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

GB/T 32556.2-2016

**Cutter arbors with tenon drive -- Part 2: Dimensions of 7: 24
taper**

带端键传动的铣刀杆 第2部分：带7:24锥柄的铣刀杆尺寸

(English Translation)

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Foreword

GB/T 32556 "with the end of the cutter bar key drive" is divided into three parts.

- Part 1. Dimensions cutter bar with Morse taper shank;
- Part 2. with 7.24 taper shank cutter bar size;
- Part 3. belt cutter bar size flange contact surface of the hollow handle.

This section GB/T Part of 232,556.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This section uses redrafted Law Amendment uses ISO 3937-2:2008 "with the end of the key drive cutter bar - Part 2. With 7.24 taper shank cutter bar Size" (in English).

Compared to 2008 the following modifications have differences in editorial and technical terms related to these differences have been by a single vertical line (-) its outer margin positions were marked. this part and ISO 3937-2.

- Deleted PDF disclaimer and introduction;
- Remove the preface of international standards, it added a new preface;
- Normative references to international standards in the alternative by the national standards;
- Mechanical drawing standards prescribed by our country;
- 3.1, "mk" level to "k" level;
- Table 2, taper No. 30 and No. 40, d3 value by "50" to "48";
- Table 3, taper No. 45, d2 is 32 rows, l4 value from "44" to "60"; taper No. 50, d2 27 and 32 lines, l4 value by "44" change "60";
- Table 4, d2 is 16 lines, l2 by "20" to "22"; taper No. 45, d2 is 40 lines, l3 from "35.9" to

"30.9";

--- Adds table Note;

--- Increasing the mark;

--- Increased signs and packaging.

This part is proposed by China Machinery Industry Federation.

This part of the tool by the National Standardization Technical Committee (SAC/TC91) centralized.

This section is responsible for drafting unit. Chengdu into a tool Group Co., Ltd. Chengdu Tool Research Institute.

1 Scope

This section provides the basic requirements with key drive end types and dimensions, material and hardness 7.24 shank cutter bar, marks, logos and packaging.

This section applies to manual tool change with 7.24 taper shank of cutter bar, cutter bar with A-type and U-type automatic tool changer 7.24 taper tool shank. This section does not apply to cutter bar with J-type automatic tool changer tool shank taper 7.24.

2 Normative references

The following documents for the application of this document is essential. For cited documents with dates, only the dated edition applies to this document. For undated references, the latest edition (including any amendments) applies to this document.

GB/T 1184 shape and position tolerances without individual tolerance value (GB/T 1184-1996, ISO 2768-2. 1989, EQV) GB/T 1804 General tolerances for linear and angular dimensions without individual tolerance (GB/T 1804-2000, ISO 2768-1. 1989, EQV) GB/T 3837 7.24 taper shank tool manually (GB/T 3837-2001, ISO 297. 1988, EQV) GB/T 10944.1 ATC 7.24 taper shank tools - Part 1. A, AD, AF, U, UD and UF type shank dimensions and marking (GB/T 10944.1-2013, ISO 7388-1:2007, IDT) GB/T 20329 end key drive arbor for milling cutters and tool holders swap Size (GB/T 20329-2006, ISO 2780. 1986, IDT)

3.1 General provisions

All dimensions and tolerances are in millimeters. Not according to individual tolerance GB/T "k" class of 1184 and according to GB/T 1804 "m" of class.

The cutter Arbor knife interchangeability dimensions conform to GB/T 20329. Locking threaded hole cutter dimensions conform to GB/T 20329.

7.24 taper shank tool manually in line with GB/T 3837, ATC 7.24 cone tool shank in line with GB/T 10944.1.

3.2 with manual tool change 7.24 taper shank cutter bar

3.2.1 General

7.24 shank cutter bar type size with manual tool change shown in Figure 1.