



International
Standard

ISO 26622-3

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

**Part 3:
Dimensions of shanks for interface
utilizing four locking elements**

Interfaces à cône modulaire avec système de serrage à billes —

*Partie 3: Dimensions de la queue pour une interface utilisant
quatre éléments de verrouillage*

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Sample Document

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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This document was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, holding tools, cutting items, adaptive items and interfaces*.

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

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Modular taper interface with ball track system —

Part 3: Dimensions of shanks for interface utilizing four locking elements

1 Scope

This document specifies dimensions of tapered shanks for modular taper interfaces with ball track system with four locking elements for automatic and manual tool exchange to be applied on machine tools (e.g. lathe machines, drilling machines, milling machines and turn/milling machine centres). A range of shank sizes is specified. Details of the coolant sealing coolant tube and coolant sealing O-ring shall be specified according to [Annex A](#) and [Annex B](#).

The shank incorporates a flange with a groove to enable automatic tool exchange. The tools can also be exchanged manually. The clamping of the shank can be realized using locking balls of a standard size and by a variety of mechanisms.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 8015, *Geometrical product specifications (GPS) — Fundamentals — Concepts, principles and rules*

ISO 22081, *Geometrical product specifications (GPS) — Geometrical tolerancing — General geometrical specifications and general size specifications*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

4 Dimensions

4.1 General

Tolerances shall be in accordance with ISO 8015.

General tolerances shall be in accordance to ISO 22081, such that the surface profile be within a tolerance of 0,2 mm with respect to the primary datum A, secondary datum B, and tertiary datum C. Additionally, the permissible deviations for linear dimensions not otherwise specified shall be in accordance to the values defined in [Table 1](#) and the permissible deviations for angular dimensions not otherwise specified shall be in accordance to the values defined in [Table 2](#).

Table 1 — Permissible deviations for linear dimensions

Dimensions in millimetres

Nominal linear size	≤ 6	$6 < S_1 \leq 30$	$30 < S_1 \leq 120$	$120 < S_1 \leq 400$
Tolerance values	$\pm 0,1$	$\pm 0,2$	$\pm 0,3$	$\pm 0,5$

Table 2 — Permissible deviations for angular dimensions

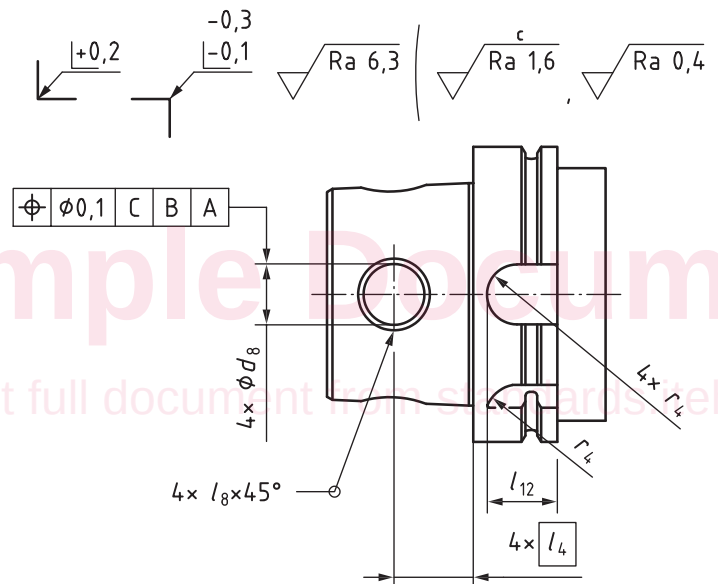
Dimensions in millimetres

Nominal length of short leg	≤ 10	$10 < S_2 \leq 50$	$50 < S_2 \leq 120$	$120 < S_2 \leq 400$
Tolerance values	$\pm 1^\circ$	$\pm 0^\circ 30'$	$\pm 0^\circ 20'$	$\pm 0^\circ 10'$

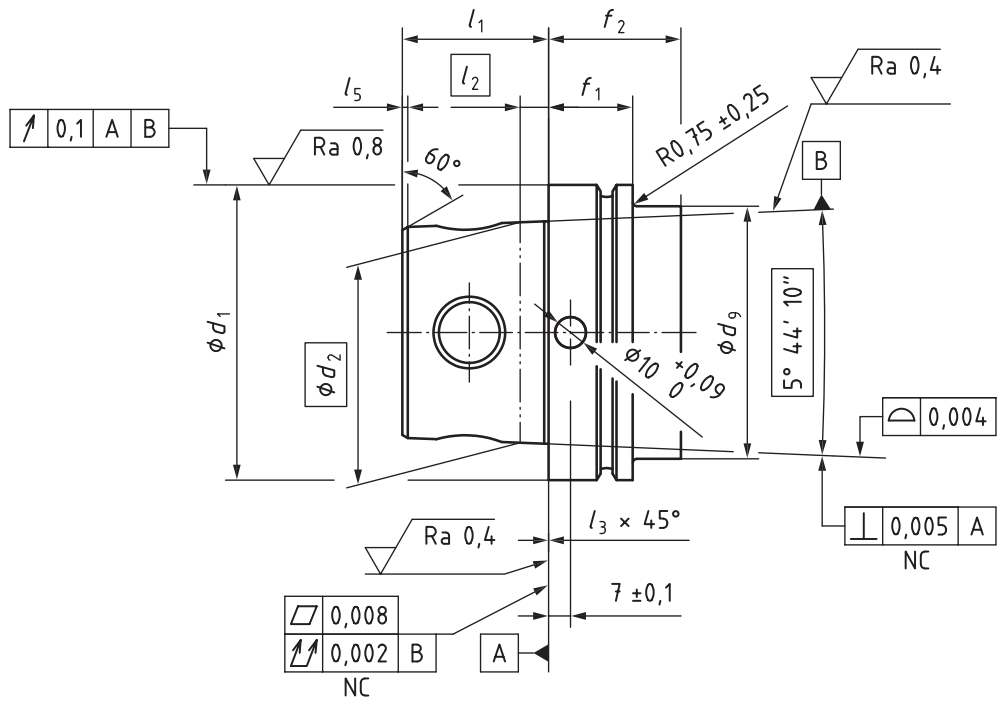
4.2 Tapered hollow shank

The dimensions of modular tapered shanks with the ball track system with four locking elements and the details of automatic tool changer/chip hole configuration are shown in Figure 1 and given in Table 3.

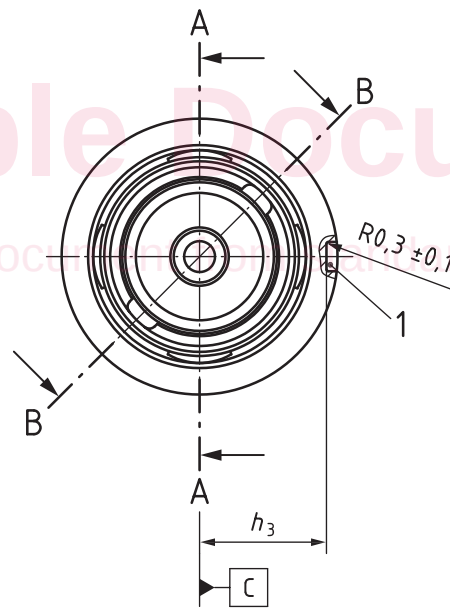
Surface roughness in micrometres
Dimensions in millimetres



a) Outside views of tapered shank



b) Outside views of tapered shank



c) Outside views of tapered shank