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

GB/T 25378-2010

**Collets with 8-degreesetting angle for tool shanks -- Collets,
nuts and fitting dimensions**

工具柄用8°安装锥的弹簧夹头 弹簧夹头、螺母和配合尺寸

(English Translation)

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Foreword

This revised standard adopts ISO 15488:2003 "Installation tool holder with 8 ° cone collets, nuts and fitting dimensions" (In English).

This standard is based on ISO 15488:2003 redrafted.

Taking into account China's national conditions, in the use of ISO 15488:2003 when you made the following technical modifications.

--- The surface roughness Rz Ra value to value.

This standard and ISO 15488:2003 as compared to, editorial changes as follows.

--- The "this International Standard" by "this standard";

--- Use the decimal symbol "." instead of as a decimal comma ",";

--- Remove the foreword and introduction of international standards.

Appendix A of this standard is a normative appendix.

The standard proposed by China Machinery Industry Federation.

The standard metal cutting machine tools by the National Standardization Technical Committee (SAC/TC22) centralized.

This standard was drafted. Yantai Machine Tool Research Institute annex, Shanghai Jin Precision Machine Tool Accessories Co., Ltd. basket.

1 Scope

This standard specifies the tools with cylindrical shank for clamping collet chuck (A, B type), the cartridge holder and nut size, material, technical requirements and tags. Do not meet this standard collet chuck, chuck, for example drawings as otherwise provided by the agreement between the decision.

Type A for milling and other holes for clamping stiffness requirements, clamping tolerance range h10.

B type is generally used to expand the circumstances clamping range requirements.

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 1804-2000 General tolerances for linear and angular dimensions without individual tolerance (eqv ISO 2768-1. 1989)

3.1 General Description

Collets, collet nut does not have to match the seat and Figs. 1 to 3; only a given size should be consistent.

General tolerances. GB/T 1804-2000 specified m.

3.2 Collet chuck

Figure 1 and Table 1.

Tolerances in millimeters the surface roughness in microns

Figure 1 A and B collets