INTERNATIONAL STANDARD

ISO 5748

Third edition
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Pliers and nippers — End cutting nippers — Dimensions and test values

Pinces et tenailles — Pinces coupantes en bout — Dimensions et valeurs d'essai

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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.

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 5748 was prepared by Technical Committee 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 5748:1988) which has been technically revised.

Pliers and nippers — End cutting nippers — Dimensions and test values

1 Scope

This International Standard specifies the principal dimensions of end cutting nippers and the test values for the nippers in order to verify their aptitude to function in conformity with ISO 5744. General technical requirements are given in ISO 5743.

The end nippers illustrated in this International Standard are examples only and are not intended to affect the manufacturer's design.

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 5743, *Pliers and nippers — General technical requirements*

ISO 5744:2004, *Pliers and nippers — Methods of test*

3 Dimensions and test values

3.1 End cutting nippers for hard wire

The main dimensions for cutting nippers for hard wire are shown in Figure 1 and given in Table 1.

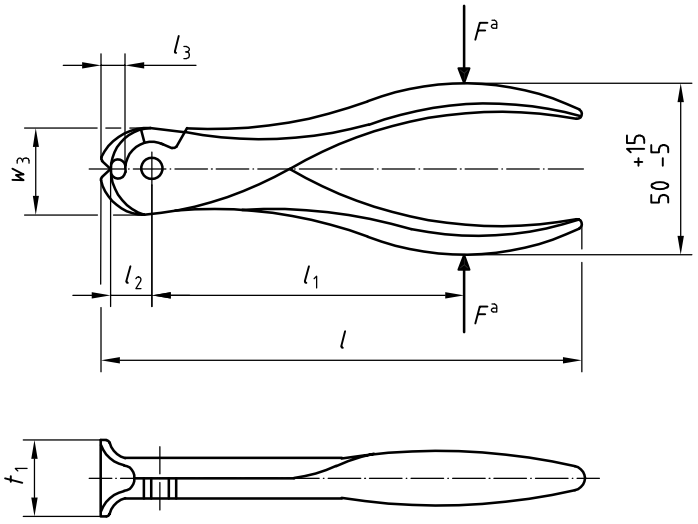
Cutting nippers shall be tested in accordance with ISO 5744.

After the load test, the permanent set s shall not exceed the value given in Table 2. If distance l_1 is not suitable for the load test, the formula given in ISO 5744:2004, 4.2 shall be used.

The cutting force, F_1, and the diameter, d, of the test wire shall not exceed the values given in Table 2.

Nippers having a lever ratio differing from the values given in Table 2 shall be checked for compliance using the formula given in ISO 5744:2004, 5.3.3.

Dimensions in millimetres



a F = Load applied in load test or F_1 force applied in cutting test.

Figure 1 — End cutting nippers for hard wire

Table 1 — End cutting nippers for hard wire, main dimensions

Dimensions in millimetres

l	l_3 max.	W_3 max.	t_1 max.
140 ± 8	8	25	22
160 ± 9	9	28	25
180 ± 10	10	32	28
200 ± 11	11	36	32

Table 2 — End cutting nippers for hard wire, force application and test values

Nominal length			Cutting test		Load test	
			Diameter of hard test wire	Maximum cutting force	Load	Maximum permanent set
l	l_1	l_2	d [a]	$F_{1\,max}$	F	s_{max} [b]
mm	mm	mm	mm	N	N	mm
140	100	16	1,4	750	1 000	1
160	112	18	1,6	900	1 120	1
180	125	20	1,8	1 060	1 250	1
200	140	22	2	1 260	1 400	1

a Data for hard test wire are given in ISO 5744.

b $s = w_1 - w_2$ (see ISO 5744).

3.2 End cutting nippers for medium hard wire

The main dimensions for cutting nippers for hard wire are shown in Figure 2 and given in Table 3.

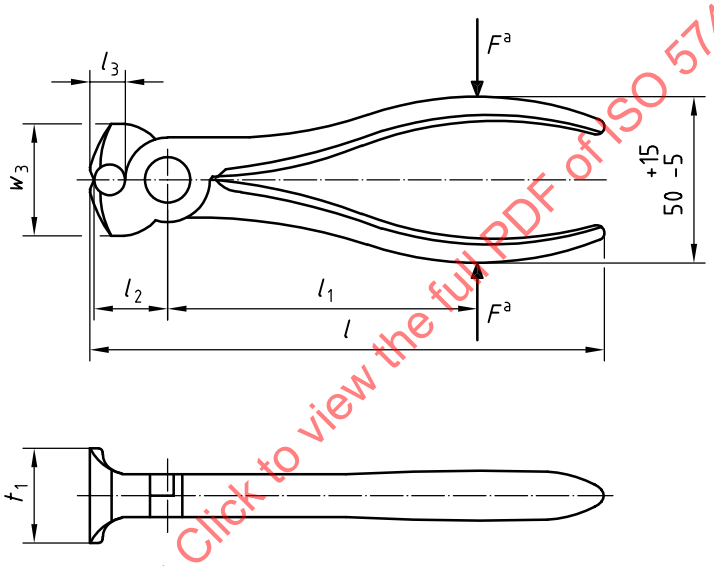
Cutting nippers shall be tested in accordance with ISO 5744.

After the load test, the permanent set s shall not exceed the value given in Table 4. If distance l_1 is not suitable for the load test, the formula given in ISO 5744:2004, 4.2 shall be used.

The cutting force, F_1, and the diameter, d, of the test wire shall not exceed the values given in Table 4.

Nippers having a lever ratio differing from the values given in Table 4 shall be checked for compliance using the formula given in ISO 5744:2004, 5.3.2.

Dimensions in millimetres



a F = Load applied in load test or F_1 force applied in cutting test.

Figure 2 — End cutting nippers for medium hard wire

Table 3 — End cutting nippers for medium hard wire, main dimensions

Dimensions in millimetres

l	l_3 max.	w_3 max.	t_1 max.
125 ± 7	8	25	20
140 ± 8	9	28	22
160 ± 9	10	32	25
180 ± 10	11	36	28
200 ± 11	12	40	32

Table 4 — End cutting nippers for medium hard wire, force application and test values

Nominal length			Cutting test		Load test	
			Diameter of medium hard test wire	Maximum cutting force	Load	Maximum permanent set
l	l_1	l_2	d [a]	$F_{1\,max}$	F	s_{max} [b]
mm	mm	mm	mm	N	N	mm
125	90	18	1,6	570	900	0,7
140	100	20	1,6	570	1 000	1
160	112	22	1,6	570	1 120	1
180	125	25	1,6	570	1 250	1
200	140	28	1,6	570	1 400	1

a Data for medium hard test wire are given in ISO 5744.

b $s = w_1 - w_2$ (see ISO 5744).

3.3 Toggle lever assisted end cutting nippers for hard wire

The main dimensions for cutting nippers for hard wire are shown in Figure 3 and given in Table 5.

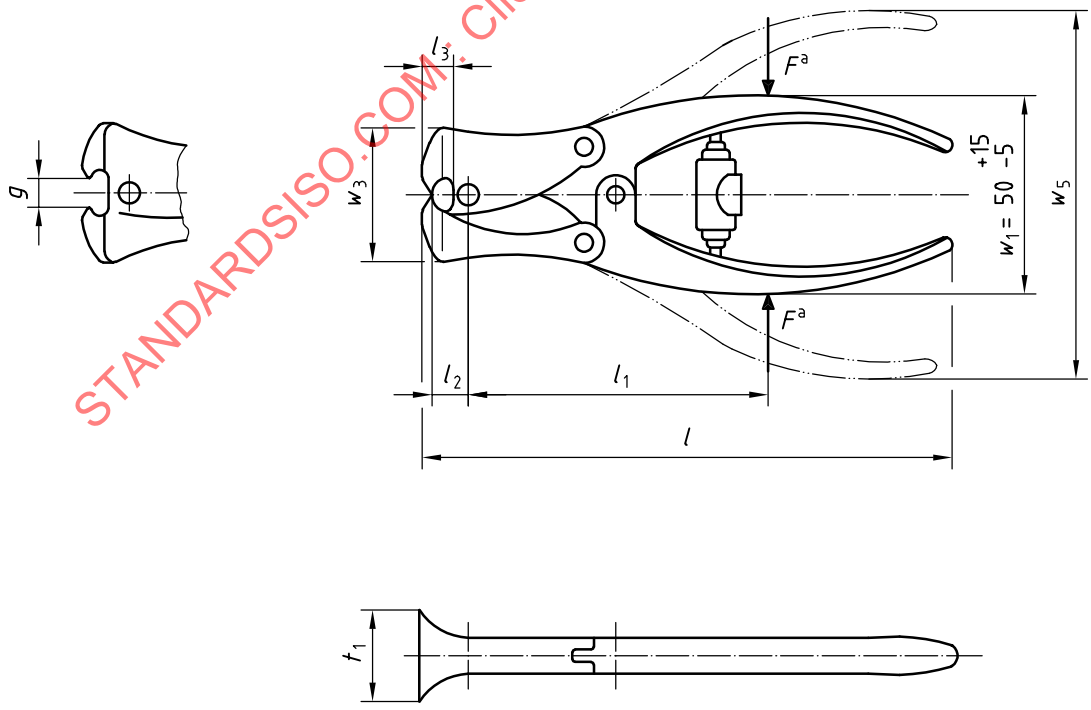
Cutting nippers shall be tested in accordance with ISO 5744.

After the load test, the permanent set s shall not exceed the value given in Table 6. If distance l_1 is not suitable for the load test, the formula given in ISO 5744:2004, 4.2 shall be used.

The cutting force, F_1, and the diameter, d, of the test wire shall not exceed the values given in Table 6.

Nippers having a lever ratio differing from the values given in Table 6 shall be checked for compliance using the formula given in ISO 5744:2004, 5.3.4.

Dimensions in millimetres



a F = Load applied in load test or F_1 force applied in cutting test.

Figure 3 — Toggle lever assisted end cutting nippers for hard wire

Table 5 — Toggle lever assisted end cutting nippers for hard wire, main dimensions

Dimensions in millimetres

l	l_3 max.	w_3 max.	g min.	t_1 max.
180 ± 10	9	45	4	33,5
200 ± 11	10	50	4	35,5

Table 6 — Toggle lever assisted end cutting nippers for hard wire, force application and test values

Nominal length l mm	l_1 mm	l_2 mm	Cutting test: Lever ratio[a]	Cutting test: Diameter of hard test wire d[b] mm	Cutting test: Maximum cutting force $F_{1\,max}$ N	Load test: Load F N	Load test: Maximum permanent set s_{max}[c] mm
180	125	16	12,5	2	640	750	1
200	140	18	14,5	2,5	790	840	1

a The lever ratio is equal to $(w_5 - w_1)/g$.

b Data for hard test wire are given in ISO 5744.

c $s = w_1 - w_2$ (see ISO 5744).

4 Designation

EXAMPLE 1 End cutting nippers, number 102 in accordance with ISO 5742, with a nominal length of 140 mm and for hard wire (H) are designated as follows:

End cutting nippers 102 - ISO 5748 - 140 - H

EXAMPLE 2 End cutting nippers, number 102 in accordance with ISO 5742, with a nominal length of 160 mm and for medium hard wire (M) are designated as follows:

End cutting nippers 102 - ISO 5748 - 160 - M

EXAMPLE 3 Toggle lever assisted end cutting nippers, number 103 in accordance with ISO 5742, with a nominal length of 200 mm are designated as follows:

Toggle lever assisted end cutting nippers 103 - ISO 5748 - 200

5 Marking

Marking shall be in accordance with ISO 5743.