
INTERNATIONAL STANDARD



839 / II

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Milling machine arbors with 7/24 tapers — Part II : Accessories

Arbres porte-fraises au cône 7/24 — Partie II : Équipements

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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 839/II was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in April 1976.

It has been approved by the member bodies of the following countries :

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

No member body expressed disapproval of the document.

This International Standard cancels and replaces sub-clauses 3.2 and 4.2 of ISO Recommendation R 839-1968, of which it constitutes a technical revision.

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0 INTRODUCTION

During the preparatory work on ISO/R 839-1968, it was found that it was impossible to unify milling machine arbors and their accessories in a manner which would be satisfactory to countries using the metric system and to those using the inch system. The ISO Recommendation therefore standardized two completely distinct series of accessories. There was thus no interchangeability between these two series, based respectively on the metric and the inch series of ISO 240.

This International Standard retains metric series only, this series being regarded as the only one recommended for the future. Nevertheless, the inch series is given in an annex.

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the recommended manufacturing dimensions for milling machine accessories : spacing collars, bearing collars and clamping nuts.

Milling machine arbors with 7/24 tapers are specified in ISO 839/I.

2 REFERENCES

ISO 240, *Milling cutters – Interchangeability dimensions for cutter arbors or cutter mandrels – Metric series and inch series.*

ISO/R 272, *Hexagon bolts and nuts – Widths across flats, heights of heads, thicknesses of nuts – Metric series.*

ISO 297, *7/24 tapers for tool shanks.*

ISO 839/I, *Milling machine arbors with 7/24 tapers – Part I : Dimensions.*

3 CHOICE OF DIMENSIONS

The dimensions retained are those corresponding to the most commonly used diameters of milling machine arbors, i.e. the values of ISO 240 from 16 to 100 mm (omitting 19 mm and 70 mm).

Bearing collars are specified only for arbors with useful lengths l greater than 160 mm, as shorter arbors are usually intended for work which does not entail mounting on the machine with a steady (working in air) or, as a result, the use of a bearing collar.

NOTE — This International Standard will be supplemented further by more precise specifications regarding tolerances.