

SVENSK STANDARD

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Brotschar –

**Del 2: Maskinbrotschar, långgräflade, fästen med Morsekona
(ISO 236-2:2013, IDT)**

Reamers –

**Part 2: Long fluted machine reamers with Morse taper shanks
(ISO 236-2:2013, IDT)**

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Den internationella standarden ISO 236-2:2013 gäller som svensk standard. Detta dokument innehåller den officiella engelska versionen av ISO 236-2:2013.

The International Standard ISO 236-2:2013 has the status of a Swedish Standard. This document contains the official version of ISO 236-2:2013.

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Denna standard är framtagen av kommittén för Skärande verktyg, SIS/TK 273.

Har du synpunkter på innehållet i den här standarden, vill du delta i ett kommande revideringsarbete eller vara med och ta fram andra standarder inom området? Gå in på www.sis.se - där hittar du mer information.

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 236-2 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 2, *High speed steel cutting tools and their attachments*.

This second edition cancels and replaces the first edition (ISO 236-2:1976), of which it constitutes a minor revision. In particular, dimensions in inches (Imperial units) have been deleted, and an informative annex, giving the relationship between the symbols of this part of ISO 236 and the symbols according to ISO 13399 (all parts), has been added.

ISO 236 consists of the following parts, under the general title *Reamers*:

- *Part 1: Hand reamers*¹⁾
- *Part 2: Long fluted machine reamers with Morse taper shanks* *Introduction*

1) It is intended that, upon revision, the main element of the title of Part one will be aligned with the main element of the title of Part two.

Reamers —

Part 2: Long fluted machine reamers with Morse taper shanks

1 Scope

This part of ISO 236 specifies the dimensions of long fluted machine reamers with Morse taper shanks.

The relationship between the symbols of this part of ISO 236 and those according to ISO 13399 (all parts) is given for information in [Annex A](#).

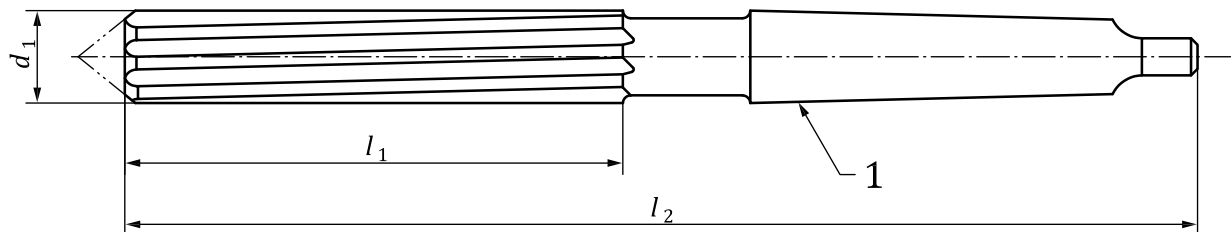
2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 296, *Machine tools — Self-holding tapers for tool shanks*

3 Dimensions

The dimensions for reamers with Morse taper shank shall be in accordance with the dimensions shown in [Figure 1](#). The diameters and corresponding dimensions shall be as given in [Table 1](#). The dimensions set out as a function of diameter steps shall be as given in [Table 2](#).



Key

- 1 Morse taper in accordance with ISO 296

Figure 1 — Long fluted machine reamer with Morse taper shank

Table 1 — Diameters and corresponding dimensions of long fluted machine reamers with Morse taper shanks

Dimensions in millimetres

d_1	l_1		l_2		Morse taper No.	d_1	l_1		l_2		Morse taper No.
		Tol.		Tol.				Tol.		Tol.	
7	54	±1,5	134	±2	1	32	133	±2	293	4	
8	58		138			(34) ^a	142		302		
9	62		142			(35) ^a					
10	66		146			36					
11	71		151			(38) ^a	152		312		
12	76		156			40					(42) ^a
(13) ^a	76		161		(44) ^a	163	323				
14	81		181		45			(46) ^a			
(15) ^a	81		187		(48) ^a	174	±3				
16	87		187		50			334			
(17) ^a	87		193		(52) ^a	184	381				
18	93		193		56			372			
(19) ^a	93		200		(58) ^a	194	391				
20	100		200		63			(60) ^a			
(21) ^a	100		207		(62) ^a	203	400				
22	107	207	67	(66) ^a							
(23) ^a	107	242	71	3							
(24) ^a	115	242									
25	115	242									
(26) ^a	115	251									
(27) ^a	124	±2	251								
28	124	±2	251								
(30) ^a	124	±2	251								

^a Sizes in parentheses should be avoided wherever possible.

In special cases, the lengths of reamers and their shank dimensions may be chosen from the next larger or smaller range.

EXAMPLE For the diameter 15 mm, length l_2 may be 187 mm with l_1 being 87 mm and Morse taper No. 2 or length l_2 may be 156 mm with l_1 being 76 mm and Morse taper No. 1 (see [Table 2](#)).