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**Reduction sleeves with 7/24 external and  
Morse internal taper and incorporated  
screw**

*Douilles de réduction aux cônes extérieur 7/24 et intérieur Morse, avec  
vis incorporée*



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## Foreword

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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 5415 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 2, *High speed steel cutting tools and their attachments*.

This second edition cancels and replaces the first edition (ISO 5415:1977), which has been technically revised.

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# Reduction sleeves with 7/24 external and Morse internal taper and incorporated screw

## 1 Scope

This International Standard specifies the dimensions of reduction sleeves with 7/24 external taper No. 30-40-45-50 and 60 and Morse internal taper No. 1 to 6 (Morse taper No. 4, 5 and 6 being either with positive drive, see Figure 2 or without positive drive, see Figure 1).

These sleeves permit driving of tools with Morse taper shanks with tapped holes with the aid of an internal screw. The form of this screw and its fixation in the sleeve are left to the manufacturer's discretion.

7/24 tapers are in accordance with ISO 297. Morse tapers are in accordance with ISO 296 and ISO 5413.

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

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

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

ISO 5413, *Machine tools — Positive drive of Morse tapers*

## 3 Dimensions

### 3.1 General

All dimensions and tolerances are given in millimetres. Tolerances not specified shall be of tolerance class “m” in accordance with ISO 2768-1:1989.

### 3.2 Reduction sleeves with 7/24 external taper shank type A and Morse internal taper No. 1 to 6

The dimensions of reduction sleeves with 7/24 external and Morse internal taper of type A are shown in Figure 1 and given in Table 1.