
INTERNATIONAL STANDARD



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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Indexable (throwaway) carbide inserts for milling cutters — Dimensions — Part I : Square inserts

Plaquettes amovibles en carbures métalliques pour fraises — Dimensions — Partie I : Plaquettes carrées

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Indexable (throwaway) carbide inserts for milling cutters — Dimensions —

Part I : Square inserts

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of square indexable (throwaway) carbide inserts intended to be mounted mechanically, and not by brazing, on face milling cutters.

Triangular inserts are dealt with in ISO 3365/II.

2 REFERENCES

ISO 513, *Application of carbides for machining by chip removal — Designation of the main groups of chip removal and groups of application.*

ISO 1832, *Indexable (throwaway) inserts for cutting tools — Designation — Code of symbolization.*

ISO 3365/II, *Indexable (throwaway) carbide inserts for milling cutters — Dimensions — Part II : Triangular inserts.*¹⁾

3 INTERCHANGEABILITY

Dimension *m* specified in the tables refers to a theoretically perfect insert. In practice, as the points on which the inserts are located in both manufacture and measuring may be different, the nominal value of dimension *m* may vary from one manufacturer to another within a range of $\pm 0,05$ mm. Nevertheless, for inserts of the same manufacturer, dimension *m* shall comply with the tolerances according to ISO 1832 (see the annex).

4 TYPES OF INSERTS

The types of square indexable carbide inserts for milling cutters are the following :

- SN EN : Square inserts with chamfered corners, 75° cutting edge angle and 0° normal clearance.

- SP ED : Square inserts with chamfered corners, 75° cutting edge angle, 11° normal clearance and 15° wiper edge normal clearance.
- SP EP : Square inserts with chamfered corners, 75° cutting edge angle, 11° normal clearance and 11° wiper edge normal clearance.
- SN AN : Square inserts with 45° cutting edge angle and 0° normal clearance.

5 TOLERANCES

Indexable (throwaway) carbide inserts to this International Standard are provided in tolerance classes A, C or K, according to ISO 1832. The values of these tolerances are given in the annex.

6 DESIGNATION AND MARKING

6.1 Designation

The designation of the indexable (throwaway) carbide inserts for milling cutters complying with this International Standard shall conform to ISO 1832.

In addition to this designation, one or both of the following may be indicated :

- the symbol of the group of application, according to ISO 513;
- the commercial designation of the carbide grade.

6.2 Marking

The following symbol, at least, shall be marked on the insert itself :

- symbol of the group of application, or commercial designation of the carbide grade (or both, if possible, on large inserts).

1) At present at the stage of draft.