
International Standard



3338/2

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

**Parallel shanks for milling cutters —
Part 2: Dimensional characteristics of flatted parallel
shanks**

Queues cylindriques d'outils à fraiser — Partie 2: Caractéristiques dimensionnelles des queues cylindriques à méplat

Third edition — 1985-10-01

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ISO 3338-2:1985

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

Price based on 2 pages

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.

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. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 3338/2 was prepared by Technical Committee ISO/TC 29, *Small tools*.

ISO 3338/2 was first published in 1975. This third edition cancels and replaces the second edition, of which the tolerances on l_1 and l_2 have been revised technically.

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Parallel shanks for milling cutters — Part 2: Dimensional characteristics of flatted parallel shanks

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1 Scope and field of application

This part of ISO 3338 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 given in ISO 3338/1.

Threaded shanks are excluded from ISO 3338/1 and ISO 3338/2.

The two shank types covered by ISO 3338/1 and ISO 3338/2 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.

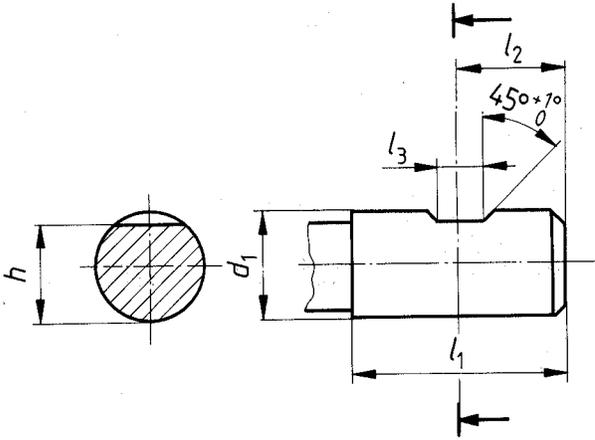
2 References

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

ISO 3338/1, *Parallel shanks for milling cutters — Part 1: Dimensional characteristics of plain parallel shanks.*

3 Dimensional characteristics of flatted parallel shanks

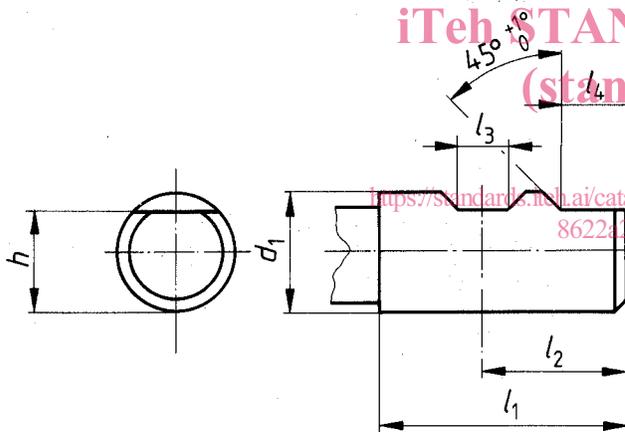
3.1 Flatted parallel shanks with single flat for diameters $d_1 = 6$ to 20 mm



Dimensions in millimetres

d_1	l_1	l_2	l_3	l_4	h
h6	+2 0	0 -1	+ 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					38
50	80	45	18	23	47,8
63	90	50			60,8

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



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1) Not in conformity with ISO 237.