
**Cartridges, type A, for indexable
inserts —**

**Part 1:
General survey, correlation and
determination of dimensions**

Cartouches du type A, à plaquettes amovibles —

Partie 1: Vue d'ensemble, corrélation et détermination des dimensions



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ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

Contents

	Page
Foreword	iv
1 Scope	1
2 Normative references	1
3 Survey	1
4 Correlation of dimensions	4
4.1 Length l_1 and dimension f	4
4.2 Smallest possible internal diameter for operating	4
4.3 Correlation of the shank dimension and fastening of the shank	5
5 Determination of dimensions	7
5.1 Cutting edge corners	7
5.1.1 Cutting edge corner K	7
5.1.2 Theoretical cutting edge corner T	8
5.2 Corner radius r_ϵ of master inserts	8
5.3 Length l_1	9
5.4 Dimension f	9
5.5 Height h_1	9
5.6 Tolerances	10
5.7 Dimension a	10
5.7.1 General	10
5.7.2 Styles R and T	10
5.7.3 Styles K, S, W and Y	10
5.7.4 Values for dimension a	10
5.8 Correction values x and y	10
Annex A (informative) Relationship between designations in ISO 5611 and ISO/TS 13399-2 and ISO/TS 13399-3	15
Bibliography	17

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 defined cutting edges, cutting items*.

This first edition of ISO 5611-1, together with ISO 5611-2, ISO 5611-3, ISO 5611-4, ISO 5611-5, ISO 5611-6, ISO 5611-7, ISO 5611-8, ISO 5611-9, ISO 5611-10, ISO 5611-11, and ISO 5611-12, cancels and replaces ISO 5611:1995, which has been technically revised.

ISO 5611 consists of the following parts, under the general title *Cartridges, type A, for indexable inserts*:

- *Part 1: General survey, correlation and determination of dimensions*
- *Part 2: Style F*
- *Part 3: Style G*
- *Part 4: Style J*
- *Part 5: Style K*
- *Part 6: Style L*
- *Part 7: Style R*
- *Part 8: Style S*
- *Part 9: Style T*
- *Part 10: Style U*
- *Part 11: Style W*
- *Part 12: Style Y*

Cartridges, type A, for indexable inserts —

Part 1:

General survey, correlation and determination of dimensions

1 Scope

This part of ISO 5611 is general and is completed by ISO 5611-2 to ISO 5611-12. ISO 5611 applied for cartridges, type A, for indexable inserts and gives their styles in relation to their dimensions in accordance with ISO 5611-2 to ISO 5611-12. These cartridges are primarily intended for indexable inserts made of hard metal, ceramic or other cutting materials to be used for turning operations.

These kinds of cartridges are mainly clamped with one or two screws on the cartridges.

Explanation of the designation code according to ISO 5608.

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 5611-2¹⁾, *Cartridges, type A, for indexable inserts — Part 2: Style F*

ISO 5611-3¹⁾, *Cartridges, type A, for indexable inserts — Part 3: Style G*

ISO 5611-4¹⁾, *Cartridges, type A, for indexable inserts — Part 4: Style J*

ISO 5611-5¹⁾, *Cartridges, type A, for indexable inserts — Part 5: Style K*

ISO 5611-6¹⁾, *Cartridges, type A, for indexable inserts — Part 6: Style L*

ISO 5611-7¹⁾, *Cartridges, type A, for indexable inserts — Part 7: Style R*

ISO 5611-8¹⁾, *Cartridges, type A, for indexable inserts — Part 8: Style S*

ISO 5611-9¹⁾, *Cartridges, type A, for indexable inserts — Part 9: Style T*

ISO 5611-10¹⁾, *Cartridges, type A, for indexable inserts — Part 10: Style U*

ISO 5611-11¹⁾, *Cartridges, type A, for indexable inserts — Part 11: Style W*

ISO 5611-12¹⁾, *Cartridges, type A, for indexable inserts — Part 12: Style Y*

3 Survey

[Table 1](#) contains the survey of cartridges, type A, for indexable inserts which are standardized in ISO 5611-2 to ISO 5611-12 their corresponding letter symbols and the height h_1 of the cutting edge. The arrows in the figures show the primary direction of feed.

1) To be published.

Table 1 — Survey of cartridges, type A

Dimensions in millimetres

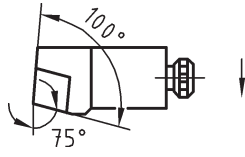
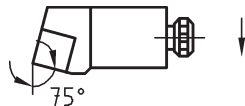
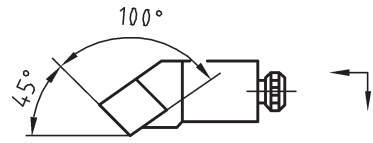
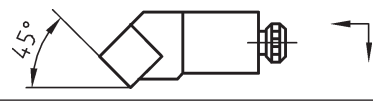
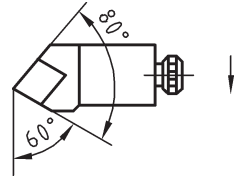
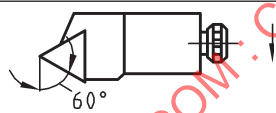
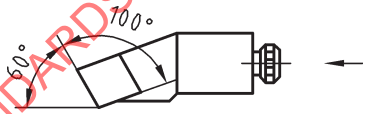
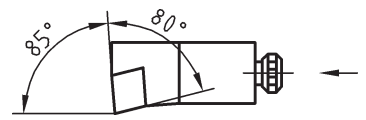
Style	Sketch	Height of the cutting edge							Dimensions in ISO
		6	8	10	12	16	20	25	
F		•	•						ISO 5611-2
			•	•	•	•	•	•	
G		•	•						ISO 5611-3
			•	•	•	•	•	•	
J			•						ISO 5611-4
			•	•	•	•	•	•	
K		•	•						ISO 5611-5
				•	•	•	•	•	
L		•	•	•	•	•	•	•	ISO 5611-6

^a It is left to the manufacturer's discretion or by agreement with edge angle $\epsilon_r = 80^\circ$ instead 100° .

• = Standardized dimensions.

blank = Not standardized.

Table 1 (continued)

Style	Sketch	Height of the cutting edge							Dimensions in ISO
		h_1							
		6	8	10	12	16	20	25	
R		•a	•a						ISO 5611-7
				•	•	•	•	•	
S		•a	•						ISO 5611-8
				•	•	•	•	•	
			•	•	•	•	•	•	
T		•	•						ISO 5611-9
			•	•	•	•	•	•	
U			•	•	•	•	•	•	ISO 5611-10
W		•	•						ISO 5611-11
			•	•	•	•	•	•	
Y		•	•						ISO 5611-12
				•	•	•	•	•	
a It is left to the manufacturer's discretion or by agreement with edge angle $\epsilon_r = 80^\circ$ instead 100°. • = Standardized dimensions. blank = Not standardized.									

4 Correlation of dimensions

4.1 Length l_1 and dimension f

Table 2 contains the correlation between the length l_1 and the dimension f to their relevant height h_1 of the cutting edge and style of the cartridges, see also Figure 1.

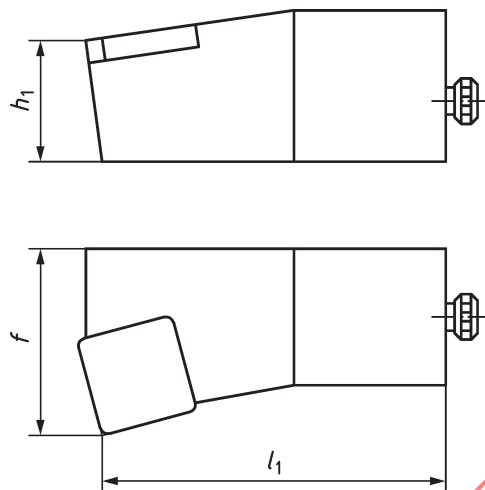


Figure 1 — Cartridge style K

Table 2 — Correlation of dimensions

Dimensions in millimetres

h_1	l_1		f 0 -0,08	
$\pm 0,08$	for cartridge style		for cartridge style	
	F, G, J, K, L, R, T, U, Y	W, S	F, G, J, K, L, R, S, U, W, Y	T
6	25	21	8	5,5
8	32	28	10	6
10	50	44	14	9
12	55	47	20	13
16	63	53	25	15
20	70	60		
25	100	87	32	20

4.2 Smallest possible internal diameter for operating

Table 3 contains the smallest possible internal diameter $d_{1 \min}$ for operating in relation with the relevant cartridge size h_1 , see also Figures 4 and 5.

Table 3 — Smallest possible internal diameter for operating

Dimensions in millimetres

$h_1 \pm 0,08$	6	8	10	12	16	20	25
d_1 min.	20	25	40	50	60	70	100

4.3 Correlation of the shank dimension and fastening of the shank

Table 4 contains the correlation between the shank dimensions and the bore diameter for fastening the shank and their relevant height h_1 of the cutting edge, see Figures 2, 3, 4 and 5.

Dimension l_3 applies to the adjusting screw in its mid-position, which is the reference point of the length l_1 , see 5.3. From this position, a minimum adjusting length of 0,4 mm shall be given in both directions.

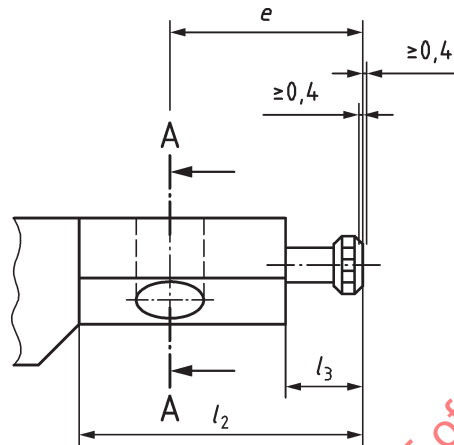


Figure 2 — Shank having $h_1 = 6 \text{ mm}, 8 \text{ mm}, 10 \text{ mm}, 12 \text{ mm}, 16 \text{ mm}$ and 20 mm

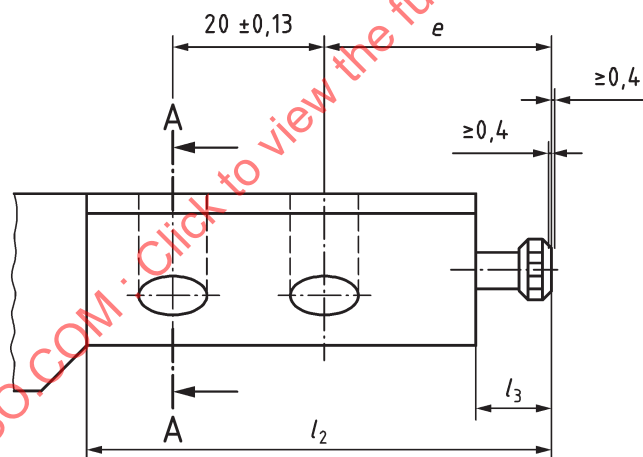


Figure 3 — Shank having $h_1 = 25 \text{ mm}$

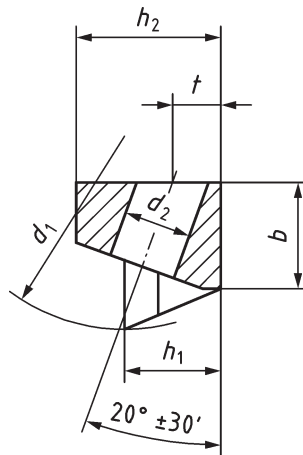


Figure 4 — Sectional drawing A-A for cartridges having $h_1 = 6 \text{ mm}, 8 \text{ mm}, 10 \text{ mm}$ or 12 mm

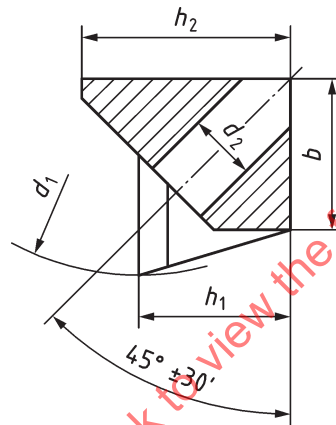


Figure 5 — Sectional drawing A-A for cartridges having $h_1 = 16 \text{ mm}, 20 \text{ mm}$ or 25 mm

Table 4 — Correlation of the shank dimension and fastening of the shank

Dimensions in millimetres

h_1	b	d_2^a	e	h_2	l_2	l_3	t	Fastening screw
$\pm 0,08$	0 -0,2	H13		0 -0,2	min.		$\pm 0,13$	
6	6	4	12	8,5	16	4,5	3,5	M3,5
8	8	4,5	17	11	21,5	6	4,5	M4
10	11	7	20	15	26	8	5	M6
12	16			20			6	
16	20	9	25	25	32,5	10	—	M8
20	20	9	30	30	37,5		—	M8
25	25	11		35	59			M10

^a The hole for fastening screws can be designed also as slotted hole at the manufacturer's option.

5 Determination of dimensions

5.1 Cutting edge corners

5.1.1 Cutting edge corner K

The specified point K is defined as follows:

Consider plane P_f (assumed working plane) and P_s (tool cutting edge plane) according to ISO 3002-1 for a selected point on the major cutting edge (for example point of tangency of major cutting edge with inscribed circle).

- For $\kappa_r \leq 90^\circ$, point K is defined as the intersection of plane P_s , a plane parallel to plane P_f tangent to the corner radius and a plane containing the tool face A_γ (see [Figures 6](#) and [7](#)).
- For $\kappa_r > 90^\circ$, point K is defined as the intersection of a plane parallel to plane P_f tangent to the corner radius, a plane perpendicular to plane P_f tangent to the corner radius and a plane containing the tool face A_γ (see [Figures 8](#) and [9](#)).

NOTE The position of the cutting edge corner K is dependent from the corner radius r_ϵ of the indexable insert.

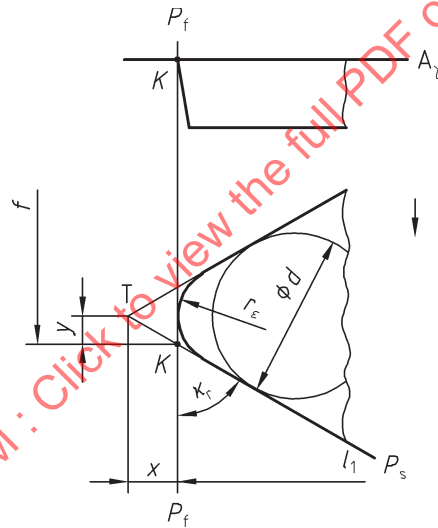


Figure 6 — Cutting edge angle $\kappa_r \leq 90^\circ$, with transverse feed

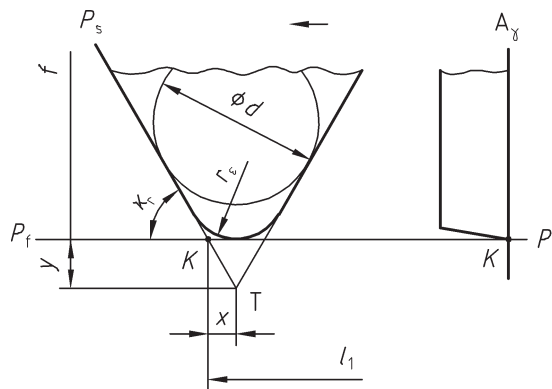


Figure 7 — Cutting edge angle $\kappa_r \leq 90^\circ$, with longitudinal feed



Figure 9 — Cutting edge angle $\kappa_r > 90^\circ$, with longitudinal feed



NOTE The position of the theoretical corner T is independent of the corner radius r_ε of the indexable insert.

Table 5 contains the values of the corner radius r_ϵ of the master insert (master gauge) used for the definition and testing of length l_1 , dimension f and height h_1 .

The corner radius r_e of the master indexable insert is a function of the size of the indexable insert associated to cartridges and in [Table 5](#) it is therefore related to the diameter of the inscribed circle.

Table 5 — Corner radius r_ϵ of master inserts

Dimensions in millimetres

d	r_ϵ Nominal dimensions ^a
5,56	0,4
6,35	
7,94	
9,525	0,8
12,7	
15,875	1,2
19,05	
25,4	2,4

^a For the determination of the values of l_1 , f and the correction values x and y are derived from the accurate values of the corner radii $r_\epsilon = 0,397$ mm; 0,794 mm; 1,191 mm and 2,381 mm, which correspond to the inch dimensions.

5.3 Length l_1

The length l_1 (for values see [Table 2](#)) is the distance between the specified point K and the shank end including adjustable screw in their mid-position (see [Figure 1](#), [Figures 6](#) to [9](#) and figures in [Table 6](#)), measured on a master indexable insert with corner radius r_ϵ in accordance with [5.2](#).

For cartridges with indexable inserts with a corner radius r_ϵ deviating from [Table 5](#), the modified length l_1 shall be determined with correction value x as shown in [Figures 6](#) to [9](#).

The correction value x (see [Table 6](#)) corresponds to the distance, measured parallel to the shank, between the specified point K and the theoretical corner T .

The modified length is obtained from the length l_1 given in [Table 2](#) and the difference between the values x for the new corner radius and the corner radius given in [Table 5](#).

5.4 Dimension f

Dimension f (for values see [Table 2](#)) is the distance between the specified point K and the rear backing surface of the cartridges (see [Figure 1](#), [Figures 6](#) to [9](#) and figures in [Table 6](#)), measured on a master insert with corner radius r_ϵ in accordance with [5.2](#).

For cartridges with inserts with a corner radius r_ϵ deviating from [Table 5](#), the modified dimension f shall be determined with correction value y as shown in [Figures 6](#) to [9](#).

Correction value y corresponds to the distance between the specified point K and the theoretical cutting edge corner T , measured transverse to the shank.

The modified dimension f is obtained from the value given in [Table 2](#) and the difference between the y -values for the new corner radius and the corner radius given in [Table 5](#).

5.5 Height h_1

The height h_1 determined the size of the cartridges and specified the distance between the cutting edge K and the base of the cartridges (see [Figures 1](#) to [5](#)) measured on a master indexable insert and optional on a master shim.

5.6 Tolerances

The tolerances given in [Tables 2](#) and [4](#) for the dimension f and the height h_1 measured on a master indexable insert and a master shim, if applicable. Therefore, the tolerances on f and h_1 do not include the tolerances on indexable insert, shim and respectively width of shank.

5.7 Dimension a

5.7.1 General

Dimension a is related to the determination of the overall width and overall length of cartridges.

In general, the width of cartridges corresponds to dimension f for the shank width and its length l_1 with the exception of cartridges of styles which are listed in [5.7.2](#) and [5.7.3](#).

5.7.2 Styles R and T

For styles R and T, the overall width of the cartridge is the sum of the values for f and a .

Dimension a is defined as the distance between the specified point K and the tangent to the corner radius of the indexable insert, measured perpendicular to the shank length, see also figures in [Table 6](#).

5.7.3 Styles K, S, W and Y

For styles K, S, W and Y the overall length of the cartridges is the sum of the values for l_1 and a .

Dimension a is defined as the distance between the specified point K and the tangent on the corner radius of the indexable insert, measured parallel to the shank length, see also figures in [Table 6](#).

5.7.4 Values for dimension a

The values for dimension a are given in the respective dimension standards and apply to indexable inserts with corner radii in accordance with [5.2](#), with rake angle $\gamma_0 = 0^\circ$ and inclination angle $\lambda_s = 0^\circ$.

For cartridges with indexable inserts with corner radii deviating from the values given in [Table 5](#), the modified dimension a shall be determined for styles R and T with correction values y and for styles K, S, W and Y with correction value x ; for values for x and y see [Table 6](#).

For the rake angle γ_0 and cutting edge inclination angle λ_s varying between -6° and $+6^\circ$, variations of the values for a are less than 0,1 mm and thus negligible.

5.8 Correction values x and y

The correction values x and y given in [Table 6](#) apply to rake angle $\gamma_0 = 0^\circ$ and cutting edge inclination $\lambda_s = 0^\circ$. Rake angles γ_0 and cutting edge inclinations λ_s varying between -6° and $+6^\circ$ result in variations from the x - and y -values in the range of 0,001 mm to 0,01 mm, which are significantly smaller than the tolerances on f and h_1 . If necessary, the correction values have to be determined.

Table 6 — Correction values x and y

Dimensions in millimetres

Style	Sketch	r_E	x	y
F		0,2	—	0,039
		0,4	—	0,076
		0,8	—	0,152
		1,2	—	0,288
		1,6	—	0,305
		2,4	—	0,457
		0,2	—	0,149
		0,4	—	0,291
		0,8	—	0,581
		1,2	—	0,872
		1,6	—	1,162
		2,4	—	1,743
G		0,2	0,039	—
		0,4	0,076	—
		0,8	0,152	—
		1,2	0,228	—
		1,6	0,305	—
		2,4	0,457	—
		0,2	0,149	—
		0,4	0,291	—
		0,8	0,581	—
		1,2	0,872	—
		1,6	1,162	—
		2,4	1,743	—
J		0,2	0,176	0,020
		0,4	0,344	0,039
		0,8	0,688	0,079
		1,2	1,031	0,118
		1,6	1,375	0,157
		2,4	2,062	0,236
		0,2	0,138	0,018
		0,4	0,269	0,035
		0,8	0,538	0,071
		1,2	0,806	0,106
		1,6	1,075	0,142
		2,4	1,613	0,213

Table 6 (continued)

Style	Sketch	r_ε	x	y
K		0,2	0,004	0,014
		0,4	0,007	0,028
		0,8	0,015	0,055
		1,2	0,022	0,083
		1,6	0,029	0,110
		2,4	0,044	0,165
		0,2	0,012	0,046
		0,4	0,024	0,089
		0,8	0,048	0,178
		1,2	0,072	0,268
		1,6	0,096	0,357
		2,4	0,143	0,535
L		0,2	0,020	0,020
		0,4	0,040	0,040
		0,8	0,079	0,079
		1,2	0,119	0,119
		1,6	0,159	0,159
		2,4	0,238	0,238
R		0,2	0,014	0,004
		0,4	0,028	0,007
		0,8	0,055	0,015
		1,2	0,083	0,022
		1,6	0,110	0,029
		2,4	0,165	0,044
		0,2	0,046	0,012
		0,4	0,089	0,024
		0,8	0,178	0,048
		1,2	0,268	0,072
		1,6	0,357	0,096
		2,4	0,535	0,143

Table 6 (continued)

Style	Sketch	r_ϵ	x	y
S		0,2	0,061	0,061
		0,4	0,119	0,119
		0,8	0,239	0,239
		1,2	0,358	0,358
		1,6	0,477	0,477
		2,4	0,715	0,715
		0,2	0,084	0,084
		0,4	0,164	0,164
		0,8	0,329	0,329
		1,2	0,493	0,493
		1,6	0,658	0,658
		2,4	0,986	0,986
		0,2	0,185	0,185
		0,4	0,370	0,370
		0,8	0,740	0,740
		1,2	1,109	1,109
		1,6	1,479	1,479
		2,4	2,219	2,219
T		0,2	0,108	0,062
		0,4	0,211	0,122
		0,8	0,422	0,244
		1,2	0,634	0,366
		1,6	0,845	0,488
		2,4	1,267	0,731
		0,2	0,203	0,117
		0,4	0,397	0,229
		0,8	0,794	0,458
		1,2	1,191	0,687
		1,6	1,588	0,917
		2,4	2,381	1,375
U		0,2	0,018	0,138
		0,4	0,035	0,269
		0,8	0,071	0,538
		1,2	0,106	0,806
		1,6	0,142	1,075
		2,4	0,213	1,613