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

GB/T 4243-2017

Replacing GB/T 4243-2004

Long fluted machine reamers with Morse taper shanks

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces GB/T 4243-2004 "Morse taper shank long edge reamers."

Compared with GB/T 4243-2004, except editorial repair

Change the main technical changes are as follows.

- Modify the scope of Chapter 1;
- Removed Chapter 3 interchangeability;
- Removed the table 1, the limits of each size limit included in the table;
- Removed Table 3, recommended diameter and the corresponding size (in inches).

This standard uses redrafted Law Amendment uses ISO 236-2.2013 "Reamers Part 2. Morse taper shank long edge reamers."

This standard compared with ISO 236-2.2013 in the structure of the fourth chapter added a tag example, an increase of normative Appendix A.

This standard and ISO 236-2.2013 technical differences and the reasons are as follows.

- Modify the scope of international standards (see Chapter 1).
- On normative references, this standard made a technical difference with the adjustment to adapt to China's technical conditions, adjust the situation

Concentration reflected in Chapter 2 "Normative references", the specific adjustments are as follows.

* ISO 296 (see Chapter 3) replaced by GB/T 1443 modified to adopt international standards;

* Increased reference to GB/T 4246 (see Chapter 3).

--- According to the actual situation in the country, revised Figure 1.

--- According to the actual situation in the country, an increase of diameter d1 tolerance m6 (see Table 1, Table 2).

--- According to the actual situation in the country, an increase of the diameter of the reamer diameter tolerances for the processing of specific tolerance hole requirements (see Chapter 3).

--- According to the actual situation in the country, added a mark example (see Chapter 4).

--- Added Appendix A (normative) "processing H7, H8, H9-level hole reamer diameter limit deviation."

This standard made the following editorial changes.

--- Change the standard name;

--- According to the actual situation in the country, delete the international standard information appendix A.

This standard is proposed by the China Machinery Industry Federation.

This standard by the National Standardization Technical Committee Tool (SAC/TC91) centralized.

This standard was drafted by Chengdu Institute of Tools Co., Ltd., Changshu measuring tool factory.

1 Scope

This standard specifies the Morse taper shank long edge reamer type and size and marking examples.

This standard applies to Morse taper shank long edge reamers.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 1443 machine tools and tool shanks with self-clamping cones (GB/T 1443-2016, ISO 296.1991, MOD)

GB/T 4246 Reamer special tolerances (GB/T 4246-2004, ISO 522.1975, IDT)

3 type and size

Morse taper shank long edge reamer type shown in Figure 1, the size according to Table 1.
The diameter of the segmented size in Table 2. Morse taper shank

GB/T 1443 provisions.

For the machining of tolerance holes reamer diameter tolerance according to GB/T 4246
design, this standard is given in Appendix A processing H7, H8,

H9 level hole reamer diameter limit deviation.

Figure 1 Morse taper shank long edge reamers

Table 1 Morse taper shank long edge reamer dimensions in millimeters

d1

m6

l1

Size limit deviation

l2

Size limit deviation

Morse conic

+/- 1.5

+/- 2 1