
INTERNATIONAL STANDARD 3338 / II

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

Parallel shanks for milling cutters — Part II : Dimensional characteristics of flatted parallel shanks

Queues cylindriques d'outils à fraiser —

Partie II : Caractéristiques dimensionnelles des queues cylindriques à méplat

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[ISO 3338-2:1977](https://standards.iteh.ai/catalog/standards/sist/c6620e2e-a961-41ae-83a8-5b8b76b55e14/iso-3338-2-1977)

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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/II 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	Sweden:1977
Austria	Italy	Switzerland
Belgium	Korea, Rep. of	Turkey
Bulgaria	Mexico	United Kingdom
France	Netherlands	U.S.A.
Germany	Romania	U.S.S.R.
Hungary	South Africa, Rep. of	
India	Spain	

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

Japan
Poland

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

Parallel shanks for milling cutters – Part II : Dimensional characteristics of flatted parallel shanks

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1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of flatted parallel shanks for milling cutters (of diameters 6 to 20 mm for single-flatted shanks and diameters 25 to 63 mm for double-flatted shanks). In the case of single-flatted shanks, it is applicable to both single-ended cutters and double-ended cutters, as double-flatted shanks cannot admit single-ended cutters.

The dimensions of plain parallel shanks are the subject of ISO 3338/I.

Threaded shanks are excluded from these two 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.

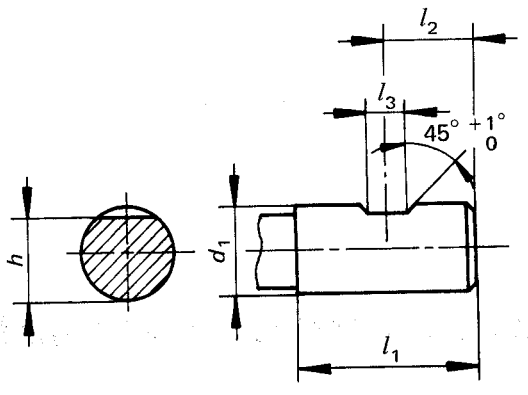
2 REFERENCES

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

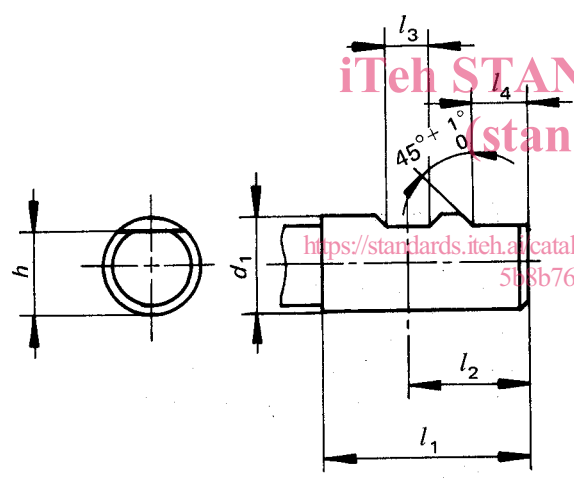
ISO 3338/I, *Parallel shanks for milling cutters – Part I : Dimensional characteristics of plain parallel shanks.*

3 DIMENSIONAL CHARACTERISTICS OF FLATTED PARALLEL SHANKS

3.1 Flatted parallel shanks with single flat for diameters d_1 from 6 to 20 mm



3.2 Flatted parallel shanks with double flat for diameters d_1 from 25 to 63 mm



Dimensions in millimetres

d_1	l_1	l_2	l_3	l_4	h
h6	± 1	$\pm 0,5$	$+ 0,05$ 0	$+ 1$ 0	0 - 0,4
6 ¹⁾	36	18	4,2	X	4,8
8			5,5		6,6
10	40	20	7		8,4
12 ¹⁾	45	22,5	8		10,4
16	48	24	10		14,2
20	50	25	11		18,2
25	56	32	12	17	23
32 ¹⁾	60	36	14	19	30
40	70	40			38
50	80	45	18	23	47,8
63 ¹⁾	90	50			60,8

1) Not in conformity with ISO 237.