

ICS 25.100.30

CCS J 41



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

GB/T 4247-2017

Replacing GB/T 4247-2004

Machine bridge reamers with Morse taper shanks

Issued on: December 29, 2017

Implemented on: July 1, 2018

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China, Standardization
Administration of the People's Republic of China**

Table of Contents

Foreword

1 Scope

2 Normative references

3 type and size

3.1 General provisions

1 --- taper 1:10;

2 --- Morse taper shank according to ISO 296;

Foreword

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

This standard replaces GB/T 4247-2004 "Morse taper shank bridge reamer." Compared with GB/T 4247-2004, except editorial repair

Change the main technical changes are as follows.

--- Modify the normative references;

--- text symbols Reamer diameter d , total length L , the blade length l by the standard symbols d_1 , l_3 , l_2 instead;

--- Deleted in Table 1 in inch size.

This standard uses the translation method identical with ISO 2238.2011 "Machine Bridge Reamer."

The documents of our country that are consistent with the corresponding international documents that are normative references in this standard are as follows.

Self - clamping cones for machine tools and tools shanks (ISO 296.1991, MOD).

This standard made the following editorial changes.

--- Change the standard name;

--- Corrected ISO 2238.2011 Table 1 Note l_1 and l_2 editing errors, " l_1 and l_2 tolerance" to " l_2 and l_3 of the public

Poor ", after the corresponding letters have been modified.

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 Tool Co., Ltd.

1 Scope

This standard specifies the type and size of Morse taper shank bridge reamers. This standard is given in millimeters diameter range d1 from 6mm to 50.8mm bridge reamer the following dimensions.

- Total length l3;
- Total cutting edge length l2;
- Taper cutting edge length l1.

Unless otherwise specified, these reamers are made right-cut.

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.

ISO 296 machine tools and tool shanks with self-clamping cone
(Machinetools-Self-holdingtapersfortoolshanks)

3.1 General provisions

Morse taper shank bridge reamer type and size shown in Figure 1 and Table 1.

Description.

2 --- Morse taper shank according to ISO 296;

a --- taper 1.10, approximately equivalent to the open angle of $5^\circ 45'$.

Figure 1 Morse taper shank bridge reamer dimensions