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

GB/T 1139-2017

Replacing GB/T 1139-2004

Morse and metric taper reamers

莫氏圆锥和米制圆锥铰刀

(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 1139-2004 "Mohs cone and metric cone reamer". This standard compared with GB/T 1139-2004, except Editorial changes, the main technical changes are as follows.

- modified the scope of Chapter 1;
- canceled in Table 1, Table 2 in the inch size;
- Table 1 increases the basic size of the square head;
- canceled the "Chapter 3 handle", in Table 1, Table 2 to increase the table note;
- Increased chip breaker size and number of teeth are added in Table A.1.

This standard adopts the re-drafting method to use ISO 2250.:2009 "straight shank and Morse taper shank Morse cones and metric tapered reamers".

The technical differences between this and ISO 2250.:2009 and the reasons are as follows.

- normative reference documents, ISO 237 replaced with GB/T 4267; ISO 296 replaced with GB/T 1443; increased GB/T 4250;
- according to the domestic situation, an increase of marking examples and technical conditions;
- according to the domestic situation, the addition of information on Appendix A;
- taking into account the domestic habits, Figure 1, Figure 2 and Table 1, Table 2, I1 to L, I2 to I, I3 to I1, d1 to d, d2 Changed to d1;
- According to the domestic situation, Table 1 increased the basic size of the square head;
- According to the domestic situation, Table 2 increased the Morse taper handle number.

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).

The main drafting unit of this standard. Chengdu into the amount of Tools Group Co., Ltd., Chengdu Tools Research Institute Co., Ltd., Henan a tool limited the company.

1 Scope

This standard specifies the type and dimensions of the Morse cones and the metric cone reamers of the shank type with the straight shank and the Morse taper shank, the mark and the technique Conditions and other basic requirements.

This standard applies to the following types of reamers.

- straight shank and Morse taper shank 4 and 6 m cone reamer;
- Straight handle and Morse taper handle 0 to 6 Morse conical reamer.

Unless otherwise stated, the reamers are right cut.

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 dated references, the latest edition (including all amendments) 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 4267 Straight handle rotary tool Shank diameter and size of the drive head (GB/T 4267-2004, ISO 237. 1975, IDT) GB/T 4250 cone reamer technical conditions

3.1 Straight handle Morse cones and metric tapered reamers

Straight handle Morse cones and metric tapered reamers are shown in Table 1 according to the size of Figure 1. Small hinge with a small end diameter less than or equal to 6mm Knife can be made anti-tip; handle square head size deviation according to GB/T 4267 requirements.

Figure 1 Straight handle Morse cones and metric cone reamers