
INTERNATIONAL STANDARD



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

**Parallel shanks for milling cutters —
Part I : Dimensional characteristics of plain parallel shanks**

Queues cylindriques d'outils à fraiser —

Partie I : Caractéristiques dimensionnelles des queues cylindriques lisses

Second edition — 1977-03-15

Corrected and reprinted — 1977-06-01

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[ISO 3338-1:1977](https://standards.iteh.ai/catalog/standards/sist/f66e8284-279e-40bb-b72c-d40bd1e58e04/iso-3338-1-1977)

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UDC 621.914.22

Ref. No. ISO 3338/I-1977 (E)

Descriptors : tools, milling cutters, shanks, parallel shanks, specifications, dimensions.

Price based on 1 page

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.

International Standard ISO 3338/I was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in January 1976.

It has been approved by the member bodies of the following countries:

| | | |
|-----------|-----------------------|----------------|
| Australia | Israel | Spain |
| Austria | Italy | Switzerland |
| Belgium | Japan | Turkey |
| Bulgaria | Korea, Rep. of | United Kingdom |
| France | Mexico | U.S.A. |
| Germany | Netherlands | U.S.S.R. |
| Hungary | Romania | |
| India | South Africa, Rep. of | |

The member bodies of the following countries expressed disapproval of the document on technical grounds:

Poland
Sweden

This International Standard, together with ISO 3338/II, cancels and replaces International Standard ISO 3338-1975, of which these two new documents constitute a technical revision.

Parallel shanks for milling cutters — Part I : Dimensional characteristics of plain parallel shanks

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of plain parallel shanks for milling cutters (of diameters 4 to 63 mm). It is applicable to both single-ended cutters and double-ended cutters.

The dimensions of flatted parallel shanks are the subject of ISO 3338/II.

Threaded shanks are excluded from these two International Standards.

The two shank types covered by ISO 3338/I and II have the same dimensional characteristics (diameters and lengths) but different tolerances on diameters, namely :

- h8 for plain parallel shanks, commonly used for tools mounted in collets;

- h6 for flatted parallel shanks intended to be mounted in chucks and secured with a clamping screw, and requiring an accuracy adjustment.

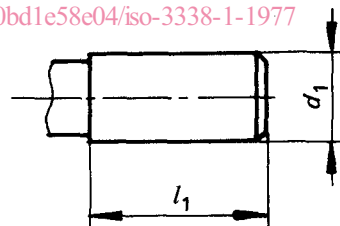
2 REFERENCES

ISO 237, *Rotating tools with parallel shanks — Diameters of shanks and sizes of driving squares.*

ISO 3338/II, *Parallel shanks for milling cutters — Part II : Dimensional characteristics of flatted parallel shanks.*

3 DIMENSIONAL CHARACTERISTICS OF PLAIN PARALLEL SHANKS

See the figure and table below.



Dimensions in millimetres

| | | | | | | | | | | | | | |
|-------------|----|---|-----------------|---|----|------------------|----|----|----|------------------|----|----|----|
| d_1 h8 | 4 | 5 | 6 ¹⁾ | 8 | 10 | 12 ¹⁾ | 16 | 20 | 25 | 32 ¹⁾ | 40 | 50 | 63 |
| $l_1 \pm 1$ | 28 | | 36 | | 40 | 45 | 48 | 50 | 56 | 60 | 70 | 80 | 90 |

1) Not in conformity with ISO 237.

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