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

GB/T 1132-2017

Replacing GB/T 1132-2004

**Machine chucking reamers with cylindrical shanks and Morse
taper shanks**

直柄和莫氏锥柄机用铰刀

(English Translation)

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Foreword

This standard is drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces GB/T 1132-2004 "Reamer for Straight Shank and Morse Taper Shank". This standard is compared with GB/T 1132-2004 the technical changes are as follows.

- the provisions of the scope of the recommended only and the provisions of the provisions of the metric size, straight handle and Mohs taper shank with other provisions of the reamer 3.1 in the provisions;
- adjust the contents of the original standard range to the third chapter type and size;
- modified the normative reference file;
- all figures and the table sign reamer diameter d , total length L , blade length l , handle length l_1 , handle diameter d_1 by the standard symbol $D1$, l_1 , l_2 , l_3 , d_2 instead;
- the original Chapter 3 "handle" the contents of the adjustment to Chapter 3;
- increase 3.1 general requirements;
- Chapter 4 Title is changed from "Tolerance" to "Length Tolerance", part of which is adjusted to Chapter 3;
- adjust the size of the original reamer in Chapter 5 and Chapter 6 to Chapter 3;
- adjust the original 7th chapter mark example to the fifth chapter mark example;
- Table 2 and Table 4 add to the description of the cutting diameter measurement and the special tolerance reamer length and handle size and tolerances.

This standard uses the re-drafting method to modify the ISO 521.:2011 "straight handle and the Mo's taper shank reamer".

The technical differences between this standard and ISO 521.:2011 are as follows.

- modified the scope of the international standard (see Chapter 1), part of the content included in 3.1, the reasons for the editor;
- normative reference documents, ISO 237 replaced with GB/T 4267; ISO 296 replaced with GB/T 1443; increased GB/T 4246 (see Chapter 2);
- In accordance with the actual situation in the country, in 3.1 to increase the processing of specific tolerance hole reamer diameter tolerance requirements;
- Find the reason for convenience, increase the length of Chapter 4 tolerance, the length of the table tolerance included in this chapter;
- According to the actual situation of the country, an example of the fifth chapter is added;
- According to the actual situation in the country, Appendix A has been added.

Compared with ISO 521.:2011, the editorial changes are as follows.

- modify the indication position of "1" in Figure 1;

The instructions in Figure 1 and Figure 2 are adjusted to 3.2 and 3.3.

This standard is proposed by the China Machinery Industry Federation.

This standard is under the jurisdiction of the National Tool Standardization Technical Committee (SAC/TC91).

This standard is responsible for drafting units. Chengdu Institute of Tools Co., Ltd., Henan a tool Tools Co., Ltd.

1 Scope

This standard specifies the type and dimensions of reamers for straight shank and Morse taper shank and examples of marking.

This standard applies to the diameter of more than 1.32mm ~ 20mm straight handle reamer and diameter greater than 5.30mm ~ 50mm Mohs Cone reducer with taper shank.

This standard applies to the standard reamer with a tolerance of d6 of m6.

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article Pieces. For undated references, the latest edition (including all modifications) applies to this document.

GB/T 1443 Self-clamping cones for machine tools and tool handles (GB/T 1443-2016, ISO 296.:1991, MOD) GB/T 4246 Reamer special tolerances (GB/T 4246-2004, ISO 522. 1975, IDT) GB/T 4267 Straight handle rotary tool Shank diameter and size of the drive head (GB/T 4267-2004, ISO 237. 1975, IDT)

3.1 General provisions

Unless otherwise stated, these reamers are made to the right cut. Straight or spiral grooves are determined by the manufacturer.

Two counters are listed for the straight and Morse taper reducers used in this standard, one for priority and other corresponding Size; the other is the diameter of the segmented size. The length of the reamer, the diameter of the cutting part and the diameter of the shank of the straight handle are also specified.

The diameter of the reamer for machining the specific tolerance hole is designed according to GB/T 4246. This standard gives the processing H7, H8, H9 hole reamer diameter limit deviation.

3.2 Reamer with straight handle

Straight handle with reamer type and size shown in Figure 1 and Table 2, Table 3.

Straight handle according to GB/T 4267.

3.3 Reamer with Morse taper shank

The type and size of the reamers for the Morse taper shank are shown in Figure 2 and Table 4 and Table 5.

Morse taper shank according to GB/T 1443.

4 Length tolerance

The length tolerances of all types of machine reamers shall be as specified in Table 1.