

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 297

7/24 TAPERS FOR TOOL SHANKS

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BRIEF HISTORY

The ISO Recommendation R 297, *7/24 Tapers for Tool Shanks*, was drawn up by Technical Committee ISO/TC 39, *Machine Tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1950, taking into account the studies which had been made by the former International Federation of the National Standardizing Associations (ISA), and led, in 1955, to the adoption of a Draft ISO Recommendation.

In July 1960, this Draft ISO Recommendation (No. 389) was circulated to all the ISO Member Bodies for enquiry. It was approved by the following Member Bodies:

Argentina	Germany	Poland
Australia	Hungary	Portugal
Belgium	India	Romania
Chile	Israel	Spain
Colombia	Italy	Sweden
Czechoslovakia	Japan	Switzerland
Denmark	Netherlands	United Kingdom
France	New Zealand	U.S.A.
		U.S.S.R.

No Member Body opposed the approval of the Draft.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in March 1963, to accept it as an ISO Recommendation.

7/24 TAPERS FOR TOOL SHANKS

1. INTRODUCTION

The following tables deal with $7/24$ tapers. They relate

on the one hand, to spindle noses	Table 1, page 4, for millimetre sizes, and Table 2, page 5, for inch sizes,
on the other hand, to tool shanks	Table 3, page 6, for millimetre sizes, and Table 4, page 7, for inch sizes.

This type of taper is designed especially for milling machine spindle noses, as well as for the corresponding tool shanks, and for this reason it is hoped to prepare a more comprehensive ISO Recommendation which will deal with “Spindle Noses with $7/24$ Tapers for Milling Machines”.

2. INTERCHANGEABILITY

The present ISO Recommendation provides, as regards threads, two entirely distinct types of products according to the type of thread, **M** or **UNC**.

In order to distinguish between those two types, it is important that the component itself be marked with the corresponding thread symbol, each national standards body being free to adopt, in its national standard, either of the two threads.

For all other sizes, however, the products manufactured either to metric or to inch sizes are strictly interchangeable, though not absolutely identical. Acceptance conditions, if provided for in national standards, should therefore be such as to allow for the acceptance of products specified either in inch or metric sizes.