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NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 20332-2025

Replacing GB/T 20332-2006

Machine taper 1: 50 pin reamers with Morse taper shanks

锥柄机用1:50锥度销子铰刀

(English Translation)

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Foreword

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

This document replaces GB/T 20332-2006 "1.50 Taper Pin Reamers for Taper Shank Machines". Compared with GB/T 20332-2006, except for... Aside from structural adjustments and editorial changes, the main technical changes are as follows.

a) The style and size have been changed (see Chapter 4, Chapter 4 of the 2006 edition);

b) The tagging has been changed (see Chapter 5, 4.2 of the 2006 edition);

c) The technical requirements have been changed (see Chapter 6, Chapter 5 of the 2006 edition);

d) A new chapter on "Logos and Packaging" has been added (see Chapter 7).

This document is modified to adopt ISO 3467:2016 "Mohr taper pin reamers for machine tools".

This document has undergone the following structural adjustments compared to ISO 3467:2016.

---A chapter on "Terms and Definitions" has been added;

---Chapter 4 corresponds to Chapters 1 and 2 of ISO 3467:2016, where 4.1 corresponds to Section 4 of Chapter 1 of ISO 3467:2016.

The first paragraph, the fifth paragraph, and Chapter 2 have been expanded by 4.2;

---Chapters 5 through 7 have been added.

The technical differences between this document and ISO 3467:2016, and the reasons therefor, are as follows.

---The design drawing has been modified, and dimensions d3 and y1 have been removed

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(see Figure 1 and Table 1) to meet actual domestic production needs;

---Added requirements for taper shanks (see 4.2) to meet actual production needs;

---Added "Marking" (see Chapter 5), "Technical Requirements" (see Chapter 6), and "Marking and Packaging" (see Chapter 7) to meet domestic needs. The following editorial changes have been made to this document.

---To align with existing standards, the standard name has been changed to "1.50 Tapered Pin Reamer for Tapered Shank Machines";

---Informative references to ISO 2339, ISO 3465, and ISO 3466 (see Chapter 1) have been removed.

1 Scope

This document specifies the type, dimensions, markings, and technical requirements of 1.50 taper pin reamers (hereinafter referred to as "pin reamers") for taper shank machines. Requirements, logos, and packaging.

This document applies to the manufacture of pin reamers with diameters ranging from 5mm to 50mm.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included.

For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies to this document.

GB/T 1443 Self-clamping tapers for machine tools and tool shanks (GB/T 1443-1996, ISO 296:1991, MOD)

3 Terms and Definitions

This document does not contain any terms or definitions that need to be defined.

4 Types and Sizes

4.1

The chip groove may be made into a straight groove or a left-hand spiral groove, at the manufacturer's discretion. Unless otherwise specified, the pin reamer shall be made for right-hand cutting.

The type of sub-reamer is shown in Figure 1, and its dimensions conform to the

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specifications in Table 1.

The relationship between the symbols in this document and those in ISO 13399 (all parts) is given in Appendix A.

a) Spiral groove

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