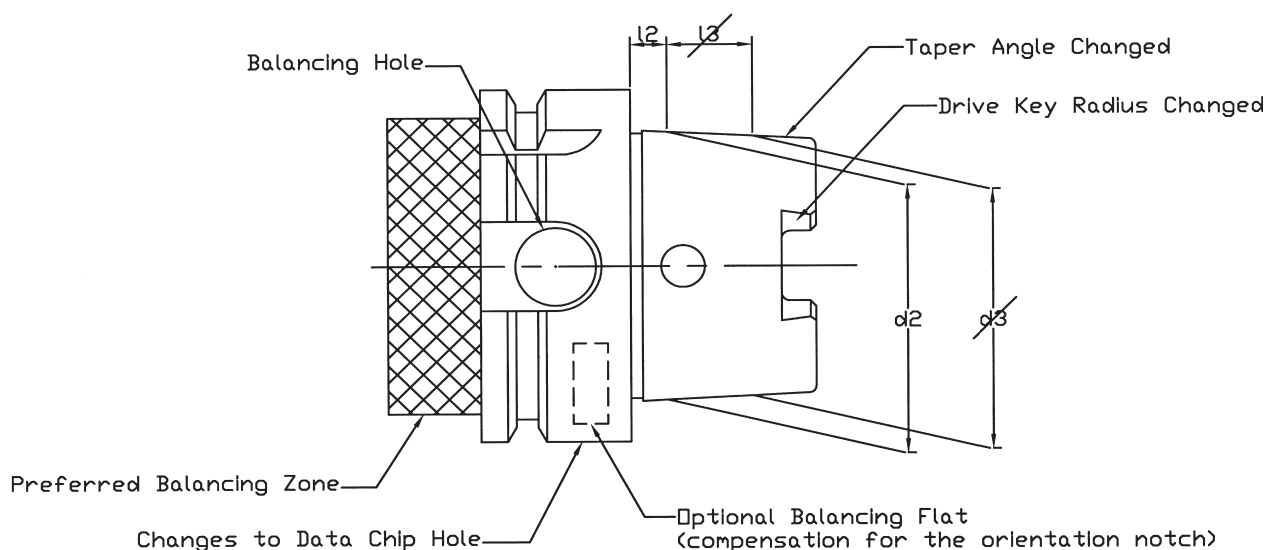


The HSK Taper: DIN vs. ISO

The HSK taper standard, formerly a DIN (German) standard, was made an international ISO standard in 2001. The standards are very similar, but certain key elements were changed in the ISO standard:

- Elimination of gage dimension d3
- Change in taper angle
- Drive key radius changed
- Defined balancing area and balancing hole, additional balancing area added
- Changes to the data chip hole; data chip hole is optional
- Covers only types HSK-A and HSK-C

The ISO specification was designed to be interchangeable with DIN HSK tooling — “old” tooling will fit in new spindles, and “new” spindles will fit the old tooling. However, dimensional gages should be recalibrated to reflect the new ISO standard.



Dimension	Change	Example HSK-A63, DIN	Example HSK-A63, ISO
d2	Dimension Change	48 +0.011/+0.007	48.010
d3	Eliminated	46.53 +0.007/+0.003	N/A
l2	No Change	6.3	6.3
l3	Eliminated	14.7	N/A
Taper	Taper Change	1:10	1:9.98

The official ISO designation for HSK taper holders is:

Hollow shank + ISO 12164-1 + HSK + Type (A or C) + Nominal size

Example: Hollow shank ISO 12164-1-HSK-A 50

This document is for reference only; accuracy of information is not guaranteed. Contact Transatlantic Connection, Inc. for information on how to obtain the ISO specification for production.