
**Morse taper shank countersinks for
angles 60 degrees, 90 degrees and 120
degrees inclusive**

*Outils à chanfreiner à queue cône Morse, à angle au sommet de 60
degrés, 90 degrés et 120 degrés*

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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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

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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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This second edition cancels and replaces the first edition (ISO 3293:1975), of which it constitutes a minor revision.

Morse taper shank countersinks for angles 60 degrees, 90 degrees and 120 degrees inclusive

1 Scope

This International Standard specifies the dimensions of Morse taper shank countersinks for angles 60°, 90° and 120° inclusive.

It specifies dimensions in metric units only, these being regarded as the only recommended dimensions in the future, for countersinks with cutting diameters in the range 16 mm to 80 mm.

The dimensions given apply only to tools made from high speed steel. However, if the method of production allows, the shanks may be manufactured from a suitable alternative material, such as a carbon steel.

The Morse taper shanks are in accordance with ISO 296.

Unless otherwise indicated, the countersinks will be right-hand cutting.

Parallel shank countersinks are the subject of ISO 3294.

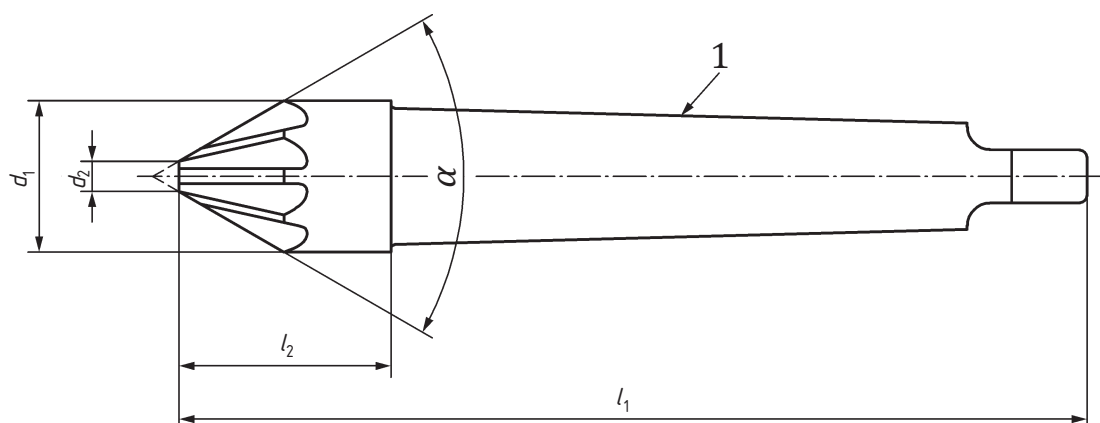
2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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

3 Dimensions

See [Figure 1](#) and [Table 1](#).



Key

1 Morse taper shank (according to ISO 296)

α = 60°, 90° or 120° inclusive (tolerance: ${}^0_{-1^\circ}$)

Figure 1