

BS ISO 16463:2014



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Polycrystalline diamond inserts, tipped — Dimensions, types

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National foreword

This British Standard is the UK implementation of ISO 16463:2014. It supersedes BS ISO 16463:2004 which is withdrawn.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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ISBN 978 0 580 83607 7

ICS 25.100.01

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 May 2014.

Amendments issued since publication

Date	Text affected
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INTERNATIONAL STANDARD

BS ISO 16463:2014

ISO
16463

Second edition
2014-05-01

Polycrystalline diamond inserts, tipped — Dimensions, types

Plaquettes brasées en diamant polycristallin — Dimensions, types



Reference number
ISO 16463:2014(E)
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Published in Switzerland

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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).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

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 WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 29, *Small Tools*, Subcommittee SC 9, *Tools with cutting edges made of hard cutting materials*.

This second edition cancels and replaces the first edition (ISO 16463:2004), of which it constitutes a minor revision.

Polycrystalline diamond inserts, tipped — Dimensions, types

1 Scope

This International Standard applies to inserts with insert shapes in accordance with ISO 883 and ISO 6987, tipped with polycrystalline diamond (DP).

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 513, *Classification and application of hard cutting materials for metal removal with defined cutting edges — Designation of the main groups and groups of application*

ISO 883, *Indexable hardmetal (carbide) inserts with rounded corners, without fixing hole — Dimensions*

ISO 1832, *Indexable inserts for cutting tools — Designation*

ISO 3365, *Indexable hardmetal (carbide) inserts with wiper edges, without fixing hole — Dimensions*

ISO 6987, *Indexable hard material inserts with rounded corners, with partly cylindrical fixing hole — Dimensions*

3 Insert shapes and design

3.1 Insert shapes

Triangular (T), square (S), rhombic 80° (C), 55° (D), and 35° (V) and trigon (W).

3.2 Normal clearance, α_n

Normal clearance 5° (B), 7° (C), 11° (P), and 20° (E).

3.3 Cutting edge corner

Inserts for turning with corner radius r_E 0,2 mm, 0,4 mm, 0,8 mm, 1,2 mm, and 1,6 mm.

Inserts for milling with wiper edge.

NOTE The design of non-tipped corners is optional.

3.4 Tolerance class

Tolerance class in accordance with ISO 1832 shall be applied. In [Tables 1 to 10](#), this position is shown with a dot (•).

3.5 Design of cutting edges

Any design shall be indicated in the designation (see ISO 1832).

3.6 Insert type

The styles of tipped cutting edges in accordance with ISO 1832 shall be applied.

4 Designation

4.1 General

The designation of inserts tipped with polycrystalline diamond (DP) is based on ISO 1832. The letter symbol for the cutting edge condition and the letter symbol for the insert type shall be indicated in the designation in each case.

Designations contained in [4.2](#) and [4.3](#) are examples of use of designations in accordance with ISO 1832.

4.2 Designation of a tipped insert for turning

Designation of a rhombic insert with included angle $\varepsilon_r = 55^\circ$ (D), normal clearance $\alpha_n = 7^\circ$ (C), with tolerance class G, without chip breakers and with fixing hole (W), with side length $l = 11,6$ mm (11), thickness $s = 3,97$ mm (T3), corner radius $r_\varepsilon = 0,8$ mm (08), with sharp cutting edges (F), tipped — one sided — one corner (A), long (L), cutting material in accordance with ISO 513 (e.g. DP05):

Insert DCGW 11T308F — AL — DP05 — ...

NOTE DP05 is optional in accordance with ISO 1832, designation symbol 13.

4.3 Designation of a tipped insert for milling

Designation of a square insert (S) with normal clearance $\alpha_n = 11^\circ$ (P), with tolerance class G, without chip breakers and with fixing hole (W), with side length $l = 12,7$ mm (12), thickness $s = 4,76$ mm (04), cutting edge angle $\kappa_r = 75^\circ$ (E), normal clearance at wiper edge $\alpha = 15^\circ$ (D), right-hand type (R), tipped — one sided — one corner (A), long (L), cutting material in accordance with ISO 513 (e.g. DP05):

Insert SPGW 1204EDR — AL — DP05 — ...

NOTE DP05 is optional in accordance with ISO 1832, designation symbol 13.

5 Dimensions

5.1 Insert shape T with fixing hole (inserts for turning)

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

NOTE For the dimensions of l_1 , see [Table 11](#).