

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ADDENDUM 3 TO ISO RECOMMENDATION R 297 - 1963

7/24 TAPERS FOR TOOL SHANKS

TAPERS Nos. 65 TO 80 (DIMENSIONS IN INCHES)

1st EDITION

December 1975

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BRIEF HISTORY

Addendum 3 to ISO Recommendation R 297-1963 was drawn up by Technical Committee ISO/TC 39, *Machine tools*, and circulated to the Member Bodies in September 1974.

It has been approved by the Member Bodies of the following countries :

Austria	Ireland	Turkey
Belgium	Italy	United Kingdom
Czechoslovakia	Mexico	U.S.A.
France	Romania	Yugoslavia
Hungary	South Africa, Rep. of	
India	Switzerland	

The Member Bodies of the following countries expressed disapproval of the document on technical grounds :

Germany
U.S.S.R.

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Addendum 3 to ISO Recommendation R 297-1963

7/24 TAPERS FOR TOOL SHANKS

TAPERS Nos. 65 TO 80 (DIMENSIONS IN INCHES)

SCOPE

ISO Recommendation R 297-1963 specifies the characteristics of 7/24 tapers Nos. 30, 40, 50 and 60. It has been supplemented by Addendum 1 in March 1971, for the insertion of tapers Nos. 45 and 55 and, in May 1974, by Addendum 2, for the insertion of tapers Nos. 65, 70, 75 and 80 (dimensions in millimetres).

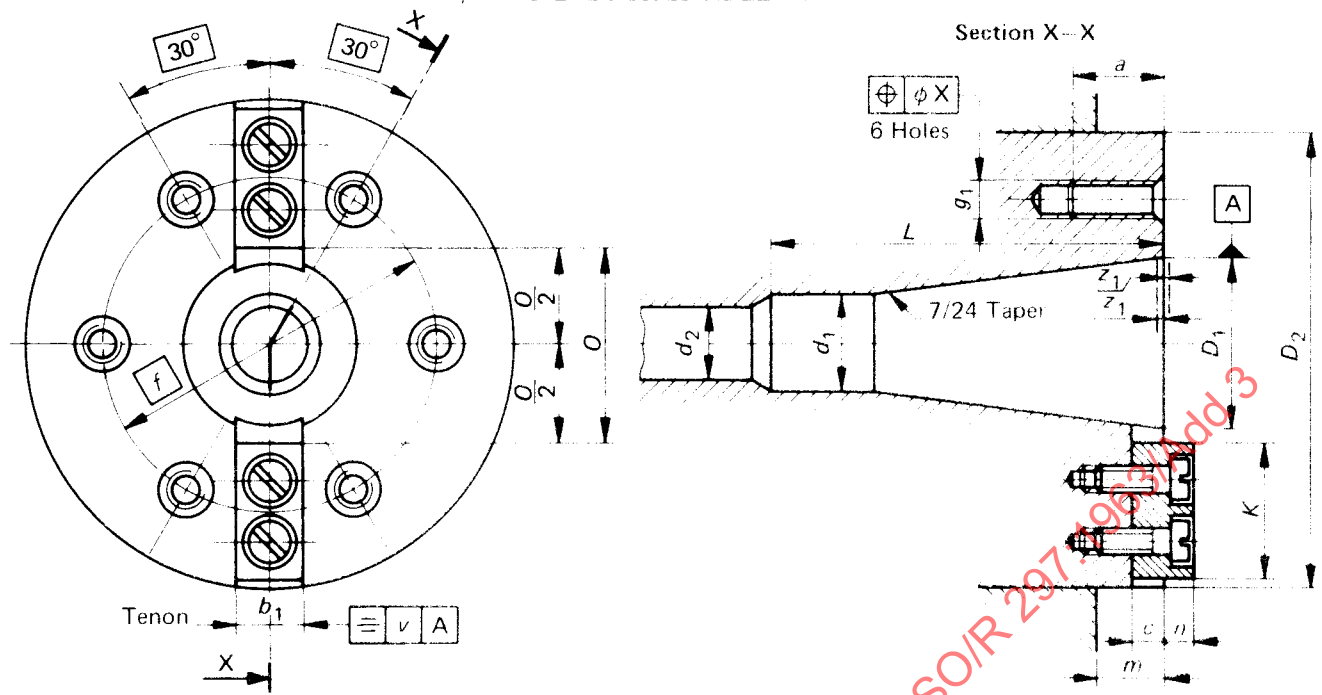
This third Addendum specifies the characteristics of tapers Nos. 65, 70, 75 and 80 (dimensions in inches).

INTERCHANGEABILITY

This Addendum provides, as regards threads, two entirely distinct types of products according to the type of thread, M or UN.

For all other dimensions, however, the products manufactured either to metric sizes (Addendum 2 to ISO Recommendation R 297) or to inch sizes (present Addendum 3 to ISO Recommendation R 297) are strictly interchangeable, though not absolutely identical.

7/24 TAPERS FOR SPINDLE NOSES



Dimensions in inches

Designation		No. 65	No. 70	No. 75	No. 80
D_1	1)	5.250	6.500	8.000	10.000
D_2		11.023 6 11.022 7	13.188 9 13.187 9	15.748 0 15.747 0	19.688 0 19.683 9
d_1		2.965 2.953	3.636 3.622	4.502 4.488	5.528 5.512
d_2	min.	1.68	1.68	2.20	2.20
L	min.	10.44	12.40	15.75	19.70
g_1	2)	UN 1.000-8	UN 1.000-8	UN 1.250-7	UN 1.250-7
a	min.	1.42	1.78	2.22	2.48
f		8.661	10.433	12.401	15.748
m	min.	1.50	1.97	1.97	1.97
n	max.	0.625	0.781	0.984	1.234
$\frac{O}{2}$	min.	2.953	3.544	4.250	5.354
b_1	3)	1.259 8 1.259 3	1.259 8 1.259 3	1.574 8 1.574 2	1.574 8 1.574 2
c	min.	0.625	0.781	0.984	1.234
K	max.	2.28	2.67	3.37	4.17
z_1	4)	0.015	0.015	0.015	0.015
v		0.004	0.004	0.004	0.004
x		0.010	0.010	0.013	0.013

1) D_1 = basic size.2) g_1 = thread diameter : this is either a UN thread or, if expressly stated, a metric thread M with standard pitch (see Addendum 2 for sizes in millimetres). In every case, the appropriate symbol UN or M should be marked on the component.

3) For the assembly of the tenon in its slot, fit as for key in shaft.

4) z_1 = maximum permissible deviation, on either side of the leading face, of the position of the gauge plane D_1 from the nominal position of coincidence with the leading face.