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

GB/T 33524.1-2017

**Modular taper interface with ball track system -- Part 1:
Dimensions and designation of shanks**

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Foreword

GB/T 33524 "Module with steel ball tension system cone interface" is divided into two parts.

- Part 1. Shank size and marking;
- Part 2. Mounting hole size and marking.

This part is part 1 of GB/T 33524.

This part is drafted in accordance with the rules given in GB/T 1.1-2009.

This part uses the translation method equivalent to ISO 26622-1..2008 "Module with steel ball tensioning system Conical interface Part 1. Handle

Section size and mark ".

In this part of the normative reference to the international documents have a consistent correspondence between the following documents.

GB/T 1182-2008 Geometrical product specifications (GPS) Geometric tolerances Shapes, orientations, positions and beating Tolerances

(ISO 1101..2004, IDT)

--- GB/T 1184-1996 Shape and position tolerances Not specified Tolerance values (eqvISO 2768-2. 1989)

--- GB/T 1804-2000 General tolerances Tolerances of linear and angular dimensions without tolerances (eqvISO 2768-1. 1989)

This section makes the following editorial changes as compared to ISO 26622-1..2008.

--- correct the drawing of d2 in Figure 1 and the hatching in the enlarged view of W;

--- In the mark, ISO 26622-1 is replaced with GB/T 33524.1.

This part is made by the China Machinery Industry Federation.

This part is headed by the National Tool Standardization Technical Committee (SAC/TC91).

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Module Conical Interface with Ball Tension System

Part 1. Shank size and marking

1 Scope

This part of GB/T 33524 specifies the use of automatic tool changers and manual tool changers (eg lathes, drilling machines, milling machines and milling centers)

The size of the taper shank of the modular cone of the steel ball tensioning system.

Different specifications of the taper shank with O-type cooling ring size

See Appendix A.

Flange parts with trenches can be used for automatic tool change, can also be used for manual tool change. The grip of the handle can pass the standard size of the ball

And a variety of clamping mechanisms to achieve.

Torque transmission is achieved by the frictional force of the tail of the shank, the clamping element and the key.

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 undated references, the latest edition (including all modifications) applies to this document.

ISO 1101 Geometrical product specifications (GPS) Geometric tolerances Shape, direction, position and beating Tolerance (Geometrical

productspecifications (GPS) -Geometricaltolerancing-Tolerancesofform, orientation, locationand

run-out

ISO 2768-1 General tolerances - Part 1. Linear and angular tolerances for non-tolerable tolerances (Generaltolerances-Part 1. Tol-

erancesforlinearandangulardimensionswithoutindividualtoleranceindications

ISO 2768-2 General tolerances - Part 2. Geometrical tolerances for non-tolerable characteristics (General tolerances-Part 2. Geometrical tolerances for features without individual tolerance indications)

3.1 General provisions

Shape, direction, position and beating tolerance according to ISO 1101. Unspecified linear and angular tolerances are in accordance with ISO 2768-1 "m"

The notched geometric tolerances are "k" of ISO 2768-2.

3.2 hollow taper shank

The dimensions of the module with a steel ball tensioning system are shown in Figure 1 and Table 1.