

ICS 25.100.20
CCS J 41



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

GB/T 1115-2022

**Cylindrical cutters
(English Translation)**

Issued on: January 1, 1970

Implemented on: January 1, 1970

**Issued by: State Administration for Market Regulation, China National
Standardization Administration**

Table of Contents

- Foreword
- 1 Scope
- 2 Normative references
- 3 Terms and Definitions
- 4 Types and Dimensions
- 4.1 Solid cylindrical milling cutter

Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1: Structure and Drafting Rules of Standardization Documents" drafted.

This document replaces GB/T 1115.1-2002 "Cylindrical milling cutters - Part 1: Types and dimensions" and GB/T 1115.2-2002 "Circular milling cutters" Cylindrical milling cutters - Part 2: Technical conditions", compared with GB/T 1115.1-2002 and GB/T 1115.2-2002, except for structural adjustment and in addition to editorial changes, the main technical changes are as follows.

- Changed the scope (see Chapter 1, Chapter 1 of the 2002 edition);
- Increased the combined cylindrical milling cutter (see 4.2);
- Increase the mark of the combined cylindrical milling cutter (see 4.3);
- Increased the material and hardness of high-performance high-speed steel (see Chapter 6, Chapter 4 of GB/T 1115.2-2002).

This document is modified using ISO 2584:2016 "Metric Series of Cylindrical Milling Cutter Driven by Straight Hole and Flat Key".

The technical differences between this document and ISO 2584:2016 and their reasons are as follows.

- Increased the limit deviation of cylindrical milling cutter dimension L;
- Added mark to facilitate the use of this document;
- Increased the geometric tolerance of cylindrical milling cutters to facilitate the use of this document;
- Increased material and hardness to facilitate the use of this document;

- Increased appearance and surface roughness to facilitate the use of this document;
- Added signs and packaging to facilitate the use of this document;
- Added Appendix B to facilitate the use of this document.

Please note that some content of this document may be patented. The issuing agency of this document assumes no responsibility for identifying patents.

1 Scope

This document specifies the types and dimensions and technical condition.

This document applies to the manufacture of solid cylindrical milling cutters and combined cylindrical milling cutters.

See Appendix A for the relationship between this document and ISO 13399 (all parts) notations.

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text. Among them, dated citations documents, only the version corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to this document.

GB/T 6132 Interchangeable dimensions of milling cutters and milling cutter holders (GB/T 6132-2021, ISO 240:2016, IDT)

3 Terms and Definitions

There are no terms and definitions that need to be defined in this document.

4.1 Solid cylindrical milling cutter

The overall cylindrical milling cutter type is shown in Figure 1, and the dimensions are shown in Table 1. Can be made into straight teeth or helical teeth (left-hand or right-hand).

Figure 1 Integral cylindrical milling cutter