
**Indexable inserts for cutting tools —
Designation**

Plaquettes amovibles pour outils coupants — Désignation

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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.

ISO 1832 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with cutting edges made of hard cutting materials*.

This fourth edition cancels and replaces the third edition (ISO 1832:1991), which has been technically revised. It also incorporates Amendment ISO 1832:1991/Amd. 1:1999.

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Indexable inserts for cutting tools — Designation

1 Scope

This International Standard establishes a code for the designation of the usual types of indexable inserts for cutting tools, in hard cutting materials or any other cutting materials, in the interests of simplifying orders and specifications for such inserts. It also specifies the designation symbols for cubic boron nitride (BL, BH, BC) inserts, tipped and solid as well as polycrystalline diamond (DP) inserts, tipped.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 513, *Classification and application of hard cutting materials for metal removal with defined cutting edges — Designation of the main groups and groups of application*

ISO 3002-1:1982, *Basic quantities in cutting and grinding — Part 1: Geometry of the active part of cutting tools — General terms, reference systems, tool and working angles, chip breakers*

ISO 3002-1:1982/Amd. 1:1992, *Basic quantities in cutting and grinding — Part 1: Geometry of the active part of cutting tools — General terms, reference systems, tool and working angles, chip breakers — Amendment 1*

ISO 16462, *Cubic boron nitride inserts, tipped or solid — Dimensions, types*

ISO 16463, *Polycrystalline diamond inserts, tipped — Dimensions, types*

3 Explanation of designation code

For indexable inserts the designation code comprises nine symbols for designating the dimensions and other characteristics; the first seven symbols (symbols ① to ⑦) shall be used in every designation. Symbols ⑧ and ⑨ may be used when necessary.

For tipped inserts in accordance with ISO 16462 and ISO 16463 the designation code comprises twelve symbols for designating the dimensions and other characteristics; symbols ① to ⑦ as well as ⑪ and ⑫ shall be used in every designation. Symbols ⑧, ⑨ and ⑩ may be used when necessary. Symbols ⑪ and ⑫ shall be separated from symbol ⑨ by a dash as shown in example 2 of this clause.

In addition to the standardized designation for indexable inserts and tipped inserts, a supplementary symbol ⑬, consisting of one or two characters, may be added by the manufacturer for a better description of his product (e.g., different chip breakers), provided that this symbol is separated from the standardized designation by a dash and that it does not contain letters specific for references ⑧, ⑨ and ⑩.

No addition to or extension of the designation specified in this International Standard shall be made without consulting Technical Committee ISO/TC 29 and receiving its agreement. Rather than adding symbols not provided for in this system, it is preferable to add to the designation, in accordance with this International Standard, all necessary explanations in the form of detailed sketches or specifications.

However, if the symbol "X" is used in position 4 of the designation, it is possible to use, in positions 5, 6 and 7, symbols representing values not appearing in this International Standard but which shall be described explicitly by the sketch or the detailed specifications given in 4.4.

The significance of the symbols constituting the designation is as follows:

①	Letter symbol identifying	insert shape (see 4.1)	} Compulsory symbols for indexable inserts	} Compulsory symbols for tipped inserts in accordance with ISO 16462 and ISO 16463, except as noted
②	Letter symbol identifying	normal clearance (see 4.2)		
③	Letter symbol identifying	tolerance class (see 4.3)		
④	Letter symbol indicating	fixing and/or chip breakers (see 4.4)		
⑤	Number symbol identifying	insert size (see 4.5)		
⑥	Number of symbol identifying	insert thickness (see 4.6)		
⑦	Letter or number symbol identifying	insert corner configuration (see 4.7)		
⑧ ^a	Letter symbol indicating	cutting edge condition (see 5.2)	}	
⑨ ^a	Letter symbol indicating	cutting direction (see 5.3)		
⑩ ^b	Number symbol identifying	size of cutting edge condition (see 6.2)		
⑪	Letter symbol identifying	style of tipped or solid cutting edge and number of tipped corners (see 6.3)		
⑫	Letter or number symbol identifying	length of tipped cutting edge (see 6.4)		
⑬	Manufacturer's symbol or cutting material designation in accordance with ISO 513			

^a Optional symbols for indexable and tipped inserts.
^b Optional symbols for tipped inserts.

EXAMPLE 1 General designation

	①	②	③	④	⑤	⑥	⑦	⑧	⑨		⑬
Metric dimensions:	T	P	G	N	16	03	08	E	N	-	...
Inch dimensions:	T	P	G	N	3	2	2	E	N	-	...

EXAMPLE 2 Designation of inserts in accordance with ISO 16462 and ISO 16463

	①	②	③	④	⑤	⑥	⑦	⑧	⑩	⑨	⑪	⑫	⑬		
Designation of insert for turning	S	N	M	A	15	06	08	E		(N)	-	B	L	-	...
Designation of insert for milling	T	P	G	T	16	T3	AP	S	01520	R	-	M	028	-	...

NOTE The designations and symbols of the different angles allowing geometrical definition of the indexable inserts are in conformity with ISO 3002-1, with the following conventions:

- the insert is considered in the tool-in-hand system;
- the reference plane P_r is parallel to the base of the insert;
- the assumed working plane P_f is perpendicular to the reference plane P_r and is parallel to the assumed direction of feed motion. This plane is defined only in the case of inserts having one or more wiper edges.






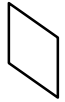

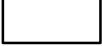
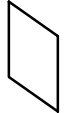
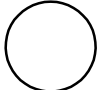
The assumed direction of feed motion is taken parallel to the considered wiper edge (see Note 1 of Table 9).

4 Symbols

4.1 Symbol for insert shape — Reference ①

See Table 1.

Table 1

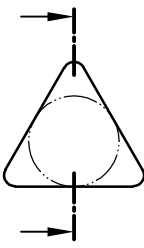
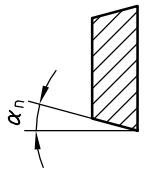
Type	Letter symbol	Description of shape	Included angle, ϵ_r	Figure
I Equilateral and equiangular inserts	H	Hexagonal inserts	120°	
	O	Octagonal inserts	135°	
	P	Pentagonal inserts	108°	
	S	Square inserts	90°	
	T	Triangular inserts	60°	
II Equilateral but non-equiangular inserts	C	Rhombic inserts	80° ^a	
	D		55° ^a	
	E		75° ^a	
	M		86° ^a	
	V		35° ^a	
	W	Trigon inserts	80° ^a	
III Non-equilateral but equiangular inserts	L	Rectangular inserts	90°	
IV Non-equilateral and non-equiangular inserts	A	Parallelogram-shaped inserts	85° ^a	
	B		82° ^a	
	K		55° ^a	
V Round inserts	R	Round inserts	—	

^a The included angle considered is always the smaller angle.

4.2 Symbol for normal clearance — Reference ②

See Table 2.

Table 2

Letter symbol	
For normal clearance, choose, from the symbols listed below, the one which corresponds to the major cutting edge (see the figure).	
If (in spite of different clearances) all cutting edges have to be used as major cutting edges, the symbol to be used for the designation of the normal clearance shall be the symbol applicable to the normal clearance of the longer cutting edge, which is also considered as the major cutting edge for the indication of the insert size (see reference ⑤).	
	
A	— 3°
B	— 5°
C	— 7°
D	— 15°
E	— 20°
F	— 25°
G	— 30°
N	— 0°
P	— 11°
O	— Other normal clearances requiring a special specification

4.3 Symbol for tolerance class — Reference ③

See Table 3.

The dimensions concerned are d (nominal diameter of the inscribed circle of the insert), s (thickness of the insert) and m . For this last dimension, the three cases represented in Figures 1 to 3 are distinguished.

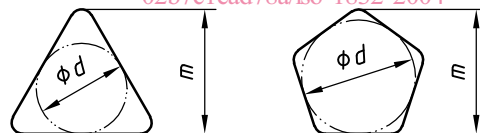


Figure 1 — Case 1: Inserts with an odd number of sides and rounded corners

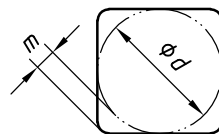


Figure 2 — Case 2: Inserts with an even number of sides and rounded corners

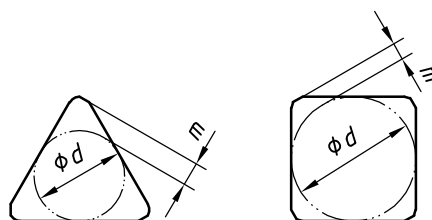


Figure 3 — Case 3: Inserts with wiper edges (see Note 1 of Table 9)

Table 3

Letter	Tolerances in millimetres			Tolerances in inches		
	<i>d</i>	<i>m</i>	<i>s</i>	<i>d</i>	<i>m</i>	<i>s</i>
A^a	± 0,025	± 0,005	± 0,025	± 0,001	± 0,000 2	± 0,001
F^a	± 0,013	± 0,005	± 0,025	± 0,000 5	± 0,000 2	± 0,001
C^a	± 0,025	± 0,013	± 0,025	± 0,001	± 0,000 5	± 0,001
H	± 0,013	± 0,013	± 0,025	± 0,000 5	± 0,000 5	± 0,001
E	± 0,025	± 0,025	± 0,025	± 0,001	± 0,001	± 0,001
G	± 0,025	± 0,025	± 0,13	± 0,001	± 0,001	± 0,005
J^a	from ± 0,05 } to ± 0,15 } ^b	± 0,005	± 0,025	from ± 0,002 } to ± 0,006 } ^b	± 0,000 2	± 0,001
K^a	from ± 0,05 } to ± 0,15 } ^b	± 0,013	± 0,025	from ± 0,002 } to ± 0,006 } ^b	± 0,000 5	± 0,001
L^a	from ± 0,05 } to ± 0,15 } ^b	± 0,025	± 0,025	from ± 0,002 } to ± 0,006 } ^b	± 0,001	± 0,001
M	from ± 0,05 } to ± 0,15 } ^b	from ± 0,08 } to ± 0,2 } ^b	± 0,13	from ± 0,002 } to ± 0,006 } ^b	from ± 0,003 } to ± 0,008 } ^b	± 0,005
N	from ± 0,05 } to ± 0,15 } ^b	from ± 0,08 } to ± 0,2 } ^b	± 0,025	from ± 0,002 } to ± 0,006 } ^b	from ± 0,003 } to ± 0,008 } ^b	± 0,001
U	from ± 0,08 } to ± 0,25 } ^b	from ± 0,13 } to ± 0,38 } ^b	± 0,13	from ± 0,003 } to ± 0,01 } ^b	from ± 0,005 } to ± 0,015 } ^b	± 0,005

^a These tolerance classes normally apply to indexable inserts with wiper edges.

^b The tolerance is dependent upon the insert size (see also Tables 4 and 5) and should be indicated for insert according to the corresponding dimensional standards.

Tolerances on *d* for tolerance classes J, K, L, M, N and U for inserts of shapes H, O, P, S, T, C, E, M, W and R and tolerances on *m* for tolerance classes M, N and U for inserts with an included angle of 60° or more, of shapes H, O, P, S, T, C, E, M and W, are indicated in Table 4.

Table 4

Diameter of inscribed circle <i>d</i>		Tolerances on <i>d</i>				Tolerances on <i>m</i>											
		Classes J, K, L, M, N		Class U		Classes M and N		Class U									
mm	in	mm	in	mm	in	mm	in	mm	in								
4,76	3/16	± 0,05	± 0,002	± 0,08	± 0,003	± 0,08	± 0,003	± 0,13	± 0,005								
5,56	7/32																
6 ^a	—																
6,35	1/4																
7,94	5/16																
8 ^a	—																
9,525	3/8																
10 ^a	—																
12 ^a	—									± 0,08	± 0,003	± 0,13	± 0,005	± 0,13	± 0,005	± 0,2	± 0,008
12,7	1/2																
15,875	5/8	± 0,1	± 0,004	± 0,18	± 0,007	± 0,15	± 0,006	± 0,27	± 0,011								
16 ^a	—																
19,05	3/4																
20 ^a	—																
25 ^a	—	± 0,13	± 0,005	± 0,25	± 0,01	± 0,18	± 0,007	± 0,38	± 0,015								
25,4	1																
31,75	1 1/4	± 0,15	± 0,006	± 0,25	± 0,01	± 0,2	± 0,008	± 0,38	± 0,15								
32 ^a	—																
		H	O	P	S	C, E, M	W	R	(tolerance on <i>d</i> only)								
Shape of the inserts concerned																	

^a Applies only for round inserts.

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.

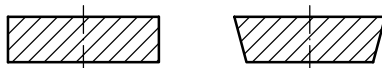
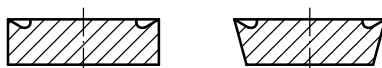
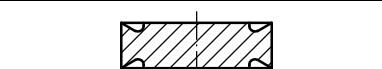
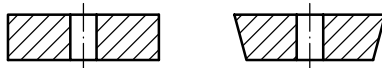

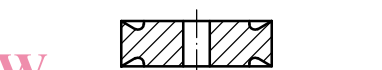

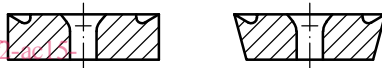
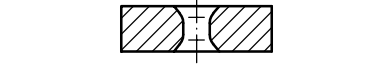
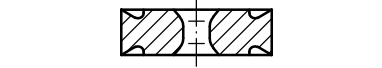
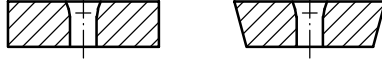



Table 5

Diameter of inscribed circle <i>d</i>		Tolerances on <i>d</i>		Tolerances on <i>m</i>		Shape of the inserts concerned
mm	in	mm	in	mm	in	
5,56	7/32	± 0,05	± 0,002	± 0,11	± 0,004	
6,35	1/4					
7,94	5/16					
9,525	3/8					
12,7	1/2					
15,875	5/8	± 0,1	± 0,004	± 0,18	± 0,007	
19,05	3/4					
6,35	1/4	± 0,05	± 0,002	± 0,16	± 0,006	
7,94	5/16					
9,525	3/8					

4.4 Symbol for fixing and/or for chip breakers — Reference ④

See Table 6.

Table 6

Letter symbol	Fixing	Chip breakers ^a	Figure
N	Without fixing hole	Without chip breakers	
R		Chip breakers on one face only	
F		Chip breakers on both faces	
A	With cylindrical fixing hole	Without chip breakers	
M		Chip breakers on one face only	
G		Chip breakers on both faces	
W	With partly cylindrical fixing hole, 40° to 60° countersunk on one side only	Without chip breakers	
T		Chip breakers on one face only	
Q	With partly cylindrical fixing hole, 40° to 60° countersunk on both sides	Without chip breakers	
U		Chip breakers on both faces	
B	With partly cylindrical fixing hole, 70° to 90° countersunk on one side only	Without chip breakers	
H		Chip breakers on one face only	
C	With partly cylindrical fixing hole, 70° to 90° countersunk on both sides	Without chip breakers	
J		Chip breakers on both faces	
X ^b	With dimensions or details requiring detailed explanation, a sketch or additional specifications		—

^a For the definition of chip breakers, see ISO 3002-1.

^b Non-equilateral inserts shall always be designated in reference ④ by X because the indication of width (measured perpendicularly on the major cutting edge or perpendicularly on the longer edge) and details concerning special features of construction are necessary.

The letter symbol X cannot be used for those insert shapes which are not defined under reference ①.