INTERNATIONAL STANDARD

ISO 1797-1

Second edition
2011-08-15

Dentistry — Shanks for rotary instruments —

Part 1: Shanks made of metals

Médecine bucco-dentaire — Queues pour instruments rotatifs —

Partie 1: Queues en matériaux métalliques

Reference number
ISO 1797-1:2011(E)

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Foreword

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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 1797-1 was prepared by Technical Committee ISO/TC 106, *Dentistry*, Subcommittee SC 4, *Dental instruments*.

This second edition cancels and replaces the first edition (ISO 1797-1:1992) and ISO 1797-1:1992/Amd.1:1997, which has been technically revised. The following changes were made:

a) addition of a maximum value for the end of the shank for Type 3;

b) addition of a definition for shank;

c) clarification of symbols and figures.

ISO 1797 consists of the following parts, under the general title *Dentistry — Shanks for rotary instruments*:

— *Part 1: Shanks made of metals*

— *Part 2: Shanks made of plastics*

Introduction

This International Standard is one of a series of basic standards on dental rotary instruments. It constitutes an important link between the standards on dental rotary instruments and those on dental handpieces.

Dentistry — Shanks for rotary instruments —

Part 1:
Shanks made of metals

1 Scope

This International Standard specifies shanks for rotary instruments used in dentistry and gives measurement methods for the verification of dimensions.

2 Normative references

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

ISO 1942, *Dentistry — Vocabulary*

ISO 3274, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Nominal characteristics of contact (stylus) instruments*

ISO 4288, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Rules and procedures for the assessment of surface texture*

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

ISO 8325, *Dentistry — Test methods for rotary instruments*

3 Terms, definitions, symbols and abbreviated terms

3.1 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 1942 and the following apply.

3.1.1
shank
part of a rotary instrument used in dentistry which is designed to fit into the chuck of a straight or geared dental handpiece, a technical handpiece or a dental turbine

3.2 Symbols and abbreviated terms

Symbols and terms are shown in Figures 1 to 8 with the following key:

d_1 shank diameter;

d_2 diameter in the groove;

s maximum distance from the circumference to the flat portion;

l_1 fitting length;

l_2 shoulder to end length;

l_3 shoulder to groove length;

l_4 width of groove;

l_5 length of conical or rounded end;

δ cylindricity of shank cylinder.

4 Classification

Shanks for rotary instruments are classified into the following types, according to their diameters and designs:

— Type 1: diameter 2,35 mm with groove and flat (for contra-angle-connection);

— Type 2: diameter 2,35 mm cylindrical;

— Type 3: diameter 1,6 mm cylindrical with conical or rounded end;

— Type 4: diameter 3 mm cylindrical.

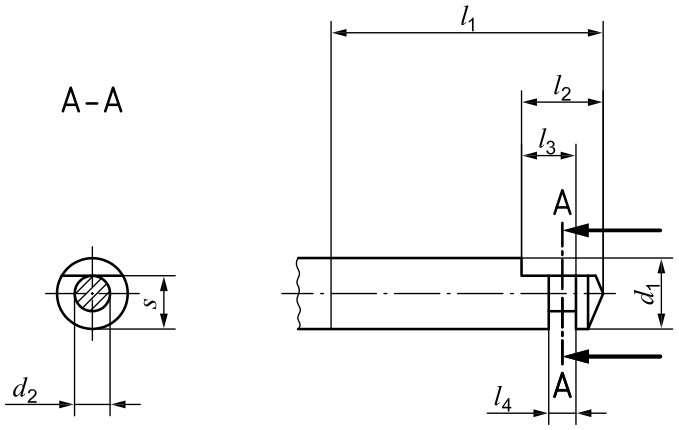


Figure 1 — Type 1 shank

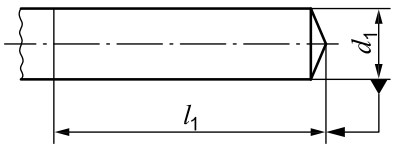


Figure 2 — Type 2 and Type 4 shank

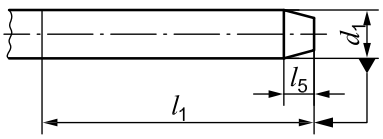


Figure 3 — Type 3 shank

5 Requirements

5.1 Material

Shanks shall be made of metallic materials (e.g. steel or tungsten carbide). The exact type of material and the treatment given to it are at the discretion of the manufacturer.

5.2 Dimensions

The dimensions and tolerances shall be as shown in Figures 4 to 7 and as given in Table 1.

Dimensions are given in millimetres, surface roughness in micrometres.

The end of the shank for Types 1, 2 and 4 shall be either flat, conical or rounded. The end of the shank for Type 3 shall be either conical or rounded.

The shape of the shank end shall be at the discretion of the manufacturer.

Dimensions in millimetres

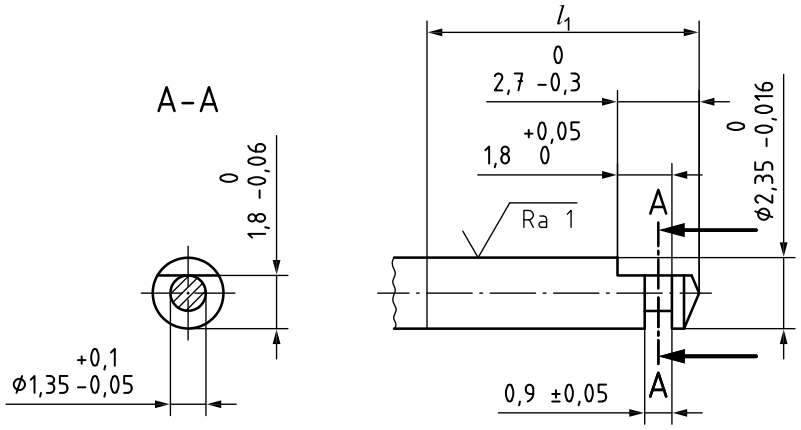


Figure 4 — Dimensions Type 1 shank

Dimensions in millimetres

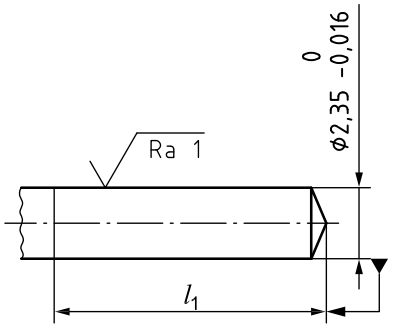


Figure 5 — Dimensions Type 2 shank

Dimensions in millimetres

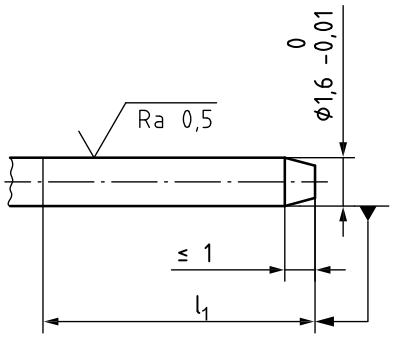


Figure 6 — Dimensions Type 3 shank

Dimensions in millimetres

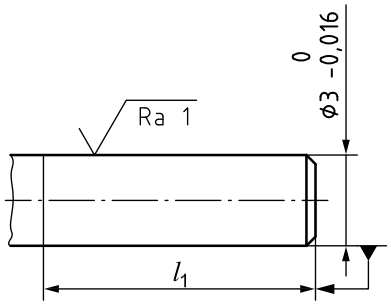


Figure 7 — Dimensions Type 4 shank

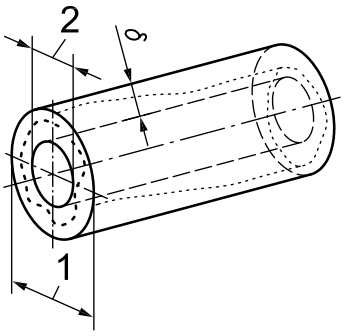
Table 1 — Fitting length of shank

Dimensions in millimetres

Shank	**Diameter**	**Fitting length**, l_1 min.		
		miniature, short	standard, long	extra long
Type 1[a]	2,35	—	11	12
Type 2	2,35	15	30	30
Type 3	1,6	9	11	12
Type 4	3	—	30	30
[a] The start of any enlargement on a Type 1 shank (e.g. by marking or the working head) shall be outside l_1 = 13,5 mm.				

5.3 Shank cylindricity

The shank cylindricity (see Figure 8) shall be within the tolerances of the acceptable shank diameter.



Key

1 upper limit of d_1

2 lower limit of d_1

Figure 8 — Shank cylindricity

The requirement for the shank cylindricity covers the fitting length, l_1, of the shank with the exception of the shank end geometry.

Test in accordance with 6.3.

5.4 Surface roughness

The surface roughness, Ra, shall be for

a) Type 1, Type 2, and Type 4: ≤1 µm;

b) Type 3: ≤0,5 µm,

as it is located and shown in Figure 4 to Figure 7.

Test in accordance with 6.4.

5.5 Vickers hardness

The Vickers hardness for shanks made of metallic material, shall be not less than 250 HV5.

Test in accordance with 6.5.

5.6 Marking

Marking, if envisaged, should be outside the fitting length, l_1.

If the marking is applied within the fitting length, l_1, the outside diameter of the shank with the marking shall not exceed the effective diameter of the shank.

Marking shall be resistant to reprocessing procedures as disinfection, cleaning and sterilization according to the manufacturer's instructions.

6 Test methods

6.1 Shank diameter

Measurements of the shank diameter shall be made with suitable measuring devices that have an accuracy of 0,001 mm. The accuracy of the measuring device shall be verified.

The shank diameter, d_1, shall be measured by traversing the length, l_1.

6.2 Other dimensions

Measurements shall be made in accordance with ISO 8325 with suitable measuring devices with an accuracy of 0,01 mm. The accuracy of the measuring device shall be verified.

6.3 Shank cylindricity

The test method is left to the discretion of the manufacturer.

6.4 Surface roughness

Test the surface roughness in accordance with ISO 3274 and ISO 4288.

6.5 Vickers hardness

Test the hardness in accordance with ISO 6507-1.

7 Quality control

7.1 Types of shank

For the purpose of quality control, the shanks of the instruments shall be classified as given in Clause 4.

7.2 Defects

7.2.1 Major defects

Major defects shall be those deviations from the specifications listed in Table 2. Major defects include only those items which prevent an instrument from operating.

7.2.2 Minor defects

Minor defects shall be all deviations in fitting dimensions not listed in Table 2. Minor defects include all other deviations from the specification which lower the quality of the instrument.

Acceptable quality levels are given in Annex A.

Table 2 — Major defects

Shank	d_1	d_2	l_3	l_4	s
Type 1	>2,35	>1,45	<1,80	<0,85	>1,80
Type 2	>2,35	—	—	—	—
Type 3	>1,60 <1,59	—	—	—	—
Type 4	>3	—	—	—	—

Annex A
(informative)

Acceptable quality levels (AQL)

The acceptable quality level (AQL) expressed in terms of the number of defects per 100 pieces, for each type of instrument, should be as shown in Table A.1.

Table A.1 — Acceptable quality level

Shank	AQL	
	Major defects	Minor defects
Type 1	2,5	6,5
Type 2	2,5	6,5
Type 3	1,5	4,0
Type 4	2,5	6,5

Bibliography

[1] ISO 2859-1, *Sampling procedures for inspection by attributes — Part 1: Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection*

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