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STANDARD

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**Single point cutting tools — Corner
radii**

Outils de coupe à partie active unique — Rayons de pointe



Reference number
ISO 3286:2016(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.

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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 3286:1976), of which it constitutes a minor revision.

Single point cutting tools — Corner radii

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*

