
Hardmetal burrs —

Part 9:
**60 degrees and 90 degrees cone burrs
(styles J and K)**

Fraises-limes en métaux-durs —

Partie 9: Fraises-limes coniques 60 degrés et 90 degrés (formes J et K)





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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. www.iso.org/directives

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The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with cutting edges made of hard cutting materials*.

This second edition cancels and replaces the first edition (ISO 7755-9:1984), of which it constitutes a minor revision.

ISO 7755 consists of the following parts, under the general title *Hardmetal burrs*:

- *Part 1: General specifications*
- *Part 2: Cylindrical burrs (style A)*
- *Part 3: Cylindrical round- (ball-) nose burrs (style C)*
- *Part 4: Spherical burrs (style D)*
- *Part 5: Oval burrs (style E)*
- *Part 6: Arch round- (ball-) nose burrs (style F)*
- *Part 7: Arch pointed-nose burrs (style G)*
- *Part 8: Flame burrs (style H)*
- *Part 9: 60° and 90° cone burrs (styles J and K)*
- *Part 10: Conical round- (ball-) nose burrs (style L)*
- *Part 11: Conical pointed-nose burrs (style M)*
- *Part 12: Inverted cone burrs (style N)*

Hardmetal burrs —

Part 9: 60 degrees and 90 degrees cone burrs (styles J and K)

1 Scope

This part of ISO 7755 specifies the main dimensions of the cutting part for hardmetal burrs of 60° cone and 90° cone shape and designated by the symbols J and K.

Tolerances on the cutting diameter, direction of helix and cut, diameter and length of the cylindrical shank and designation of burrs are dealt with in ISO 7755-1.

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 7755-1, *Hardmetal burrs — Part 1: General specifications*

3 Dimensions

See [Figure 1](#) and [Table 1](#). Tolerances on the cutting diameter, direction of helix and cut, diameter and length of the cylindrical shank and designation of burrs are specified in ISO 7755-1.

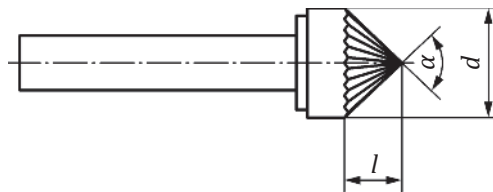


Figure 1 — Hardmetal burr, styles J and K

Table 1 — Dimensions

Dimensions in millimetres

<i>d</i>	<i>l</i> ^a	
	$\alpha = 60^\circ$	$\alpha = 90^\circ$
3	2,6	1,5
6	5,2	3
10	8,7	5
12	10,4	6
16	13,8	8
^a Calculated values.		

The cutting part length, *l*, should be measured from the flat part (whose value, which should be as small as possible, is left to the manufacturer's discretion).

Annex A (informative)

Relationship between designations in this part of ISO 7755 and the ISO 13399 series

For the relationship between designations in this part of ISO 7755 and preferred symbols according to the ISO 13399 series, see [Table A.1](#).

Table A.1 — Relationship between designations in this part of ISO 7755 and the ISO 13399 series

Symbol in this part of ISO 7755 (ISO 7755-9)	Reference in this part of ISO 7755 (ISO 7755-9)	Property name in the ISO 13399 series	Symbol in the ISO 13399 series	Reference in the ISO 13399 series
d	Clause 3	Cutting diameter	DC	ISO/TS 13399-3 71D084653E57F
l	Clause 3	Cutting edge length	L	ISO/TS 13399-3 71DD6C95DA49B
α	Clause 3	Point angle	SIG	ISO/TS 13399-3 71DCCC4FEF366

Bibliography

- [1] ISO 13399 (all parts), *Cutting tool data representation and exchange*

