



Machine tools — Lathe tool posts — Overall internal height

Machines-outils — Supports d'outils pour tours — Encombrement intérieur en hauteur

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 213 was developed by Technical Committee ISO/TC 39, *Machine tools*.

It was submitted directly to the ISO Council, in accordance with clause 6.11.2 of part 1 of the Directives for the technical work of ISO. It cancels and replaces ISO Recommendation R 213-1961, which had been approved by the member bodies of the following countries :

Belgium	Germany, F. R.	Romania
Brazil	Hungary	Sweden
Bulgaria	India	Switzerland
Czechoslovakia	Italy	United Kingdom
Denmark	Netherlands	USA
Finland	Pakistan	USSR
France	Poland	

No member body had expressed disapproval of the document.

Machine tools — Lathe tool posts — Overall internal height

1 Scope and field of application

This International Standard lays down overall internal heights of lathe tool posts, from the horizontal level of the lathe axis.

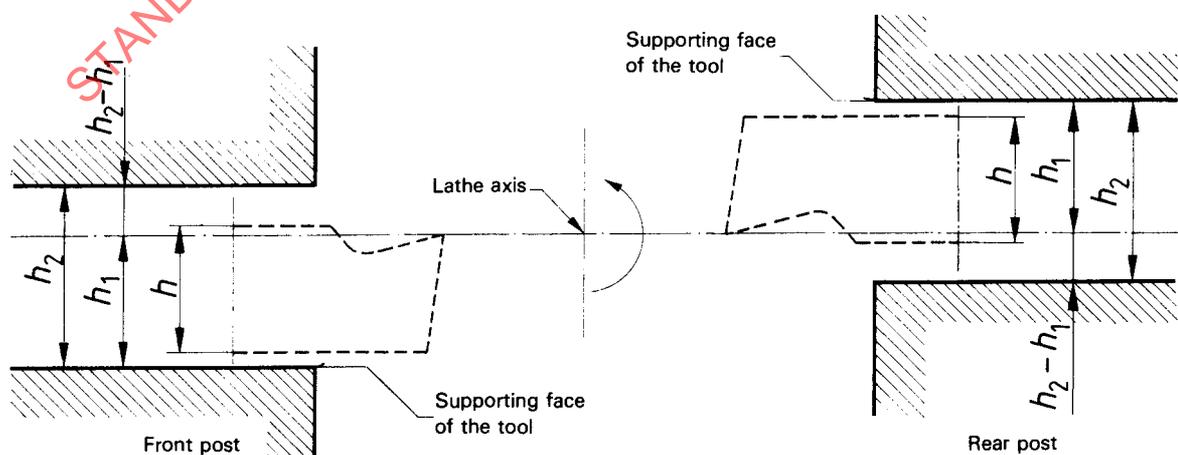
2 Sizes

2.1 The overall internal heights are fixed, from the horizontal level of the lathe axis, in terms of height h of the strongest standardized tool suitable for the full power of the lathe.

2.2 These sizes are given in millimetres, and in inches for countries using the imperial system of units, and were determined so as to ensure complete interchangeability of posts and tools.

In order to fulfil this condition, height h_1 (distance in height from supporting face of the tool in relation to the horizontal level of the lathe axis) was taken slightly greater than height h of the tool, that is, approximately $1,1 h$.

The overall internal height h_2 was taken greater than height h_1 by about $0,5 h$, so as to leave a sufficient margin for using the tool after a certain number of resharpenings had reduced the height of the edge above the base of this tool.



Figure