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# International Standard



# 5407

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

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## As-sintered hardmetal pellets used in heading dies — Dimensions and tolerances

*Noyaux bruts en métaux-durs pour matrices de frappe à froid — Dimensions et tolérances*

First edition — 1981-10-01

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[ISO 5407:1981](#)

<https://standards.iteh.ai/catalog/standards/iso/f19957c8-b8f7-4aa2-8d1a-0537441d6e8e/iso-5407-1981>

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Ref. No. ISO 5407-1981 (E)

Descriptors : die pellets, dimensions, dimensional tolerances.

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

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 5407 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in May 1980.

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

Australia	India	Poland
Austria	Israel	Romania
Belgium	Italy	South Africa, Rep. of
Czechoslovakia	Japan	Spain
France	Korea, Dem. P. Rep. of	Sweden
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The member body of the following country expressed disapproval of the document on technical grounds :

USSR

# As-sintered hardmetal pellets used in heading dies — Dimensions and tolerances

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## 1 Scope and field of application

This International Standard lays down the dimensions and tolerances of as-sintered hardmetal pellets used in heading dies.

### NOTES

- <https://standards.itih.ai/standards/iso-5407-1981> <https://www.iso.org/standard/7441d6e8e/iso-5407-1981>
- 1) As defined in ISO 3252, the term “hardmetal” may be used synonymously with “cemented carbide”.
  - 2) In the United States, the term “nib” is used instead of the term “pellet”.

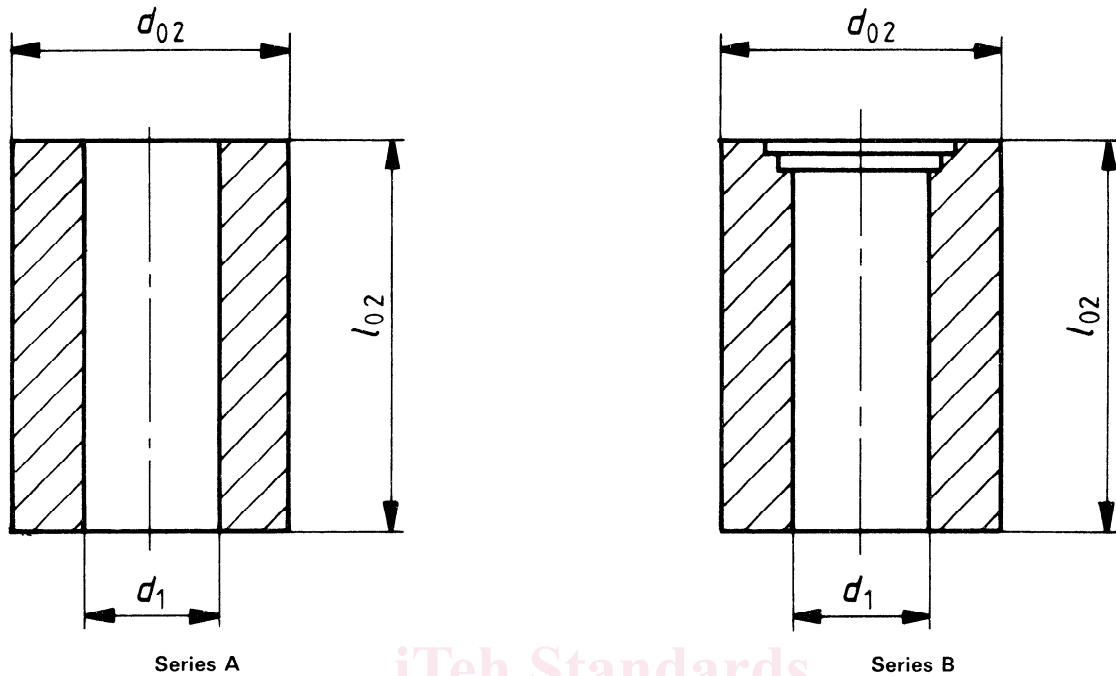
## 2 References

ISO 3252, *Powder metallurgy — Vocabulary*.<sup>1)</sup>

ISO 5396, *Hardmetal heading dies — Terminology*.

<sup>1)</sup> At present at the stage of draft. (Revision of ISO 3252-1975.)

3 Dimensions



NOTE

- $d_1$  is the diameter of the finished bore;
- $d_{02}$  is the outside diameter of as-sintered pellet;
- $l_{02}$  is the length of as-sintered pellet.

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<https://standards.itih.ai/catalog/standards/iso/fl9957c8-b8f7-4aa2-8d1a-0537441> Dimensions in millimetres

Diameter of the finished bore $d_1$		Outside diameter of as-sintered pellet $d_{02}$		As-sintered pellet length $l_{02}$																		
over	up to and including	Series A	Series B <sup>1)</sup>	15	20	25	30	35	40	45	50	55	60	70	80 <sup>3)</sup>	90	100	110	120	140		
1,50 <sup>2)</sup>	1,75	10	10	x	x	x																
1,75	2,10	10	10	x	x	x	x															
2,10	3,00	10	12	x	x	x	x	x	x	x												
3,00	4,00	12	14			x	x	x	x	x	x	x	x									
4,00	5,00	14	16			x	x	x	x	x	x	x	x	x	x							
5,00	6,00	16	18			x	x	x	x	x	x	x	x	x	x							
6,00	7,00	18	20			x	x	x	x	x	x	x	x	x	x							
7,00	8,00	20	22			x	x	x	x	x			x	x	x	x	x					
8,00	10,00	24	26			x	x	x	x	x			x	x	x	x	x					
10,00	12,00	26	28				x		x		x		x	x	x	x	x					
12,00	14,00	28	32				x		x		x		x	x	x	x	x	x	x			
14,00	16,00	32	36				x		x		x		x	x	x	x	x	x	x			
16,00	18,00	36	40						x		x		x	x	x	x	x	x	x	x		
18,00	20,00	40	45						x		x		x	x	x	x	x	x	x	x		
20,00	24,00	45	50						x		x		x	x	x	x	x	x	x	x		

- 1) Series B refers to heading dies, washer faced.
- 2) Inclusive.
- 3) Only for series B.