

BS ISO 1641-1:2016



BSI Standards Publication

## End mills and slot drills

Part 1: Milling cutters with cylindrical shanks

**National foreword**

This British Standard is the UK implementation of ISO 1641-1:2016. It supersedes BS ISO 1641-1:2003 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee MTE/18, Tools tips and inserts for cutting applications.

A list of organizations represented on this committee can be obtained on request to its secretary.

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**End mills and slot drills —**

**Part 1:**

**Milling cutters with cylindrical shanks**

*Fraises cylindriques 2 tailles et fraises à rainurer —*

*Partie 1: Fraises à queue cylindrique*



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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html)

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This third edition cancels and replaces the second edition (ISO 1641-1:2003), of which it constitutes a minor revision.

ISO 1641 consists of the following parts, under the general title *End mills and slot drills*:

- *Part 1: Milling cutters with cylindrical shanks*
- *Part 2: Dimensions and designation of milling cutters with Morse taper shanks*
- *Part 3: Dimensions and designation of milling cutters with 7/24 taper shanks*

# End mills and slot drills —

## Part 1: Milling cutters with cylindrical shanks

### 1 Scope

This part of ISO 1641 specifies the general dimensions of the following milling cutters with plain cylindrical, flatted cylindrical and threaded shanks:

- end mills, flat-ended or ball-nosed — standard series and long series;
- slot drills — short series and standard series.

The dimensional characteristics of cylindrical shanks are in accordance with ISO 3338-1, ISO 3338-2 and ISO 3338-3.

NOTE These same milling cutters with Morse taper shanks having a tapped hole are dealt with in ISO 1641-2, those with 7/24 taper shanks in ISO 1641-3.

This part of ISO 1641 does not apply to solid hard metal end mills and slot drills.

### 2 Normative references

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

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

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

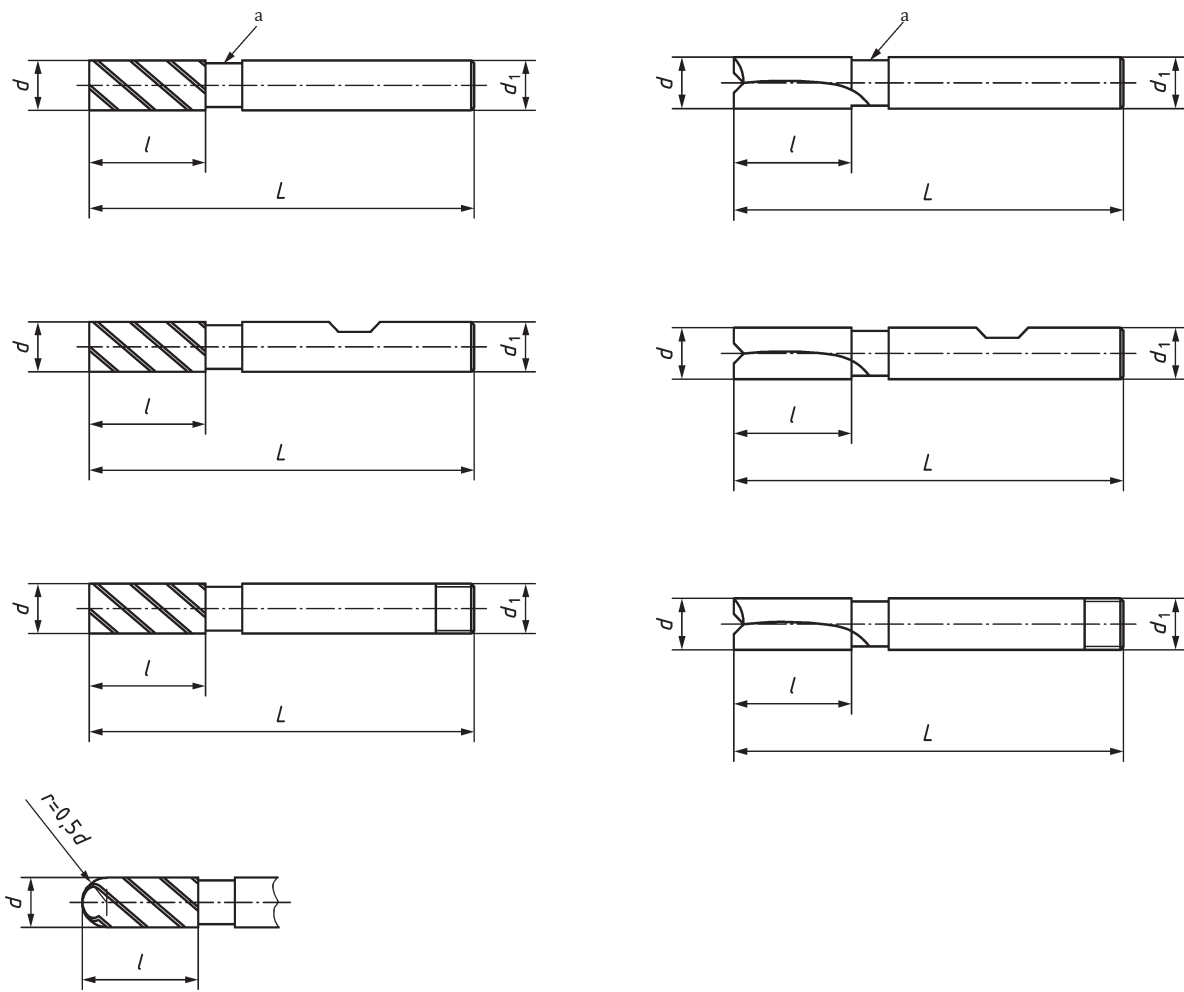
ISO 3338-3, *Cylindrical shanks for milling cutters — Part 3: Dimensional characteristics of threaded shanks*

### 3 Dimensions

For flat-ended end mills and ball-nosed cylindrical end mills, the standard series and long series given in [Table 1](#) according to the cutting length,  $l$ , shall be used.

For slot drills, the short series and standard series given in [Table 1](#) according to the cutting length,  $l$ , shall be used.

See [Figure 1](#), [Table 1](#) and [Table 2](#).



a) End mills, flat-ended and ball-nosed

b) Slot drills

a Optional recess.

Figure 1 — Milling cutters with cylindrical shanks



**Table 1**

Dimensions in millimetres

Range of diameters $d$	Recommended diameter $d$		Shank		Short series			Standard series			Long series		
			$d_1^a$		$l$	$L^b$		$l$	$L^b$		$l$	$L^b$	
			Alternative			Alternative			Alternative			Alternative	
I	II	I	II	I	II	I	II	I	II	I	II		
$1,9 < d \leq 2,36$	<b>2</b>	—			4	36	48	7	39	51	10	42	54
$2,36 < d \leq 3$	<b>2,5</b>	—	4 <sup>c</sup>	6	5	37	49	8	40	52	12	44	56
	<b>3</b>												
$3 < d \leq 3,75$	—	<b>3,5</b>			6	38	50	10	42	54	15	47	59
$3,75 < d \leq 4$	<b>4</b>	—	5 <sup>c</sup>	6	7	39	51	11	13	55	19	51	63
$4 < d \leq 4,75$	—					41			45			53	
$4,75 < d \leq 5$	<b>5</b>	—			8	42	52	13	47	57	24	58	68
$5 < d \leq 6$	<b>6</b>	—	6			52			57			68	
$6 < d \leq 7,5$	—	<b>7</b>	8	10	10	54	60	16	60	66	30	74	80
$7,5 < d \leq 8$	<b>8</b>	—			11	55	61	19	63	69	38	82	88
$8 < d \leq 9,5$	—	<b>9</b>	10		13	61		22	69		45	88	
$9,5 < d \leq 10$	<b>10</b>	—				63			72			95	
$10 < d \leq 11,8$	—	<b>11</b>	12		16	70		26	79		53	102	
$11,8 < d \leq 15$	<b>12</b>	<b>14</b>				73			83			110	
$15 < d \leq 19$	<b>16</b>	<b>18</b>	16		19	79	32	92	63	123			
$19 < d \leq 23,6$	<b>20</b>	<b>22</b>	20		22	88	38	104	75	141			
$23,6 < d \leq 30$	<b>24</b> and <b>25</b>	<b>28</b>	25		26	102	45	121	90	166			
$30 < d \leq 37,5$	<b>32</b>	<b>36</b>	32		32	112	53	133	106	186			
$37,5 < d \leq 47,5$	<b>40</b>	<b>45</b>	40		38	130	63	155	125	217			
$47,5 < d \leq 60$	<b>50</b>	<b>56</b>	50		45	147	75	177	150	252			
$60 < d \leq 67$	<b>63</b>	—	50	63	53	155	165	90	192	202	180	282	292
$67 < d \leq 75$	—	<b>71</b>	63			165			202			292	

<sup>a</sup> Tolerances on  $d_1$  in accordance with ISO 3338-1, ISO 3338-2 and ISO 3338-3.

<sup>b</sup> The two alternatives for the total length result from the two alternatives for the shanks.

<sup>c</sup> Only for plain cylindrical shanks.

The values  $L$  and  $l$  have been so chosen that the length difference ( $L - l$ ) remains constant whatever the series, short, standard or long (see [Table 2](#)).

**Table 2**

Dimensions in millimetres

Range of diameters $d$	$L - l$	
	Alternative I	Alternative II
$1,9 < d \leq 4$	32	44
$4 < d \leq 5$	34	44
$5 < d \leq 6$	44	
$6 < d \leq 8$	44	50
$8 < d \leq 10$	50	
$10 < d \leq 15$	57	
$15 < d \leq 19$	60	
$19 < d \leq 23,6$	66	
$23,6 < d \leq 30$	76	
$30 < d \leq 37,5$	80	
$37,5 < d \leq 47,5$	92	
$47,5 < d \leq 60$	102	
$60 < d \leq 67$	102	112
$67 < d \leq 75$	112	

## 4 Tolerances

Tolerances on cutting diameter,  $d$ , shall be as follows:

- js 14, for end mills;
- e8, for slot drills.

In the case of double-ended end milling cutters having a cutting diameter nominally equal to the shank diameter, the maximum cutting diameter should be slightly smaller than the minimum shank diameter.

## Annex A (informative)

### Relationship between designations in this part of ISO 1641 and ISO 13399

#### A.1 Relationship between designations

For the relationship between the designations in this part of ISO 1641 and preferred symbols according to ISO 13399, see [Table A.1](#).

**Table A.1 — Relationship between designations in this part of ISO 1641 and ISO 13399**

Symbol in this part of ISO 1641	Reference in this part of ISO 1641	Property name in the ISO 13399 series	Symbol in the ISO 13399 series	Reference in the ISO 13399 series
$d$	<a href="#">Figure 1</a> and <a href="#">Table 1</a>	cutting diameter	DC	ISO/TS 13399-3 BSU 71D084653E57F
$d_1$	<a href="#">Figure 1</a> and <a href="#">Table 1</a>	connection diameter machine side	DCONMS	ISO/TS 13399-3 BSU 71EBDBF5060E6
$l$	<a href="#">Figure 1</a> and <a href="#">Table 1</a>	depth of cut maximum	APMX	ISO/TS 13399-3 BSU 71D07576C0558
$L$	<a href="#">Figure 1</a> and <a href="#">Table 1</a>	overall length	OAL	ISO/TS 13399-3 BSU 71D078EB7C086
$r$	<a href="#">Figure 1</a>	profile radius	PRFRAD	ISO/TS 13399-3 BSU 71E019EBAE1B1

## Bibliography

- [1] ISO 1641-2, *End mills and slot drills — Part 2: Dimensions and designation of milling cutters with Morse taper shanks*
- [2] ISO 1641-3, *End mills and slot drills — Part 3: Dimensions and designation of milling cutters with 7/24 taper shanks*
- [3] ISO 11529, *Milling cutters — Designation — Shank-type and bore-type milling cutters of solid or tipped design or with indexable cutting edges*
- [4] ISO 13399 (all parts), *Cutting tool data representation and exchange*







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