
**Single point cutting tools — Corner
radii**

Outils de coupe à partie active unique — Rayons de pointe

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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 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