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

GB/T 20960-2025

Replacing GB/T 20960-2007

NC horizontal turret

数控卧式转塔刀架

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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". Drafting.

This document replaces GB/T 20960-2007 "CNC Horizontal Turret Tool Post". Compared with GB/T 20960-2007, the main differences are in structural adjustments and...

Aside from editorial changes, the main technical changes are as follows.

- The scope has been changed (see Chapter 1, Chapter 1 of the 2007 edition);

- The repeatability tolerance for item G4 has been changed (see Table 5, Table 2 in the 2007 edition);
- The offset tolerance value of the tool groove in the working position in item G7 has been changed from "0.050" to "0.030" (see Table 8, 2007 edition). (Table 2)
- The parallelism tolerance values of the axial and radial positioning grooves of the tool mounting surface in the working position of item G8 have been changed from "a) Change "0.020" to "a) 0.010" and "c) 0.030" to "c) 0.020" (see Table 9, Table 2 of the 2007 edition);
- The standard for checking the cleanliness of the tool holder after assembly has been changed from "according to JB/T 9877" to "according to GB/T 25374".

The provisions (see 5.4.3, 2007 edition 4.4.3);

- The standard for the sealing and waterproofing test has been changed from "according to 13.2.5 of GB 4208-1993" to "according to..." The provisions of GB/T 4208-2017, section 14.2.5 (see section 6.4, section 5.4 of the 2007 edition).

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

This document was proposed by the China Machinery Industry Federation.

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The release history of this document and the document it replaces is as follows.

- First published in 2007 as GB/T 20960-2007;
- This is the first revision.

1 Scope

This document specifies the type and connection dimensions, requirements, test methods, inspection, and marking of CNC horizontal turret tool holders (hereinafter referred to as tool holders).

Packaging and accompanying documents.

This document applies to the design and manufacture of tool holders with a center height of 50mm~200mm and a rotation axis parallel to the mounting base. Other tool holders...

For reference, the connection dimensions are suitable for the newly designed tool holder.

2 Normative references

GB/T 4208-2017

GB/T 9061

GB/T 17421.1-2023

GB/T 17421.5

GB/T 25374

3 Terms and Definitions

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

4.1 Type

4.1.1 Tool holders are classified into Type I and Type II according to their functions.

Type I bidirectional indexing tool post;

Type II unidirectional indexing tool post.

4.1.2 The tool post is mainly defined by the height of the center of the rotation axis.

4.2 Connection Dimensions

The connection dimensions of the tool holder are shown in Figure 1 and Table 1. Special requirements can be agreed upon by the manufacturer and the user.