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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 10944.1-2013

Replacing GB/T 10944.1-2006

**Tool shanks with 7/24 taper for automatic tool changers -- Part
1: Dimensions and designation of shanks of forms A, AD, AF, U,
UD and UF**

自动换刀7:24圆锥工具柄 第1部分：A、AD、AF、U、UD和UF型柄的尺寸和标记
(English Translation)

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Foreword

GB/T 10944 "ATC 7.24 cone tool shank" is divided into five sections.

--- Part 1. A, AD, AF, U, UD and UF type shank dimensions and marking;

--- Part 2. J, JD and JF type shank dimensions and marking;

Part --- Section 3. AC, AD, AF, UC, UD, UF, JD and JF type Rivet;

--- Part 4. handles the technical conditions;

--- Part 5. Rivet technical conditions.

This section GB/T Part of 110,944.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This Part replaces GB/T 10944.1-2006 "automatic tool changer with tool shank taper 7.24 Part 40, 45 and 50 handle 1.

Size and taper angle tolerance ", compared with the GB/T 10944.1-2006, the main technical changes are as follows.

--- Modify the name in English;

--- Modify the scope;

--- Modify the normative references;

--- Remove the original tool shank shown (Figure 1), adding a new type A and U-shank icon;

--- Remove the original tool shank size table (Table 1), adding a new type A and U-shank size table;

--- Remove the cone angle tolerances, annotations directly on the chart;

--- Tool shank model increased by 30 and 60, the corresponding type and size has also

increased;

- Increase the size of some models of the tool shank of 40,45,50;
- Provide increased coolant hole of AD, AF, UD and UF tool handles;
- Handle increased data chip with holes;
- Increased material and heat treatment information;
- Increasing the mark;
- Increased by reference.

This section uses the translation method identical with ISO 7388-1:2007 "with 7/24 taper for automatic tool changers tool shank - Part 1. A, AD, AF, U, UD and UF type shank types and dimensions "(in English).

Consistency correspondence between this part of international documents and normative references of our files are as follows.

- GB/T 1804-2000 General tolerances Tolerances for linear and angular dimensions without individual tolerance (eqv ISO 2768-1. 1989);
- GB/T 1184-1996 shape and position tolerances without individual tolerance value (eqv ISO 2768-2. 1989);
- GB/T 4249-2009 Geometrical product specifications (GPS) principles of tolerance (ISO 8015. 1985, MOD).

This part of ISO 7388-1:2007 compared to modify the following editorial.

- Tags, ISO 7388 with the GB/T 10944.1 instead.

This part is proposed by China Machinery Industry Federation.

This part of the tool by the National Standardization Technical Committee (SAC/TC91) centralized.

This section is responsible for drafting unit. Chengdu Tool Research Institute Co., Ltd., Chengdu into a tool Group Co., Ltd., Harbin Measuring & Cutting Tool Sets Group limited liability company.

1 Scope

GB/T 10944 in the provisions of this Part A, AD, AF, U, UD and UF automatic tool changer 7.24 taper tool shank size, which Species conical tool holder with a suitable delivery vehicle from the magazine to the spindle or spindle from the tool to the magazine conveyor automatic gripper system from Movable tool change on the machine to use. The most important of these dimensions of the tool shank and spindle nose size according to ISO

9270 to match the design.

This section applies to automatic tool change tool shank taper 7.24.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

ISO 2768-1 General tolerances - Part 1. No NOTE tolerances for linear and angular tolerances (General tolerances-Part 1.

Tolerances for linear and angular dimensions without individual tolerance indications) ISO 2768-2 General tolerances - Part 2. No individual tolerance components of geometric tolerances (General tolerances-Part 2.

Geometric tolerances for features without individual tolerance indications first edition; CEN EN 22768-2:1993) ISO 8015 Technical drawings - tolerancing basic principles (Technical drawings-Fundamental tolerancing principle)

3.1 General provisions

All dimensions and tolerances are in millimeters, tolerance according to ISO 8015, ISO 2768-1 did not note tolerance press the "m" level and press ISO 2768-2 of "k" level.

3.2 A and U shank

Figure 1 and Table 1.