

BS ISO 1832:2017



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Indexable inserts for cutting tools — Designation



National foreword

This British Standard is the UK implementation of ISO 1832:2017. It supersedes BS ISO 1832:2012 which is withdrawn.

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A list of organizations represented on this committee can be obtained on request to its secretary.

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Plaquettes amovibles pour outils coupants — Désignation



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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 voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

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This document was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This sixth edition cancels and replaces the fifth edition (ISO 1832:2012), which has been technically revised.

Indexable inserts for cutting tools — Designation

1 Scope

This document establishes a code for the designation of the usual types of indexable inserts for cutting tools in hard cutting materials or any other cutting materials, in order to simplify orders and specifications for such inserts.

It also specifies the designations for cubic boron nitride (BL, BH, BC) inserts, tipped and solid, as well as polycrystalline diamond (DP) inserts, tipped.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 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 3002-1, *Basic quantities in cutting and grinding — Part 1: Geometry of the active part of cutting tools — General terms, reference systems, tool and working angles, chip breakers*

ISO 16462, *Cubic boron nitride inserts, tipped or solid — Dimensions, types*

ISO 16463, *Polycrystalline diamond inserts, tipped — Dimensions, types*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 Explanation of designation code

For indexable inserts, the designation code comprises nine symbols for designating the dimensions and other characteristics; the first seven symbols (symbols ① to ⑦) shall be used in every designation. Symbols ⑧ and ⑨ may be used when necessary.

For tipped inserts in accordance with ISO 16462 and ISO 16463, the designation code comprises 12 symbols for designating the dimensions and other characteristics; symbols ① to ⑦ as well as ⑪ and ⑫ shall be used in every designation. Symbols ⑧, ⑨ and ⑩ may be used when necessary. Symbols ⑪ and ⑫ shall be separated by a dash as shown in [Clause 4](#), example 2.

In addition to the standardized designation for indexable inserts and tipped inserts, a supplementary symbol ⑬ consisting of one or two characters may be added by the manufacturer for a better description of his/her product (for example, different chip breakers), provided this symbol is separated from the standardized designation by a dash and that it does not contain letters specific to references ⑧, ⑨ and ⑩.

No addition to or extension of the designations specified in this document shall be made without consultation with ISO/TC 29 and without its agreement. Rather than adding symbols not provided for in this system, it is preferable to add all necessary explanations in the form of detailed sketches or specifications to the designation in accordance with this document.

However, if the letter symbol “X” is used in position 4 of the designation, it is allowed to use, in positions 5, 6 and 7, symbols representing values not appearing in this document, but which shall be described explicitly using the sketch or the detailed specifications given in [5.4](#).

The significance of the symbols constituting the designation code is as follows:

①	Letter symbol identifying	insert shape (see 5.1)	Compulsory symbols for indexable inserts	Compulsory symbols for tipped inserts according to ISO 16462 and ISO 16463, except as noted
②	Letter symbol identifying	normal clearance (see 5.2)		
③	Letter symbol identifying	tolerance class (see 5.3)		
④	Letter symbol indicating	fixing and/or chip breakers (see 5.4)		
⑤	Number symbol identifying	insert size (see 5.5)		
⑥	Number symbol identifying	insert thickness (see 5.6)		
⑦	Letter or number symbol identifying	insert corner configuration (see 5.7)		
⑧	Letter symbol indicating (optional symbol for indexable and tipped inserts)	cutting edge condition (see 6.2)		
⑨	Letter symbol identifying (optional symbol for indexable and tipped inserts)	cutting direction (see 6.3)		
⑩	Number symbol identifying (optional symbol for tipped inserts)	size of cutting edge condition (see 7.2)		
⑪	Letter symbol identifying	style of tipped or solid cutting edge and number of tipped corners (see 7.3)		
⑫	Letter or number symbol identifying	length of tipped cutting edge (see 7.4)		
⑬	Manufacturer's symbol or cutting material designation according to ISO 513 (optional symbol for indexable and tipped inserts)			

EXAMPLE 1 General designation

	①	②	③	④	⑤	⑥	⑦	⑧	⑨		⑬
Metric dimensions:	T	P	G	N	16	03	08	E	N	—	...
Inch dimensions:	T	P	G	N	3	2	2	E	N	—	...

EXAMPLE 2 Designation of inserts according to ISO 16462 and ISO 16463

	①	②	③	④	⑤	⑥	⑦	⑧	⑩	⑨		⑪	⑫		⑬
Designation of insert for turning	S	N	M	A	15	06	08	E		(N)	—	B	L	—	...
Designation of insert for milling	T	P	G	T	16	T3	AP	S	01520	R	—	M	028	—	...

The designations and symbols of the different angles allowing geometrical definition of the indexable inserts shall conform with ISO 3002-1, with the following conventions:

- the insert is considered in the tool-in-hand system;
- the reference plane, P_r , is parallel to the base of the insert;
- the assumed working plane, P_f , is perpendicular to the reference plane, P_r , and is parallel to the assumed direction of feed motion. This plane is defined only in the case of inserts having one or more wiper edges.

The assumed direction of feed motion is taken parallel to the considered wiper edge (see Note 1 to Table 9).

For the relationship between designations in this document and the ISO 13399 series, see Annex C.

5 Symbols

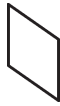
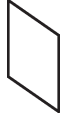
5.1 Symbol for insert shape — Reference ①

See Table 1.

Table 1

Type		Letter symbol	Description of shape	Included angle, ϵ_r	Illustration
I	Equilateral and equian-gular inserts	H	Hexagonal inserts	120°	
		O	Octagonal inserts	135°	
		P	Pentagonal inserts	108°	
		S	Square inserts	90°	
		T	Triangular inserts	60°	
^a The smaller angle is always the included angle that is considered.					

Table 1 (continued)

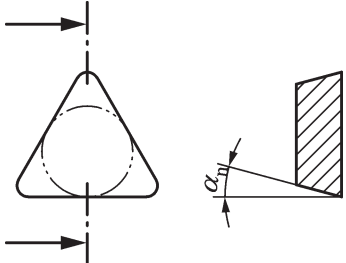
Type		Letter symbol	Description of shape	Included angle, ε_r	Illustration
II	Equilateral but non-equiangular inserts	C	Rhombic inserts	80° ^a	
		D		55° ^a	
		E		75° ^a	
		M		86° ^a	
		V		35° ^a	
		W	Trigon inserts	80° ^a	
III	Non-equilateral but equiangular inserts	L	Rectangular inserts	90°	
IV	Non-equilateral and non-equiangular inserts	A	Parallelogram-shaped inserts	85° ^a	
		B		82° ^a	
		K		55° ^a	
V	Round inserts	R	Round inserts	—	

^a The smaller angle is always the included angle that is considered.

5.2 Symbol for normal clearance — Reference ②

See [Table 2](#).

Table 2

Letter symbol	
For normal clearance, choose, from the letter symbols listed below, the one that corresponds to the major cutting edge (see the figure below).	
If (in spite of different clearances) all cutting edges have to be used as major cutting edges, the symbol to be used for the designation of the normal clearance shall be the symbol applicable to the normal clearance of the longer cutting edge, which is also considered the major cutting edge for the indication of the insert size (see reference ⑤).	
	A — 3° B — 5° C — 7° D — 15° E — 20° F — 25° G — 30° N — 0° P — 11° O — Other normal clearances requiring special specification

5.3 Symbol for tolerance class — Reference ③

See [Table 3](#).

The dimensions concerned are d (nominal diameter of the inscribed circle of the insert), s (thickness of the insert) and m . For this last dimension, the three cases represented in [Figures 1 to 3](#) are distinguished.

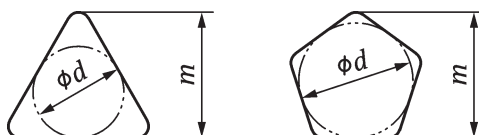


Figure 1 — Case 1: inserts with odd numbers of sides and rounded corners

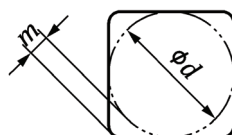


Figure 2 — Case 2: inserts with even numbers of sides and rounded corners

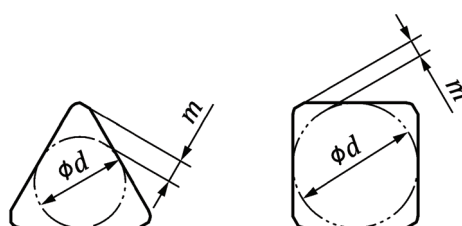


Figure 3 — Case 3: inserts with wiper edges (see Note 1 in Table 9)

Table 3

Letter	Tolerance in millimetres			Tolerance in inches		
	d	m	s	d	m	s
A^a	$\pm 0,025$	$\pm 0,005$	$\pm 0,025$	$\pm 0,001$	$\pm 0,000\ 2$	$\pm 0,001$
F^a	$\pm 0,013$	$\pm 0,005$	$\pm 0,025$	$\pm 0,000\ 5$	$\pm 0,000\ 2$	$\pm 0,001$
C^a	$\pm 0,025$	$\pm 0,013$	$\pm 0,025$	$\pm 0,001$	$\pm 0,000\ 5$	$\pm 0,001$
H	$\pm 0,013$	$\pm 0,013$	$\pm 0,025$	$\pm 0,000\ 5$	$\pm 0,000\ 5$	$\pm 0,001$
E	$\pm 0,025$	$\pm 0,025$	$\pm 0,025$	$\pm 0,001$	$\pm 0,001$	$\pm 0,001$
G	$\pm 0,025$	$\pm 0,025$	$\pm 0,13$	$\pm 0,001$	$\pm 0,001$	$\pm 0,005$
J^a	from $\pm 0,05^b$ to $\pm 0,15^b$	$\pm 0,005$	$\pm 0,025$	from $\pm 0,002^b$ to $\pm 0,006^b$	$\pm 0,000\ 2$	$\pm 0,001$
K^a	from $\pm 0,05^b$ to $\pm 0,15^b$	$\pm 0,013$	$\pm 0,025$	from $\pm 0,002^b$ to $\pm 0,006^b$	$\pm 0,000\ 5$	$\pm 0,001$
L^a	from $\pm 0,05^b$ to $\pm 0,15^b$	$\pm 0,025$	$\pm 0,025$	from $\pm 0,002^b$ to $\pm 0,006^b$	$\pm 0,001$	$\pm 0,001$
M	from $\pm 0,05^b$ to $\pm 0,15^b$	from $\pm 0,08^b$ to $\pm 0,2^b$	$\pm 0,13$	from $\pm 0,002^b$ to $\pm 0,006^b$	from $\pm 0,003^b$ to $\pm 0,008^b$	$\pm 0,005$
N	from $\pm 0,05^b$ to $\pm 0,15^b$	from $\pm 0,08^b$ to $\pm 0,2^b$	$\pm 0,025$	from $\pm 0,002^b$ to $\pm 0,006^b$	from $\pm 0,003^b$ to $\pm 0,008^b$	$\pm 0,001$
U	from $\pm 0,08^b$ to $\pm 0,25^b$	from $\pm 0,13^b$ to $\pm 0,38^b$	$\pm 0,13$	from $\pm 0,003^b$ to $\pm 0,01^b$	from $\pm 0,005^b$ to $\pm 0,015^b$	$\pm 0,005$

a These tolerance classes normally apply to indexable inserts with wiper edges.

b The tolerance is dependent upon the insert size (see Tables 4 and 5) and should be indicated for insert according to the corresponding dimensional standards.