
**Assembly tools for screws and nuts —
Screwdrivers for cross-recessed head
screws —**

**Part 2:
General requirements, lengths of blades
and marking of hand-operated
screwdrivers**

*Outils de manœuvre pour vis et écrous — Tournevis pour vis
à empreinte cruciforme —*

*Partie 2: Spécifications générales, longueurs des lames et marquage
des tournevis à main*



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Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 8764-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 10, *Assembly tools for screws and nuts, pliers and nippers*.

This second edition cancels and replaces the first edition (ISO 8764-2:1992), which has been technically revised as follows:

- a designation has been added;
- in the English version, the term “point” becomes “tip” and “type” becomes “form”;
- in the French version, the term “type” becomes “forme”.

ISO 8764 consists of the following parts, under the general title *Assembly tools for screws and nuts — Screwdrivers for cross-recessed head screws*:

- *Part 1: Driver tips*
- *Part 2: General requirements, lengths of blades and marking of hand-operated screwdrivers*

Assembly tools for screws and nuts — Screwdrivers for cross-recessed head screws —

Part 2: General requirements, lengths of blades and marking of hand-operated screwdrivers

1 Scope

This part of ISO 8764 specifies general requirements, lengths of blades and marking of hand-operated screwdrivers for H and Z cross-recessed head screws, as specified in ISO 4757.

The specifications for blade tips are given in ISO 8764-1.

NOTE Screwdrivers for cross-recessed head screws are listed under number 106 in ISO 1703:1983.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 272, *Fasteners — Hexagon products — Widths across flats*

ISO 4759-1, *Tolerances for fasteners — Part 1: Bolts, screws, studs and nuts — Product grades A, B and C*

ISO 8764-1, *Assembly tools for screws and nuts — Screwdrivers for cross-recessed head screws — Part 1: Driver tips*

3 General requirements

The material, shape and finish of the handle shall ensure use under normal conditions.

The handle and the blade shall show neither roughness nor faults which could cause accidents during use.

4 Blade lengths

The lengths of blades are specified in Table 1 according to the sizes of tip forms PH and PZ of the screwdrivers as defined in ISO 8764-1. Two series of lengths are provided.

NOTE Figures 1 and 2 are given as examples and are not intended to affect the manufacturer's design.

**Table 1 — Lengths of screwdriver blades
for cross-recessed head screws**

Dimensions in millimetres

Tip sizes for driver forms PH and PZ	l $+5$ 0	
	Series A	Series B
0	25 (35)	60
1	25 (35)	75 (80)
2	25 (35)	100
3	—	150
4	—	200

NOTE The dimensions in parentheses are non-preferred.

From tip size 2, screwdrivers with hexagonal driver near the handle are permitted (see Figure 2); widths across flats s and the corresponding tolerances shall be in accordance with ISO 272 and ISO 4759-1. The dimensions h_{\min} is determined by the formula

$$h_{\min} = 0,5 s.$$

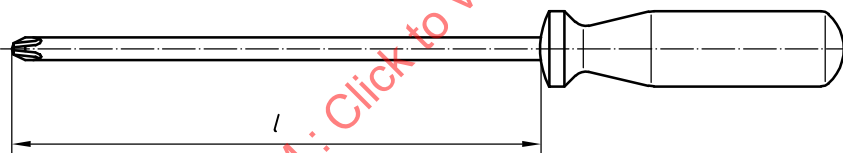


Figure 1 — Screwdriver

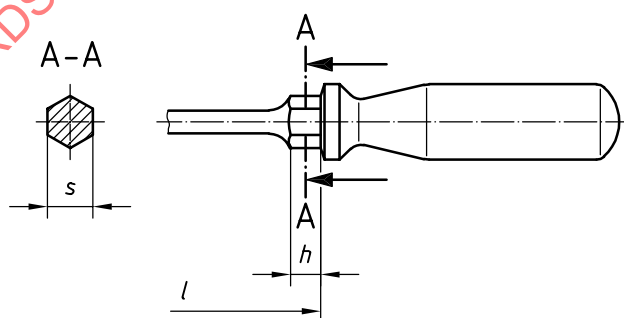


Figure 2 — Hexagonal driver near the handle

5 Designation

EXAMPLE 1 Designation of a screwdriver, series A, tip form PH, size 2:

Screwdriver ISO 8764-2 — A — PH2

EXAMPLE 2 Designation of a screwdriver, series B, tip form PZ, size 3:

Screwdriver ISO 8764-2 — B — PZ3

6 Marking

The marking of the form of tip, PZ or PH, the tip size and the trademark shall be legible and indelible under normal conditions of use. Indication of the blade length is optional, but when given it shall correspond to the nominal length given in Table 1.

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Bibliography

- [1] ISO 1703, *Assembly tools for screws and nuts — Nomenclature*
- [2] ISO 4757, *Cross recesses for screws*

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