

# INTERNATIONAL STANDARD

**ISO  
9766**

First edition  
1990-12-15

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## **Drills with indexable inserts — Cylindrical shanks with a parallel flat**

**iTeh STANDARD PREVIEW**  
*Forets à plaquettes amovibles — Queues cylindriques à méplat*  
**(standards.iteh.ai)**

ISO 9766:1990

<https://standards.iteh.ai/catalog/standards/sist/5fc5d7d3-6c4f-452b-af8a-e52abcab2382/iso-9766-1990>



Reference number  
ISO 9766:1990(E)

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 9766 was prepared by Technical Committee ISO/TC 29, *Small tools*.

ISO 9766:1990  
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# Drills with indexable inserts — Cylindrical shanks with a parallel flat

## 1 Scope

This International Standard specifies the dimensions necessary for the interchangeability of cylindrical shanks with a parallel flat for drills with indexable inserts.

## 2 Dimensions

See figure 1 and table 1.

## 3 Specifications

A hole shall be provided for axially feeding coolant through the drill.

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Dimensions in millimetres

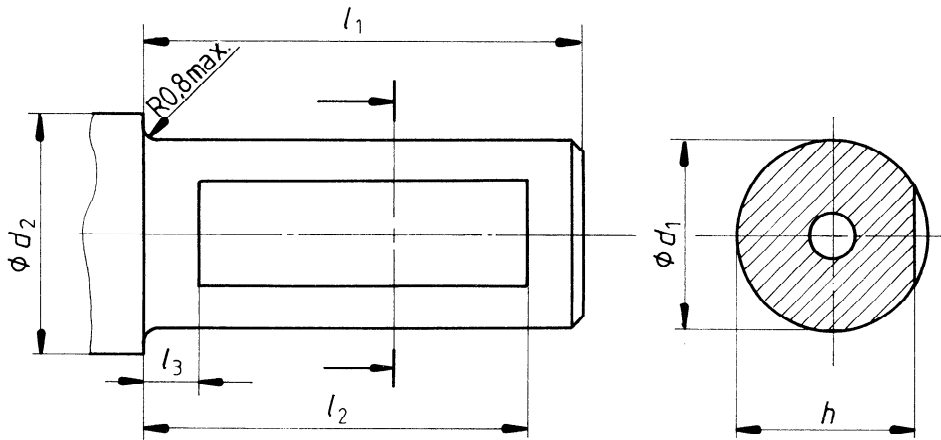


Figure 1

Table 1

Dimensions in millimetres

| $d_1$ | $d_2$ | $h$  | $l_1$   | $l_2$ | $l_3$ |
|-------|-------|------|---------|-------|-------|
| h6    | min.  | h13  | $\pm 1$ | min.  | max.  |
| 20    | 25    | 18,2 | 50      | 43    | 7     |
| 25    | 31    | 23   | 56      | 49    | 7     |
| 32    | 38    | 30   | 60      | 53    | 7     |
| 40    | 46    | 38   | 70      | 63    | 7     |
| 50    | 56    | 47,8 | 80      | 73    | 7     |

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Descriptors: tools, cutting tools, drills, specifications, dimensions.

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