INTERNATIONAL STANDARD

ISO 10145-2

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End mills with brazed helical hardmetal tips —

Part 2:
Dimensions of end mills with 7/24 taper shank

Fraises cylindriques deux tailles à plaquettes hélicoïdales en métaux-durs, brasées —

Partie 2: Dimensions des fraises à queue cône 7/24

Reference number
ISO 10145-2:1993(E)

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.

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.

International Standard ISO 10145-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Sub-Committee SC 9, *Tools with cutting edges made of hard cutting materials*.

ISO 10145 consists of the following parts, under the general title *End mills with brazed helical hardmetal tips*:

— *Part 1: Dimensions of end mills with parallel shank*

— *Part 2: Dimensions of end mills with 7/24 taper shank*

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End mills with brazed helical hardmetal tips —

Part 2:
Dimensions of end mills with 7/24 taper shank

1 Scope

This part of ISO 10145 specifies the general dimensions of end mills with brazed helical hardmetal tips, with 7/24 taper shank.

Two types of end mills with 7/24 taper shank are specified:

— end mills with 7/24 taper shank for manual changing, in accordance with ISO 297;

— end mills with 7/24 taper shank for automatic tool changers, in accordance with ISO 7388-1.

This part of ISO 10145 applies to right-hand and left-hand end mills, irrespective of helix angle and number of flutes.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 10145. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 10145 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

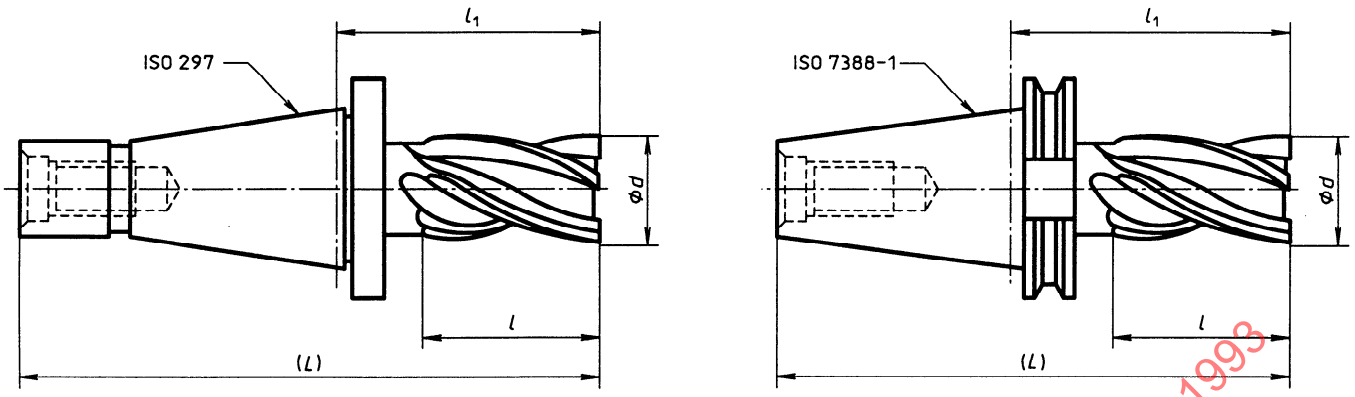
ISO 297:1988, *7/24 tapers for tool shanks for manual changing.*

ISO 7388-1:1983, *Tool shanks with 7/24 taper for automatic tool changers — Part 1: Shanks Nos. 40, 45 and 50 — Dimensions.*

ISO 7388-1:1983/Add.1:1984, *Addendum 1: Conicity tolerances.*

3 Dimensions

The dimensions for endmills as shown in figure 1 are specified in table 1.



Type 1: With 7/24 taper shank for manual changing

Type 2: With 7/24 taper shank for automatic tool changers

Figure 1

Table 1

Dimensions in millimetres

d k12	l +3 0	Type 1 taper No. 40 l_1 +3 0	Type 1 taper No. 40 L	Type 1 taper No. 50 l_1 +3 0	Type 1 taper No. 50 L	Type 2 taper No. 40 l_1 +3 0	Type 2 taper No. 40 L	Type 2 taper No. 50 l_1 +3 0	Type 2 taper No. 50 L
32	40	84	177,4	—	—	91	159,4	—	—
	50	94	187,4	—	—	101	169,4	—	—
40	50	94	187,4	103	229,8	101	169,4	107	208,75
	63	107	200,4	116	242,8	114	182,4	120	221,75
50	50	94	187,4	103	229,8	101	169,4	107	208,75
	80	124	217,4	133	259,8	131	199,4	137	238,75
63	63	—	—	116	242,8	—	—	120	221,75
	100	—	—	153	279,8	—	—	157	258,75

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