
**Modular taper interface with ball
track system —**

**Part 1:
Dimensions and designation of shanks**

Interfaces à cône modulaire avec système de serrage à billes —

Partie 1: Dimensions et désignation des queues

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ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

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Foreword

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This document was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 26622-1:2008), [Figure 1](#) of which has been technically revised to correct the following:

- gauge diameter, d_2 ;
- tool changer groove diameter, d_3 ;
- ball track dimensioning, related to b_2 , w_2 and d_9 ;
- flange hole dimensioning, related to l_{24} and d_{13} ;
- taper undercut depth;
- divers other corrections in the drawings.

A list of all parts in the ISO 26622 series can be found on the ISO website.

Introduction

The modular taper with ball track system design originated from a joint development effort between two prominent tooling manufacturers in 1985. The benefits to be achieved by the joint development effort were to offer a complete but flexible tooling system-to-machine connection by joining the strengths of two tooling suppliers for the European and North American markets. The modular taper with ball track system product was first introduced at exposition mondiale de la machine-outil (EMO) in Milan in 1987.

Since its introduction, this tooling system has become a globally accepted design for both static and rotating applications. The design characteristics of the modular taper interface with ball track system allow it to be used equally well on both turning and rotating applications. The high mechanical advantage of the modular taper with ball track system design application allows for small springs, small bearings and high spindle speeds. This tool interface uses three areas of contact (one face and two on the taper) that provide a very simple but rigid tool design. These features have made the modular taper with ball track system the quick-change tooling of choice on many tens of thousands of machine tools throughout the world.

The purpose of this document is to ensure compliance of the manufacturing accuracy and quality of the modular taper with the ball track system tool interface.

The International Organization for Standardization (ISO) draws attention to the fact that it is claimed that compliance with this document can involve the use of a patent concerning the modular taper with ball track system.

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CP 56 - CH-1211 Geneva 20, Switzerland