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## Tool shanks with 7/24 taper for automatic tool changers —

### Part 3: Retention knobs of forms AD, AF, UC, UD, UF, JD and JF

*Queues d'outils à conicité 7/24 pour changement automatique  
d'outils —*

*Partie 3: Tirettes pour queues de formes AD, AF, UC, UD, UF, JD et JF*

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# Contents

	Page
Foreword.....	v
Introduction.....	vi
<b>1 Scope.....</b>	<b>1</b>
<b>2 Normative references.....</b>	<b>1</b>
<b>3 Dimensions.....</b>	<b>1</b>
3.1 General.....	1
3.2 Retention knobs of form AD, for centric inner cooling lubricant supply.....	1
3.3 Retention knobs of form AF, without cooling lubricant supply.....	2
3.4 Retention knobs of form UD, for centric inner cooling lubricant supply.....	3
3.5 Retention knobs of form UF, without cooling lubricant supply.....	4
3.6 Retention knobs of form JD with centric inner cooling supply.....	5
3.7 Retention knobs of form JF, without cooling lubricant supply.....	6
3.8 Retention knobs with data medium, forms AC and UC.....	7
<b>4 Material.....</b>	<b>7</b>
<b>5 O-ring.....</b>	<b>8</b>
<b>6 Designation.....</b>	<b>8</b>
<b>Bibliography.....</b>	<b>9</b>

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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 (see [www.iso.org/directives](http://www.iso.org/directives)).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 2, *Holding tools, adaptive items and interfaces*.

This third edition cancels and replaces the second edition (ISO 7388-3:2013), of which it constitutes a minor revision with the following changes:

- in the title and in all the text, “retention knobs for shanks of form” was changed to “retention knobs of form”;
- forms AC and UC have been deleted from the title and from the designation ([Clause 6](#));
- a footnote was added to [Tables 1](#) and [5](#).

ISO 7388 consists of the following parts, under the general title *Tool shanks with 7/24 taper for automatic tool changers*:

- *Part 1: Dimensions and designation of shanks of forms A, AD, AF, U, UD and UF*
- *Part 2: Dimensions and designation of shanks of forms J, JD, and JF*
- *Part 3: Retention knobs of forms AD, AF, UD, UF, JD and JF*

## Introduction

The aim of ISO 7388 is to integrate existing standards which are most commonly used as an industrial standard. In addition, the different developments for cooling and data chip have been taken into account.

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# Tool shanks with 7/24 taper for automatic tool changers —

## Part 3:

## Retention knobs of forms AD, AF, UC, UD, UF, JD and JF

### 1 Scope

This part of ISO 7388 specifies the dimensions of retention knobs of forms AD, AF, UD, UF, JD and JF for tool shanks with a 7/24 taper for automatic tool changers used on machines having an automatic gripping system for feeding tools from the magazine to the spindle and vice-versa. These tools are designed with the most important dimensions for use in spindle noses according to ISO 9270 (all parts).

### 2 Normative references

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

ISO 1629, *Rubber and latices — Nomenclature*

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 8015, *Geometrical product specifications (GPS) — Fundamentals — Concepts, principles and rules*

### 3 Dimensions

#### 3.1 General

All dimensions and tolerances are given in millimetres; tolerancing is according to ISO 8015. Tolerances not specified shall be of tolerance class “m” in accordance with ISO 2768-1 and of class “k” in accordance with ISO 2768-2.

#### 3.2 Retention knobs of form AD, for centric inner cooling lubricant supply

The dimensions of retention knobs of form AD shall be in accordance with the dimensions shown in [Figure 1](#) and given in [Table 1](#).





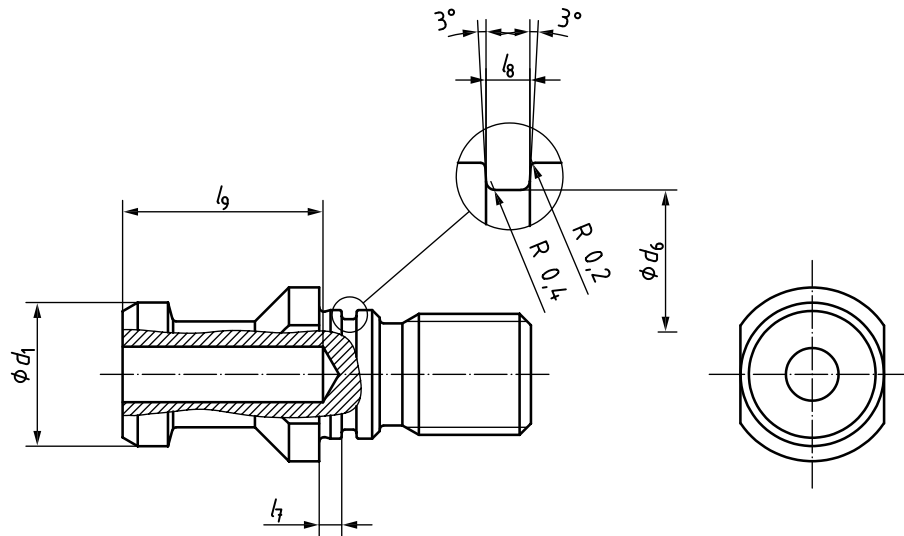


Figure 2 — Retention knob — Form AF — Without cooling lubricant supply

Table 2 — Retention knobs — Form AF — Dimensions

Shank no.	Dimension					O-ring
	$d_1$ f7	$d_6$ h11	$l_7$ 0 -0,1	$l_8$ +0,2 0	$l_9$ +1 0	
30	13	11,5	2,3	1,4	—	11 × 1,0
40	19	14,6	3,0	1,9	27	14 × 1,5
45	23	17,8	3,3	2,5	33	17 × 2,0
50	28	20,8	4,5	3,0	37	20 × 2,5
60	40	27,8	5,5	3,0	45	27 × 2,5

### 3.4 Retention knobs of form UD, for centric inner cooling lubricant supply

The dimensions of retention knobs of form UD shall be in accordance with the dimensions shown in [Figure 3](#) and given in [Table 3](#).