

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

Revised

ISO RECOMMENDATION R 236

HAND REAMERS AND
LONG FLUTED MACHINE REAMERS
MORSE TAPER SHANK

1st EDITION
December 1961

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BRIEF HISTORY

The ISO Recommendation R 236, *Hand Reamers and Long Fluted Machine Reamers, Morse Taper Shank*, was drawn up by Technical Committee ISO/TC 29, *Small Tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1947, taking into account the studies which had been made by the former International Federation of the National Standardizing Associations (ISA), and led, in 1958, to the adoption of a Draft ISO Recommendation.

In September 1959, this Draft ISO Recommendation (No. 302) was submitted to all the ISO Member Bodies for enquiry. It was approved, subject to some modifications, by the following Member Bodies:

Austria	Hungary	Portugal
Belgium	India	Romania
Burma	Italy	Sweden
Czechoslovakia	Mexico	Switzerland
France	Netherlands	United Kingdom
Germany	Pakistan	U.S.S.R
Greece	Poland	

One Member Body opposed the approval of the Draft: U.S.A.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in December 1961, to accept it as an ISO RECOMMENDATION.

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INTRODUCTION

I. SCOPE

This ISO Recommendation relates to reamers and deals with the following two types:

1. Hand reamers. Tables 1.1 to 1.3,
2. Long fluted machine reamers, Morse taper shank Tables 2.1 to 2.3.

Other types of reamers will be dealt with in further ISO Recommendations as and when current work on them is completed.

For each type of reamer mentioned above, this ISO Recommendation comprises three tables, giving respectively:

- (1) the recommended dimensions in millimetres,
- (2) the recommended dimensions in inches,
- (3) the corresponding dimensions, in millimetres and in inches, set out as functions of diameter steps.

II. INTERCHANGEABILITY

The numerical tables have been drawn up in such a way as to ensure that the standard dimensions in millimetres and inches correspond as closely as possible.

To this end, the complete range of diameters has been subdivided into a number of steps, the limits of which have been derived from the preferred number series for the metric values and converted directly from those for the inch values; the lengths and taper shank dimensions remain the same for the metric and the inch values within a given step.

The recommended diameters in the two systems of units of measurement differ, however, and the number of recommended diameters, in a given step, also differs in one system from that in the other.