
**Collets with 8° setting angle for tool
shanks — Collets, nuts and fitting
dimensions**

*Pinces de serrage avec angle de réglage de 8° pour queues d'outil —
Pinces, écrous de serrage et dimensions d'assemblage*



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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.

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The main task of technical committees is to prepare International Standards. 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.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 15488 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 15488:1996), which has been technically revised. In particular, in Table 3, the values of d_{10} for nominal dimensions 25 mm and 32 mm as well, as the values of l_{10} for nominal values 25 mm, 32 mm and 40 mm, have been modified. Figure 5 has been modified for the sake of clarity.

Collets with 8° setting angle for tool shanks — Collets, nuts and fitting dimensions

1 Scope

This International Standard specifies the dimensions, materials and manufacturing requirements, and designation of collets (of form A or of form B) for tools with cylindrical shanks and their corresponding holders and nuts. For non-standardized clamping devices, such as clamping devices specified in drawings, these holders can be agreed upon between customer and supplier.

Form A applies to milling and any other application where a hard collet bore is required, provided that the clamping range of h10 be sufficient.

Form B applies for general purposes where an extended clamping range is required.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2768-1:1989, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

3 Dimensions

3.1 General

Collets, holders and nuts need not correspond to Figures 1 to 3; only the given dimensions shall be complied with.

General tolerances: ISO 2768-m