

TECHNICAL REPORT

29
**ISO
TR 6987-3**

First edition
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Indexable inserts for cutting tools — Hardmetal (carbide) inserts with rounded corners, with partly cylindrical fixing hole —

Part 3: V-shape inserts

*Plaquettes amovibles pour outils coupants — Plaquettes en métaux-durs
(carbures métalliques) avec arrondi de pointe et trou de fixation
partiellement cylindrique —*

Partie 3: Plaquettes de forme V



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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 main task of technical committees is to prepare International Standards, but in exceptional circumstances a technical committee may propose the publication of a Technical Report of one of the following types:

- type 1, when the required support cannot be obtained for the publication of an International Standard, despite repeated efforts;
- type 2, when the subject is still under technical development or where for any other reason there is the future but not immediate possibility of an agreement on an International Standard;
- type 3, when a technical committee has collected data of a different kind from that which is normally published as an International Standard ("state of the art", for example).

Technical Reports of types 1 and 2 are subject to review within three years of publication, to decide whether they can be transformed into International Standards. Technical Reports of type 3 do not necessarily have to be reviewed until the data they provide are considered to be no longer valid or useful.

ISO/TR 6987-3, which is a Technical Report of type 2, was prepared by Technical Committee ISO/TC 29, *Small tools*.

ISO 6987-1 and ISO 6987-2 deal with indexable inserts with rounded corners and partly cylindrical fixing hole, with 7° and 11° normal clearance and with the following shapes:

- triangular inserts, T;
- square inserts, S;

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- rhombic inserts, C, with 80° included angle;
- rhombic inserts, D, with 55° included angle;
- round inserts, R.

It was intended to standardize also rhombic V-shape inserts with 35° included angle. However, because of the interaction of tolerances on the clamping of the insert, it appears to be impossible to ensure interchangeability between different suppliers, and thus an International Standard on the subject cannot be published for the time being.

It was felt, however, that the results of the work should be published in the form of a Technical Report in order to present the points of agreement and to give orientations for the future.

ISO 6987 consists of the following parts, under the general title *Indexable inserts for cutting tools — Hardmetal (carbide) inserts with rounded corners, with partly cylindrical fixing hole*:

- Part 1: *Dimensions of inserts with 7 degrees normal clearance*
- Part 2: *Dimensions of inserts with 11 degrees normal clearance*
- Part 3: *V-shape inserts*
[Technical Report]

Annex A of this part of ISO 6987 is for information only.

