
INTERNATIONAL STANDARD



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Single point cutting tools — Corner radii

Outils de coupe à partie active unique — Rayons de pointe

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FOREWORD

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Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 3286 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the Member Bodies in January 1976.

It has been approved by the Member Bodies of the following countries :

Australia	Israel	Spain
Austria	Italy	Sweden
Belgium	Japan	Switzerland
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The Member Body of the following country expressed disapproval of the document of technical grounds :

U.S.A.

Single point cutting tools – Corner radii

1 SCOPE AND FIELD OF APPLICATION

This International Standard lays down the values for the corner radius of single point cutting tools.

It applies to all types of single point cutting tools (with or without inserts), the corner of which is rounded.

2 DIMENSIONS

Corner radii shall have the dimensions given in the table.

3 TOLERANCES

Tolerance on the corner radius will be given in particular tool standards, if necessary.

TABLE

Corner radius r_c	
mm	in
0,2	0.008
0,4	1/64
0,8	1/32
1,2	3/64
1,6	1/16
2,0	5/64
2,5*	3/32
3,2	1/8

* For indexable (throwaway) inserts, corner radius 2,4 mm instead of 2,5 mm is to be used.

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