
INTERNATIONAL STANDARD



4204

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

Countersinks, 90°, with Morse taper shanks and detachable pilots

Outils à chanfreiner à 90°, à queue cône Morse et pilote amovible

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[ISO 4204:1977](#)

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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 4204 was drawn up 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	Italy	Spain
Austria	Japan	Sweden
Belgium	Korea, Rep. of	Switzerland
Brazil	Mexico	Turkey
Bulgaria	Netherlands	United Kingdom
Germany	Poland	U.S.S.R.
Hungary	Romania	
Israel	South Africa, Rep. of	

The member body of the following country expressed disapproval of the document on technical grounds :

U.S.A.

Countersinks, 90°, with Morse taper shanks and detachable pilots

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1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of 90° countersinks with Morse taper shanks and detachable pilots for general use.

The illustration is diagrammatic only and is not intended to indicate details of design.

2 REFERENCES

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

ISO 4207, *Counterbores with Morse taper shanks and detachable pilots.*

ISO 4208, *Detachables pilots for use with counterbores and 90° countersinks.*

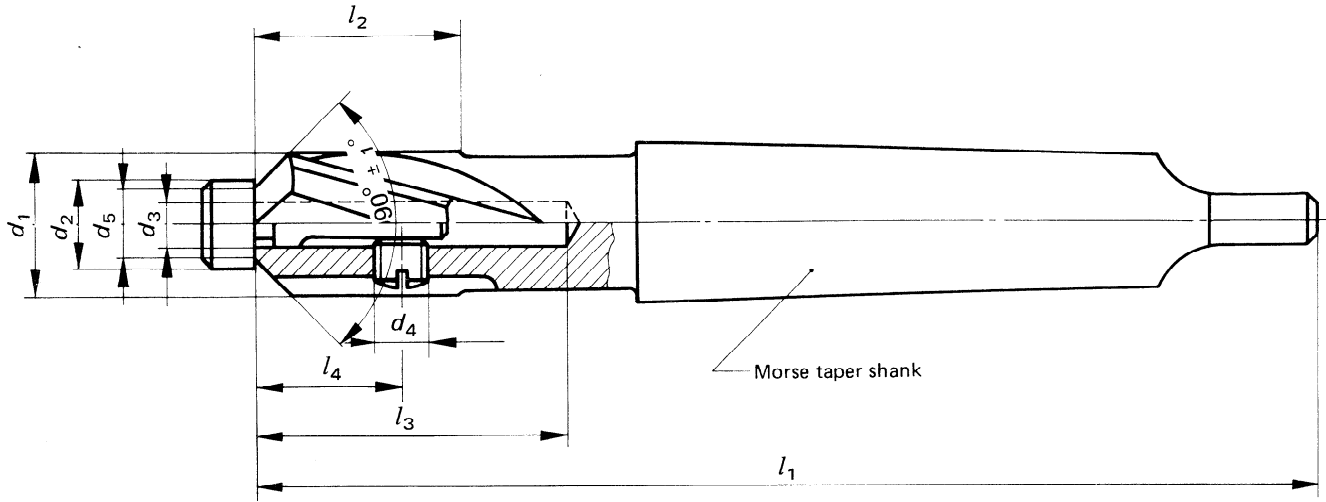
3 DIMENSIONS

The dimensions for 90° countersinks with Morse taper shanks and detachable pilots are given in the table. It specifies dimensions in metric units only, these being regarded as the only recommended dimensions in the future.

4 TOLERANCES

The tolerances relating to the countersink, Morse taper shanks and detachable pilots are as follows :

- cutting diameter d_1 : z9
- pilot diameter d_2 : e8
- pilot hole diameter d_3 : H8
- Morse taper : according to ISO 296.



Dimensions in millimetres

Cutting diameter d_1 (z9)		Pilot diameter d_2 (e8)		d_3 H8	Set screw d_4	d_5	l_1	l_2	l_3	l_4	Morse taper shank No.
over	to	over	to								
12,5	16	6,3	14	4	M3	6	132	22	30	16	2
16	20	6,3	18	5	M4	6	140	25	38	19	
20	25	8	22,4	6	M5	7,5	150	30	46	23	
25	31,5	10	28	8	M6	9,5	180	35	54	27	3
31,5	40	12,5	35,5	10	M8	12	190	40	64	32	