International Standard 6986

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION•МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ•ORGANISATION INTERNATIONALE DE NORMALISATION

Side and face milling (slotting) cutters with indexable inserts — Dimensions

Fraises trois tailles à plaquettes amovibles — Dimensions

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Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6986 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in August 1982.

It has been approved by the member bodies of the following countries:

Australia	Germany, F.R.	Poland
Austria	Hungary	Romania
Belgium	India	South Africa, Rep. of
Brazil	Israel	Spain
China	Italy	Sweden
Czechoslovakia	Japan	Switzerland
Egypt, Arab Rep. of	Korea, Dem. P. Rep. of	United Kingdom
France	Netherlands	USSR

The member body of the following country expressed disapproval of the document on technical grounds:

Bulgaria

Printed in Switzerland

Side and face milling (slotting) cutters with indexable inserts — Dimensions

1 Scope and field of application

This International Standard specifies the dimensions of side and face milling (slotting) cutters with indexable inserts.

The shape and dimensions of the inserts are left to the choice of the manufacturer.

The range of outside diameters is taken from ISO 523.

2 References

ISO 240, *Milling cutters — Interchangeability dimensions for cutter arbors or cutter mandrels — Metric series and inch series.*

ISO 523, *Milling cutters — Recommended range of outside diameters.*

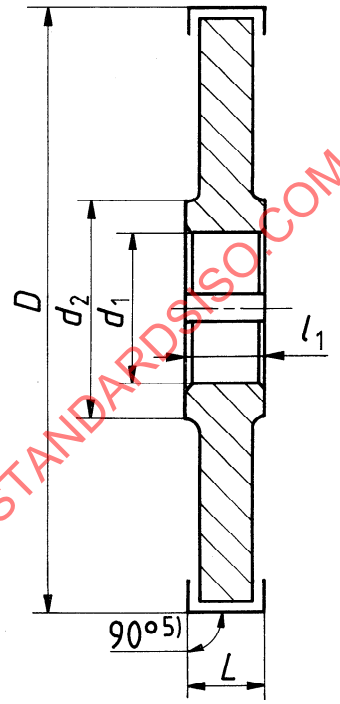
ISO 883, *Indexable hardmetal (carbide) inserts with rounded corners, without fixing hole — Dimensions.*[1)]

ISO 3364, *Indexable hardmetal (carbide) inserts with rounded corners, with cylindrical fixing hole — Dimensions.*[2)]

ISO 3365, *Indexable hardmetal (carbide) inserts with wiper edges, without fixing hole — Dimensions.*[3)]

ISO 6987/1, *Indexable hardmetal (carbide) inserts with rounded corners, with partly cylindrical fixing hole — Dimensions of inserts with 7° normal clearance.*[4)]

3 Dimensions



Dimensions in millimetres

D j_s16	d_1 6) H7	d_2 min.	L	l_1 $^{+2}_{0}$
80	27	41	10	10
100	32	47	10	10
			12	12
125	40	55	12	12
			16	16
160	40	55	16	16
			20	20
200	50	69	20	20
			25	25

1) At present at the stage of draft. (Revision of ISO 883-1976.)

2) At present at the stage of draft. (Revision of ISO 3364-1977.)

3) At present at the stage of draft. (Revision of ISO 3365/1-1977 and 3365/2-1980.)

4) At present at the stage of draft.

5) The value of 90° is the nominal cutting edge angle of the insert.

6) The dimensions of the bore and key shall be in accordance with ISO 240.