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

GB/T 1112.1-1997

Replacing GB/T 1112.1-1997; GB/T 1112.3-1997; GB/T 1112.2-1997

**Slot drills
(English Translation)**

Issued on: January 1, 1970

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Foreword

This standard rule according to GB/T 1.1-2009 given draft.

This standard is GB/T 1112.1-1997 "keyway cutters Part 1. straight shank keyway cutter type and size" GB/T 1112.2-1997 "keyway cutters - Part 2. Morse taper shank keyway cutter type and size" and GB/T 1112.3-1997 "key Slot cutters - Part 3. Technical conditions" consolidated amendments.

This standard replaces GB/T 1112.1 ~ 1112.3-1997.

This standard and GB/T 1112.1 ~ 1112.3-1997 technical differences are as follows.

--- The three parts into one standard;

--- Amend the foreword;

--- Remove the ISO foreword;

--- Modify the scope;

--- Modify the normative references;

--- Straight shank keyway cutters and taper shank keyway cutters increase in length recommended series;

--- Taper shank keyway cutters added size 6, size 7, size 8 and size 38;

--- Modified tag example;

--- Technical conditions and increased requirements shank material;

--- Delete the contents of the performance tests.

This standard uses redrafted law, reference ISO 1641-1:2003 "keyway cutter and milling cutter - Part 1. straight shank cutter" and ISO 1641-2:2011 "and end mills Slot drills - Part 2. Morse taper shank cutter" establishment, with its non-equivalent.

The standard proposed by China Machinery Industry Federation.

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

Drafting of this standard. Chengdu into a tool Group Co., Ltd., Zhejiang Province tool cutting tool detection and processing technology research focused on real Laboratory, measuring and cutting tools factory in Changshu, Chengdu Tool Research Institute Limited.

1 Scope

This standard specifies the general straight shank keyway cutter, flatted straight shank keyway milling cutter, 2 ° beveled straight shank keyway cutter, keyway cutters and threaded shank Basic requirements Morse taper shank keyway cutter type, size, label and technical conditions.

This standard applies to a diameter of 2mm ~ 63mm keyway cutter.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated edition applies to this article Member. Where not dated references, the latest edition (including any amendments) applies to this document.

GB/T 1443 machine tools and tool handles with a clip from the cone (GB/T 1443-1996, eqvISO 296.1991) GB/T 4133 Morse tapers transmission type and size (GB/T 4133-1984, eqvISO 5413. 1976) GB/T 6118 end mills technical conditions GB/T 6131.1 straight shank cutters - Part 1. The types and dimensions ordinary straight shank (GB/T 6131.1-2006, ISO 3338-1.

1996, IDT)

GB/T 6131.2 straight shank cutters - Part 2. flatted straight shank type and size (GB/T 6131.2-2006, ISO 3338-2.

2000, MOD)

GB/T 6131.3 straight shank cutter Part 3. 2 ° beveled straight shank types and dimensions GB/T 6131.4 straight shank cutter Part 4. The types and dimensions of the threaded shank

3.1 Straight shank cutter keyway

Straight shank cutter keyway according shank type divided into four types as shown in Figure 1 to Figure 4. divided according to their different lengths, short, standard system Recommended series of columns and its size as shown in Table 1. The shank dimensions and deviations respectively GB/T 6131.1, GB/T 6131.2, GB/T 6131.3 and GB provisions/T6131.4's.

1 ordinary straight shank cutter keyway