

BS ISO 5610-2:2014



BSI Standards Publication

# Tool holders with rectangular shank for indexable inserts

Part 2: Style A

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**National foreword**

This British Standard is the UK implementation of ISO 5610-2:2014. It supersedes BS ISO 5610-2:2010 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee MTE/18, Tools tips and inserts for cutting applications.

A list of organizations represented on this committee can be obtained on request to its secretary.

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**ISO**  
**5610-2**

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**Tool holders with rectangular shank  
for indexable inserts —**

Part 2:  
**Style A**

*Porte-plaquette à queue rectangulaire pour plaquettes amovibles —  
Partie 2: Forme A*



Reference number  
ISO 5610-2:2014(E)

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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 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](http://www.iso.org/directives)).

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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 second edition cancels and replaces the first edition (ISO 5610-2:2010), of which it constitutes a minor revision.

ISO 5610 consists of the following parts, under the general title *Tool holders with rectangular shank for indexable inserts*:

- *Part 1: General survey, correlation and determination of dimensions*
- *Part 2: Style A*
- *Part 3: Style B*
- *Part 4: Style D*
- *Part 5: Style F*
- *Part 6: Style G*
- *Part 7: Style J*
- *Part 8: Style K*
- *Part 9: Style L*
- *Part 10: Style N*
- *Part 11: Style R*
- *Part 12: Style S*
- *Part 13: Style T*

- *Part 14: Style H*
- *Part 15: Style V*





# Tool holders with rectangular shank for indexable inserts —

## Part 2: Style A

### 1 Scope

This part of ISO 5610 specifies tool holders with rectangular shank, style A, i.e. with straight shank and cutting edge angle  $\kappa_r = 90^\circ$  for side cutting.

These tool holders are primarily intended for indexable inserts made of hard metal or other cutting materials intended to be mounted by clamping and used for turning operations.

NOTE The symbols for the dimensions shown in the tables of this part of ISO 5610 and the corresponding preferred symbols of properties defined in ISO/TS 13399-2 and ISO/TS 13399-3 are given in ISO 5610-1:2014, Table A.1.

### 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 5608:2012, *Turning and copying tool holders and cartridges for indexable inserts — Designation*

ISO 5610-1:2014, *Tool holders with rectangular shank for indexable inserts — Part 1: General survey, correlation and determination of dimensions*

### 3 Dimensions

#### 3.1 General

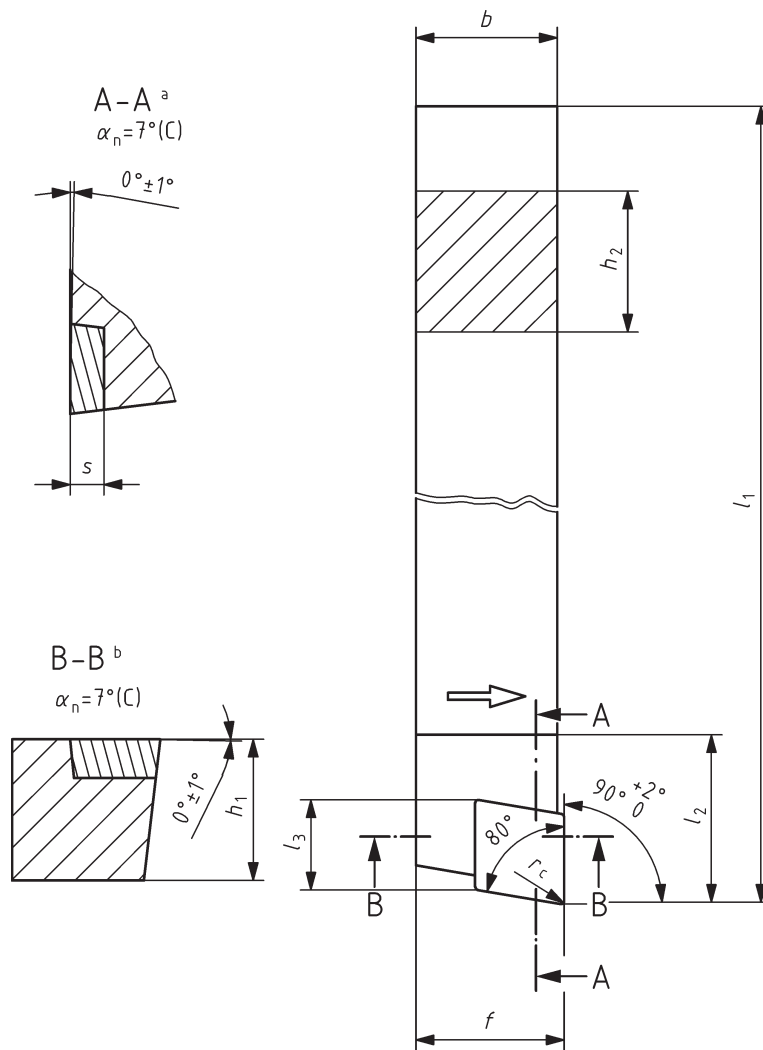
It is not necessary for tool holders to comply with the pictorial representation; only the dimensions given shall be observed.

For determination of dimensions  $h_1$ ,  $f$ , and  $l_1$ , see ISO 5610-1.

For explanation of the designation code for tool holders, see ISO 5608.

NOTE The values of rake angles and inclination angles shown in the figures are recommended values; they can vary according to the application.

3.2 Tool holder style A for rhombic indexable insert shape C



**Key**

- a Inclination angle,  $\lambda_s$ .
- b Rake angle,  $\gamma_o$ .

NOTE This figure shows a right-hand tool holder (R); left-hand tool holder (L) laterally reversed.

**Figure 1 — Tool holder style A for rhombic indexable insert — C**

**Table 1**

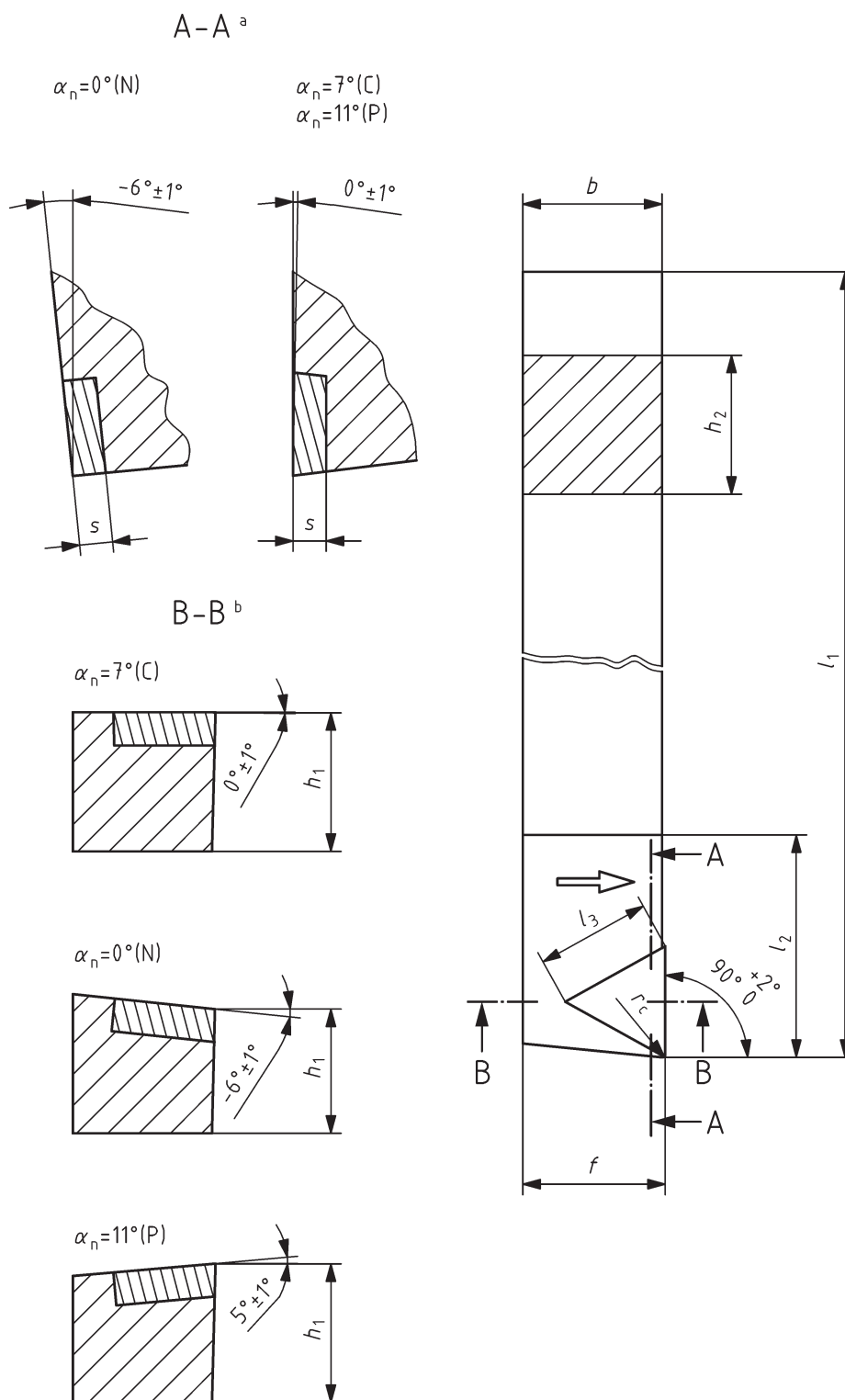
Dimensions in millimetres

Symbol <sup>a</sup>	$h_1$	$b$	$l_3$	$f$	$h_2$	$l_1^a$	$l_2$	$s^b$
	js13	h13	≈	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	h13	k16	max.	
<b>SCACR 0808 — 06</b>	8	8	6,4	8,5	8	—	12	2,38
<b>SCACL 0808 — 06</b>								
<b>SCACR 1010 — 06</b>	10	10	6,4	10,5	10	—	12	2,38
<b>SCACL 1010 — 06</b>								

<sup>a</sup> For the selection of length,  $l_1$ , the dash can be replaced by the dimensions of ISO 5610-1:2014, Table 2. For the letter symbols identifying the tool length, see ISO 5608:2012, Table 6.

<sup>b</sup> Insert thickness without shim, if applicable.

### 3.3 Tool holder style A for triangular indexable insert shape T



**Key**

- a Inclination angle,  $\lambda_s$ .
- b Rake angle,  $\gamma_0$ .

NOTE This figure shows a right-hand tool holder (R); left-hand tool holder (L) laterally reversed.

**Figure 2 — Tool holder style A for triangular indexable insert — T**

**Table 2**

Dimensions in millimetres

Symbol <sup>a</sup>	$h_1$ js13	$b$ h13	$l_3$ ≈	$f$ $+0,5$ 0	$h_2$ h13	$l_1^a$ k16	$l_2$ max.	$s^b$
<b>STACR 1212 — 11</b>	12	12	11	12,5	12	—	25	2,38
<b>STACL 1212 — 11</b>								3,18
<b>PTANR 1212 — 11</b>								
<b>PTANL 1212 — 11</b>								
<b>CTAPR 1212 — 11</b>								
<b>CTAPL 1212 — 11</b>								
<b>STACR 1616 — 11</b>	16	16	11	16,5	16	—	25	2,38
<b>STACL 1616 — 11</b>								3,18
<b>PTANR 1616 — 11</b>								
<b>PTANL 1616 — 11</b>								
<b>CTAPR 1616 — 11</b>								
<b>CTAPL 1616 — 11</b>								
<b>STACR 2020 — 16</b>	20	20	16,5	20,5	20	—	32	3,97
<b>STACL 2020 — 16</b>								4,76
<b>PTANR 2020 — 16</b>								
<b>PTANL 2020 — 16</b>								
<b>CTAPR 2020 — 16</b>								
<b>CTAPL 2020 — 16</b>								3,18
<b>STACR 2525 — 16</b>	25	25	16,5	25,5	25	—	32	3,97
<b>STACL 2525 — 16</b>								4,76
<b>PTANR 2525 — 16</b>								
<b>PTANL 2525 — 16</b>								
<b>CTAPR 2525 — 16</b>								
<b>CTAPL 2525 — 16</b>								3,18
<b>STACR 3225 — 16</b>	32	25	16,5	25,5	32	—	32	3,97
<b>STACL 3225 — 16</b>								4,76
<b>PTANR 3225 — 16</b>								
<b>PTANL 3225 — 16</b>								
<b>CTAPR 3225 — 16</b>								
<b>CTAPL 3225 — 16</b>								3,18

<sup>a</sup> For the selection of length,  $l_1$ , the dash can be replaced by the dimensions of ISO 5610-1:2014, Table 2. For the letter symbols identifying the tool length, see ISO 5608:2012, Table 6.

<sup>b</sup> Insert thickness without shim, if applicable.

Table 2

Symbol <sup>a</sup>	$h_1$ js13	$b$ h13	$l_3$ $\approx$	$f$ $^{+0,5}_0$	$h_2$ h13	$l_1^a$ k16	$l_2$ max.	$s^b$
STACR 3232 — 22	32	32	22	33	32	—	36	4,76
STACL 3232 — 22								
PTANR 3232 — 22								
PTANL 3232 — 22								
CTAPR 3232 — 22								
CTAPL 3232 — 22								
STACR 4040 — 22	40	40	22	41	40	—	36	4,76
STACL 4040 — 22								
PTANR 4040 — 22								
PTANL 4040 — 22								
CTAPR 4040 — 22								
CTAPL 4040 — 22								

<sup>a</sup> For the selection of length,  $l_1$ , the dash can be replaced by the dimensions of ISO 5610-1:2014, Table 2. For the letter symbols identifying the tool length, see ISO 5608:2012, Table 6.

<sup>b</sup> Insert thickness without shim, if applicable.

## 4 Designation

A tool holder in accordance with this part of ISO 5610 shall be designated by the following:

- “Tool holder”;
- a reference to this part of ISO 5610 (i.e. ISO 5610-2);
- type of mounting, in accordance with ISO 5608;
- symbol for indexable insert shape, in accordance with ISO 5608;
- symbol for tool style, in accordance with ISO 5608;
- symbol for the indexable insert normal clearance, in accordance with ISO 5608;
- symbol for hand of tool, in accordance with ISO 5608;
- its height,  $h_1$ , width,  $b$ , and length,  $l_1$  (symbol for tool length in accordance with ISO 5608);
- its cutting edge length  $l_3$ .

EXAMPLE 1 Tool holder for a screw-clamped (S) rhombic indexable insert shape C (C), tool holder style A (A), for normal clearance of indexable insert  $\alpha_n = 7^\circ$  (C), right-hand type (R), with height  $h_1 = 10$  mm, and width  $b = 10$  mm (1010), length  $l_1 = 70$  mm (E), for cutting edge length  $l_3 = 6,4$  mm (06) is designated as follows:

**Tool holder ISO 5610-2 – SCACR 1010 E06**

EXAMPLE 2 Tool holder for a horizontally mounted, bore-clamped (P) triangular indexable insert shape T (T), tool holder style A (A), normal clearance of indexable insert  $\alpha_n = 0^\circ$  (N), right-hand type (R), with height  $h_1 = 32$  mm, and width  $b = 25$  mm (3225), length  $l_1 = 170$  mm (P), for cutting edge length  $l_3 = 16,5$  mm (16) is designated as follows:

**Tool holder ISO 5610-2 – PTANR 3225 P16**

## 5 Material

The material should be steel with a tensile strength of at least 1 200 N/mm<sup>2</sup>.

## 6 Design

### 6.1 Type of mounting

Standard design of tool holders with indexable insert shall be mounted in accordance with [Tables 1](#) and [2](#).

Other types of mounting are at the manufacturer's discretion or upon agreement. The letter symbol in the designation, symbol 1, shall then be replaced by the respective symbol for the chosen or agreed-upon type of mounting, in accordance with ISO 5608.

For the modified type of mounting deviating from [Tables 1](#) and [2](#), the relevant indexable insert thickness shall also be considered.

### 6.2 Corner radius, $r_{\epsilon}$

Tool holders in accordance with this part of ISO 5610 can be equipped with indexable inserts with cutting edge length,  $l_3$ , as specified in [Tables 1](#) and [2](#), and any corner radius,  $r_{\epsilon}$ .

The values for  $l_1$  given in ISO 5610-1:2014, Table 2 apply to tool holders with indexable inserts having corner radii,  $r_{\epsilon}$ , in accordance with [Table 3](#).

**Table 3**

Dimensions in millimetres

$l_3$	$r_{\epsilon}$
6,4	0,4
11	
16,5	
22	0,8
NOTE The values given for $r_{\epsilon}$ are nominal values. The accurate values converted from the inch dimensions are 0,397 mm and 0,794 mm.	

For indexable inserts with corner radii,  $r_{\epsilon}$ , other than those specified in [Table 3](#), the dimensions of  $l_1$  shall be determined in accordance with ISO 5610-1.

The tolerances for  $h_1$ ,  $f$ , and  $l_1$  refer to dimensions measured with master indexable insert and master shim, if applicable.

### 6.3 Thickness, $s$ , of indexable insert

The values for thickness,  $s$ , given in [Tables 1](#) and [2](#) apply to indexable inserts without shim and for the standard design of tool holders.

For tool holders for indexable inserts with thicknesses deviating from the specified values, the thickness shall be indicated when ordering or upon delivery (in the handbook).

## 7 Extent of delivery

The tool holders shall be delivered complete with clamping device, but without indexable insert(s).

## **8 Marking**

Tool holders shall be marked with the letter symbol and the name or trademark of the manufacturer.

Additional marking is at the manufacturer's discretion or upon agreement.

Deviations in marking may be by mutual agreement.

A reference to this part of ISO 5610, i.e. ISO 5610-2:2014, shall be given on the packaging.



## Bibliography

- [1] ISO 883, *Indexable hardmetal (carbide) inserts with rounded corners, without fixing hole — Dimensions*
- [2] ISO 3002-1, *Basic quantities in cutting and grinding — Part 1: Geometry of the active part of cutting tools — General terms, reference systems, tool and working angles, chip breakers*
- [3] ISO 3364, *Indexable hardmetal (carbide) inserts with rounded corners, with cylindrical fixing hole — Dimensions*
- [4] ISO 6987, *Indexable hard material inserts with rounded corners, with partly cylindrical fixing hole — Dimensions*
- [5] ISO/TS 13399-2, *Cutting tool data representation and exchange — Part 2: Reference dictionary for the cutting items*
- [6] ISO/TS 13399-3, *Cutting tool data representation and exchange — Part 3: Reference dictionary for tool items*





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