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

GB/T 6117.2-2010

Replacing GB/T 6117.2-1996

End mills -- Part 2: Milling cutters with Morse taper shanks

立铣刀 第2部分：莫氏锥柄立铣刀

(English Translation)

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Foreword

GB/T 6117 "end mill" consists of three parts.

--- Part 1. straight shank end mills;

--- Part 2. Morse taper shank end mills;

--- Part 3. 7.24 shank cutter.

This part of GB/T 26117 Part of.

The partial modification of international standards ISO 1641-2. 1978 "and end mills Slot drills - Part 2. Morse taper shank cutter." this section according to ISO 1641-2. 1978 redrafted.

Compared to 1978 there is the following editorial changes and technical differences. this part of ISO 1641-2.

--- Remove the foreword to international standards;

--- Used instead of using decimal comma " , " . " , " ;

--- Normative documents column items, ISO 296 with the standard of GB/T 1443 in place, ISO 5413 with our standard GB/T 4133 instead;

--- Increase the marked sample;

--- Table 1 Recommended diameter d increase in size 24, size 71;

--- Increased coarse teeth, tooth, Teeth fine teeth;

--- Remove the ISO 1641-2. in ball mills and keyway cutters 1978 legend;

--- Remove the ISO 1641-2. 1978 Table 1 keyway cutters, short dimension;

--- Remove the ISO 1641-2. 1978 Table 1 Note.

This Part replaces GB/T 6117.2-1996 "mills - Part 2. Morse taper shank end mill type and size." this portion of the GB/T 6117.2-1996 have compared the following changes.

--- Added "foreword";

--- Canceled Chapter 3, "symbol" of the content;

--- Table 1 Recommended diameter d increase in size 24, size 71;

Header --- Table 1 "group" to the "type";

--- Remove the 4.3 tag example item 2 and paragraph 3, sample content;

--- According to GB/T 1.1 format requirements for the preparation of editorial changes were made.

This part is proposed by China Machinery Industry Federation.

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

This part mainly drafted by. Chengdu into a tool Group Co., Ltd., Chengdu Tool Research Institute, Shanghai Tool Works Co., Ltd.

1 Scope

GB/T 6117 This section provides the basic requirements of the Morse taper shank end mill type, size and marking like.

This section applies to a diameter greater than 5mm ~ 75mm Morse taper shank end mills.

2 Normative references

The following documents contain provisions which, through reference in this part of the GB/T 6117, constitute provisions of this part. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

GB/T 1443 from machine tools and tool handles with clip cone (GB/T 1443-1996, eqv ISO 296:1991) GB/T 4133 Morse tapers transmission type and size (GB/T 4133-1984, eqv ISO 5413. 1976)

3 Type and size

3.1

Morse taper shank end mills according to their type divided into two kinds of patterns, Figures 1 and 2, the size shown in Table 1.

Morse taper shank end mill according blade length is divided into different standard series

and long series.

I type Morse taper shank end mill shank dimensions and tolerances according to GB/T 1443. II type Morse taper shank end mill shank dimensions and tolerances According to GB/T 4133.

Figure 1 I type

Figure 2 II type