INTERNATIONAL STANDARD ISO 4203

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

Parallel shank tools — Driving tenons and sockets — Dimensions

Outils à queue cylindrique — Tenons d'entraînement et douilles extensibles — Dimensions

First edition — 1978-04-01

UDC 621.9.06-229.2 **Ref. No. ISO 4203-1978 (E)**

Descriptors : tools, power-operated tools, drills, reamers, parallel shanks, tenon driving, tenons, chuck bushings, specifications, dimensions, dimensional tolerances.

Price based on 2 pages

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 4203 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in March 1976.

It has been approved by the member bodies of the following countries :

Australia	Italy	Spain
Austria	Japan	Turkey
Belgium	Mexico	United Kingdom
Brazil	Netherlands	U.S.A.
Bulgaria	Philippines	U.S.S.R.
Czechoslovakia	Poland	Yugoslavia
Hungary	Romania	
Israel	South Africa, Rep. of	

The member bodies of the following countries expressed disapproval of the document on technical grounds :

France
Germany
India
Switzerland

Printed in Switzerland

Parallel shank tools — Driving tenons and sockets — Dimensions

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions and tolerances of driving tenons and sockets for parallel shank drills and machine reamers.

The illustrations are diagrammatic only and are not intended to indicate details of design.

2 REFERENCE

ISO 296, *Machine tools — Self-holding tapers for tool shanks.*

3 DIMENSIONS

3.1 The dimensions for the driving tenons of parallel shank tools are given in table 1.

3.2 The dimensions for the sockets for parallel shank tools with driving tenons are given in table 2. The external dimensions of the sockets shall be in accordance with ISO 296 with the exception of the overall length and distance from the gauge plane, which shall be as shown in table 2.

The dimensions shown in tables 1 and 2 are in metric units only, these being regarded as the only recommended dimensions in the future.

4 TOLERANCE

The tolerance relating to width t of driving tenons for parallel shank tools is h12.

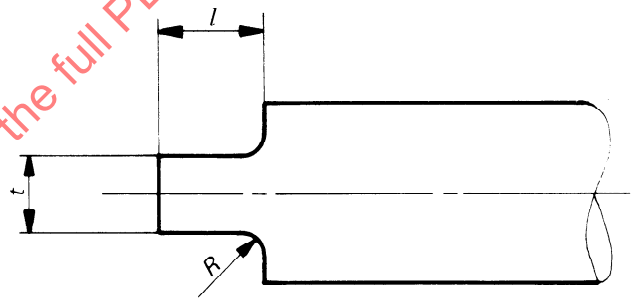

FIGURE 1

TABLE 1 — **Dimensions of driving tenons for parallel shank tools**

Values in millimetres

Shank diameter range		t		l	R
above	up to	dimension	tolerance (h12)		max.
3,00	3,75	2,12	0 −0,10	6,0	0,2
3,75	4,75	2,65		7,0	
4,75	6,00	3,35	0 −0,12	8,0	
6,00	7,50	4,25		9,0	0,3
7,50	9,50	5,30		10,0	
9,50	11,80	6,70	0 −0,15	11,5	0,4
11,80	15,00	8,50		13,0	
15,00	19,00	10,60	0 −0,18	15,0	
19,00	23,60	13,20		17,0	0,5
23,60	30,00	17,00		20,0	