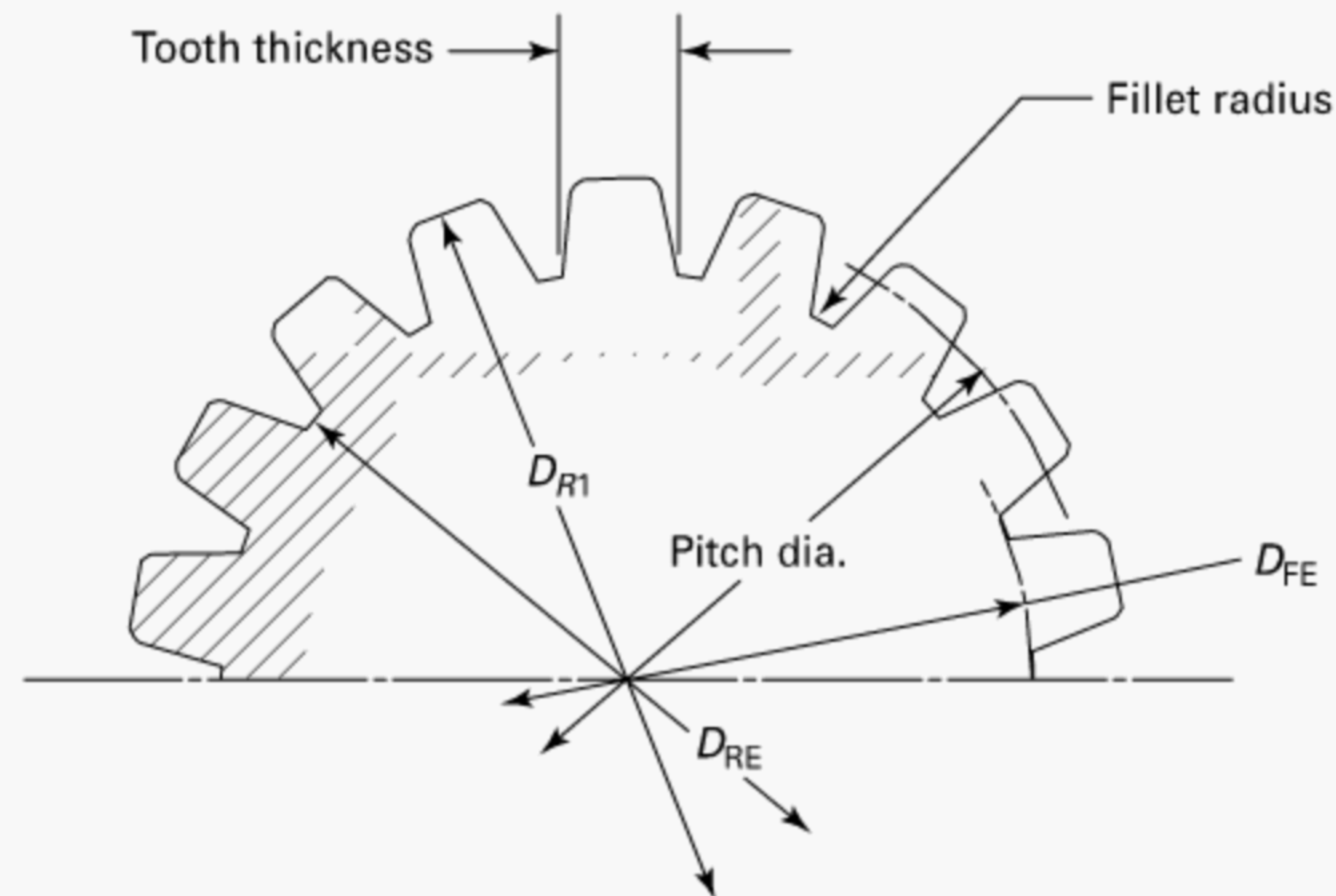
Drive Size Number	Nominal Size	Number of Teeth	Pitch	Press Angle, deg	Pitch Dia.	Major Dia., $D_{R1}$		Form Dia., $D_{F1}$	Minor Dia., $D_1$		Fillet Radius	Space Width	
						Max.	Min.		Max.	Min.		Max. Act	Min. Eff
1	0.5420	12	$\frac{24}{48}$	30	0.5000	0.5840	0.5750	0.5457	0.4633	0.4583	0.009	0.0678	0.0654
2	0.6500	12	$\frac{20}{40}$	30	0.6000	0.7000	0.6900	0.6540	0.5550	0.5500	0.012	0.0811	0.0785
2A	0.7500	14	$\frac{20}{40}$	30	0.7000	0.8000	0.7900	0.7540	0.6550	0.6500	0.013	0.0812	0.0785
3	0.9380	14	$\frac{16}{32}$	30	0.8750	0.9985	0.9875	0.9415	0.8185	0.8125	0.017	0.1009	0.0982
4	1.2500	14	$\frac{12}{24}$	30	1.1667	1.3297	1.3167	1.2540	1.0903	1.0833	0.025	0.1338	0.1309
5 [Note (1)]	1.6250	14	$\frac{10}{12}$	20	1.4000	1.6850	1.6700	1.6358	1.3620	1.3520	0.055	0.2015	0.1980
5A	1.9000	18	$\frac{10}{20}$	30	1.8000	1.9950	1.9800	1.9040	1.7100	1.7000	0.033	0.1601	0.1571
6	2.3750	18	$\frac{8}{16}$	30	2.2500	2.4930	2.4750	2.3795	2.1370	2.1250	0.041	0.1995	0.1963

**SI Units, mm**

Drive Size Number	Nominal Size	Number of Teeth	Module	Press Angle, deg	Pitch Dia.	Major Dia., $D_{R1}$		Form Dia., $D_{F1}$	Minor Dia., $D_1$		Fillet Radius	Space Width	
						Max.	Min.		Max.	Min.		Max. Act	Min. Eff
1	13.77	12	1.0583/0.5292	30	12.700	14.833	14.605	13.861	11.767	11.641	0.23	1.722	1.661
2	16.51	12	1.2700/0.6350	30	15.240	17.780	17.526	16.612	14.097	13.970	0.30	2.059	1.994
2A	19.05	14	1.2700/0.6350	30	17.780	20.320	20.066	19.152	16.637	16.510	0.33	2.062	1.994
3	23.83	14	1.5875/0.7938	30	22.225	25.361	25.083	23.914	20.789	20.638	0.43	2.562	2.494
4	31.75	14	2.1167/1.0583	30	29.634	33.774	33.444	31.852	27.693	27.516	0.64	3.398	3.325
5 [Note (1)]	41.28	14	2.5400/2.1167	20	35.560	42.799	42.418	41.549	34.594	34.341	1.40	5.118	5.030
5A	48.26	18	2.5400/1.2700	30	45.720	50.673	50.292	48.362	43.434	43.180	0.84	4.066	3.990
6	60.33	18	3.1750/1.5875	30	57.150	63.322	62.865	60.439	54.279	53.975	1.04	5.067	4.986

NOTE: (1) Size 5 prescribes proportions in common use for splined socket drives. Other splines conform to ANSI B92.1-1996 for fillet root, side fit, Class 1 (except the minor diameter maximum dimension,  $D_1$  max., for sizes 3, 4, 5A, and 6).



**Table 9-2 Spline Drives — External Spline Proportions****U.S. Customary Units, in.**

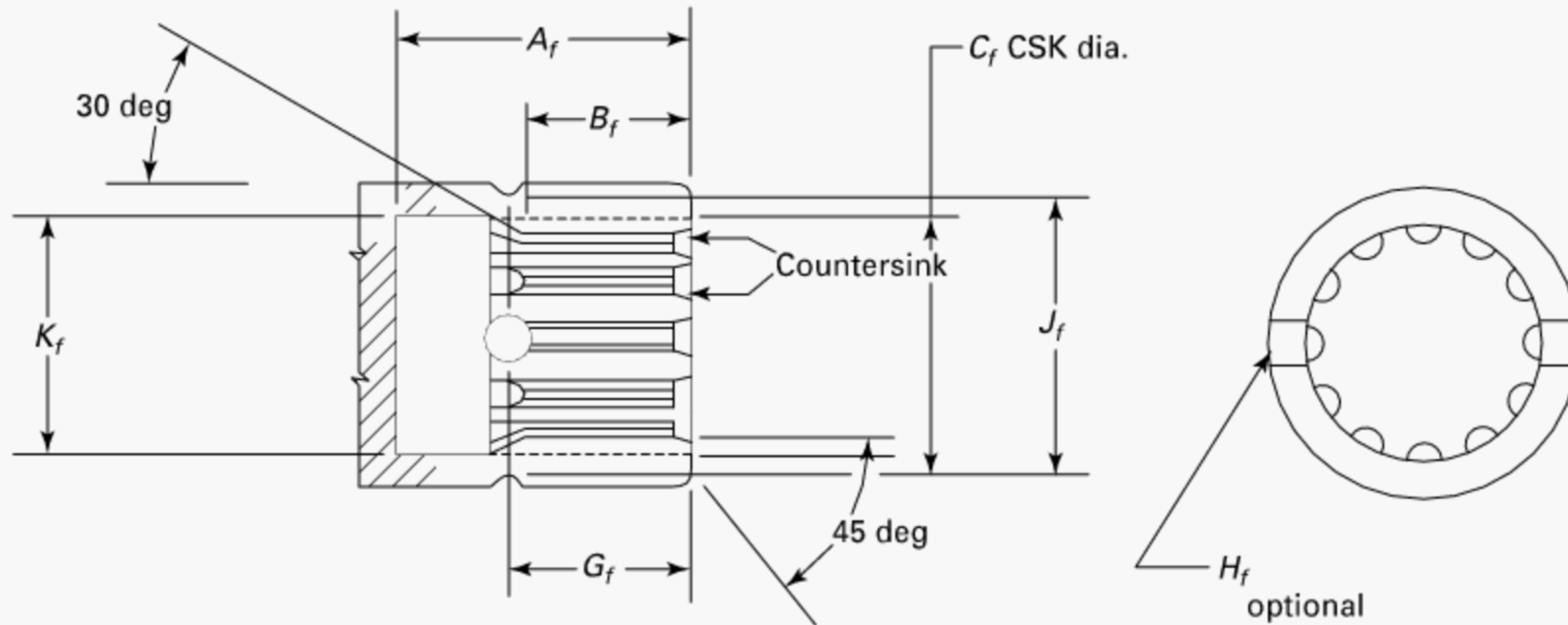
Drive Size Number	Nominal Size	Number of Teeth	Pitch	Press Angle, deg	Pitch Dia.	Major Dia., $D_{R1}$		Form Dia., $D_{FE}$	Minor Dia., $D_{RE}$		Fillet Radius	Tooth Thickness	
						Max.	Min.		Max.	Min.		Max. Eff	Min. Act
1	0.542	12	$\frac{24}{48}$	30	0.5000	0.5417	0.5367	0.4543	0.4167	0.4077	0.018	0.0639	0.0615
2	0.650	12	$\frac{20}{40}$	30	0.6000	0.6500	0.6450	0.5460	0.5000	0.4900	0.021	0.0770	0.0744
2A	0.750	14	$\frac{20}{40}$	30	0.7000	0.7500	0.7450	0.6460	0.6000	0.5900	0.020	0.0770	0.0743
3	0.938	14	$\frac{16}{32}$	30	0.8750	0.9375	0.9325	0.8085	0.7500	0.7390	0.025	0.0967	0.0940
4	1.250	14	$\frac{12}{24}$	30	1.1667	1.2500	1.2450	1.0793	1.0167	1.0037	0.038	0.1294	0.1265
5 [Note (1)]	1.625	14	$\frac{10}{12}$	20	1.4000	1.6150	1.6110	1.3156	1.2500	1.2350	0.050	0.1950	0.1900
5A	1.900	18	$\frac{10}{20}$	30	1.8000	1.9000	1.8950	1.6950	1.6200	1.6150	0.044	0.1556	0.1526
6	2.375	18	$\frac{8}{16}$	30	2.2500	2.3750	2.3700	2.1205	2.0250	2.0070	0.055	0.1948	0.1915

**SI Units, mm**

Drive Size Number	Nominal Size	Number of Teeth	Module	Press Angle, deg	Pitch Dia.	Major Dia., $D_{R1}$		Form Dia., $D_{FE}$	Minor Dia., $D_{RE}$		Fillet Radius	Tooth Thickness	
						Max.	Min.		Max.	Min.		Max. Eff	Min. Act
1	13.77	12	1.0583/0.5292	30	12.700	13.759	13.632	11.539	10.584	10.356	0.46	1.623	1.562
2	16.51	12	1.2700/0.6350	30	15.240	16.510	16.383	13.868	12.700	12.446	0.53	1.955	1.890
2A	19.05	14	1.2700/0.6350	30	17.780	19.050	18.923	16.408	15.240	14.986	0.51	1.955	1.887
3	23.83	14	1.5875/0.7938	30	22.225	23.812	23.686	20.536	19.050	18.771	0.64	2.456	2.388
4	31.75	14	2.1167/1.0583	30	29.634	31.750	31.623	27.414	25.824	25.494	0.97	3.286	3.213
5 [Note (1)]	41.28	14	2.5400/2.1167	20	35.560	41.021	40.919	33.416	31.750	31.369	1.27	4.953	4.826
5A	48.26	18	2.5400/1.2700	30	45.720	48.260	48.133	43.078	41.148	41.020	1.12	3.952	3.876
6	60.33	18	3.1750/1.5875	30	57.150	60.325	60.198	53.861	51.435	50.978	1.40	4.947	4.864

NOTE: (1) Size 5 prescribes proportions in common use for splined socket drives. Other splines conform to ANSI B92.1-1996 for fillet root, side fit, Class 1.



**Table 9-3 Spline Drives — Internal Mounting Dimensions****U.S. Customary Units, in.**

Drive Size Number	$A_f$ Min.	$B_f$ Max.	$C_f$ $\pm \frac{1}{64}$	$G_f$ $\pm 0.006$	$H_f$ $+\frac{1}{32}$ $-0$	$J_f$ $+\frac{1}{16}$ $-0$	$K_f$ Min.
1	0.656	0.375	$\frac{35}{64}$	0.468	$\frac{3}{16}$	...	0.5417
2	0.937	0.562	$\frac{21}{32}$	0.672	$\frac{7}{32}$	...	0.6500
2A	1.094	0.625	$\frac{3}{4}$	0.750	$\frac{7}{32}$	$1\frac{1}{8}$	0.7500
3	1.312	0.687	$\frac{15}{16}$	0.844	$\frac{5}{16}$	$1\frac{3}{8}$	0.9375
4	1.500	0.750	$1\frac{1}{4}$	0.953	$\frac{3}{8}$	$1\frac{11}{16}$	1.2500
5	1.875	0.906	$1\frac{5}{8}$	0.625	$\frac{5}{16}$	$2\frac{1}{16}$	1.6150
5A	2.060	1.010	$2\frac{1}{32}$	1.250	$\frac{15}{32}$	$2\frac{11}{32}$	1.9000
6	2.125	1.094	$2\frac{3}{8}$	1.328	$\frac{1}{2}$	$3\frac{3}{16}$	2.3750

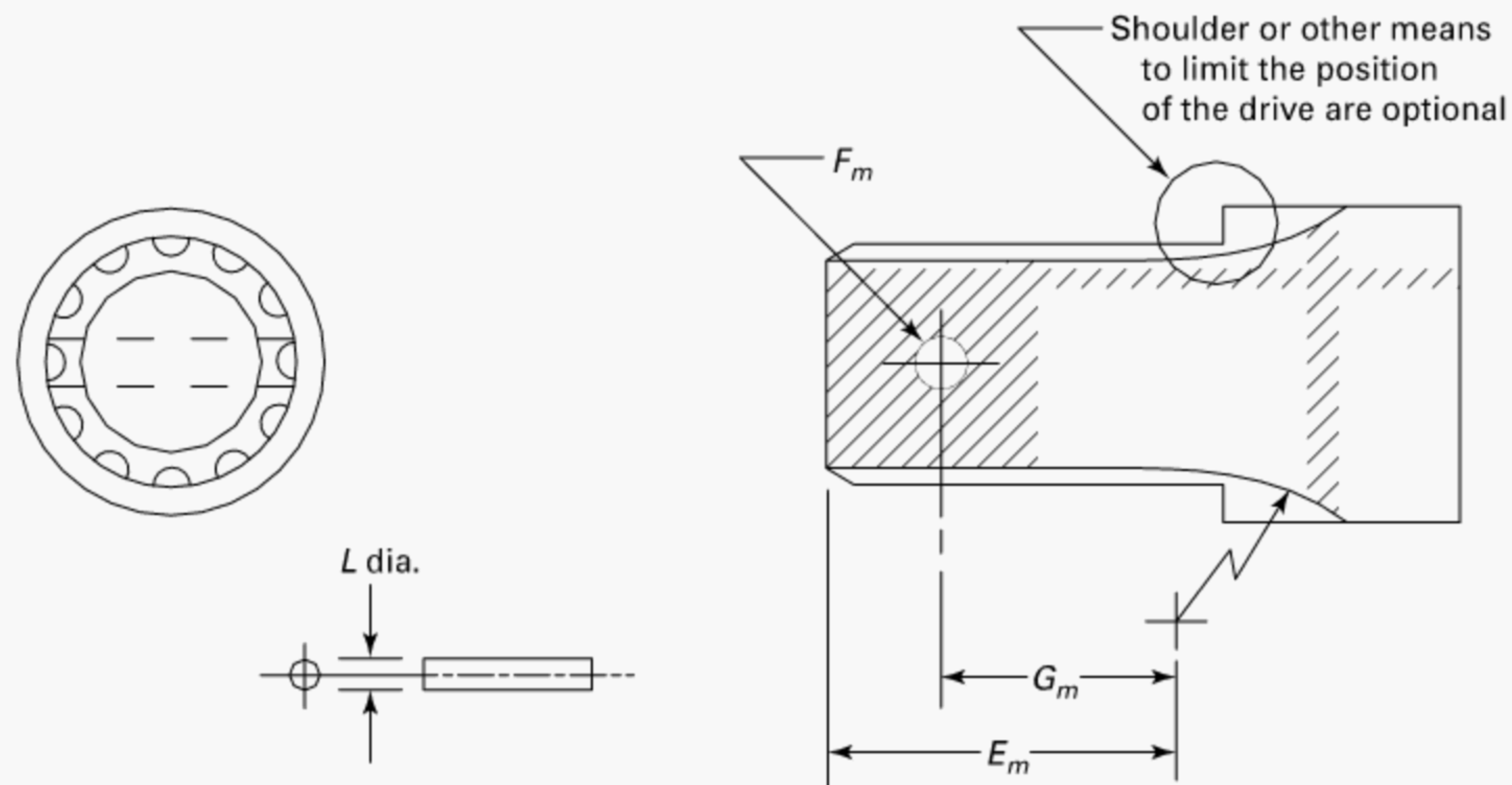
**SI Units, mm**

Drive Size Number	$A_f$ Min.	$B_f$ Max.	$C_f$ $\pm 0.40$	$G_f$ $\pm 0.15$	$H_f$ $+0.79$ $-0.00$	$J_f$ $+1.58$ $-0.00$	$K_f$ Min.
1	16.66	9.52	13.89	11.89	4.76	...	13.759
2	23.80	14.27	16.67	17.07	5.56	...	16.510
2A	27.79	15.87	19.05	19.05	5.56	28.58	19.050
3	33.32	17.44	23.81	21.44	7.94	34.93	23.813
4	38.10	19.05	31.75	24.21	9.53	42.86	31.750
5	47.63	23.01	41.28	15.88	7.94	52.39	41.021
5A	52.32	25.65	51.59	31.75	11.91	59.53	48.260
6	53.98	27.79	60.33	33.73	12.70	80.96	60.325

**GENERAL NOTES:**

- Hole  $H_f$  must be oriented on the centerline of a tooth (as shown) for all sizes except Size 5. Hole  $H_f$  must be oriented on the centerline of a tooth space for Size 5 only.
- The proportions of the internal drive shall permit entry of a comparably sized external drive end, conforming to [Table 10-4](#) of this Standard, to a depth equal to dimension  $A_f$ .
- The 30-deg angle forward of the spline shall extend to the major diameter of the spline.



**Table 9-4 Spline Drives — External Mounting Dimensions****U.S. Customary Units, in.**

Drive Size Number	$E_m$ , Max.	$F_m$ , Min.	$G_m$ , $\pm 0.006$	Maximum Dia., $L$
1	0.656	$\frac{9}{64}$	0.468	$\frac{1}{8}$
2	0.937	$\frac{11}{64}$	0.672	$\frac{5}{32}$
2A	1.094	$\frac{11}{64}$	0.750	$\frac{5}{32}$
3	1.312	$\frac{7}{32}$	0.844	$\frac{3}{16}$
4	1.500	$\frac{9}{32}$	0.953	$\frac{1}{4}$
5	1.875	$\frac{5}{16}$	0.625	$\frac{1}{4}$
5A	2.060	$\frac{11}{32}$	1.250	$\frac{5}{16}$
6	2.125	$\frac{13}{32}$	1.328	$\frac{3}{8}$

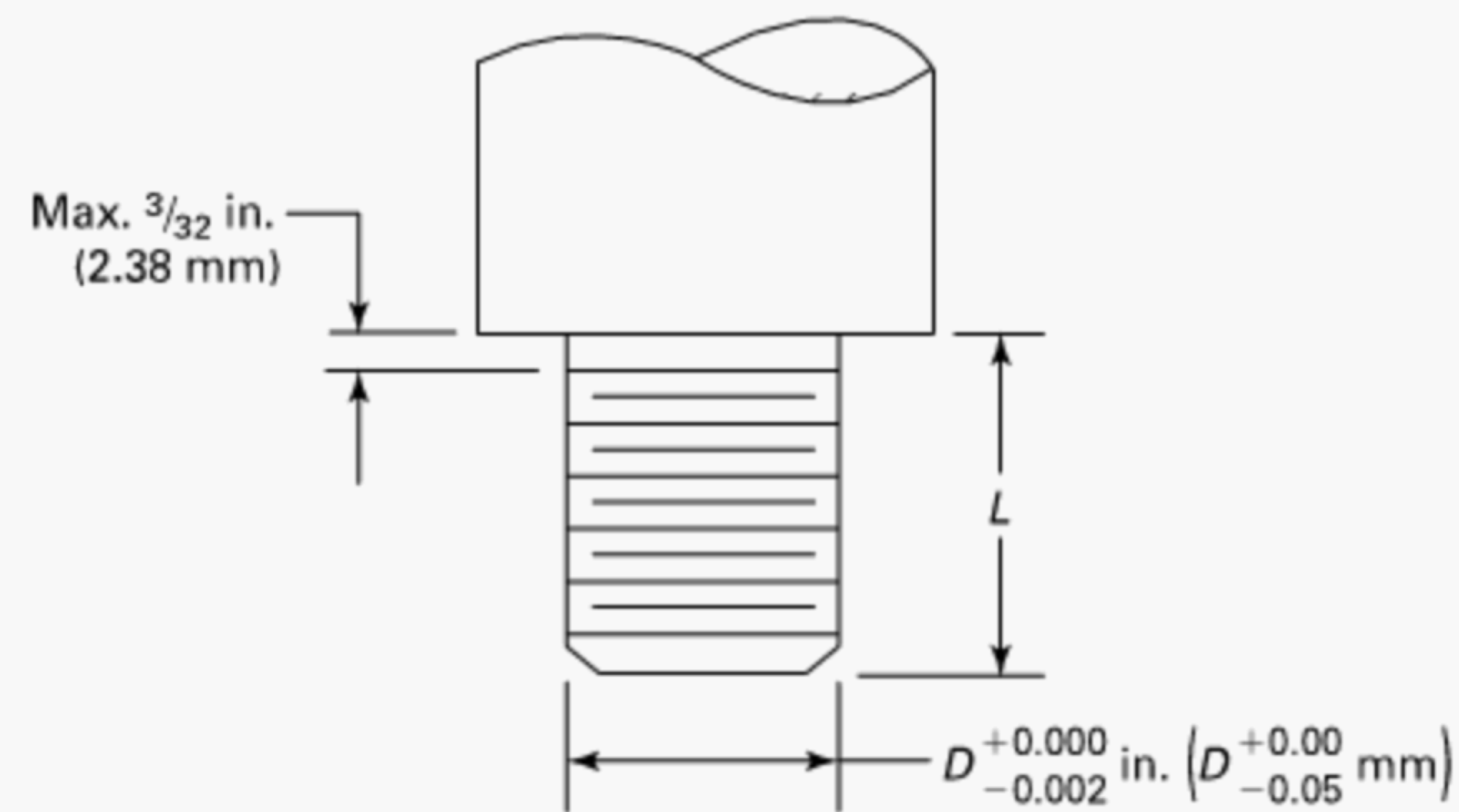
**SI Units, mm**

Drive Size Number	$E_m$ , Max.	$F_m$ , Min.	$G_m$ , $\pm 0.15$	Maximum Dia., $L$
1	16.66	3.57	11.89	3.17
2	23.80	4.37	17.07	3.96
2A	27.78	4.37	19.05	3.96
3	33.32	5.56	21.44	4.76
4	38.10	7.14	24.21	6.35
5	47.62	7.94	15.88	6.35
5A	52.32	8.73	31.75	7.93
6	53.97	10.32	33.73	9.52

**GENERAL NOTES:**

- (a) Hole  $F_m$  must be oriented on the centerline of a tooth space (as shown) for all sizes except Size 5.
- (b) Hole  $F_m$  must be oriented on the centerline of a tooth for Size 5 ONLY. External drive ends shall provide means to retain internal drive ends that conform to [Table 10-3](#) of this Standard.
- (c) Hole  $F_m$  must be deleted when other means are employed.

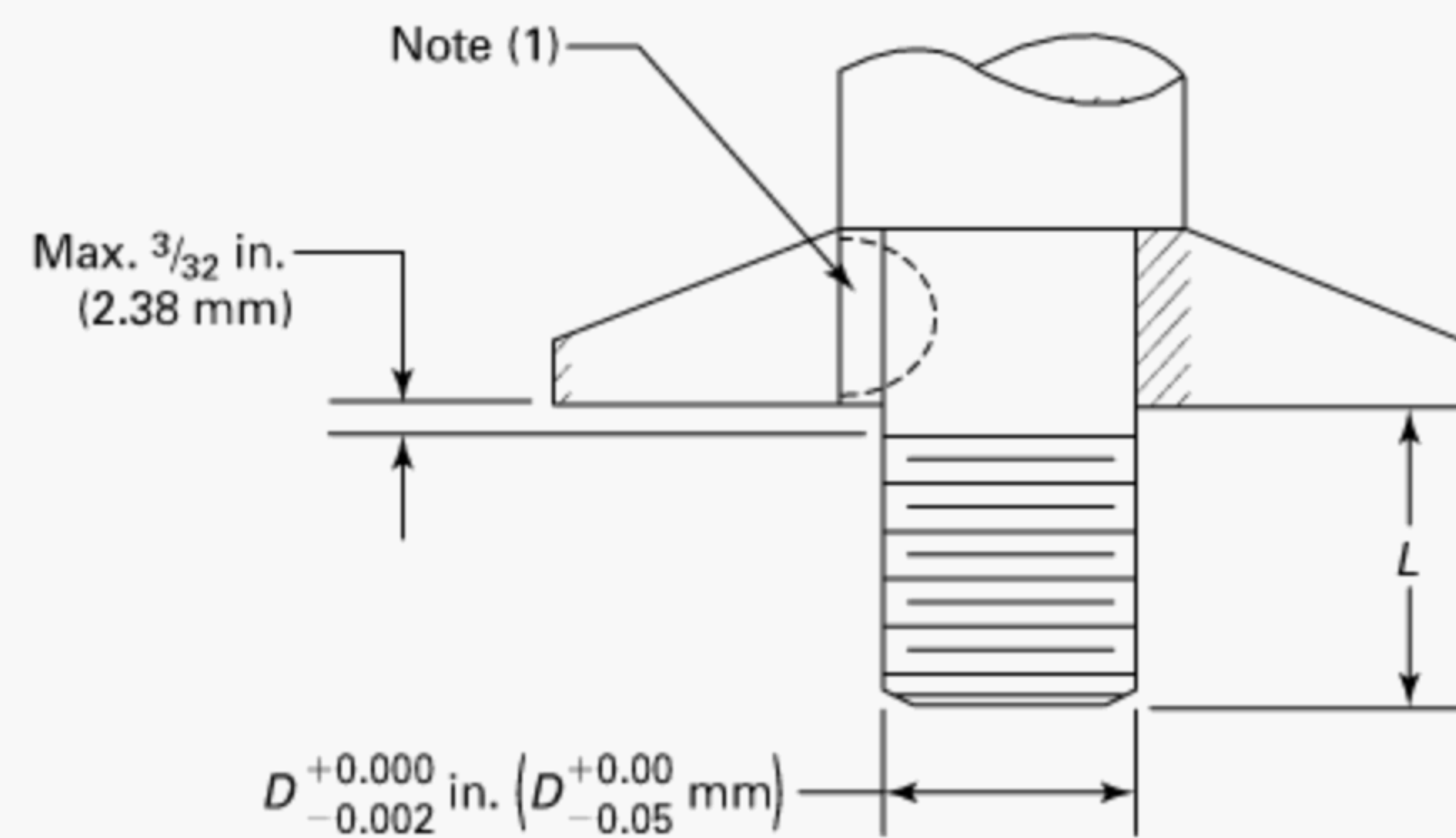


**Table 10-1 Sanders and Polishers**

<i>D</i>	<i>L</i> , in.	<i>L</i> , mm
$\frac{5}{8}$ -11 UNC-2A	$\frac{15}{16}$ +0 $-\frac{1}{16}$	23.81 +0.00 -1.58

## GENERAL NOTES:

- (a) Not suited for use with grinding wheels.  
 (b) Threads right hand.

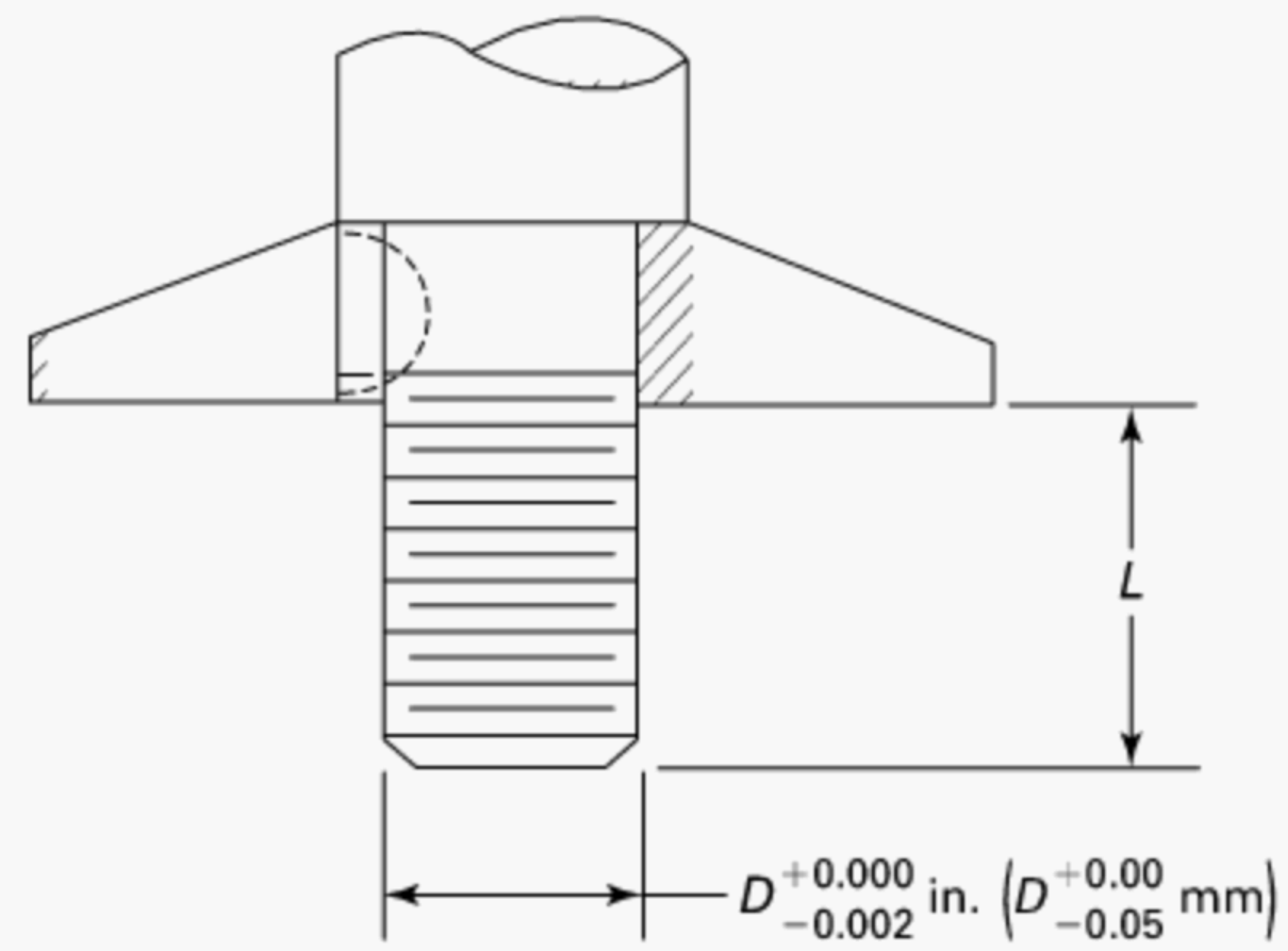
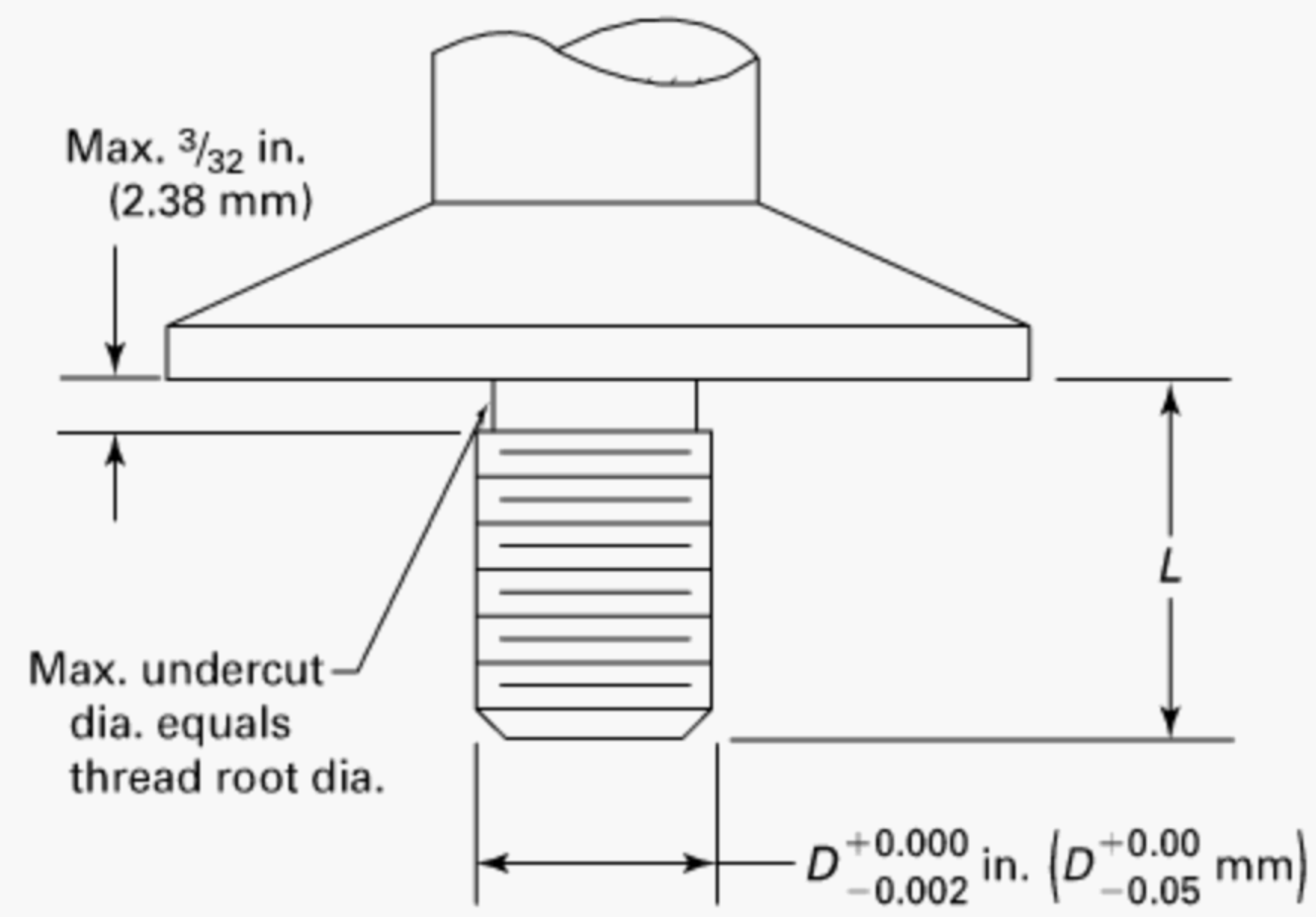
**Table 10-2 Vertical and Angle Grinders for Unthreaded Wheels**

Wheel Dia., <i>D</i>		Maximum <i>L</i> , in.	Maximum <i>L</i> , mm
Over 5 in.	5 in. and Under		
$\frac{5}{8}$ -11 UNC-2A	$\frac{5}{8}$ -11 UNC-2A through $\frac{3}{8}$ -24	1½	38.10

## GENERAL NOTES:

- (a) See ANSI B7.1-2000 for proper flange diameters.  
 (b) Threads right hand.

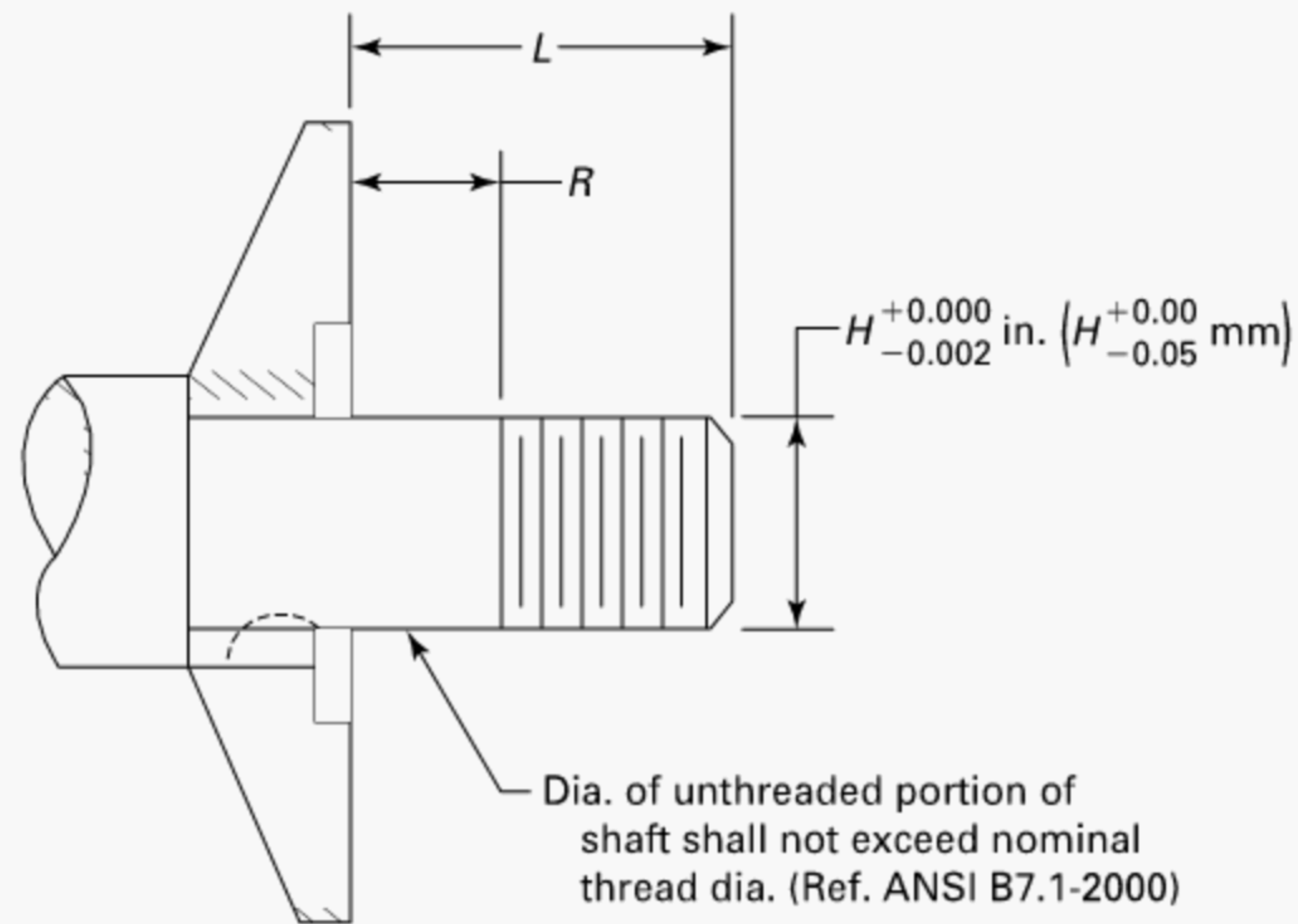
NOTE: (1) Driven flange for wheels over 5-in. diameter.

**Table 10-3 Grinder Type****Separate Flange****Integral Flange**

$D$	$L$ , in.	$L$ , mm
<b>Vertical and Angle Grinders for Threaded Wheels</b>		
$\frac{5}{8}$ -11 UNC-2A	$\frac{15}{16}$	23.81
<b>Cone Wheel Grinders</b>		
$\frac{3}{8}$ -24 UNF-2A	$\frac{9}{16}$	14.29
$\frac{1}{2}$ -13 UNC-2A	$\frac{11}{16}$	17.46
$\frac{5}{8}$ -11 UNC-2A	$\frac{15}{16}$	23.81

GENERAL NOTE: See ANSI B7.1-2000 for proper flange diameters.



**Table 10-4 Straight Wheel Grinders**

$H$	$L$ , in.	$L$ , mm
$\frac{3}{8}$ -24 UNF-2A	$1\frac{1}{8}$	28.58
$\frac{1}{2}$ -13 UNC-2A	$1\frac{3}{4}$	44.45
$\frac{5}{8}$ -11 UNC-2A	$2\frac{1}{8}$	53.98
$\frac{5}{8}$ -11 UNC-2A	$3\frac{1}{8}$	79.38
$\frac{3}{4}$ -10 UNC-2A	$3\frac{1}{4}$	82.55

## GENERAL NOTES:

- (1) See ANSI B7.1-2000 for proper flange diameters.  
 (2)  $R$  is governed by the thickness of the wheel.

**Table 11-1 Round Arbors**

Nominal Blade Dia., in.	Nominal Blade Dia., mm	Round Arbor Dia., in.	Round Arbor Dia., mm
6 to $8\frac{1}{2}$ , incl.	152 to 216	$\frac{5}{8}$	15.88
9 to 12, incl.	228 to 305	$\frac{3}{4}$	19.05



## NONMANDATORY APPENDIX A CHUCKS AND SPINDLES

Table A-1 provides recommended spindle sizes for given chuck sizes.

**Table A-1 Chucks and Spindles**

Recommended Spindles		
Chuck Sizes	Threaded	Taper
$\frac{3}{16}$ and $\frac{1}{4}$ light	$\frac{3}{8}$ -24 UNF-2A	1
$\frac{1}{4}$ and $\frac{5}{16}$ medium	$\frac{3}{8}$ -24 UNF-2A or $\frac{1}{2}$ -20 UNF-2A	2 short
$\frac{3}{8}$ light	$\frac{3}{8}$ -24 UNF-2A or $\frac{1}{2}$ -20 UNF-2A	2
$\frac{3}{8}$ medium	$\frac{1}{2}$ -20 UNF-2A or $\frac{5}{8}$ -16 UN-2A	2
$\frac{1}{2}$ light	$\frac{1}{2}$ -20 UNF-2A or $\frac{5}{8}$ -16 UN-2A	33
$\frac{1}{2}$ medium	$\frac{5}{8}$ -16 UN-2A or $\frac{3}{4}$ -16 UNF-2A	6
$\frac{5}{8}$ and $\frac{3}{4}$ medium	$\frac{5}{8}$ -16 UN-2A or $\frac{3}{4}$ -16 UNF-2A	3



## **NONMANDATORY APPENDIX B**

# **MOUNTING OF ABRASIVE WHEELS ON THREADED SPINDLES**

Mounting shall conform to the applicable requirements of ANSI B7.1-2000.



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