

ASME B107.34-2003
(Revision of ASME B107.34M-1997)

Socket Wrenches for Spark Plugs

AN AMERICAN NATIONAL STANDARD



**The American Society of
Mechanical Engineers**

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Three Park Avenue • New York, NY 10016

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FOREWORD

The American National Standards Committee B107, Socket Wrenches and Drives, under sponsorship by The American Society of Mechanical Engineers, was reorganized as an ASME Standards Committee and its title was changed to Hand Tools and Accessories. In 1996 its scope was expanded to include safety considerations.

The purposes of this Standard are to define dimensional, performance, and safety requirements specifically applicable to socket wrenches for spark plugs and to specify test methods to evaluate performance relating to the defined requirements.

This Standard is a revision of B107.34M-1997, Socket Wrenches for Spark Plugs. Updated references, finish requirements, test requirements, and dimensional data are included.

The format of this Standard is in accordance with *The ASME Codes & Standards Writing Guide 2000*. Requests for interpretations and suggestions for the improvement of this Standard should be addressed to The American Society of Mechanical Engineers, Secretary, B107 Standards Committee, Three Park Avenue, New York, NY 10016-5990.

The requirements of this Standard become effective at the time of publication. ASME B107.34-2003 was approved as an American National Standard on May 1, 2003.

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Hand Tools and Accessories

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Subject:	Cite the applicable paragraph number(s) and the topic of the inquiry.
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. The inquirer may also include any plans or drawings, which are necessary to explain the question; however, they should not contain proprietary names or information.

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SOCKET WRENCHES FOR SPARK PLUGS

1 SCOPE

This Standard provides dimensional, performance, and safety requirements for detachable hand use socket wrenches with square drive for spark plugs. Inclusion of dimensional data in this Standard is not intended to imply that all of the products described herein are stock production sizes. Consumers are requested to consult with manufacturers concerning list of stock production sizes.

2 CLASSIFICATION (see Fig. 1)

Figure 1 shows the different Types and Classes of socket wrenches for spark plugs.

Type I: Socket, single hexagon (6 point)

Class 1: Regular length

Class 2: Long length

Type II: Universal sockets, single hexagon (6 point)

Class 1: Square block

Class 2: Ball swivel

3 NORMATIVE REFERENCES

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

ASME B46.1-1995, Surface Texture (Surface Roughness, Waviness, and Lay)

ASME B107.4M-1995, Driving and Spindle Ends for Portable Hand Air and Electric Tools (Percussion Tools Excluded)

ASME B107.17M-1997, Gages, Wrench Opening, Reference

Publisher: American Society of Mechanical Engineers (ASME International), Three Park Avenue, New York, NY 10016; Order Department: 22 Law Drive, Box 2300, Fairfield, NJ 07007-2300

ASTM B 117-97, Standard Practice for Operating Salt Spray (Fog) Apparatus

ASTM B 537-70(1997) Standard Practice for Rating of Electroplated Panels Subjected to Atmospheric Exposure

ASTM B 571-97, Standard Test Methods for Qualitative Adhesion Testing of Metallic Materials

ASTM D 968-93, Standard Test Methods for Abrasion Resistance of Organic Coatings by Falling Abrasive

ASTM E 18-00, Standard Test Methods for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

Publisher: American Society for Testing and Materials (ASTM), 100 Barr Harbor Drive, West Conshohocken, PA 19428

Guide to Hand Tools-Selection, Safety Tips, Proper Use and Care

Publisher: Hand Tools Institute (HTI), 25 North Broadway, Tarrytown, NY 10591

4 REQUIREMENTS

4.1 Figures

The figures herein are descriptive and not restrictive, and are not intended to preclude the manufacture of sockets that are otherwise in accordance with this Standard.

4.2 Materials

The materials used in the manufacture of the sockets shall be such as to produce tools conforming to requirements specified in this Standard.

4.3 Marking

Sockets shall be marked in a plain and permanent manner with the manufacturer's name or with a trademark of such known character that the source of manufacture and country of origin may be readily determined. In addition, sockets shall be marked in a plain and permanent manner with the nominal size of the wrench opening (distance across flats).

4.4 Hardness

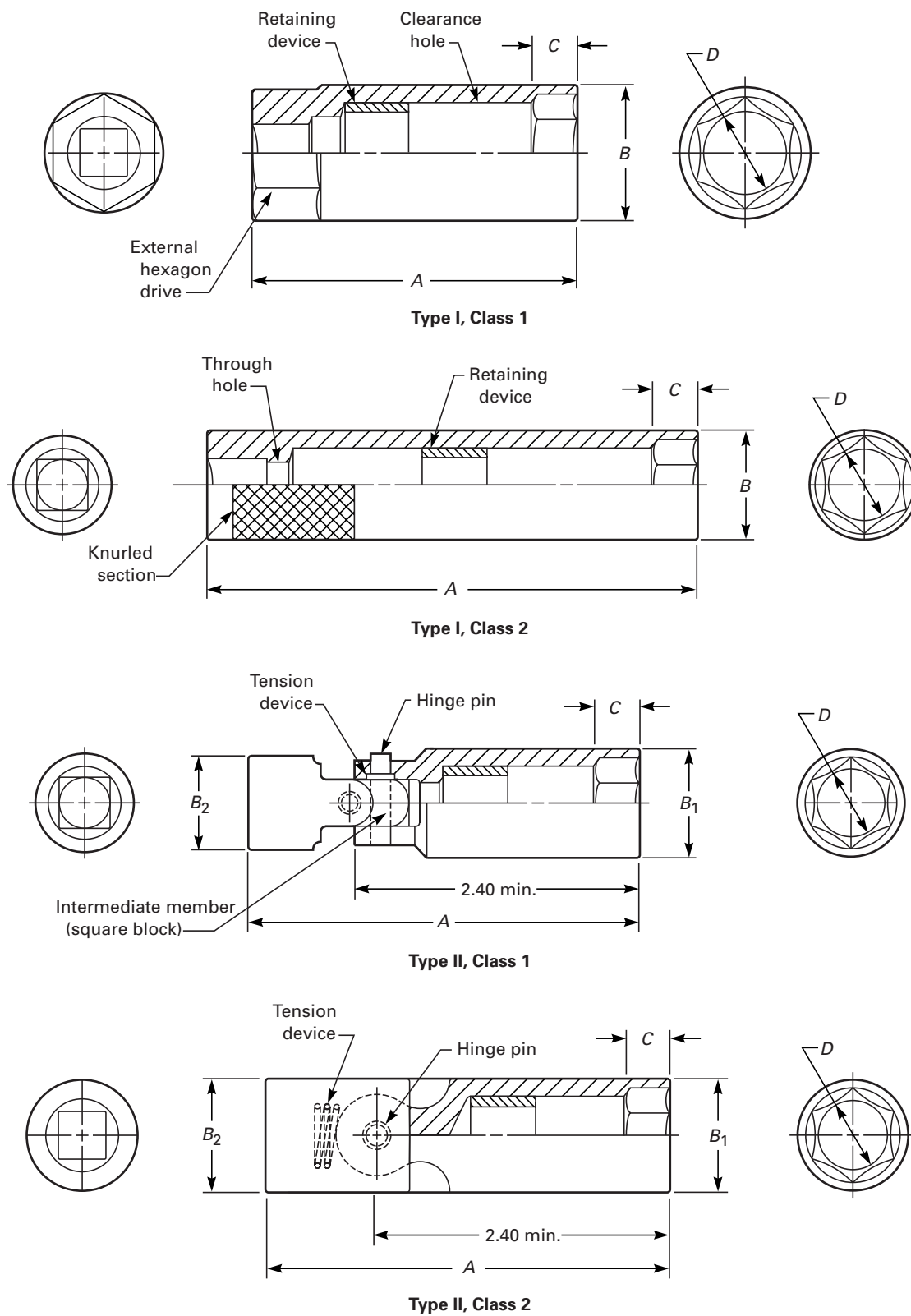
Sockets shall be heat treated to a hardness of 38 HRC to 54 HRC.

4.5 Proof Torque

When tested as specified, tools shall withstand the proof torque specified in the applicable tables without failure or permanent deformation (set), that might affect the durability or serviceability of the tools.

4.6 Finish

All external surfaces shall be free from uncoated areas, pits, blisters, nodules, forge flash, burrs, cracks, and any

**Fig. 1 Universal Socket**

other conditions which would interfere with their protective value and serviceability.

4.6.1 Surface Roughness. The external forge flash shall be removed to blend smoothly with adjacent surfaces. Maximum surface roughness values shall be determined by microinch (micrometer) values. Determination of microinch (micrometer) values shall be taken on a representative surface. Areas that are ground and buffed, or otherwise finished by an equivalent method, shall have a coating as specified in para. 4.6.2.1 or para. 4.6.2.3, and have a uniform bright finish with a maximum surface roughness in microinches (micrometer) when tested per para. 5.4. At least 50% of the outer longitudinal surface or major diameter shall be bright with 30 $\mu\text{in.}$ (0.76 μm) maximum. Except for the external hex drive, knurled or grooved areas, the remaining exterior longitudinal socket surface shall be 150 $\mu\text{in.}$ (3.81 μm) maximum. Oxide or phosphate coated sockets shall have a maximum surface roughness of 150 $\mu\text{in.}$ (3.81 μm).

4.6.2 Coatings. The sockets and assembly components excluding retaining devices shall be coated with one (or a combination) of the coatings in accordance with paras. 4.6.2.1, 4.6.2.2, or 4.6.2.3.

4.6.2.1 Nickel-Chromium Coating. The coating shall be a bright protective decorative nickel-chromium plating. Sockets shall pass the surface adhesion test as specified in the file, grind-saw, or heat quench test of ASTM B 571, the minimum thickness of the nickel or nickel-iron shall be 0.0002 in. (0.0051 mm), and the minimum thickness of the chromium shall be 0.000005 in. (0.00013 mm), unless sockets pass the Alternative Coating Test.

4.6.2.2 Oxide or Phosphate Coating. The coating shall consist of a chemically produced oxide or phosphate, followed with a coating of rust preventative.

4.6.2.3 Alternative Coatings. Alternative coatings may be used, in lieu of nickel-chromium plating, and shall be subjected to the Alternative Coating Test, as specified in para. 5.3.

4.7 Design

All socket designs shall provide the following features.

4.7.1 Wrench Opening. Wrench end opening shall be such as to ensure acceptance when measured with gages conforming to Table 3A in ASME B107.17M.

4.7.2 Clearance Hole. An area shall be provided for clearance of the insulator section of the spark plug. The diameter of the clearance hole shall be in accordance with that of the applicable size socket, as specified in the respective tables. The minimum depth of the clearance hole shall be of sufficient depth as to clear the insulator section of the spark plug size for which it is

intended. The diameter and depth of the clearance hole may be included in the wrench opening area, if size and depth of the wrench opening are adequate to provide the clearance. A through hole between the drive square and the clearance hole may be provided.

4.7.3 Retaining Device. A replaceable, oil resistant and heat resistant retaining bushing, or other equally suitable device, shall be installed inside the socket to prevent damaging the spark plug insulator, and for aligning the spark plug for easy installation and removal. This bushing should be pliable and compressible to reduce side loading to the spark plug insulator.

4.7.4 Drive End. The drive end may be reduced in diameter for marking purposes, and at the option of the manufacturer, an external hexagon drive and/or a knurled section may be provided on the drive end, in addition to the internal drive specified in para. 4.7.5. If an external hex is provided, it shall be capable of being driven by a wrench opening conforming to Table 1A or 2A in ASME B107.17M.

4.7.5 Internal Drive Opening. The opening dimensions shall conform to ASME B107.4M.

4.7.6 Countersink of Wrench Opening. The wrench opening shall be countersunk with an included angle of 85 to 155 deg and a minimum diameter equal to the across corners dimension of the opening.

4.7.7 Dimensions. Dimensions shall be in accordance with the applicable tables.

4.7.8 Type II, Class 1 Universal Sockets, Square Block, Single Hexagon (6 Point). Sockets shall consist of a single hexagon (6 point) socket and a square female socket, attached to an intermediate member in a manner so as to form a universal type of joint. The socket shall be provided with a tension device that will hold the socket end in any set position relative to the drive end against gravity. It shall be capable of rotation in a complete arc when the angular deviation of either end member from the common centerline is 20 deg minimum. The hinge pins shall not extend beyond the periphery of the universal joint section for more than 0.031 in. (0.79 mm). If the hinge pin extends beyond the periphery, it shall not interfere with the regular operation of the universal joint section. The portion of the hinge pin that extends beyond the periphery shall not have sharp edges. Sockets shall conform to Table 4 for the size and drive specified.

4.7.9 Type II, Class 2 Universal Sockets, Ball Swivel, Single Hexagon (6 Point). Sockets shall consist of a single hexagon (6 point) socket and a square female socket, attached in a manner so as to form a universal ball swivel type of joint. The sockets shall be provided with a tension device which will hold the socket end in any set position relative to the drive end against gravity. The tension device shall compensate for wear. The ball

Table 1 Type I, Class 1, Spark Plug Socket, Regular Length, Single Hexagon (Inch)

Nominal Opening, in.	Internal Drive Square, in.	Max. Overall Length, A, in.	Max. Outside Diameter, B, in.	Min. Depth of Opening Nut End, C, in.	Min. Diameter of Spark Plug Clearance Hole, D, in.	Min. Proof Torque, lbf-in.
$\frac{5}{8}$	$\frac{3}{8}$	3.000	0.890	0.188	0.469	1,500
$\frac{5}{8}$	$\frac{1}{2}$	3.000	0.890	0.188	0.469	1,500
$\frac{3}{4}$	$\frac{3}{8}$	3.000	1.067	0.218	0.525	1,700
$\frac{13}{16}$	$\frac{3}{8}$	3.000	1.080	0.218	0.680	1,800
$\frac{13}{16}$	$\frac{1}{2}$	3.000	1.080	0.218	0.735	1,800
$\frac{7}{8}$	$\frac{1}{2}$	3.650	1.218	0.250	0.813	1,900

Table 2 Type I, Class 1, Spark Plug Socket, Regular Length, Single Hexagon (Metric)

Nominal Opening, mm	Internal Drive Square, mm	Max. Overall Length, A, mm	Max. Outside Diameter, B, mm	Min. Depth of Opening Nut End, C, mm	Min. Diameter of Spark Plug Clearance Hole, D, mm	Min. Proof Torque, Nm
18.0	10.0	76.0	25.8	5.1	13.0	192
20.8	10.0	76.0	27.5	5.5	19.0	203

Table 3 Type I, Class 2, Spark Plug Socket, Long Length, Single Hexagon (Inch)

Nominal Opening, in.	Internal Drive Square, in.	Min. Overall Length, A, in.	Max. Outside Diameter, B, in.	Min. Depth of Opening Nut End, C, in.	Min. Diameter of Spark Plug Clearance Hole, D, in.	Min. Proof Torque, lbf-in.
$\frac{5}{8}$	$\frac{3}{8}$	3.800	0.890	0.188	0.469	1,500
$\frac{13}{16}$	$\frac{3}{8}$	5.750	1.080	0.218	0.680	1,800

Table 4 Type II, Class 1, Universal Spark Plug Socket, Square Block, Single Hexagon ($\frac{3}{8}$ in. Drive, Inch)

Nominal Opening, in.	Min. Socket Length, A, in.	Max. Outside Diameter of Nut End, B ₁ , in.	Max. Outside Diameter of Drive End, B ₂ , in.	Min. Depth of Opening Nut End, C, in.	Min. Diameter of Spark Plug Clearance Hole, D, in.	Min. Proof Torque, lbf-in.
$\frac{5}{8}$	2.400	0.890	0.885	0.188	0.469	1,000
$\frac{13}{16}$	2.400	1.080	0.885	0.218	0.735	1,000

swivel type joint shall be capable of rotation in a complete arc when the angular deviation of one member from a common centerline is 20 deg minimum and 35 deg maximum. Sockets shall conform to Table 5 for the size and drive specified.

5 TEST PROCEDURES

Many tests required herein are inherently hazardous and adequate safe guards for personnel and property shall be employed in conducting such tests.

5.1 Hardness

Hardness shall be tested in accordance with ASTM E 18. When surface preparation is necessary, the amount of material removed in the area contacted by the indenter shall not exceed 0.007 in. (0.178 mm).

5.2 Proof Torque Test

5.2.1 Mandrels for Wrench Openings. Sockets shall be tested on mandrels. The size of all wrench openings mandrels shall conform to Table 6. Mandrels shall be

**Table 5 Type II, Class 2,
Universal Spark Plug Socket, Ball Swivel, Single Hexagon ($\frac{3}{8}$ in. Drive, Inch)**

Nominal Opening, in.	Min. Overall Length, A, in.	Max. Outside Diameter of Nut End, B ₁ , in.	Max. Outside Diameter of Drive End, B ₂ , in.	Min. Depth of Opening Nut End, C, in.	Min. Diameter of Spark Plug Clearance Hole, D, in.	Min. Proof Torque, lbf-in.
$\frac{5}{8}$	3.400	0.890	1.000	0.188	0.469	1,500
$\frac{13}{16}$	3.400	1.080	1.000	0.218	0.735	1,800

Table 6 Hexagon Mandrel Dimensions and Maximum Depth of Mandrel Insertion

Nominal Size of Wrench Opening	Hexagon Mandrel Dimensions			Depth of Mandrel Insertion, Max.
	Across Flats Tolerance		Across Corners, Min.	
	U.S. Customary Units (in.)			
$\frac{5}{8}$	+0.001	−0.003	0.7055	0.188
$\frac{3}{4}$	+0.001	−0.003	0.8485	0.218
$\frac{13}{16}$	+0.001	−0.003	0.9201	0.218
$\frac{7}{8}$	+0.001	−0.003	0.9917	0.250
SI Units (mm)				
18.0	+0.025	−0.076	20.35	5.50
20.8	+0.025	−0.076	23.78	5.50

hardened not less than 55 HRC and shall be smoothly finished. A mandrel of suitable strength and complying with the dimensional requirements of the drive tang specified in ASME B107.4M shall be employed.

5.2.2 Application of Proof Torque. Torque shall be applied with a suitable torque producing machine. Wrench openings shall be gaged prior to testing. Means may be provided at the outer end of the drive end mandrel to prevent slippage of the socket end wise from the mandrel and to keep the socket assembly in the axis about which the proof torque is applied. Socket shall be subjected to the proof torque using *maximum* mandrel depth specified in Table 6. Following the removal of the proof torque, they shall be regaged. Any socket which cracks, fractures or does not gage shall be considered to have failed the test.

5.3 Alternative Coating Test

This test consists of an adhesion, abrasion, and corrosion test specified in paras. 5.3.2, 5.3.3, and 5.3.4.

5.3.1 Test Preparation. The quantity and condition of the sockets used for the following testing shall be per the manufacturer's standard practice or as mutually agreed to by the manufacturer and the customer.

5.3.2 Adhesion Test. Sockets shall pass the file or grind-saw test of ASTM B 571.

5.3.3 Abrasion Test. Sockets shall have no base material exposed after being subjected to 100 L of falling sand per ASTM D 968 Method A.

5.3.4 Corrosion Test. Sockets shall be tested for corrosion resistance by exposure to a 48 hr salt spray test as specified in ASTM B 117, without falling below the ASTM B 537 rating of 6.

5.4 Surface Roughness Test

Measurement shall be made according to ASME B46.1 with a surface measuring instrument using a 0.03 in. cutoff. Surface roughness values shall be rated as the arithmetical average.

6 SAFETY REQUIREMENTS AND LIMITATIONS OF USE

Instructors and employers shall stress proper use and safety in the use of socket wrenches, information about which can be found in the HTI publication, Guide to Hand Tools-Selection, Safety Tips, Proper Use and Care.

7 DESIGNATIONS

Spark plug sockets shall be designated by the following data in the sequence shown:

- Type
- Class
- Drive size
- Wrench opening size and configuration
- Finish or coating

EXAMPLE: Spark plug socket, Type I, Class 1, $\frac{3}{8}$ in. drive size, $\frac{5}{8}$ in. opening, single hexagon, black oxide.

AMERICAN NATIONAL STANDARDS FOR HAND TOOLS

Socket Wrenches, Hand (Inch Series)	B107.1-2002
Socket Wrenches, Extensions, Adaptors, and Universal Joints, Power Drive (Impact) (Inch Series).	B107.2-2002
Driving and Spindle Ends for Portable Hand, Impact, Air, and Electric Tools (Percussion Tools Excluded).	B107.4M-1995
Socket Wrenches, Hand (Metric Series)	B107.5M-2002
Adjustable Wrenches.	B107.8-2003
Handles and Attachments for Hand Socket Wrenches — Inch and Metric Series.	B107.10M-1996
Pliers: Diagonal Cutting and End Cutting.	B107.11-2002
Nutdrivers (Spin Type, Screwdriver Grip) (Inch Series)	B107.12-2004
Pliers: Long Nose, Long Reach	B107.13-2003
Hand Torque Tools.	B107.14M-1994
Flat Tip Screwdrivers	B107.15-2002
Shears (Metal Cutting, Hand)	B107.16M-1998 (R2004)
Gages, Wrench Openings, Reference	B107.17M-1997
Pliers: Wire Twister	B107.18-2003
Pliers, Retaining Ring	B107.19-2004
Pliers (Lineman's, Iron Worker's, Gas, Glass, Fence, and Battery)	B107.20M-1998
Wrench, Crowfoot Attachments.	B107.21-1998
Electronic Cutters.	B107.22M-1998
Pliers, Multiple Position, Adjustable	B107.23M-1997
Locking Pliers.	B107.24-2002
Pliers: Performance Test Methods	B107.25-2002
Pliers: Multiple Position, Electrical Connector.	B107.27-2003
Electronic Torque Instruments	B107.28M-1997
Electronic Tester, Hand Torque Tools	B107.29M-1998
Cross Tip Screwdrivers	B107.30-2002
Screwdrivers, Cross Tip Gaging.	B107.31M-1997
Socket Wrenches, Impact (Metric Series).	B107.33M-2002
Socket Wrenches for Spark Plugs.	B107.34-2003
Nut Drivers (Spin Type, Screwdriver Grip) (Metric Series).	B107.35M-1997
Pliers: Locking, Clamp, and Tubing Pinch-Off	B107.36-2002
Pliers: Wire Cutters/Strippers	B107.37-2003
Electronic Pliers.	B107.38M-1998
Nail Hammers: Safety Requirements	B107.41-2004
Hatchets: Safety Requirements.	B107.42M-1997 (R2004)
Wood-Splitting Wedges	B107.43-2002
Glaziers' Chisels and Wood Chisels	B107.44-2002
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Stud, Screw, and Pipe Extractors: Safety Requirements.	B107.46-2004
Metal Chisels: Safety Requirements.	B107.47M-1998
Metal Punches and Drift Pins: Safety Requirements.	B107.48M-1998
Nail Sets: Safety Requirements	B107.49M-1998
Brick Chisels and Brick Sets: Safety Requirements.	B107.50M-1998
Star Drills: Safety Requirements.	B107.51-2001
Nail-Puller Bars: Safety Requirements	B107.52M-1998
Ball Peen Hammers: Safety Requirements.	B107.53-2004
Heavy Striking Tools: Safety Requirements	B107.54-2001
Axes: Safety Requirements	B107.55M-2002
Body Repair Hammers and Dolly Blocks: Safety Requirements.	B107.56-1999
Bricklayers' Hammers and Prospecting Picks: Safety Requirements	B107.57-2001
Riveting, Scaling, and Tinner's Setting Hammers: Safety Requirements	B107.58M-1998
Slugging and Striking Wrenches.	B107.59-2002
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