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

GB/T 6374-2018

Replacing GB/T 6374-2004

**Rock drilling machines and pneumatic tools -- Shanks and
fitting dimensions of chuck bushings**

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1991 "Hard rock drill with hollow hexagonal brazed steel forged shoulder and tail sleeve".

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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 6374-2004 "rock drilling machinery and pneumatic tool tail handle and bushing fit size", and GB/T 6374-

The main technical changes in.2004 are as follows.

- Increase the method of marking the tail shank in Chapter 3 (see Chapter 3);
- Increased brazing specifications for 24, 26 and 30 (see Table 1);
- Change the end chamfer size 22mm of the tail shank to 20mm (see Table 1);
- Removed the upper limit of the diameter of the drill rod (see Table 1);
- Increase 1 to 159 series (see Table 12);
- Added informative Appendix A and Appendix B.

This standard uses the redrafting method to modify ISO 1180.1983 "Tail shank and bushing fit dimensions for pneumatic tools" and ISO 723.

1991 "Hard rock drill with hollow hexagonal brazed steel forged shoulder and tail sleeve".

This standard has some structural adjustments compared to ISO 1180.1983 and ISO 723.1991. This standard is listed in Appendix A.

A list of chapter numbers for ISO 1180.1983 and ISO 723.1991.

There are technical differences between this standard and ISO 1180.1983 and ISO 723.1991. The terms involved in these differences have been adopted in

The vertical single line (|) of the outer margin is marked. A list of the corresponding

technical differences and their causes is given in Appendix B.

This standard also made the following editorial changes.

---Incorporate the contents of ISO 1180-Add.1.1985, with vertical double lines (??) on the margins outside the modified terms

Marked.

This standard was proposed by the China Machinery Industry Federation.

This standard is under the jurisdiction of the National Standardization Technical Committee for Rock Drilling Machinery and Pneumatic Tools (SAC/TC173).

This standard was drafted. Tianshui Rock Drilling Machinery Pneumatic Tools Research Institute, Changsha Mining and Metallurgy Research Institute Co., Ltd., Luoyang Bianli Engineering Machinery

Machinery Co., Ltd.

1 Scope

This standard specifies the dimensions of the shank and bushings for rock drilling machines and pneumatic tools.

This standard is applicable to pneumatic tools such as pneumatic picks and air shovel, and rod-shaped hexagonal hollow brazed steel forging with shoulder stalks and bushings.

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

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

GB/T 1301-2008 Hollow steel for rock drilling rods (ISO 722.1991, MOD)

GB/T 1443-2016 Self-clamping cone for machine tools and tool shanks (ISO 296.1991, MOD)

3 tail handle size marking method

The size of the tail handle should include the following.

- The form and name of the tail handle;
- The basic size of the tail handle (the first column of each table);
- The length of the tail handle.

Example.

The crusher tail shank with a basic size of 25 mm and a length of 108 mm is marked as.

Crusher tail handle 25x108

4 pneumatic picks and bushings

See Figure 1 and Table 1 for the matching dimensions of the tail shank and bushing.

The unit is mm

Figure 1 pneumatic pick handle and bushing