
Tool holders with cylindrical shank —
Part 2:
Type A, shanks for tool holders of special
designs

Porte-outil à queue cylindrique —
Partie 2: Porte-outil de type A de conceptions spéciales
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ISO 10889-2:2004

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Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
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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 2.

The main task of technical committees is to prepare International Standards. 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 document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 10889-2 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 10889-2:1997), Table 1 of which has been technically revised.

ISO 10889 consists of the following parts, under the general title *Tool holders with cylindrical shank*:

- *Part 1: Cylindrical shank, location bore — Technical delivery conditions*
- *Part 2: Type A, shanks for tool holders of special designs*
- *Part 3: Type B with rectangular radial seat*
- *Part 4: Type C with rectangular axial seat*
- *Part 5: Type D with more than one rectangular seat*
- *Part 6: Type E with cylindrical seat*
- *Part 7: Type F with taper seat*
- *Part 8: Type Z, accessories*

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Tool holders with cylindrical shank —

Part 2: Type A, shanks for tool holders of special designs

1 Scope

ISO 10889 is applicable to tool holders with cylindrical shank for machine tools with non-rotating tools, preferably for turning machines.

This part of ISO 10889 specifies dimensions, designations and complementary technical delivery conditions for tool holders of type A with cylindrical shank in accordance with ISO 10889-1 for tool holders of special designs.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

ISO 2768-2, *General tolerances — Part 2: Geometrical tolerances for features without individual tolerance indications*

ISO 10889-1, *Tool holders with cylindrical shank — Part 1: Cylindrical shank, location bore — Technical delivery conditions*

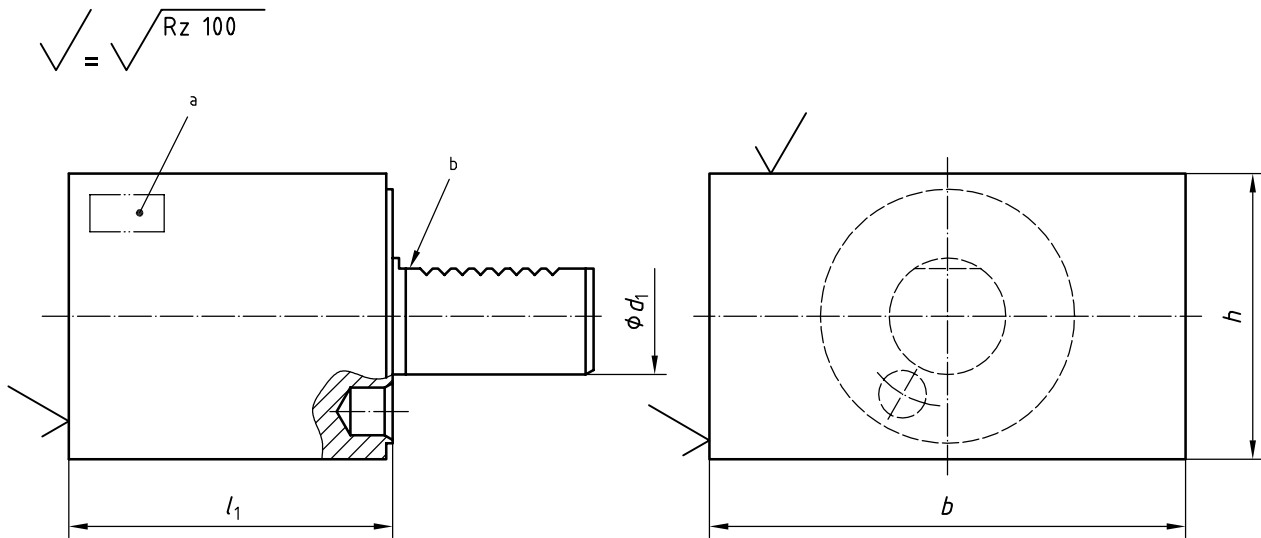
3 Dimensions

See Figures 1 and 2 and Table 1.

Unspecified details shall be chosen appropriately.

General tolerances: ISO 2768-mH.

Surface roughness in micrometres

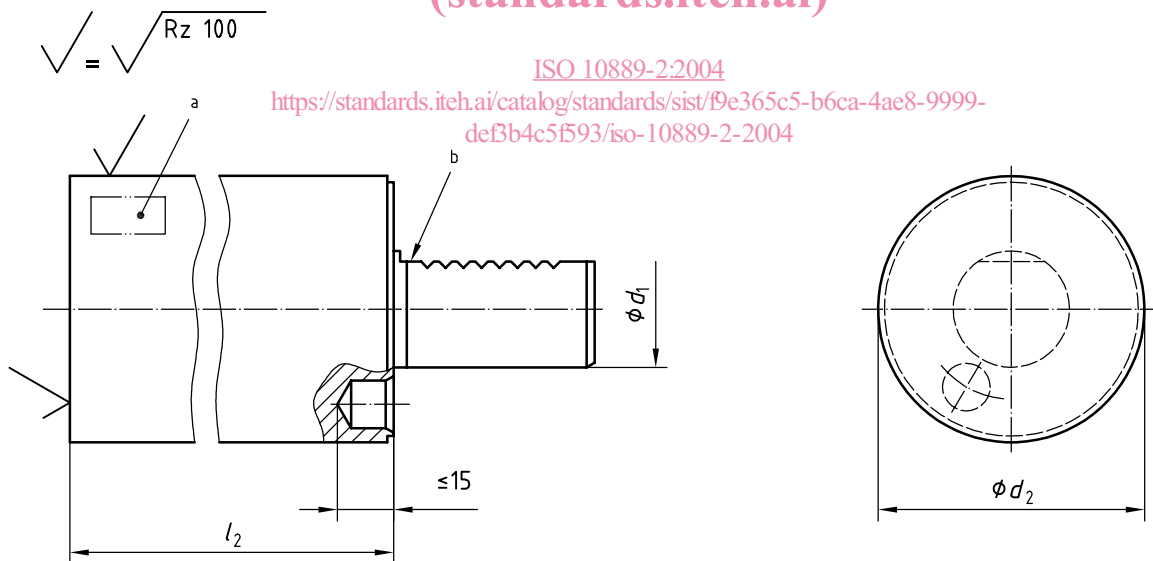


- a Field of marking.
- b Cylindrical shank in accordance with ISO 10889-1.

Figure 1 — Type A1 tool holder, rectangular

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Dimensions in millimetres,
surface roughness in micrometres



- a Field of marking.
- b Cylindrical shank in accordance with ISO 10889-1.

Figure 2 — Type A2 tool holder, round

Table 1 — Type A tool holder dimensions

Dimensions in millimetres

d_1	l_1	l_2	d_2	b	h
16	44	60	40	78	44
20	65	70	50	100	60
25	75	80	58	100	60
		200			
30	85	100	68	130	76
		240			
40	100	120	83	151	96
		320			
50	125	135	98	160	120
		400			
60	160	150	123	165	125
		480			
80	200	500	158	220	160

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4 Designation

A tool holder in accordance with this part of ISO 10889 shall be designated by

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- a) "Tool holder",
- b) reference to this part of ISO 10889, i.e. ISO 10889-2,
- c) type (A1 or A2),
- d) nominal diameter, d_1 , in millimetres,
- e) nominal length, l_1 or l_2 , in millimetres.

EXAMPLE 1 A tool holder of type A1 with a nominal diameter $d_1 = 40$ mm and a nominal length $l_1 = 100$ mm is designated as follows:

Tool holder ISO 10889-2 - A1 - 40 × 100

EXAMPLE 2 A tool holder of type A2 with a nominal diameter $d_1 = 40$ mm and a nominal length $l_2 = 320$ mm is designated as follows:

Tool holder ISO 10889-2 - A2 - 40 × 320

5 Technical delivery conditions

As a complement to the requirements of ISO 10889-1, the material shall be indicated in the field of marking.

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