

JAPANESE
INDUSTRIAL
STANDARD

Translated and Published by
Japanese Standards Association

JIS B 4232 – 1996

Involute gear milling cutters

UDC 621. 914 : 621. 833

B 4232-1996

This translation has been made based on the original Japanese Industrial Standard revised by the Minister of International Trade and Industry through deliberations at Japanese Industrial Standards Committee in accordance with the Industrial Standardization Law:

Date of Establishment: 1958-03-03

Date of Revision: 1996-12-20

Date of Public Notice in Official Gazette: 1996-12-20

Investigated by: Japanese Industrial Standards Committee

Divisional Council on FA

JIS B 4232-1996, First English edition published in 1997-05

Translated and published by: Japanese Standards Association
4-1-24, Akasaka, Minato-ku, Tokyo, 107 JAPAN

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Printed in Japan

Involute gear milling cutters

1 Scope This Japanese Industrial Standard specifies the involute gear milling cutters (hereafter, referred to as "milling cutters") to be used for gear cutting of involute spur gears and helical gears of 0.5 mm to 25 mm in module m and 20° in standard pressure angle α .

Remarks : The standards cited in this Standard are as given in the following:

- JIS B 0021 *Indications of geometrical tolerances on drawings*
- JIS B 0102 *Glossary of gear terms*
- JIS B 0172 *Glossary of terms for milling cutters*
- JIS B 0174 *Gear cutters – Vocabulary*
- JIS B 0401 *System of limits and fits*
- JIS B 0405 *General tolerances – Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*
- JIS B 0601 *Surface roughness – Definitions and designation*
- JIS B 0659 *Roughness comparison specimens*
- JIS B 1701 *Involute gear tooth profile and dimensions*
- JIS B 4201 *Cutter bores*
- JIS B 7503 *Dial gauges*
- JIS B 7513 *Precision surface plates*
- JIS B 7725 *Vickers hardness testing machines*
- JIS B 7726 *Rockwell and Rockwell superficial hardness testing machines*
- JIS G 4403 *High speed tool steels*
- JIS Z 2244 *Method of Vickers hardness test*
- JIS Z 2245 *Method of Rockwell and Rockwell superficial hardness test*

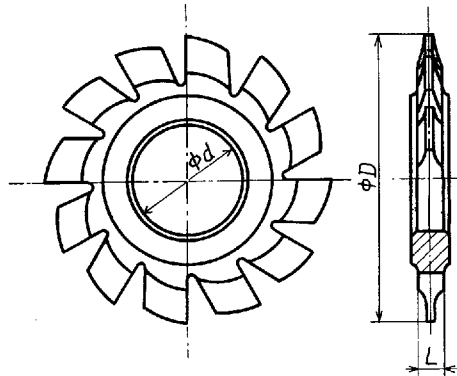
2 Definitions The definitions of main terms to be used in this Standard are in accordance with JIS B 0102, JIS B 0172 and JIS B 0174.

3 Shape and dimensions The shape and dimensions of the milling cutters shall be in accordance with Table 1.

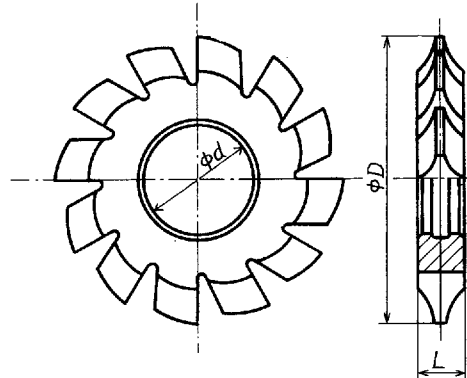
Further, the tooth profile of this milling cutter shall be the tooth profile produced by the composite tooth profile (the basic rack tooth profile composed of the tooth profile of involute gear and cycloid tooth profile). For informative reference, the tooth profile and dimensions of the forming gauge for the standard pressure angle α 20° are shown below.

Table 1 Shape and dimensions of milling cutter

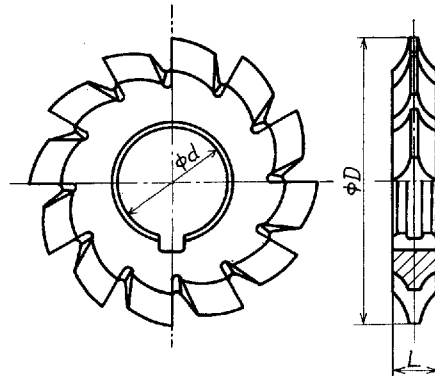
For module 0.5 mm to 1 mm



For module 1.25 mm to 4.5 mm



For module 5 mm or over



Remarks : For module 0.5 mm to 1 mm, the example of with boss is shown.

Unit : mm

Module m			Out- side dia- meter D	Bore diameter d		Width L (minimum)								Refer- ence		
Series ⁽¹⁾						No. of milling cutter								Flutes Z		
1	2	3				8	7	6	5	4	3	2	1			
Number of teeth of gear capable of being cut z																
				Type A	Type B ⁽²⁾	12 to 13	14 to 16	17 to 20	21 to 25	26 to 34	35 to 54	55 to 134	135 to rack			
0.5			40	22	22.225	4.4	4.4	4	4	4	3.6	3.6	3.6	12		
	0.55															
0.6																
		0.65	45													
	0.7															
	0.75															
0.8			50			4.8	4.8	4.4	4.4	4.4	4	4	4			
	0.9															
1																
	1.25		56		25.4	5.5	5.5	5.2	5.2	5.2	4.8	4.8	4.8		4.8	
1.5																
	1.75															
			63			6.5	6.5	6	6	6	5.5	5.5	5.5	5.5		

