

ICS 25.100.30

CCS J41



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

GB/T 1134-2008

Replacing GB/T 1134-2004

Machine reamers with edge inclination

带刃倾角机用铰刀

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Quarantine of the People's Republic of China;
Standardization Administration of China**

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Foreword

This standard replaces GB/T 1134-2004 "with edge inclination Morse taper shank machine reamers" and GB/T 4244-2004 "with edge inclination straight shank Machine reamers. " This standard and GB /major changes and GB/T 4244-2004 compared to T 1134-2004 as follows:

- The GB/T 1134-2004 and GB/T 4244-2004 merged into one standard;
- Chapter 1, the "size and marking example" with "types and dimensions";
- Canceled GB/T 1134-2004 and GB/T 4244-2004 range, "the future is only recommended metric size" words;
- 3.1 "immediately." To "close.";
- 3.3 length tolerance of "tolerance" word;
- 4.1, an increase of "give priority to the dimensions in Table 2, the diameter of the segment size in Table 3" requirements;
- 4.2, an increase of "give priority to the dimensions in Table 4, with a diameter the size of segments Table 5" requirement;
- 3.1 and Appendix A, the words "of the reamer diameter tolerance" to "band-edge inclination machine reamer diameter tolerance";
- Made editorial changes. Appendix A of this standard is a normative appendix. The standard proposed by China Machinery Industry Federation. This standard tool by the National Standardization Technical Committee (SAC/TC91) centralized. This standard was drafted. a Tools Co., Ltd., Henan. The main drafters of this standard. Zhao Jianmin, Kong Chunyan, Fan Yingjie, Wang Zhuo Lin, Dong Xiangyang. This standard replaces the standards previously issued as follows:
- GB 1134-1984, GB/T 1134-2004;
- GB 4244-1984, GB/T 4244-2004. With edge inclination machine reamers

1 Scope

GB/T 1134-2008 is the Chinese national standard on machine reamers with edge inclination, 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 4 November 2008 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 April 2009.

Classification: ICS 25.100.30, 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.

This standard specifies the band edge inclination straight shank, Morse taper shank machine reamers types and dimensions. This standard applies to a diameter greater than 5.3mm to 20mm high speed steel cutting edge inclination straight shank machine reamers and greater than 7.5mm in diameter to 40mm high speed steel cutting edge inclination Morse taper shank machine reamers. This standard only requires metric dimensions. This standard lists two tables, one is the preferred size and other appropriate dimensions; the other is a segment diameter size. Of the reamer Length, diameter of the cutting portion and a shank diameter tolerance straight shank are also specified.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 1443 from machine tools and tool handles with clip cone (GB/T 1443-1996, eqv ISO 296.1991)

GB/T 4246 reamer special tolerances (GB/T 4246-2004, ISO 522. 1975, IDT)

3 Tolerance

3.1 cutting portion A given processing H7, H8, H9 hole with edge inclination precision machine reamer diameter tolerances.

3.3 length Reamer length tolerance according to Table 1. Table 1 length tolerance in millimeters To more than tolerance 6 30 ± 1.0 30 120 ± 1.5 120 315 ± 2.0 315 1000 ±

3.0 Special tolerances reamers, shank length and size from the neighboring segments within a larger or a smaller selection, but tolerance Table

1 Provisions. Example.

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