

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 867

SPINDLE NOSES AND FACE PLATES

BAYONET TYPE

SIZES FOR INTERCHANGEABILITY

METRIC SERIES

1st EDITION

November 1968

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BRIEF HISTORY

The ISO Recommendation R 867, *Spindle noses and face plates – Bayonet type – Sizes for interchangeability – Metric series*, 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 1951 and led, in 1965, to the adoption of a Draft ISO Recommendation.

In July 1967, this Draft ISO Recommendation (No. 1327) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Austria	India	South Africa, Rep. of
Belgium	Iran	Spain
Chile	Israel	Sweden
Czechoslovakia	Italy	Switzerland
Finland	Japan	Thailand
France	Korea, Rep. of	Turkey
Germany	Netherlands	U.A.R.
Greece	Poland	United Kingdom
Hungary	Romania	Yugoslavia

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 November 1968, to accept it as an ISO RECOMMENDATION.

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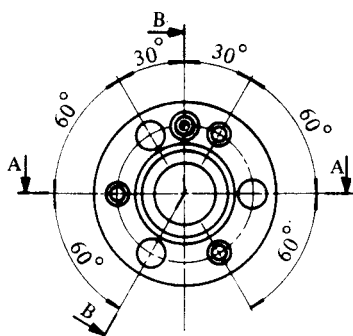
1. SCOPE

This ISO Recommendation is the second of a series of ISO Recommendations specifying the sizes for interchangeability for lathe spindle noses and face plates and covering the three types selected for international standardization, i.e. A and Camlock types and bayonet type.

The first two types, which are presently in use in most countries, are the subject of ISO Recommendation R 702, *Spindle noses and face plates – Types A and Camlock – Sizes for interchangeability*; the third type is the subject of this ISO Recommendation.

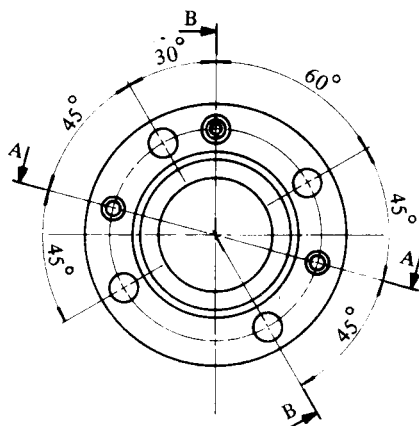
2. SPINDLE NOSES – BAYONET TYPE

Nos. 3 and 4

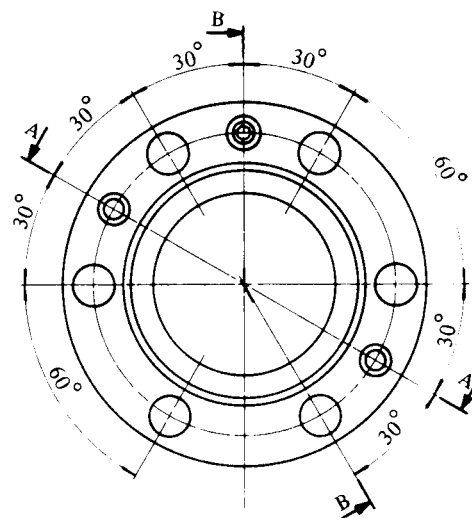


No. 3 without button

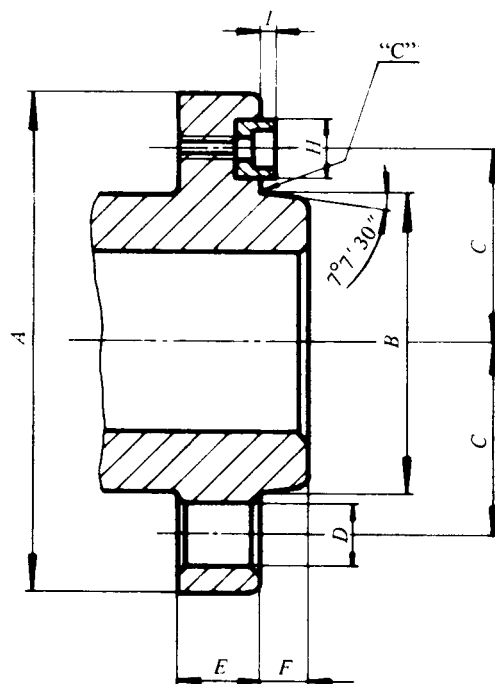
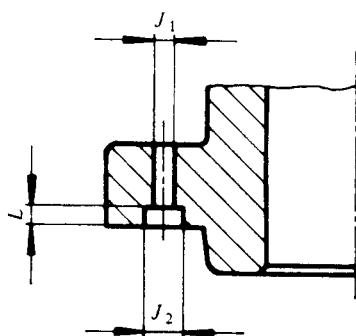
Nos. 5 to 8



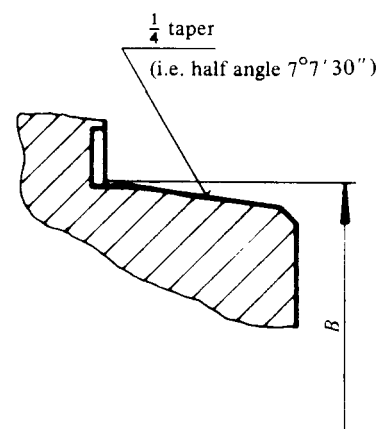
Nos. 11 to 20



Section B-B

 $\frac{1}{2}$ section A-A

Detail "C"



Dimension *B* is taken at the theoretical point of intersection between the generating line of the cone and the face of the flange.