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

**Part 8:
Style S**

*Cartouches du type A, à plaquettes amovibles —
Partie 8: Forme S*





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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).

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 5611-8, together with ISO 5611-1, ISO 5611-2, ISO 5611-3, ISO 5611-4, ISO 5611-5, ISO 5611-6, ISO 5611-7, 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 8: Style S

1 Scope

This part of ISO 5611 applies for cartridges type A, with hole(s) for fastening screw(s), of style S, i.e. with cutting edge angle $\kappa_r = 45^\circ$ for end cutting.

Cartridges are intended to be used with indexable inserts made of hard metal, ceramic, or other cutting materials and are primarily mounted to be used for internal turning of operations.

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 1832, *Indexable inserts for cutting tools — Designation*

ISO 5608, *Turning and copying tool holders and cartridges for indexable inserts — Designation*

ISO 5611-1, *Cartridges, type A, for indexable inserts — Part 1: General survey, correlation and determination of dimensions*

3 Dimensions

Cartridges type A need not comply with the pictorial representation, only the dimensions given shall be observed.

For determination of dimensions h_1 , f , and l_1 , see ISO 5611-1. For explanation of the designation code for cartridges, see ISO 5608.

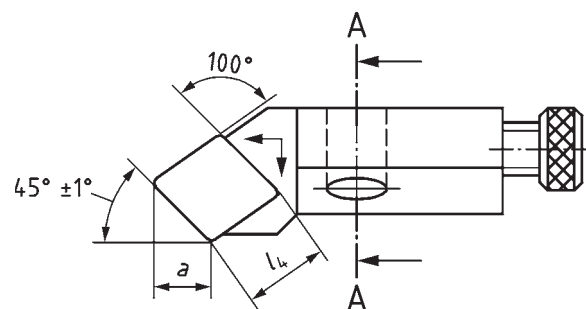
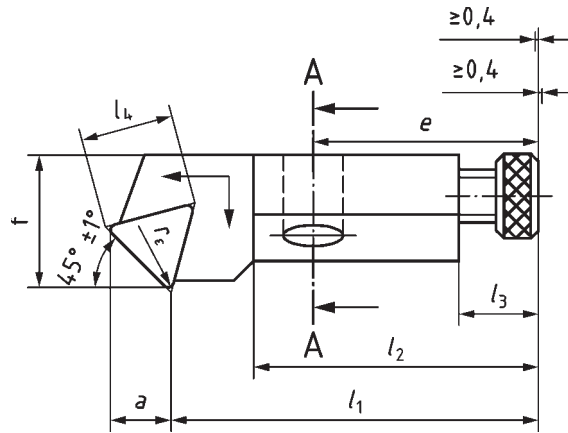
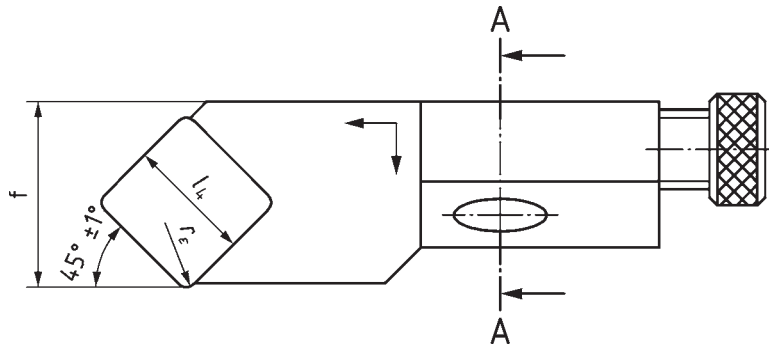


Figure 1 — Style S with height $h_1 = 6$ mm and 8 mm with rhombic indexable insert



NOTE For other dimensions, see [Figure 2](#).

Figure 2 — Style S with height $h_1 = 8$ mm, 10 mm, 12 mm, 16 mm, and 20 mm with triangular indexable insert



NOTE For other dimensions, see [Figure 2](#).

Figure 3 — Style S with height $h_1 = 10$ mm, 12 mm, 16 mm, and 20 mm with square indexable insert

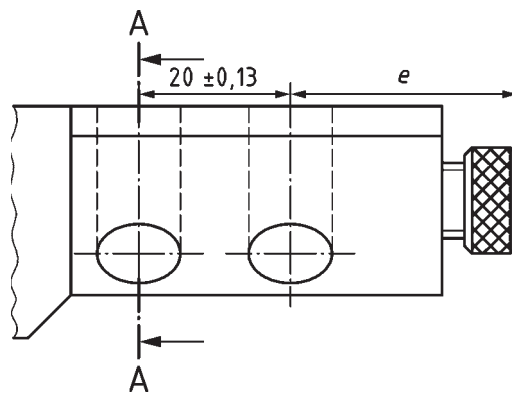


Figure 4 — Style S with height $h_1 = 25$ mm with triangular and square indexable insert

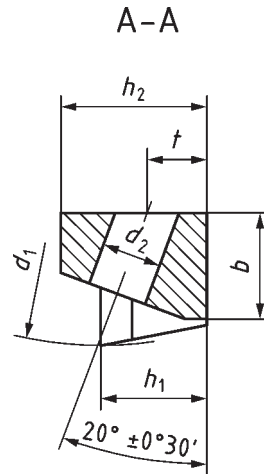


Figure 5 — Sectional drawing A-A at height $h_1 = 6 \text{ mm}$, 8 mm , 10 mm , and 12 mm

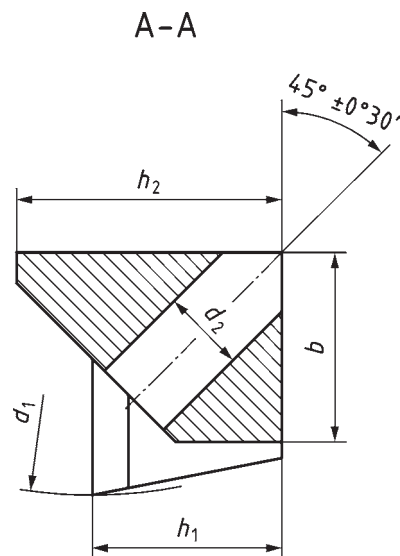


Figure 6 — Sectional drawing A-A at height $h_1 = 16 \text{ mm}$, 20 mm , and 25 mm

NOTE Pictured is a right-hand cartridge (Figure 5); left-hand cartridge (Figure 6) laterally reversed.

Table 1

Dimensions in millimetres

Symbol ^a	h_1 $\pm 0,08$	l_4 \approx	a	b 0 -0,2	d_1^b min.	d_2^c H13	e	f 0 -0,08	h_2 0 -0,2	l_1	l_2 min.	l_3	t $\pm 0,13$	Fastening screw
SCSPR 06CA — 05	6	5,6	3,7	6	20	4	12	8	8,5	21	16	4,5	3,5	M3,5
SCSPL 06CA — 05														
SCSCR 08CA — 06	8	6,4	4,2	8	25	4,5	17	10	11	28	21,5	6	4,5	M4
SCSCL 08CA — 06														

^a Cartridges for indexable inserts for holding horizontally mounted with hole clamping (first letter symbol P) can be equipped with additional top and hole clamping; the letter symbol replaced P by M in this case.

^b Smallest possible internal diameter for operating.

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

Table 1 (continued)

Symbol ^a	h_1	l_4	a	b	d_1^b	d_2^c	e	f	h_2	l_1	l_2	l_3	t	Fastening screw
	±0,08	≈		$\begin{matrix} 0 \\ -0,2 \end{matrix}$	min.	H13		$\begin{matrix} 0 \\ -0,08 \end{matrix}$	$\begin{matrix} 0 \\ -0,2 \end{matrix}$		min.		±0,13	
STSCR 08CA — 09	8	9,6	6,1	8	25	4,5	17	10	11	28	21,5	6	4,5	M4
STSCL 08CA — 09														
STSCR 10CA — 11	10	11	7	11	40	7	20	14	15	44	26	8	5	M6
STSCL 10CA — 11														
SSSCR 10CA — 09	10	9,52	6,1	11	40	7	20	14	15	44	26	8	5	M6
SSSCL 10CA — 09														
STSCR 12CA — 16	12	16,5	7	16	50	7	20	20	20	47	26	8	6	M6
STSCL 12CA — 16														
PTSNR 12CA — 16														
PTSNL 12CA — 16														
CSSPR 12CA — 09	12	9,52	6,1	16	50	7	20	20	20	47	26	8	6	M6
CSSPL 12CA — 09														
PSSNR 12CA — 09														
PSSNL 12CA — 09														
STSCR 12CA — 16	12	16,5	10,2	16	50	7	20	20	20	47	26	8	6	M6
STSCL 12CA — 16														
PTSNR 12CA — 16														
PTSNL 12CA — 16														
CSSPR 12CA — 12	12	12,7	8,3	16	50	7	20	20	20	47	26	8	6	M6
CSSPL 12CA — 12														
PSSNR 12CA — 12														
PSSNL 12CA — 12														
CTSPR 16CA — 16	16	16,5	10,2	20	60	9	25	25	25	53	32,5	8	—	M8
CTSPL 16CA — 16														
PTSNR 16CA — 16														
PTSNL 16CA — 16														
STSCR 16CA — 16														
STSCL 16CA — 16														
CSSPR 16CA — 12	16	12,7	8,3	20	60	9	25	25	25	53	32,5	8	—	M8
CSSPL 16CA — 12														
PSSNR 16CA — 12														
PSSNL 16CA — 12														
SSSCR 16CA — 12														
SSSCL 16CA — 12														

^a Cartridges for indexable inserts for holding horizontally mounted with hole clamping (first letter symbol P) can be equipped with additional top and hole clamping; the letter symbol replaced P by M in this case.

^b Smallest possible internal diameter for operating.

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

Table 1 (continued)

Symbol ^a	h_1	l_4	a	b	d_1^b	d_2^c	e	f	h_2	l_1	l_2	l_3	t	Fastening screw
	$\pm 0,08$	\approx		0 -0,2	min.	H13		0 -0,08	0 -0,2		min.		$\pm 0,13$	
PTSNR 20CA — 22	20	22	14,1	20	70	9	30	25	30	60	37,5	10	—	M8
PTSNL 20CA — 22														
PSSNR 20CA — 15	20	15,88	10,2	20	70	9	30	25	30	60	37,5	10	—	M8
PSSNL 20CA — 15														
PTSNR 25CA — 27	25	27,5	17,2	25	100	11	30	32	35	87	59	10	—	M10
PTSNL 25CA — 27														
PSSNR 25CA — 19	25	19,05	12,5	25	100	11	30	32	35	87	59	10	—	M10
PSSNL 25CA — 19														

^a Cartridges for indexable inserts for holding horizontally mounted with hole clamping (first letter symbol P) can be equipped with additional top and hole clamping; the letter symbol replaced P by M in this case.

^b Smallest possible internal diameter for operating.

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

4 Designation

A cartridge in accordance with this part of ISO 5611 shall be designated by the following:

- "Cartridge";
- reference of this part of ISO 5611, i.e. ISO 5611-8;
- letter symbol identifying the method of holding the insert, in accordance with ISO 5608;
- letter symbol identifying insert shape, in accordance with ISO 1832;
- letter symbol identifying cartridge style, in accordance with ISO 5608;
- letter symbol identifying insert normal clearance, in accordance with ISO 1832;
- letter symbol identifying hand of cartridge, in accordance with ISO 5608;
- number symbol identifying tool height (shank height of cartridges and height of cutting edge), in accordance with ISO 5608;
- number symbol identifying tool holder shank width or, for cartridges, letter C followed by a letter symbol identifying the cartridge type, in accordance with ISO 5608;
- letter symbol identifying tool length, in accordance with ISO 5608;
- number symbol identifying indexable insert size, in accordance with ISO 1832.

EXAMPLE Cartridge with screw clamping through hole (S) triangular indexable insert shape (T), cartridge style S (S), for the insert normal clearance 7° (C), right hand cartridge (R), with height $h_1 = 12$ mm (12), cartridge Type A (CA), length $l_1 = 47$ mm (-), edge length $l_4 = 16,5$ mm (16) is designated as follows:

Cartridge ISO 5611-8 - STSCR 12CA - 16

5 Material

Steel with a tensile strength of at least 1 200 N/mm².

6 Design

6.1 Method of holding

(first letter symbol identifying the method of holding the insert)

6.1.1 Cartridge for indexable inserts with insert normal clearance $\alpha_n = 7^\circ$

(fourth symbol identifying insert normal clearance C)

— holding screw clamping through hole; letter symbol S, e.g. SCSCR.

6.1.2 Cartridge for indexable inserts with insert normal clearance $\alpha_n = 11^\circ$

(fourth symbol identifying insert normal clearance P)

— holding with top clamping; letter symbol C, e.g. CSSPR.

6.1.3 Cartridge for indexable inserts with insert normal clearance $\alpha_n = 0^\circ$

(fourth symbol identifying insert normal clearance N)

— holding with hole clamping; letter symbol P, e.g. PTSNR.

6.2 Corner radius, r_ϵ

Cartridges in accordance with this part of ISO 5611 can be equipped with indexable inserts with cutting edge lengths, l_4 , as specified in [Table 1](#) and any corner radius, r_ϵ .

The values for a , f , and l_1 given in [Table 1](#) apply to cartridges with indexable inserts having corner radii, r_ϵ , in accordance with [Table 2](#).

For cartridges with indexable inserts with corner radii other than those specified in [Table 2](#), the dimensions of a , f , and l_1 shall be determined in accordance with ISO 5611-1.

The tolerances on h_1 and f refer to dimensions measured with master indexable insert and master shim, if any.

Table 2

Dimensions in millimetres

C□	l_4		r_ϵ
	T△	S□	
5,6	9,6	—	0,4
6,4	11	—	
—	16,5	9,52	0,8
—	22	12,7	
—	27,5	15,88	1,2
—	—	19,05	

NOTE The values given for r_ϵ are nominal values. The accurate values converted from the inch dimensions are 0,397 mm, 0,794 mm, and 1,191 mm.

6.3 Adjusting screw

For the adjustment of the cartridge in the direction of the f dimension, it is the manufacturer's option to equip the cartridge with an adjustment screw.

7 Extent of delivery

Cartridges need to be delivered with complete clamping device and adjusting screws.

8 Marking

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

Additional marking depends on the manufacturer's option or upon agreement.

Deviations in marking are based upon agreement.

The general number of this International Standard (ISO 5611) shall be given on the packaging.

