

INTERNATIONAL STANDARD

ISO
9270

First edition
1992-12-01

7/24 tapers for tool shanks for automatic changing — Tapers for spindle noses

*Cônes d'emmanchement d'outils à conicité 7/24 pour changement
automatique — Cônes pour nez de broches*



Reference number
ISO 9270:1992(E)
Documents
Document Sharing Hub

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 9270 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

Annex A of this International Standard is for information only.

© ISO 1992

All rights reserved. No part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

International Organization for Standardization
Case Postale 56 • CH-1211 Genève 20 • Switzerland

Printed in Switzerland

7/24 tapers for tool shanks for automatic changing — Tapers for spindle noses

1 Scope

This International Standard specifies the dimensions and tolerances of tenons and 7/24 tapers for machine-tool spindle noses for automatic changing, intended for use with the corresponding tool shanks specified in ISO 7388-1 and ISO 7388-3.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were 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 editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 297:1988, *7/24 tapers for tool shanks for manual changing*.

ISO 898-1:1988, *Mechanical properties of fasteners — Part 1: Bolts, screws and studs*.

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

ISO 4762:1989, *Hexagon socket head cap screws — Product grade A*.

ISO 7388-1:1983, *Tool shanks with 7/24 taper for automatic tool changers — Part 1: Shanks Nos. 40, 45 and 50 — Dimensions*.

ISO 7388-3:—¹⁾, *Tool shanks with 7/24 taper for automatic tool changers — Part 3: Retention knobs for shank No. 30 — Dimensions, conicity tolerances and mechanical characteristics*.

ISO 9524:1992¹⁾, *Machine tools — Front faces of spindle holders for machining centres — Functional dimensions*.

3 Dimensions

See figure 1 and table 1.

4 Conicity tolerances

The conicity tolerances shall conform with the cone angle tolerance grade AT4 specified in ISO 1947.

These values shall be negative.

1) To be published.