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AMENDMENT 1
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Indexable inserts for cutting tools — Designation

AMENDMENT 1: Tolerance of d and m of V-shape inserts

Plaquettes amovibles pour outils coupants — Désignation

AMENDEMENT 1: Tolérances sur d et m des plaquettes de forme V



Reference number
ISO 1832:1991/Amd.1:1999(E)

Foreword

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Amendment 1 to International Standard ISO 1832:1991 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with cutting edges made of hard cutting materials*.

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Indexable inserts for cutting tools — Designation

AMENDMENT 1: Tolerance of d and m of V-shape inserts

1 Scope

This amendment specifies the tolerance on d and m of V-shape inserts. At a later date, this amendment shall be incorporated in a fourth edition of ISO 1832.

2 Symbol for tolerance class — Reference 3

Delete the sentence after Table 5, add in Table 5 the tolerance on d and m of V-shape inserts and modify the sentence above Table 5 as follows:

In the case of rhombic inserts with an included angle of 55° (shape D) and of 35° (shape V), the values for tolerance classes M and N on d and m are indicated in Table 5.

Diameter of inscribed circle d		Tolerance on d		Tolerance on m		Shape of the insert concerned
mm	in	mm	in	mm	in	
6,35	1/4	± 0,05	± 0,002	± 0,16	± 0,006	V 
7,94	5/16					
9,525	3/8					

3 Symbols for insert sizes (reference 5) according to standardized inscribed circles for equilateral and round inserts

Add in annex A, Table A.1, the following insert sizes.

Diameter of inscribed circle d		Symbol for insert size (reference 5) for insert shape											
mm	in	H	O	P	S	T	C	D	E	M	V	W	R
3,97		—	—	—	03	06	—	04	—	—	06	02	—
	5/32	1,2											
4,76		—	—	—	04	08	04	05	04	04	08	L3	—
	3/16	1,5											