
INTERNATIONAL STANDARD**3936**

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

Reduction sleeves with tenon drive with external and internal 7/24 taper — Dimensions

Douilles de réduction à entraînement par tenons aux cônes extérieur et intérieur 7/24 — Dimensions

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Price based on 1 page

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 3936-1977, the second edition of this International Standard, has been drawn up by Technical Committee ISO/TC 29, *Small tools*, and contains the modifications which were circulated, in the form of an addendum, to the member bodies in September 1976.

This addendum has been approved by the member bodies of the following countries :

Australia	Hungary	South Africa, Rep. of
Austria	Israel	Spain
Belgium	India	Sweden
Brazil	Italy	Switzerland
Czechoslovakia	Korea, Rep. of	United Kingdom
France	Mexico	Yugoslavia
Germany	Romania	

The member body of the following country expressed disapproval of the document on technical grounds :

Poland

This second edition cancels and replaces the first edition (i.e. ISO 3936-1976), which had been approved by the member bodies of the following countries :

Australia	India	South Africa, Rep. of
Austria	Israel	Spain
Belgium	Italy	Switzerland
Bulgaria	Japan	Turkey
France	Korea, Rep. of	United Kingdom
Germany	Mexico	U.S.S.R.
Hungary	Romania	Yugoslavia

The member body of the following country had expressed disapproval of the document on technical grounds :

Poland

Reduction sleeves with tenon drive with external and internal 7/24 taper – Dimensions

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of reduction sleeves with tenon drive with external 7/24 taper Nos. 40, 45, 50 and 60 and internal 7/24 taper Nos. 30, 40, 45 and 50.

7/24 tapers are in accordance with ISO 297 and ISO 2583.

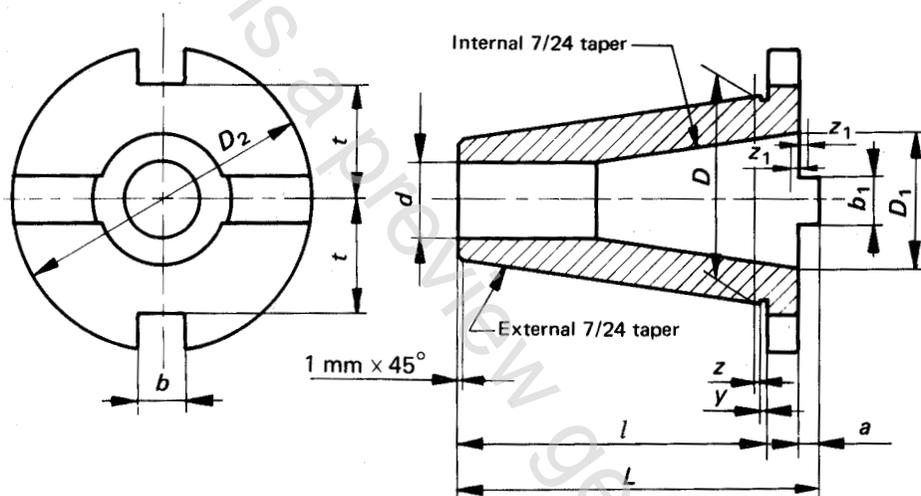
2 REFERENCES

ISO 297, 7/24 tapers for tool shanks.¹⁾

ISO 2583, Tool shanks and equipment with 7/24 tapers – Collar dimensions.

3 DIMENSIONS

See figure and table below.



Dimensions in millimetres

7/24 taper No.		External taper								Internal taper				
Ext.	Int.	D	D ₂	L max.	l max.	y	z ²⁾	b H12	t max.	D ₁	d H12	b ₁ h9	a max.	z ₁ ³⁾
40	30	44,450	63	85,0	67	1,6	± 0,4	16,1	22,5	31,750	17,4	15,9	8,0	± 0,4
45	30	57,150	80	104,0	86	3,2	± 0,4	19,3	29,0	31,750	17,4	15,9	8,0	± 0,4
	40			104,0						44,450	25,3	15,9	8,0	
50	30	69,850	100	125,0	105	3,2	± 0,4	25,7	35,3	31,750	17,4	15,9	8,0	± 0,4
	40			125,0						44,450	25,3	15,9	8,0	
	45			126,5						57,150	32,4	19,0	9,5	
60	40	107,950	160	189,0	165	3,2	± 0,4	25,7	60,0	44,450	25,3	15,9	8,0	± 0,4
	45			190,5						57,150	32,4	19,0	9,5	
	50			193,5						69,850	39,6	25,4	12,5	

1) At present at the stage of draft. (Revision of ISO/R 297 and its addenda 1, 2 and 3.)

2) z = maximum permissible deviation between the taper extremity and the plane through the basic diameter D, on either side of this plane.

3) z₁ = maximum permissible deviation, on either side of the leading face, of the position of the gauge plane D₁ from the nominal position of coincidence with the leading face.