
INTERNATIONAL STANDARD



702 / III

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

Machine tools — Spindle noses and face plates — Sizes for interchangeability — Part III : Bayonet type

*Machines-outils — Nez de broches et faux-plateaux — Dimensions d'interchangeabilité —
Partie III : Type baïonnette*

First edition — 1975-08-15

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[ISO 702-3:1975](#)

<https://standards.iteh.ai/catalog/standards/sist/f06d87b9-5a9e-492d-95ba-ce36f317a562/iso-702-3-1975>

UDC 621.941-229.33

Ref. No. ISO 702/III-1975 (E)

Descriptors : machine tools, spindle noses, lathes, face plates, dimensions, interchangeability.

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.

Prior to 1972, the results of the work of the Technical Committees were published as ISO Recommendations; these documents are now in the process of being transformed into International Standards. As part of this process, Technical Committee ISO/TC 39 has reviewed ISO Recommendation R 867 and found it technically suitable for transformation and decided that it should bear the number ISO 702/III. International Standard ISO 702/III therefore replaces ISO Recommendation R 867-1968 to which it is technically identical.

ISO Recommendation R 867 was approved by the Member Bodies of the following countries :

Austria	Hungary	Romania
Belgium	India	South Africa, Rep. of
Chile	Iran	Spain
Czechoslovakia	Israel	Sweden
Egypt, Arab Rep. of	Italy	Switzerland
Finland	Japan	Thailand
France	Korea, Rep. of	Turkey
Germany	Netherlands	United Kingdom
Greece	Poland	Yugoslavia

No Member Body expressed disapproval of the Recommendation.

No Member Body disapproved the transformation of ISO/R 867 into an International Standard.

Machine tools — Spindle noses and face plates — Sizes for interchangeability — Part III : Bayonet type

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1 SCOPE AND FIELD OF APPLICATION

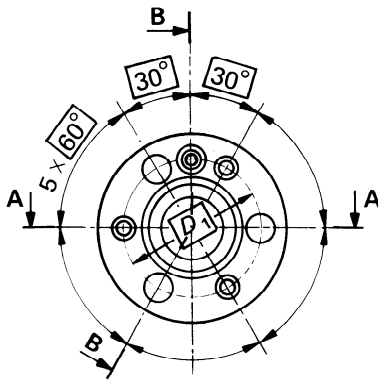
This International Standard specifies the sizes for interchangeability of bayonet-type lathe spindle noses and corresponding face plates.

NOTE — The types "A" and "Camlock" are dealt with in parts I and II respectively.

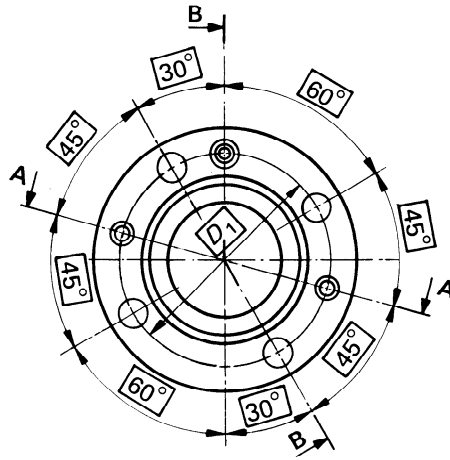
2 SIZES FOR INTERCHANGEABILITY

2.1 Spindle noses

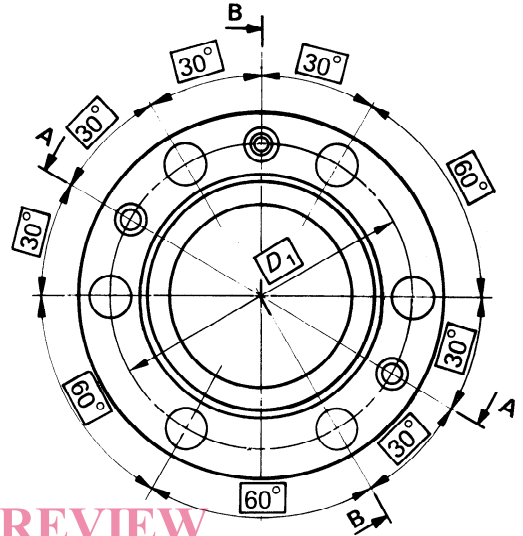
Nos. 3 and 4
(No. 3 without button)



Nos. 5 to 8

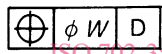


Nos. 11 to 20



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All holes

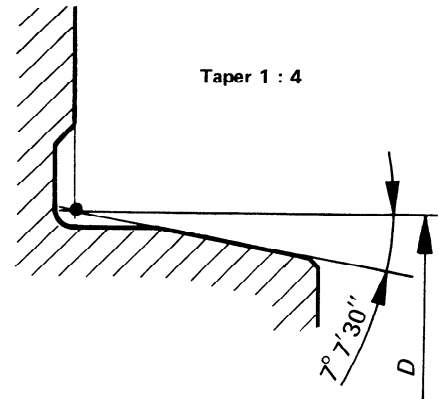
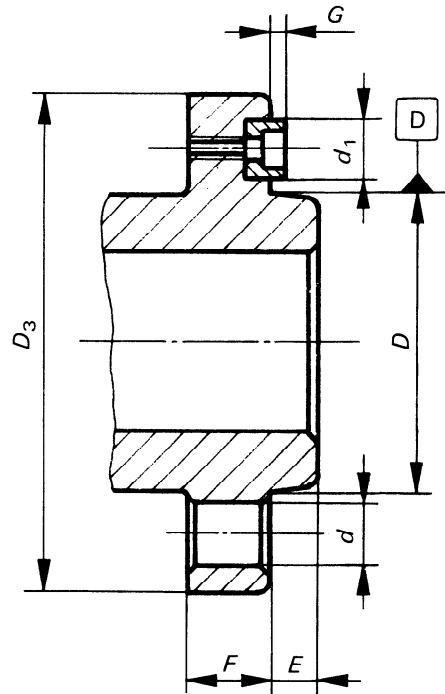
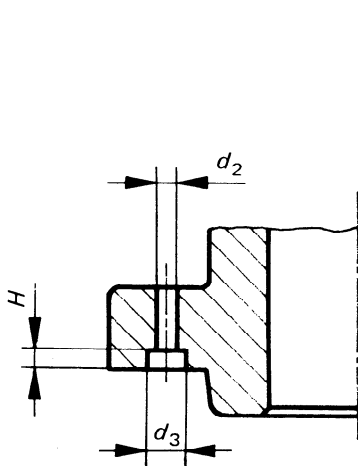


ISO 702-3:1975

<https://standards.iteh.ai/catalog/standards/sist/f06d87b9-5a9e-492d-95ba-ce36b17a562/iso-702-3-1975>

Half section A-A

Section B-B



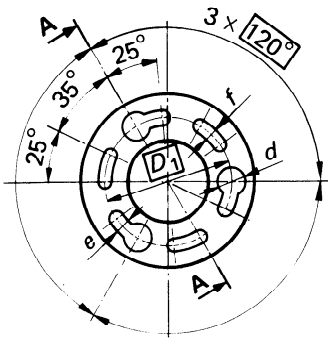
Dimensions in millimetres

Dimension \ No.	3	4	5	6	8	11	15	20
D	53,975	63,513	82,563	106,375	139,719	196,869	285,775	412,775
tol.	+ 0,008 0	+ 0,008 0	+ 0,010 0	+ 0,010 0	+ 0,012 0	+ 0,014 0	+ 0,016 0	+ 0,020 0
D_1	75	85	104,8	133,4	171,4	235	230,2	463,6
D_3	102	112	135	170	220	290	400	540
d	21	21	21	23	29	36	43	43
d_1 H8/h 8	14,25	14,25	15,9	19,05	23,8	28,6	34,9	41,3
d_2	6,4	6,4	6,4	8,4	10,5	10,5	13	13
d_3	10,4	10,4	10,4	13,5	16,5	16,5	19	19
E	11	11	13	14	16	18	19	21
F	16	20	22	25	28	35	42	48
G	5	5	5	5	6	8	8	8
H	10	10	10	11	12	13	15	15
W	0,2	0,2	0,2	0,2	0,2	0,2	0,3	0,3

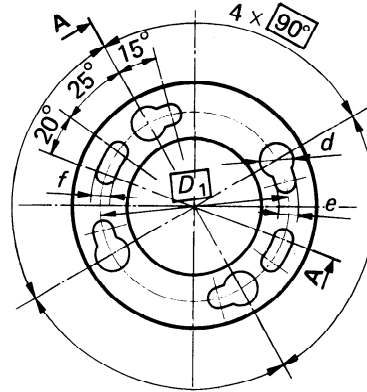
NOTE – General tolerance for untoleranced dimensions : + 0,4 mm.

2.2 Bayonet disc

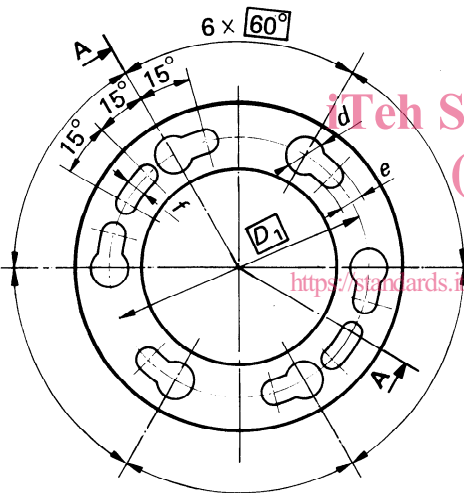
Nos. 3 and 4



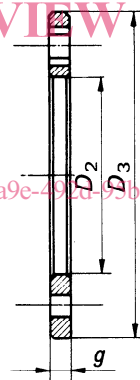
Nos. 5 to 8



Nos. 11 to 20



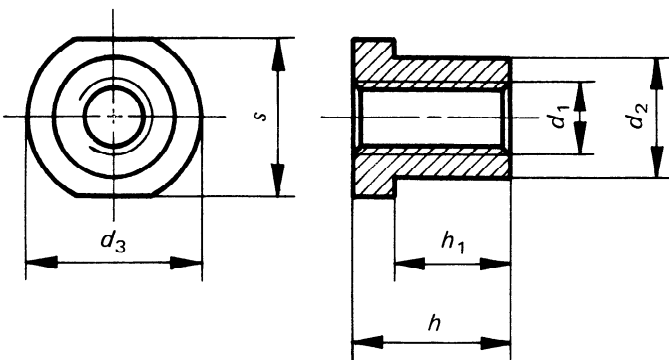
Section A-A



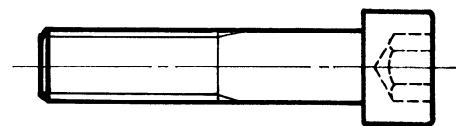
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Thrust socket

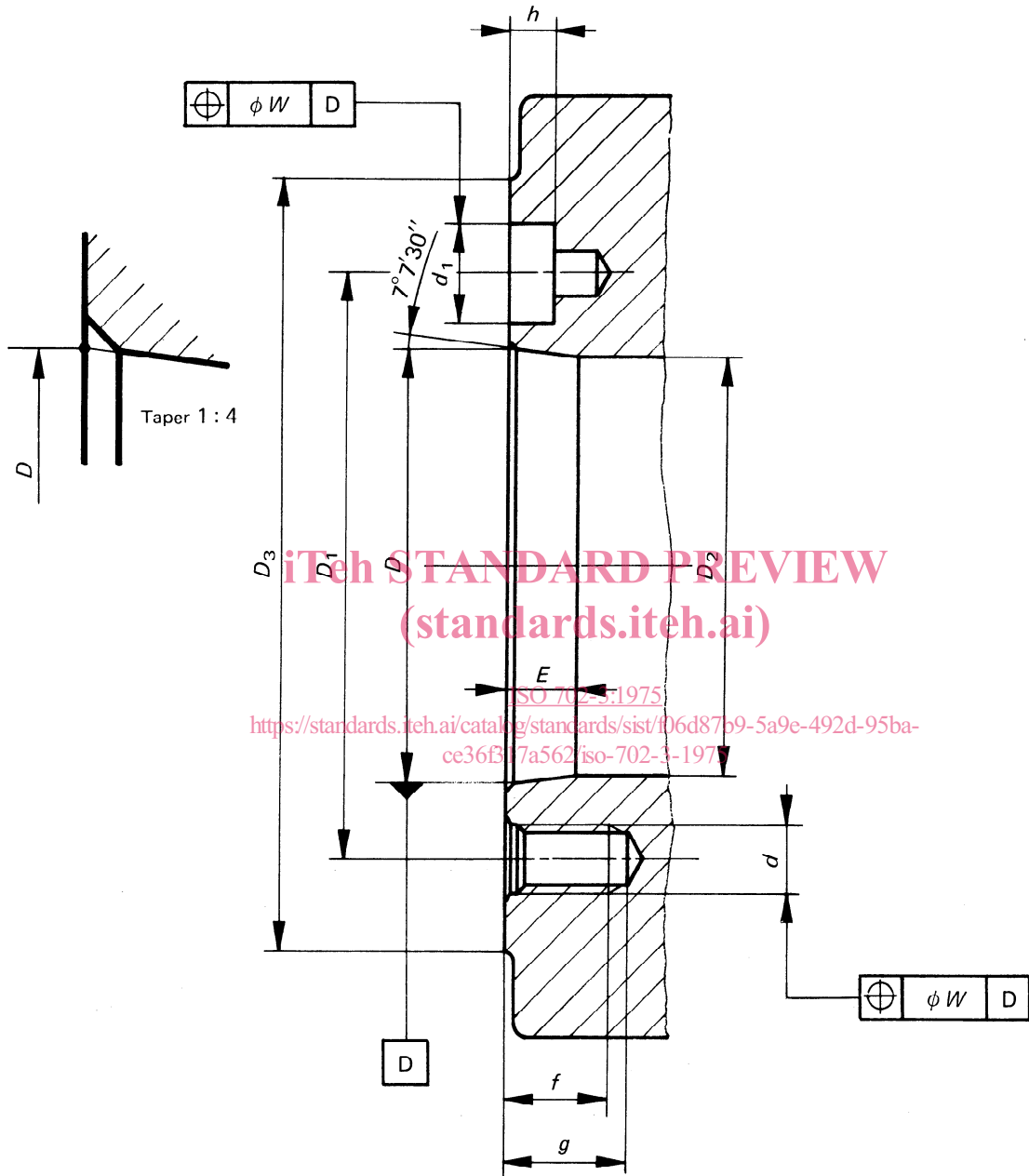


Hexagon socket head screw

Dimensions in millimetres

Dimension \ No.	3	4	5	6	8	11	15	20
D_1	75	85	104,8	133,4	171,4	235	230,2	463,6
D_2 max.	50	60	80	100	130	185	270	400
D_3	110	120	145	180	230	300	410	550
d	21	21	21	23	29	36	43	43
d_1	M 6	M 6	M 6	M 8	M 10	M 10	M 12	M 12
d_2	11	11	11	13	17	17	22	22
d_3	16	16	16	19	25	25	32	32
e	11,5	11,5	11,5	14	18	23	27	27
f	11,5	11,5	11,5	14	18	18	23	23
$g_{-0,1}^0$	5	6	8	10	12	16	18	22
h	8	9	12	15	18	22	26	30
$h_1 \begin{smallmatrix} +0,2 \\ 0 \end{smallmatrix}$	5,2	6,2	8,2	10,2	12,2	16,2	18,3	22,3
s	14	14	14	17	22	22	27	27
W	0,2	0,2	0,2	0,2	0,2	0,2	0,3	0,3
Hexagon socket head screw	M 6 × 15	M 6 × 20	M 6 × 25	M 8 × 30	M 10 × 35	M 10 × 45	M 12 × 55	M 12 × 65

2.3 Face plates



Dimensions in millimetres

Dimension \ No.	3	4	5	6	8	11	15	20
D	53,975	63,513	82,563	106,375	139,719	196,869	285,775	412,775
tol.	+ 0,008 0	+ 0,008 0	+ 0,010 0	+ 0,010 0	+ 0,012 0	+ 0,014 0	+ 0,016 0	+ 0,020 0
D_1	75	85	104,8	133,4	171,4	235	230,2	463,6
D_2	51,5	61	79,6	103,2	136,2	192,9	281,5	408
D_3	102	112	135	170	220	290	400	540
d	M 10	M 10	M 10	M 12	M 16	M 20	M 24	M 24
d_1 $\begin{matrix} + 0,1 \\ 0 \end{matrix}$	10	14,7	16,3	19,45	24,25	29,4	35,7	42,1
E	10	10	12	13	14	16	17	19
f	15	15	15	18	24	30	36	36
g	18	18	18	22	28	34	40	40
h	10	6,5	6,5	6,5	8	10	10	10
W	0,2	0,2	0,2	0,2	0,2	0,2	0,3	0,3
Stud	M 10 × 34	M 10 × 39	M 10 × 43	M 12 × 50	M 16 × 60	M 20 × 75	M 24 × 90	M 24 × 100

NOTE — General tolerance for untoleranced dimensions : ± 0,4 mm.