

Hardmetal insert tooling —

Part 13: Specification for dimensions of indexable hardmetal inserts having 7° normal clearance, rounded corners and partly cylindrical fixing hole

[ISO title: Indexable hardmetal (carbide) inserts with rounded corners with partly cylindrical fixing hole — Part 1: Dimensions of inserts with 7° normal clearance]

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Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Mechanical Engineering Standards Committee (MEE/-) to Technical Committee MEE/150 upon which the following bodies were represented:

- British Hardmetal Association
- British Railways Board
- Institution of Production Engineers
- Machine Tool Industry Research Association
- Coopted member

This British Standard, having been prepared under the direction of the Mechanical Engineering Standards Committee, was published under the authority of the Board of BSI and comes into effect on 28 September 1984

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National foreword

This Part of this British Standard has been prepared under the direction of the Mechanical Engineering Standards Committee and forms part of a series, each Part dealing with an aspect of hardmetal insert tooling. The series implements corresponding International Standards in the development of which the UK has played an active part. The following Parts have been published so far, and further Parts will be issued as related international work proceeds.

- *Part 1: Specification for the designation of indexable (throwaway) hardmetal inserts for cutting tools;*
- *Part 2: Specification for dimensions for indexable (throwaway) hardmetal inserts without fixing hole;*
- *Part 3: Specification for dimensions for indexable (throwaway) hardmetal inserts with cylindrical fixing hole;*
- *Part 4: Specification for dimensions for indexable (throwaway) hardmetal square inserts for milling cutters;*
- *Part 5: Specification for dimensions for indexable (throwaway) hardmetal triangular inserts for milling cutters;*
- *Part 6: Specification for the designation of turning and copying tool holders and cartridges for indexable (throwaway) inserts;*
- *Part 7: Specification for dimensions for single point turning and copying tool holders for indexable (throwaway) inserts;*
- *Part 8: Specification for dimensions for type A cartridges for indexable (throwaway) inserts;*
- *Part 9: Specification for end mills with indexable inserts and flatted parallel shank;*
- *Part 10: Specification for end mills with indexable inserts and Morse taper shank;*
- *Part 11: Specification for dimensions of face milling cutters with indexable inserts;*
- *Part 12: Specification for dimensions of side and face milling and slotting cutters with indexable inserts;*
- *Part 13: Specification for dimensions of indexable hardmetal inserts having 7° normal clearance, rounded corners and partly cylindrical fixing hole;*
- *Part 14: Specification for designation of boring bars (tool holders with cylindrical shank) for indexable inserts.*

This Part of BS 4193 is identical with ISO 6987 “Indexable hardmetal (carbide) inserts with rounded corners, with partly cylindrical fixing hole —

Part 1: Dimensions of inserts with 7° normal clearance” which was prepared by Technical Committee ISO/TC 29, Small tools, and published in 1983 by the International Organization for Standardization (ISO).

Terminology and conventions. The text of the International Standard has been approved as suitable for publication as a British Standard without deviation. Some terminology and certain conventions are not identical with those used in British Standards; attention is drawn especially to the following.

The comma has been used as a decimal marker. In British Standards it is current practice to use a full point on the baseline as the decimal marker.

Where the words “part of ISO 6987” appear, referring to this standard, they should be read as “Part of BS 4193”.

Cross-references

International Standards Corresponding British Standards

	BS 4193 <i>Hardmetal insert tooling</i>
ISO 883:1976 ^a	Part 2:1980 <i>Specification for dimensions for indexable (throwaway) hardmetal inserts without fixing hole</i> (Technically equivalent)
ISO 3364:1977 ^a	Part 3:1980 <i>Specification for dimensions for indexable (throwaway) hardmetal inserts with cylindrical fixing hole</i> (Technically equivalent)
ISO 3365-1:1977 ^a	Part 4:1980 <i>Specification for dimensions for indexable (throwaway) hardmetal square inserts for milling cutters</i> (Technically equivalent)
ISO 3365-2:1980 ^a	Part 5:1982 <i>Specification for dimensions for indexable (throwaway) hardmetal triangular inserts for milling cutters</i> (Identical)

^a In course of revision.

The Technical Committee has reviewed the provisions of ISO 513¹⁾ to which reference is made in the text and has decided that they are acceptable for use in conjunction with this British Standard.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i to iv, pages 1 to 12, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

¹⁾ In course of revision.

