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**Tool holders with cylindrical shank —  
Part 6:  
Type E with cylindrical seat**

*Porte-outil à queue cylindrique —*

*Partie 6: Porte-outil de type E pour outils à queue cylindrique*

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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 10889-6 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 10889-6:1997), Table 3 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 6: Type E with cylindrical seat

### 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 with cylindrical seat of types E1 to E4 with a mounting system cylindrical shank in accordance with ISO 10889-1. For non-standardized tool holders such as tool holders with a cylindrical seat as shown in the figures, it is advisable to apply the corresponding specifications of this part of ISO 10889.

### 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*

ISO 10897, *Collets for tool holders with taper ratio 1:10 — Collets, holders, nuts*

ISO 15488, *Collets with 8° setting angle for tool shanks — Collets, nuts and fitting dimensions*

### 3 Dimensions

#### 3.1 General

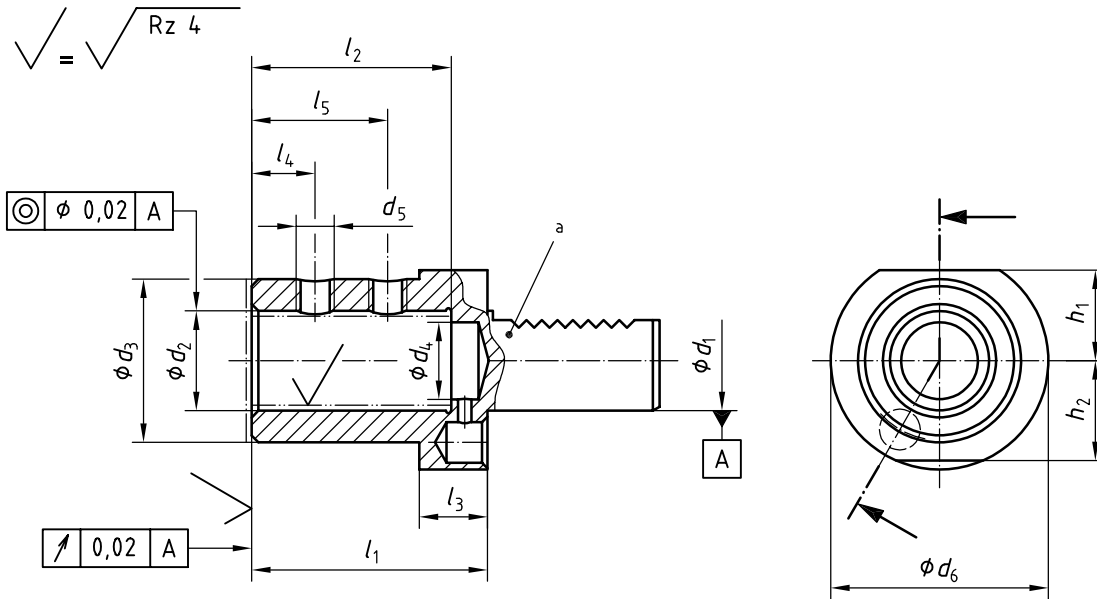
Unspecified details shall be chosen appropriately.

General tolerances: ISO 2768-mH.

#### 3.2 Tool holder of type E1

See Figure 1 and Table 1.

Dimensions in millimetres,  
surface roughness in micrometres



a Cylindrical shank in accordance with ISO 10889-1.

Figure 1 — Type E1 tool holder for drilling tools with internal coolant supply  
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Table 1 — Type E1 tool holder dimensions

Dimensions in millimetres

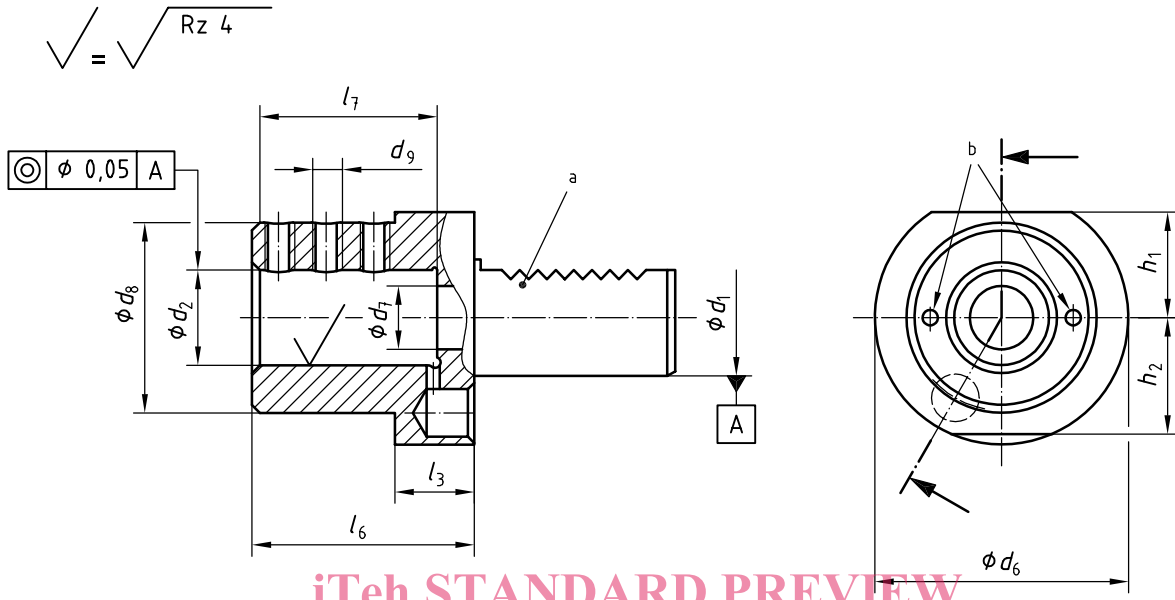
$d_1$	$d_2$ H6	$d_3$	$d_4^a$	$d_5$	$d_6$	$h_1$	$h_2$	$l_1$ 0 -0,2	$l_2$	$l_3$	$l_4$	$l_5$
20	20	40	12	M10 × 1	50	—	23	67	54	18	15	35
	25	45	17	M12 × 1				71	59		17	40
25	20	40	12	M10 × 1	58	25	25	67	54	18	15	35
	25	45	17	M12 × 1				71	59		17	40
30	20	40	12	M10 × 1	68	28	30	67	54	22	15	35
	25	45	17	M12 × 1				71	59		17	40
	32	52	24					75	63		17	44
40	20	40	12	M10 × 1	83	32,5	—	67	54	22	15	35
	25	45	17	M12 × 1				75	59		17	40
	32	52	24					75	63		17	44
	40	65	32	M16 × 1				90	73		22	50
50	20	40	12	M10 × 1	98	35	—	67	54	30	15	35
	25	45	17	M12 × 1				80	59		17	40
	32	52	24					80	63		17	44
	40	65	32	M16 × 1				90	73		22	50
	50	75	42					100	83		24	60
60	20	40	12	M10 × 1	123	42,5	—	80	54	30	15	35
	25	45	17	M12 × 1				80	59		17	40
	32	52	24					80	63		17	44
	40	65	32	M16 × 1				90	73		22	50
	50	75	42					100	83		24	60
80	20	40	12	M10 × 1	158	55	—	80	54	30	15	35
	25	45	17	M12 × 1				80	59		17	40
	32	52	24					80	63		17	44
	40	65	32	M16 × 1				90	73		22	50
	50	75	42					100	83		24	60

<sup>a</sup>  $d_4$  shall be pilot-drilled for manufacturing reasons.

### 3.3 Tool holder of type E2

See Figure 2 and Table 2.

Dimensions in millimetres,  
surface roughness in micrometres



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- a Cylindrical shank in accordance with ISO 10889-1.
- b External coolant supply (closable).

ISO 10889-6:2004  
**Figure 2 — Type E2 tool holder for turning tools with cylindrical shank**  
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Table 2 — Type E2 tool holder dimensions

Dimensions in millimetres

$d_1$	$d_2$ H7	$d_6$	$d_7$ min.	$d_8$	$d_9^a$	$h_1$	$h_2$	$l_3$	$l_6$	$l_7$
16	6	40	6,7	32	M6	18	18	13	44	34
	8				40					
	10									
	12									
	16									
20	8	50	9	40	M6	—	23	18	50	41
	10				50					
	12									
	16									
	20									
25										
25	8	58	10,5	40	M6	25	25	18	50	41
	10				58					
	12									
	16									
	20									
25										
30	8	68	16,5	55	M6	28	30	22	60	51
	10				55					
	12									
	16									
	20									
	25									
	32									
40	12	83	20,5	55	M8	32,5	—	22	75	61
	16				83					
	20									
	25									
	32									
40										
50	16	98	25,5	68	M10	35	—	30	90	76
	20				98					
	25									
	32									
	40									
50										
60	16	123	40,5	68	M10	42,5	—	30	90	76
	20				98					
	25									
	32									
	40									
50										
80	20	158	40,5	68	M12	55	—	30	100	86
	25									
	32									
	40									
50										

<sup>a</sup> For  $d_1 = 20$  mm: at least two fastening threads; other sizes at least three fastening threads.