
INTERNATIONAL STANDARD



2940/II

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Milling cutters mounted on centring arbors having a 7/24 taper — Inserted tooth cutters

Fraises à surfacer et à surfacer et dresser, à montage direct sur nez de broches à conicité 7/24 — Fraises à lames amovibles

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Descriptors : tools, milling cutters, dimensions, interchangeability.

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 2940/II was drawn up by Technical Committee ISO/TC 29, *Small tools*, and circulated to the Member Bodies in October 1972.

It has been approved by the Member Bodies of the following countries :

Belgium	India	Switzerland
Czechoslovakia	Israel	Thailand
Egypt, Arab Rep. of	Italy	Turkey
France	Poland	U.S.A.
Germany	Romania	U.S.S.R.
Hungary	South Africa, Rep. of	

The Member Bodies of the following countries expressed disapproval of the document on technical grounds :

Austria
Japan
Sweden
United Kingdom

Milling cutters mounted on centring arbors having a 7/24 taper — Inserted tooth cutters

1 SCOPE AND FIELD OF APPLICATION

This International Standard applies to inserted tooth cutters mounted on centring arbors having a 7/24 taper. These cutters are equipped either with high speed steel inserted teeth or with inserted teeth with brazed carbide tips.

It concerns

- firstly, the so-called "single purpose mounting" milling cutter, arbor located, to be used with a well-defined spindle nose having a 7/24 taper;
- secondly, the so-called "dual purpose mounting" milling cutter, arbor located, to be used with both spindle nose No. 50 and spindle nose No. 60 having a 7/24 taper.

Cutter bodies for single purpose mounting, having outside diameters of cutter bodies or nominal cutting diameters, D , from 160 to 630 mm, are intended to equip spindle noses Nos. 40 — 45 — 50 — 55 or 60 having a 7/24 taper; those for dual purpose mounting, having diameter D between 315 and 630 mm, are intended to equip either No. 50 or No. 60 spindle noses having a 7/24 taper.

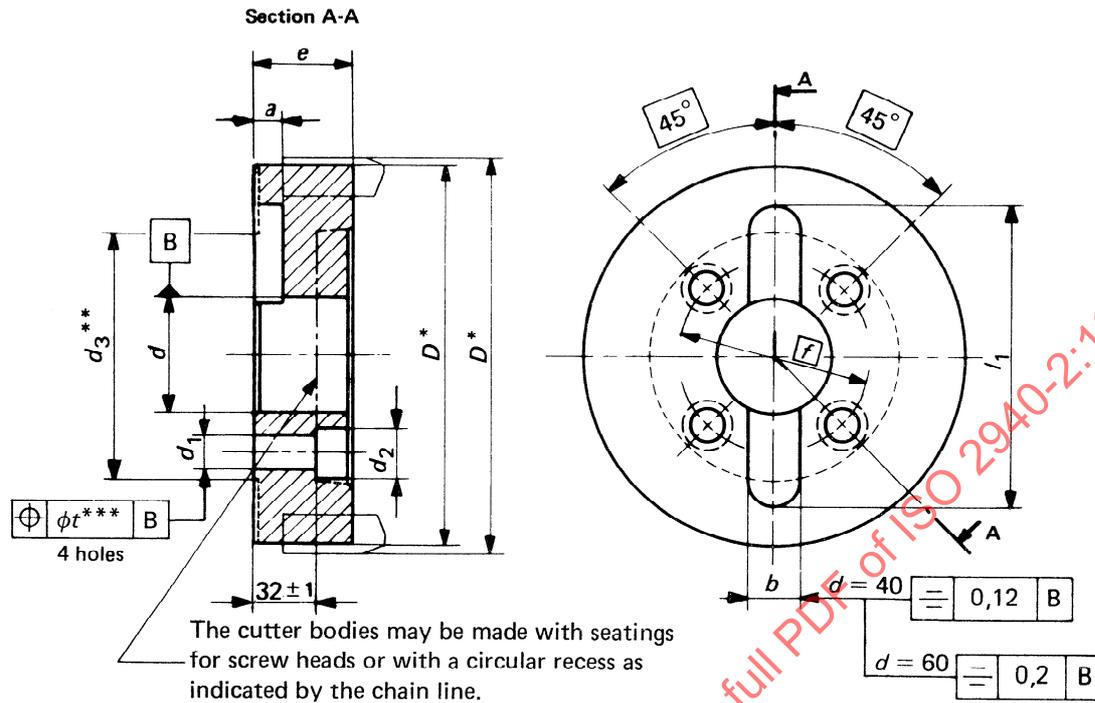
Dimensions for centring arbors and fitting dimensions for fixation are given in ISO 2940/I.

2 REFERENCES

ISO/R 1101, *Technical drawings — Tolerances of form and of position — Part 1: Generalities, symbols, indications on drawings.*

ISO 2940/I, *Milling cutters mounted on centring arbors having a 7/24 taper — Fitting dimensions — Centring arbors.*

3 SINGLE PURPOSE MOUNTING CUTTERS



Dimensions in millimetres

Nominal diameter D^*	d H7	e min.	f	d_1	t^{***}	d_2	b H12	a $+0,5$ 0	l_1 min.	d_3^{**}	For spindle 7/24 No.
160	40	46	66,7	14	0,3	20	16,1	9	105	90	40
200											
200											
250	40	46	80,0	14	0,3	20	19,3	11	123	105	45
315											
400											
200	60	52	101,6	18	0,4	26	25,7	14	155	130	50
250											
315 ¹⁾											
400 ¹⁾											
500 ¹⁾	60	60	120,6	22	0,4	34	25,7	14	180	155	55
250											
315											
400											
500											
630	60	60	177,8	22	0,4	34	25,7	14	245	225	60
315 ¹⁾											
400 ¹⁾											
500 ¹⁾											
630											

* In accordance with the manufacturer's practice, the nominal diameter D may be either the outside diameter of the cutter body or the nominal cutting diameter.

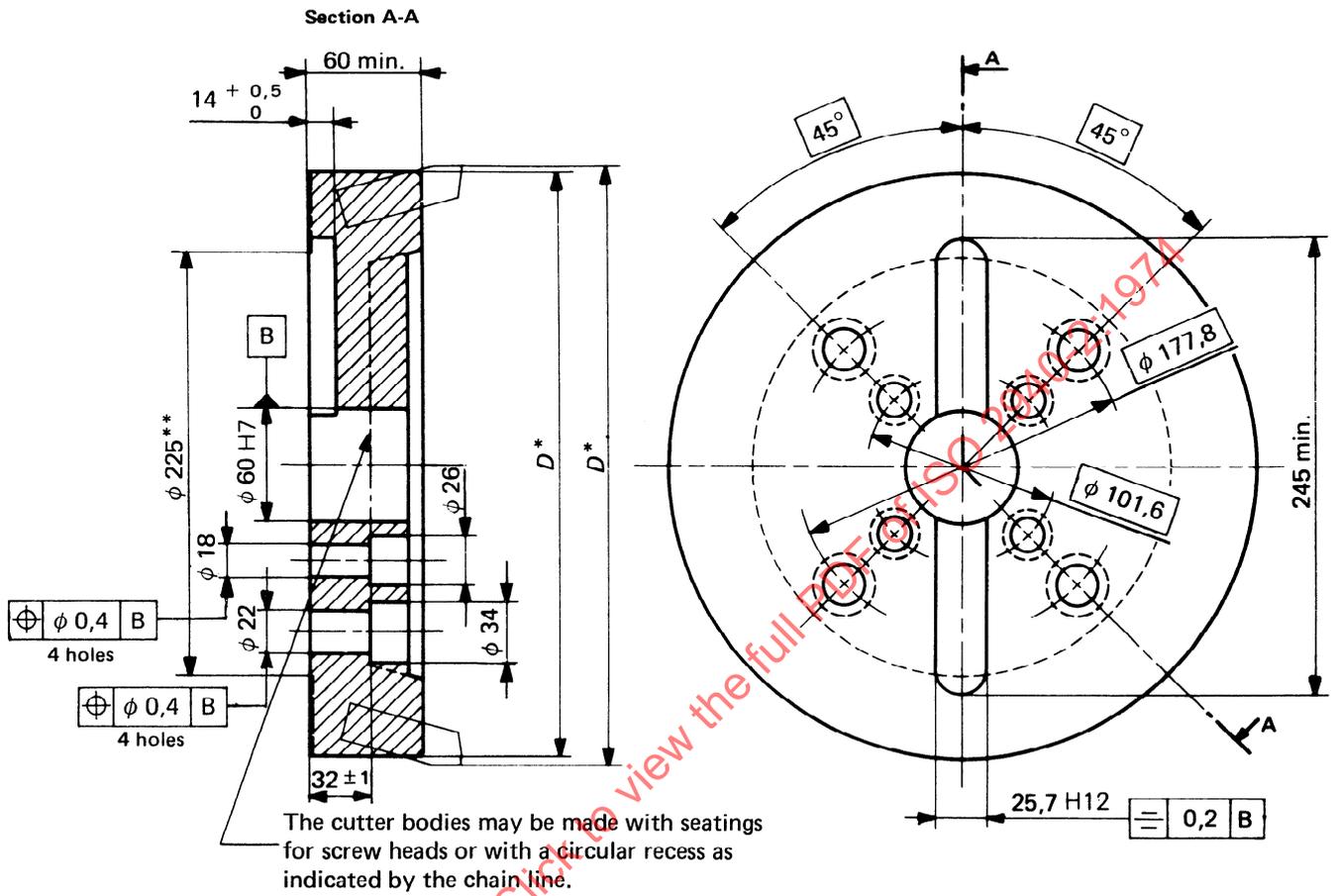
** Relief with diameter d_3 on the back face of the cutter body is optional.

*** The dimension t represents the positional tolerance of the axis of the holes of diameter d_1 . Each of the axes of the four holes should be contained within a cylindrical zone of diameter t the axes of which are in the true specified position (see ISO/R 1101).

1) For these cutter diameters, use preferably dual purpose mounting cutters.

4 DUAL PURPOSE MOUNTING CUTTERS

Diameters $D = 315, 400$ and 500 mm, mounted on 7/24 spindle noses Nos. 50 or 60.



* In accordance with the manufacturer's practice, the nominal diameter D may be either the outside diameter of the cutter body or the nominal cutting diameter.

** Relief with diameter 225 mm on the back face of the cutter body is optional.

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