

INTERNATIONAL STANDARD

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Woodruff keyseat cutters — Dimensions

Fraises pour logement de clavettes-disques — Dimensions



Reference number
ISO 12197:1996(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

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International Standard ISO 12197 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 2, *Drills, reamers, milling cutters and milling machine accessories*.

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Woodruff keyseat cutters — Dimensions

1 Scope

This International Standard specifies the dimensions of milling cutters intended for manufacturing Woodruff keyseats in accordance with ISO 3912.

Two types of Woodruff keyseat cutters with cylindrical shank are specified:

- Woodruff keyseat cutters with cylindrical shank, in accordance with ISO 3338-1;
- Woodruff keyseat cutters with flatted cylindrical shank, in accordance with ISO 3338-2.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 3338-1:1996, *Cylindrical shanks for milling cutters — Part 1: Dimensional characteristics of plain cylindrical shanks*.

ISO 3338-2:1996, *Cylindrical shanks for milling cutters — Part 1: Dimensional characteristics of flatted cylindrical shanks*.

ISO 3912:1977, *Woodruff keys and keyways*.

3 Dimensions

See figure 1 and table 1.

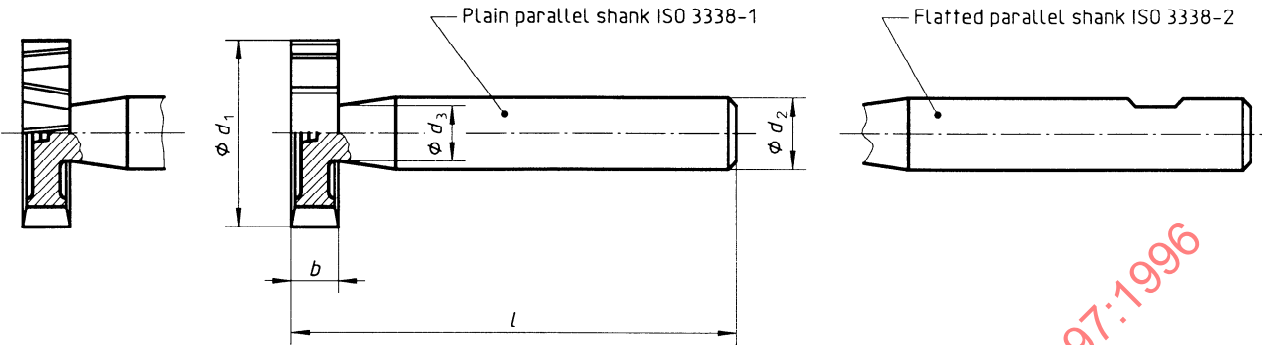


Figure 1

Table 1

Dimensions in millimetres

nom.	d_1 tol.	b e8	d_2	d_3	l	Key ISO 3912
4	+ 0,5 + 0,4	1	6	1,8	50	1 × 1,4
7		1,5		2,8		1,5 × 2,6
		2		3,2		2 × 2,6
10		2		4		2 × 3,7
		2,5				2,5 × 3,7
13	+ 0,5 + 0,3	3	10	4,6	56	3 × 5
		3		4,6		3 × 6,5
16		4		5		4 × 6,5
		5		5,6		5 × 6,5
		4		6		4 × 7,5
19	+ 0,5 + 0,3	5		6	63	5 × 7,5
		5		6,5		5 × 9
22		6		7,5		6 × 9
25		6		8,5		6 × 10
28		8		9,3		8 × 11
32		10	12		71	10 × 13

NOTE — Cutters may be provided with radius; in that case the value of the radius shall be such that cutters are able to manufacture keyways in accordance with ISO 3912.

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