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

Queues cylindriques d'outils à fraiser —

iTEH Standards
*Partie 2: Caractéristiques dimensionnelles des queues cylindriques à
méplat*

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Reference number
ISO 3338-2:2013(E)

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Published in Switzerland

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2. www.iso.org/directives

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received. www.iso.org/patents

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

The committee responsible for this document is ISO/TC 29, Subcommittee SC 2, *High speed steel cutting tools and their attachments*.

This seventh edition cancels and replaces the sixth edition (ISO 3338-2:2007), of which it constitutes a minor revision. In particular, an annex giving the relationship between the symbols of this part of ISO 3338 and the symbols according to ISO 13399 (all parts) has been added.

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 flattened cylindrical shanks*
- *Part 3: Dimensional characteristics of threaded shanks*

Cylindrical shanks for milling cutters —

Part 2: Dimensional characteristics of flattened cylindrical shanks

1 Scope

This part of ISO 3338 specifies the dimensions of flattened cylindrical shanks for milling cutters, of diameters 6 mm to 20 mm for single-flattened shanks, of 25 mm to 63 mm for double-flattened shanks and of 6 mm to 32 mm for shank with inclined clamping surface. In the case of single-flattened shanks, it is applicable to both single-ended cutters and double-ended cutters, as double-flattened shanks cannot admit single-ended cutters.

The dimensions of plain cylindrical shanks and 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 flattened cylindrical shanks, intended to be mounted in chucks and secured with a clamping screw, and requiring an accuracy adjustment.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For undated references, the latest edition of the referenced document (including any amendments) applies.

http://www.iso.org/iso/iso_catalogue/standard/catalogue_tc_tc_2_2013-05988a2d8-1da9-4cd7-b526-7a991a4bdc1a/iso-3338-2-2013
ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

3 Dimensions

3.1 General

All dimensions and tolerances are given in millimetres. Tolerances not specified shall be of tolerance class "m" in accordance with ISO 2768-1.

3.2 WE form — Flattened cylindrical shanks with single flat for diameter, d_1 , of 6 mm to 20 mm

The dimensions of flattened cylindrical shanks with single flat shall be in accordance with the dimensions shown in [Figure 1](#) and given in [Table 1](#).

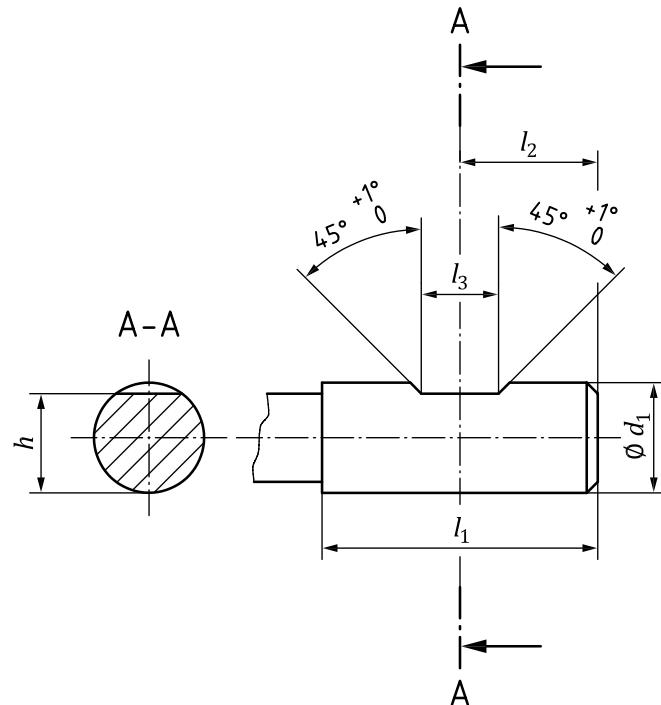


Figure 1 — WE Form — Flatted cylindrical shanks with single flat

3.3 WE form — Flatted cylindrical shanks with double flat for diameter, d_1 , of 25 mm to 63 mm

The dimensions of flatted cylindrical shanks with double flat shall be in accordance with the dimensions shown in [Figure 2](#) and [Table 1](#).

[ISO 3338-2:2013\(E\)](#)

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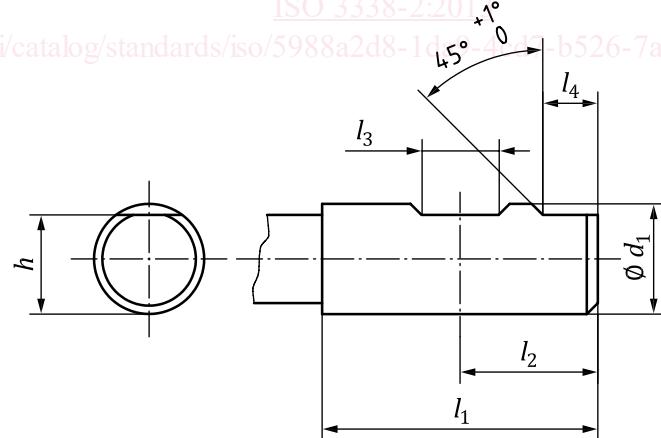


Figure 2 — WE form — Flatted cylindrical shanks with double flat