

ICS 25.100.01

CCS J41



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

GB/T 10944.4-2013

Replacing GB/T 10944.2-2006

**Tool shanks with 7/24 taper for automatic tool changers - Part
4: Technical specifications for shanks**

自动换刀7:24圆锥工具柄 第4部分：柄的技术条件

Issued on: December 31, 2013

Implemented on: October 1, 2014

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China;
Standardization Administration of China**

Table of Contents

- 1 Scope
- 2 Normative references
- 3 Cone angle tolerances and
- 4 Manufacturability
- 5 Appearance and surface roughness
- 7.24 Part 4. handles the technical conditions

Foreword

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 410,944. This section drafted in accordance with GB/T 1.1-2009 given rules. This Part replaces GB/T 10944.2-2006 "automatic tool changer with

7.24 taper tool shank -40,45 and 50 shank - Part 2. Technical conditions ", compared with the GB/T 10944.2-2006, the main changes are as follows:

- Modify the name in English;
 - Modify the scope;
 - Modify the normative references;
 - Modify the reference symbols and the roughness symbol format in Figure 1;
 - Modify the tool shank taper
- 7.24 conical shape error inspection;
- Modify the flag

1 Scope

GB/T 10944.4-2013 is the Chinese national standard on tool shanks with 7/24 taper for

automatic tool changers - part 4: technical specifications for shanks, in the field of manufacturing engineering. The /T suffix marks it as a recommended standard: it is not compulsory by itself, but it becomes binding as soon as a contract, a tender or a customer specification calls it up - which in practice is how most foreign buyers meet it. It was issued on 31 December 2013 by the General Administration of Quality Supervision, Inspection and Quarantine of the People's Republic of China; Standardization Administration of China, and has been in force since 1 October 2014. Classification: ICS 25.100.01, CCS J41. This page is published from the official record of the standard held by the Chinese standards administration: the identification, the dates, the classification and the issuing body are taken from there. The clause text, the tables and the numeric limits are in the document itself, which is delivered complete in English translation.

GB/T 10944 provisions of this part of the automatic tool changer with tool shank taper

7.24 A, AD, AF, U, UD, UF, J, JD and JF type Shank taper angle tolerance and inspection, process, appearance and surface roughness, and material hardness, marking and packaging of basic requirements. This section applies to press GB/T 10944.1 and GB/T 10944.2 production of 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. Dimensions and A, AD, AF, U, UD and UF type handle.

GB/T 10944.1 ATC tool shank taper 7.24 - Part 1 mark GB/T 10944.2 ATC

7.24 taper shank tools - Part 2. J, JD and JF type shank dimensions and marking

GB/T 11852-2003 cone gauge tolerances and technical conditions

3 Cone angle tolerances and

Taper angle tolerance value 3.1

7.24 taper tool shank taper according to GB/T 10944.1 and GB/T 10944.2 requirements.

3.2

7.24 taper tool shank taper shape error according to GB/T 10944.1 and GB/T 10944.2 requirements. 3.3

7.24 taper tool shank taper angle should be used to compare the test measurements can also be used cone gauge measurements. Press the test specification GB/T 11852-2003 Appendix A of the relevant provisions. Comparative measurements with arbitration dispute.

4 Manufacturability

Threaded shank by 4.1 6H precision manufacturing, and should be equipped with pulling nails at maximum material condition can be smoothly screwed.

4.2 should bottom groove fillet.

5.1

7.24 taper surface should not affect scratches, rust, grinding burn and cracks the use of functional defects. In addition to

5.2 GB/T 110 944 Part and Part 2 provisions, the rest of the surface roughness of the provisions shown in Figure 1.