
एक नोंक वाले कटिंग औज़ार —
कोने की त्रिज्या
(पहला पुनरीक्षण)

Single Point Cutting
Tools — Corner Radii
(First Revision)

ICS 25.100. 01

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NATIONAL FOREWORD

This Indian Standard (First Revision) which is identical to ISO 3286 : 2016 'Single point cutting tools — Corner radii' issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on recommendation of the Cutting Tools Sectional Committee and Production and General Engineering Division Council.

This standard was originally published in 2002. The first revision of this standard has been undertaken to align it with the latest version of ISO 3286.

The text of ISO standard has been approved as suitable for publication as an Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'; and
- b) Comma (,) has been used as a decimal marker while in Indian Standards, the current practice is to use a point (.) as the decimal marker.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

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Indian Standard

SINGLE POINT CUTTING TOOLS — CORNER RADII

(First Revision)

1 Scope

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 [Table 1](#).

3 Tolerances

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

Table 1

Corner radius, r_E	
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 ^a	3/32
3,2	1/8
^a For indexable (throwaway) inserts, corner radius 2,4 mm instead of 2,5 mm is to be used.	

Annex A
(informative)

**Relationship between designations in this International Standard
and ISO 13399**

For relationship between designations in this International Standard and preferred symbols according to ISO 13399, see [Table A.1](#).

**Table A.1 — Relationship between designations in this International Standard and the
ISO 13399 series**

Symbol in this International Standard	Reference in this International Standard	Property name in ISO 13399	Symbol in ISO 13399	Reference in ISO 13399
r_E	Clause 3 Table 1	corner radius	RE	ISO/TS 13399-2 71DD6C8ACA503

Bibliography

- [1] ISO/TS 13399-2:2014, *Cutting tool data representation and exchange — Part 2: Reference dictionary for the cutting items*

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