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.

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

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

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