
INTERNATIONAL STANDARD



4202

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

Reduction sleeves with external 7/24 taper for tools with Morse taper shanks

Douilles de réduction au cône extérieur 7/24 pour outils à queue cône Morse

iTeh STANDARD PREVIEW
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[ISO 4202:1978](#)

<https://standards.iteh.ai/catalog/standards/sist/9e540d1b-4b96-4e61-a71e-aa71036f9476/iso-4202-1978>

UDC 621.9.06-229.2

Ref. No. ISO 4202-1978 (E)

Descriptors : tools, Morse taper shanks, chuck bushings, adapter sleeves, dimensions.

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 4202 was developed by Technical Committee ISO/TC 29, *Small tools*. This second edition incorporates Addendum 1 (reduction sleeves with external 7/24 taper No. 45), which was circulated to the member bodies in May 1977, and has been approved by the member bodies of the following countries :

Australia	Hungary	Spain
Austria	India	Sweden
Belgium	Israel	Switzerland
Brazil	Italy	Turkey
Bulgaria	Japan	United Kingdom
Chile	Mexico	U.S.A.
Czechoslovakia	Poland	U.S.S.R.
France	Romania	Yugoslavia
Germany	South Africa, Rep. of	

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No member body expressed disapproval of Addendum 1.
<https://standards.iteh.ai/catalog/standards/sist/9e540d1b-4b96-4e61-a71e-aa71036f9476/iso-4202-1978>
ISO 4202:1978

This second edition cancels and replaces the first edition (i.e ISO 4202-1976), which had been approved by the member bodies of the following countries :

Australia	India	Spain
Austria	Israel	Sweden
Belgium	Italy	Switzerland
Bulgaria	Japan	Turkey
Czechoslovakia	Mexico	United Kingdom
France	Poland	U.S.S.R.
Germany	Romania	Yugoslavia
Hungary	South Africa, Rep. of	

No Member Body had expressed disapproval of the document.

Reduction sleeves with external 7/24 taper for tools with Morse taper shanks

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1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of reduction sleeves with external 7/24 taper (Nos. 30, 40, 45, 50 and 60) for tools with Morse taper shanks (Nos. 1 to 6).

All these sleeves allow driving of tools having Morse taper shanks which have a tenon at the small end of the shank; some sleeves allow driving of tools having Morse taper shanks which have an axially tapped hole in the shank :

- with the use of an incorporated screw for sleeves 30 × 1 – 40 × 1 – 40 × 2 – 45 × 1 – 45 × 2 – 45 × 3 – 50 × 2 – 50 × 3 – 50 × 4 – 60 × 3 – 60 × 4 – 60 × 5;

- with the use of a draw bar for sleeves 30 × 1 – 30 × 2 – 40 × 1 – 40 × 2 – 40 × 3 – 45 × 1 – 45 × 2 – 45 × 3 – 45 × 4 – 50 × 2 – 50 × 3 – 50 × 4 – 50 × 5 – 60 × 3 – 60 × 4 – 60 × 5 – 60 × 6.

Morse tapers conform to ISO 296 and 7/24 tapers are in accordance with ISO 297 and ISO 2583.

2 REFERENCES

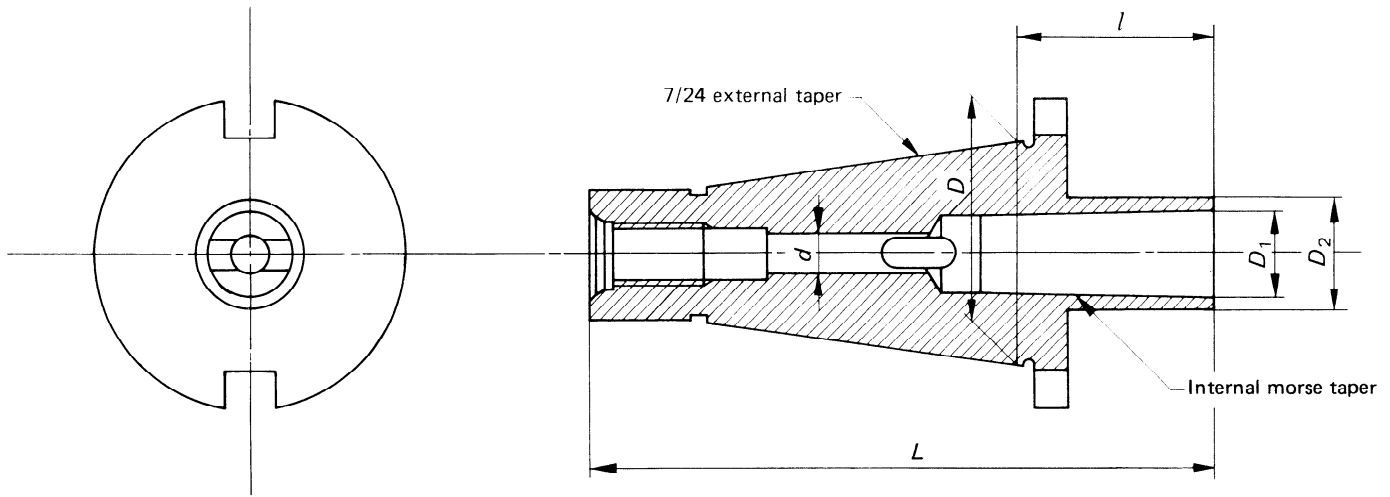
ISO 296, *Machine tools – Self-holding tapers for tool shanks.*

ISO 297, *7/24 tapers for tool shanks.*¹⁾

ISO 2583, *Tool shanks and equipment with 7/24 tapers – Collar dimensions.*

1) At present at the stage of draft. (Revision of ISO/R 297-1963 and addenda 1,2 and 3.)

3 DIMENSIONS



NOTE — The sketch is diagrammatic and is not intended to show design details.

iTeh STANDARD PREVIEW Dimensions in millimetres

Designation		D	D_1	D_2	d	l max.	L max.
7/24 external taper	Internal Morse taper						
30	1	31,750	12,065	25	6,2	50	118
	2		17,780	32	10,3	50	118
	3		23,825	40	12,5	70	138
40	1	44,450	12,065	25	6,2	50	143
	2		17,780	32	10,3	50	143
	3		23,825	40	12,5	65	158
	4		31,267	48	17,0	95	188
45	1	57,150	12,065	25	6,2	50	157
	2		17,780	32	10,3	50	157
	3		23,825	40	12,5	65	172
	4		31,267	48	17,0	75	182
	5		44,399	63	21,0	125	232
50	2	69,850	17,780	32	10,3	60	187
	3		23,825	40	12,5	65	192
	4		31,267	48	17,0	70	197
	5		44,399	63	21,0	105	232
60	3	107,950	23,825	40	12,5	70	277
	4		31,267	48	17,0	70	277
	5		44,399	63	21,0	70	277
	6		63,348	80	25,0	100	307