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Machine tools — Self-holding tapers for tool shanks

Machines-outils — Cônes pour emmanchements d'outils à faible conicité



Reference number
ISO 296:1991(E)

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.

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.

International Standard ISO 296 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

This second edition cancels and replaces the first edition (ISO 296:1974), of which it constitutes a technical revision.

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International Organization for Standardization

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Machine tools — Self-holding tapers for tool shanks

1 Scope

This International Standard specifies the dimensions of self-holding tapers for tool shanks with a small taper of about 4 % to 5 %, classified, according to their use, into the three following categories:

- a) tapers for general use;
- b) smaller tapers;
- c) larger tapers.

For the first category, tapers recommended by ISO are Nos. 1 to 6 Morse tapers. Their standard sizes in millimetres are given in table 2, and the corresponding sizes in inches are given in table 3.

For smaller and larger tapers, those recommended by ISO are, on the one hand, Nos. 4 and 6 metric 5 % tapers and No. 0 Morse taper, and on the other hand, Nos. 80 to 200 metric 5 % tapers, the sizes of which, in millimetres only, are given in table 2. However, it was agreed to include in parallel, in the category of small tapers, Nos. 1 to 3 Brown & Sharpe tapers, the sizes of which, in inches only, are given in table 3.

Consequently, as shown in table 1, the self-holding tapers dealt with in this International Standard include

- a) for general use, only Nos. 1 to 6 Morse tapers;
- b) for sizes below No. 1 Morse taper, two solutions, i.e. either Nos. 4 and 6 metric tapers and No. 0 Morse taper (without corresponding tapers in inches in table 3) or, alternatively, Nos. 1 to 3 Brown & Sharpe tapers (without corresponding tapers in millimetres in table 2);
- c) for sizes above No. 6 Morse taper, only Nos. 80 to 200 metric tapers (without corresponding tapers in inches in table 3).

Table 1 — Tapers

Designation	Sizes in millimetres	Sizes in inches
Small tapers	Nos. 4 and 6 metric and No. 0 Morse	Nos. 1 to 3 Brown & Sharpe
Tapers for general use	Nos. 1 to 6 Morse ¹⁾	
Large tapers	Nos. 80 to 200 metric	—
1) Except for threads, Nos. 1 to 6 Morse tapers, manufactured either to metric values or to inch values, are strictly interchangeable, though not absolutely identical.		

This International Standard provides, for those elements which are threaded, two entirely distinct types of product according to the type of thread, **M** or **UNC**.

In order to distinguish between those two types, it is important that the element itself be marked with the corresponding thread symbol and the type of taper symbol, as shown in the figures in clause 4.

Lastly, this International Standard specifies the dimensions of grooves and holes necessary for the design of tapers for applications where coolant supply is required.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below.

Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 1947:1973, *System of cone tolerances for conical workpieces from $C = 1:3$ to $1:500$ and lengths from 6 to 630 mm.*

3 Conicity tolerances

The cone angle tolerances shall be those given in ISO 1947 for quality AT5, and shall be positive on the external taper and negative on the internal taper.

For special applications, other cone angle tolerances in accordance with ISO 1947 may be chosen.

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