
**Tool shanks with 7/24 taper for automatic
tool changers —**

**Part 2:
Dimensions and designation of shanks of
forms J, JD and JF**

*Queues d'outils à conicité 7/24 pour changement automatique
d'outils —*

Partie 2: Dimensions et désignation des queues de formes J, JD et JF



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Foreword

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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 7388-2 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 7388-2:1984), which has been technically revised.

ISO 7388 consists of the following parts, under the general title *Tool shanks with 7/24 taper for automatic tool changers*:

- Part 1: Dimensions and designation of shanks of forms A, AD, AF, U, UD and UF
- Part 2: Dimensions and designation of shanks of forms J, JD and JF
- Part 3: Retention knobs for shanks of forms AC, AD, AF, J, UD, UF, JD and JF

Introduction

The aim of ISO 7388 is to integrate existing standards which are most commonly used as an industrial standard. In addition, the different developments for cooling and data chip have been taken into account.

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Tool shanks with 7/24 taper for automatic tool changers —

Part 2:

Dimensions and designation of shanks of forms J, JD and JF

1 Scope

This part of ISO 7388 specifies the dimensions of tool shanks with a 7/24 taper of shank form J (with two possible additions for each) for automatic tool changers used on machines having an automatic gripping system for feeding tools from the magazine to the spindle and vice-versa. These tools are designed with the most important dimensions for use in spindle noses according to ISO 9270.

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

ISO 2768-2, *General tolerances — Part 2: Geometrical tolerances for features without individual tolerance indications*

ISO 8015, *Technical drawings — Fundamental tolerancing principle*

3 Dimensions

3.1 General

All dimensions and tolerances are given in millimetres; tolerancing is according to ISO 8015. Tolerances not specified shall be of tolerance class “m” in accordance with ISO 2768-1 and of class “k” in accordance with ISO 2768-2.

3.2 Shank form J

See Figure 1 and Table 1.