
INTERNATIONAL STANDARD



5415

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Reduction sleeves with 7/24 external and Morse internal taper and incorporated screw

Douilles de réduction aux cônes extérieur 7/24 et intérieur Morse, avec vis incorporée

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[ISO 5415:1977](#)

<https://standards.iteh.ai/catalog/standards/sist/efd43a52-205d-4bc6-84ae-4186b067a42d/iso-5415-1977>

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Descriptors : tools, power-operated tools, Morse taper shanks, adapter sleeves, specifications, dimensions.

FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 5415 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in March 1976.

It has been approved by the member bodies of the following countries :

Australia	Hungary	Romania
Austria	India	South Africa, Rep. of
Belgium	Israel	Spain
Brazil	Italy	Switzerland
Bulgaria	Japan	Turkey
Czechoslovakia	Mexico	United Kingdom
France	Netherlands	U.S.S.R.
Germany	Philippines	Yugoslavia

No member body expressed disapproval of the document.

Reduction sleeves with 7/24 external and Morse internal taper and incorporated screw

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1 SCOPE AND FIELD OF APPLICATION

This International Standard lays down the dimensions of reduction sleeves with 7/24 external taper Nos. 30 – 40 – 45 – 50 and 60 and Morse internal taper Nos. 1 to 6 (Morse tapers Nos. 4 – 5 and 6 being either with positive drive – sleeves of type B – or without positive drive – sleeves of type A).

These sleeves permit driving of tools with Morse taper shanks with tapped holes with the aid of an internal screw. The form of this screw and its fixation in the sleeve are left to the manufacturer's discretion.

7/24 tapers conform to ISO/R 297 and ISO 2583. Morse tapers conform to ISO 296 and ISO 5413.

2 REFERENCES

[ISO 5415:1977](https://standards.iteh.ai/catalog/standards/sist/ef143a52-205d-4bc6-84ae-418bb067342d/iso-5415-1977)

[ISO 5413:1977](https://standards.iteh.ai/catalog/standards/sist/ef143a52-205d-4bc6-84ae-418bb067342d/iso-5413-1977)

[ISO 296:1973](https://standards.iteh.ai/catalog/standards/sist/ef143a52-205d-4bc6-84ae-418bb067342d/iso-296-1973), *Machine tools – Self-holding tapers for tool shanks.*

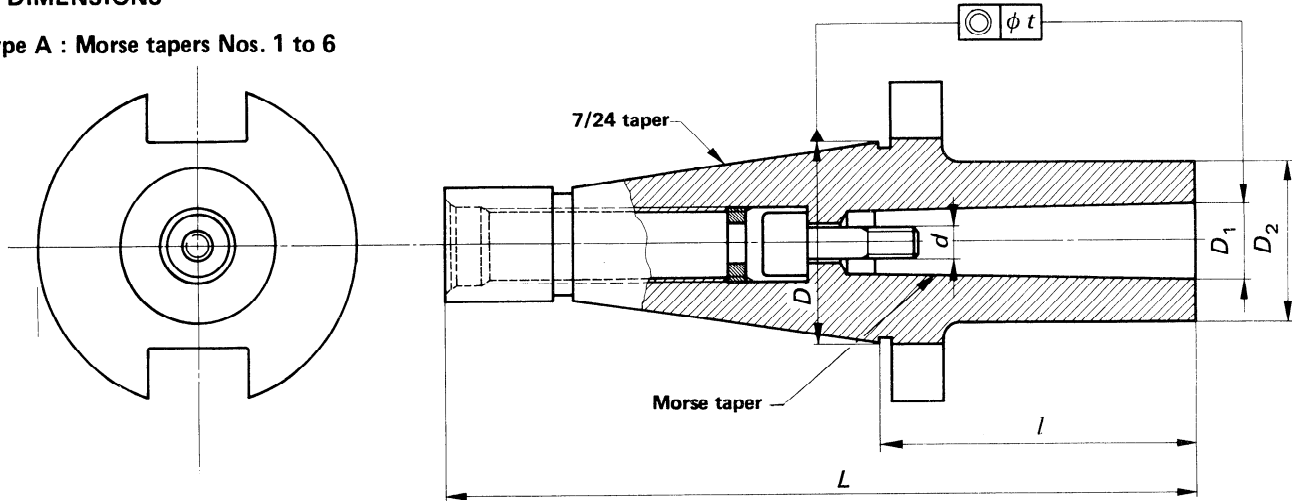
ISO/R 297, *7/24 tapers for tool shanks.*

ISO 2583, *Tool shanks and equipment with 7/24 tapers – Collar dimensions.*

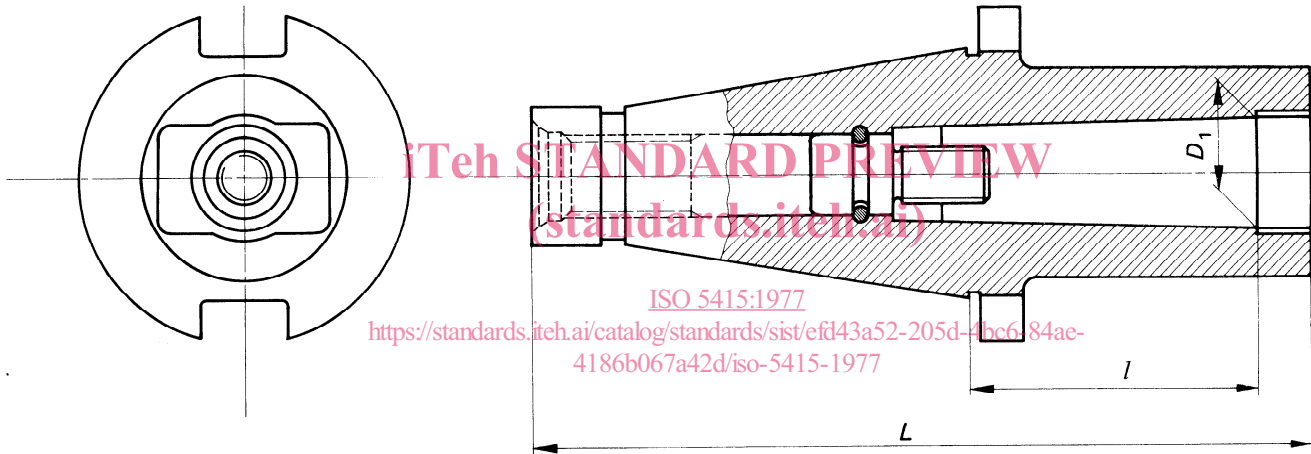
ISO 5413, *Machine tools – Positive drive of Morse tapers.*

3 DIMENSIONS

Type A : Morse tapers Nos. 1 to 3



Type B : Morse tapers Nos. 4 to 6



NOTE – The form and fixing of the screw are only given as an example.

Dimensions in millimetres

Designation		D	D ₁	D ₂		d	L max.		l max. ≈	t
7/24 taper No.	Morse taper No.			Type A	Type B		Type A	Type B		
30	1	31,75	12,065	25	—	M 6	118	—	50	0,012
	2		17,780	32	—					
40	1	44,45	12,065	25	—	M 6	143	—	50	0,016
	2		17,780	32	—					
	3		23,825	40	—	M 12	158	—	65	
	4		31,267	48	63					
45	2	57,15	17,780	32	—	M 10	157	—	50	0,016
	3		23,825	40	—					
	4		31,267	48	63	M 16	182	197	75	
50	2	69,85	17,780	32	—	M 10	187	—	60	0,020
	3		23,825	40	—					
	4		31,267	48	63	M 16	212	227	85	
	5		44,399	63	78					
60	5	107,95	44,399	63	78	M 20	292	310	85	0,020
	6		63,348	80	124					