
**Cylindrical shanks for milling cutters —
Part 2:
Dimensional characteristics of flatted
cylindrical shanks**

*Queues cylindriques d'outils à fraiser —
Partie 2: Caractéristiques dimensionnelles des queues cylindriques à
méplat*

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ISO 3338-2:2000

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

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.

Attention is drawn to the possibility that some of the elements of this part of ISO 3338 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 3338-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 2, *Drills, reamers, milling cutters and milling machine accessories*.

This fifth edition cancels and replaces the fourth edition (ISO 3338-2:1996), which has been technically revised by the inclusion of shanks of diameter 14 mm and 18 mm.

ISO 3338 consists of the following parts, under the general title *Cylindrical shanks for milling cutters*:

- *Part 1: Dimensional characteristics of plain cylindrical shanks*
- *Part 2: Dimensional characteristics of flatted cylindrical shanks*
- *Part 3: Dimensional characteristics of threaded shanks*

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Cylindrical shanks for milling cutters —

Part 2: Dimensional characteristics of flatted cylindrical shanks

1 Scope

This part of ISO 3338 specifies the dimensions of flatted cylindrical shanks for milling cutters (of diameters 6 mm to 20 mm for single-flatted shanks and diameters 25 mm to 63 mm for double-flatted shanks). In the case of single-flatted shanks, it is applicable to both single-ended cutters and double-ended cutters, as double-flatted shanks cannot admit single-ended cutters.

The dimensions of plain cylindrical shanks and of threaded shanks are given in ISO 3338-1 and ISO 3338-3 respectively.

The two shank types covered by ISO 3338-1 and this part of ISO 3338 have the same dimensional characteristics (diameters and lengths) but different tolerances on diameters, namely:

- h8 for plain cylindrical shanks, commonly used for tools mounted in collets;
- h6 for flatted cylindrical shanks intended to be mounted in chucks and secured with a clamping screw, and requiring an accuracy adjustment.

2 Dimensions

2.1 Flatted cylindrical shanks with single flat for diameters d_1 of 6 mm to 20 mm

See Figure 1 and Table 1.

2.2 Flatted cylindrical shanks with double flat for diameters d_1 of 25 mm to 63 mm

See Figure 2 and Table 1.

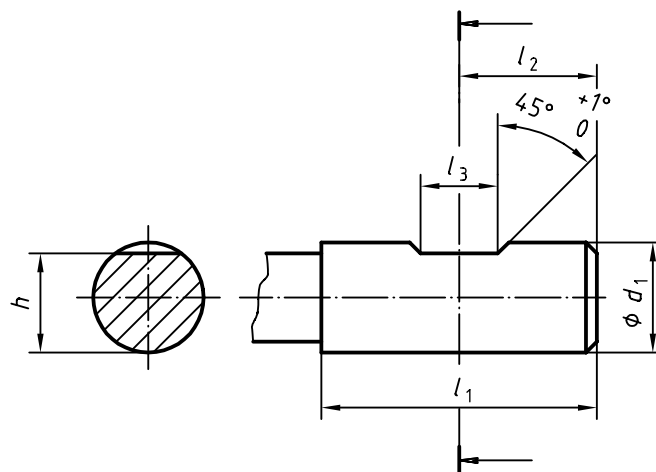


Figure 1

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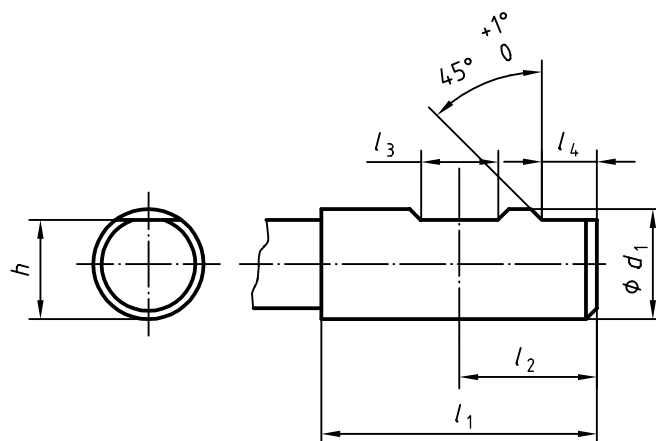


Figure 2

Table 1

Dimensions in millimetres

d_1	l_1	l_2	l_3	l_4	h
h6	+2 0	0 -1	+0,05 0	+1 0	h11
6 a)	36	18	4,2	—	4,8
8			5,5		6,6
10			7		8,4
12 a)			8		10,4
14			8		12,7
16			10		14,2
18			10		16,2
20			11		18,2
25	56	32	12	17	23
32 a)	60	36	14	19	30
40	70	40			38
50	80	45	18	23	47,8
63	90	50			60,8

a) Not in conformity with ISO 237:1975, *Rotating tools with parallel shanks — Diameters of shanks and sizes of driving squares*.

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