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**Cutting tool data representation  
and exchange —**

**Part 3:  
Reference dictionary for tool items**

*Représentation et échange des données relatives aux outils  
coupants —*  
*Partie 3: Dictionnaire de référence pour les éléments relatifs aux outils*

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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.

In other circumstances, particularly when there is an urgent market requirement for such documents, a technical committee may decide to publish other types of normative document:

- an ISO Publicly Available Specification (ISO/PAS) represents an agreement between technical experts in an ISO working group and is accepted for publication if it is approved by more than 50 % of the members of the parent committee casting a vote;
- an ISO Technical Specification (ISO/TS) represents an agreement between the members of a technical committee and is accepted for publication if it is approved by 2/3 of the members of the committee casting a vote.

An ISO/PAS or ISO/TS is reviewed after three years in order to decide whether it will be confirmed for a further three years, revised to become an International Standard, or withdrawn. If the ISO/PAS or ISO/TS is confirmed, it is reviewed again after a further three years, at which time it must either be transformed into an International Standard or be withdrawn.

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/TS 13399-3 was prepared by Technical Committee ISO/TC 29, *Small tools*.

ISO 13399 consists of the following parts, under the general title *Cutting tool data representation and exchange*:

- *Part 1: Overview, fundamental principles and general information model*
- *Part 2: Reference dictionary for the cutting items* [Technical Specification]
- *Part 3: Reference dictionary for tool items* [Technical Specification]
- *Part 4: Reference dictionary for adaptive items* [Technical Specification]
- *Part 5: Reference dictionary for assembly items* [Technical Specification]
- *Part 50: Reference dictionary for reference systems and common concepts* [Technical Specification]
- *Part 60: Reference dictionary for connection systems* [Technical Specification]
- *Part 100: Definitions, principles and methods for reference dictionaries* [Technical Specification]

## Introduction

ISO 13399 provides the means to achieve an electronic representation of cutting tool data by providing the information structure needed to describe various data about cutting tools and cutting tool assemblies. It is intended to facilitate the use, manipulation and exchange of cutting tool data within and between manufacturing, distribution and usage.

This part of ISO 13399 defines the terms, properties and definitions for those portions of a cutting tool that support one or more cutting items with defined cutting edges. Tool items include, but are not limited to, turning tools, milling tools, drilling tools, and threading tools. The purpose of this part ISO 13399 is to provide a reference dictionary to support the use of the general information model defined in ISO 13399-1.

A cutting tool with defined cutting edges is used on a machine tool to remove workpiece material through a shearing action at the cutting edge(s) of the tool. Cutting tool data are characteristics of the cutting tool and its use that must be known and evaluated in order to make manufacturing decisions and to perform manufacturing operations.

ISO 13399 includes the data representation of everything between the workpiece and the machine tool. Information about inserts (e.g. regular and irregular shaped replaceable cutting items), solid tools (e.g. solid drill and solid endmill), assembled tools (e.g. boring bars, indexable drills and indexable milling cutters), adaptors (e.g. milling arbor and chucks), components (e.g. shims, screws and clamps) or any combination of the above can be exchanged.

Possible assemblies of the components of a cutting tool are illustrated in Figure 1.

The cutting tool data described include, but are not limited to, geometrical and dimensional data, identification and designation data, miscellaneous and spare part data, cutting material data, and component connectivity.

The use of the tool information model established by ISO 13399 will provide increased productivity for the user in the same way as do the tools. The effective management of tool information will improve the management of the tools themselves. Use of the tool information model will enable the identification of the “right” tool in every operation — from tool purchase, through planning, set-up in machine-tools, maintenance and reuse of the tools — with short lead times and with high reliability and product quality. Tool users will benefit from improved support from the tool vendors who will be able to provide a standard information product to accompany the tool products. Computer interfaces for information exchange will be more efficient.

The objective of ISO 13399 is to provide the means to represent the information that describes cutting tools in a computer-sensible form that is independent of any particular computer system. Such a representation will facilitate the processing and exchange of cutting tool data within and between different software systems and computer platforms and support the application of this data in manufacturing planning, cutting operations and the supply of tools. The nature of this description makes it suitable not only for neutral file exchange, but also as a basis for implementing and sharing product databases and for archiving. The methods that are used for these representations are those developed by ISO TC 184, *Industrial automation systems and integration*, SC 4, *Industrial data*, for the representation of product data by using standardized information models and reference dictionaries.

An information model is a formal specification of types of ideas, facts and processes which together describe a portion of interest of the real world and which provides an explicit set of interpretation rules. Information is knowledge of ideas, facts and/or processes. Data are symbols or functions that represent information for processing purposes. Data are interpreted to extract information by using rules for how that should be done and a dictionary to define the terms that identify the data. Everyone in a communication process must use the same information model, the same set of explicit rules and the same dictionary in order to avoid misunderstanding. If an information model and its dictionary are written in a computer-sensible language then there is the additional benefit that they can be *computer-processable*.

An engineering information model is therefore a specification for data that establishes the meaning of that data in a particular engineering context. A model has to be developed by formal methods to ensure that it meets the needs of the situation that it represents. An engineering information model defines: the information objects that represent the concepts in an engineering application, the attributes of the objects and their relationships and the constraints that add further meaning. An information model is an abstract concept that can be used repeatedly for any example of the real-world situation that it represents. An instance of the model is produced when it is populated with the data items and their values that are applicable to a particular example of that situation.

This part of ISO 13399 uses the following resources developed by ISO TC 184/SC 4:

- a) the EXPRESS language according to ISO 10303-11 for defining the information model;
- b) the file format for data exchange derived from the model and defined in ISO 10303-21;
- c) the data dictionary defined in ISO 13584.

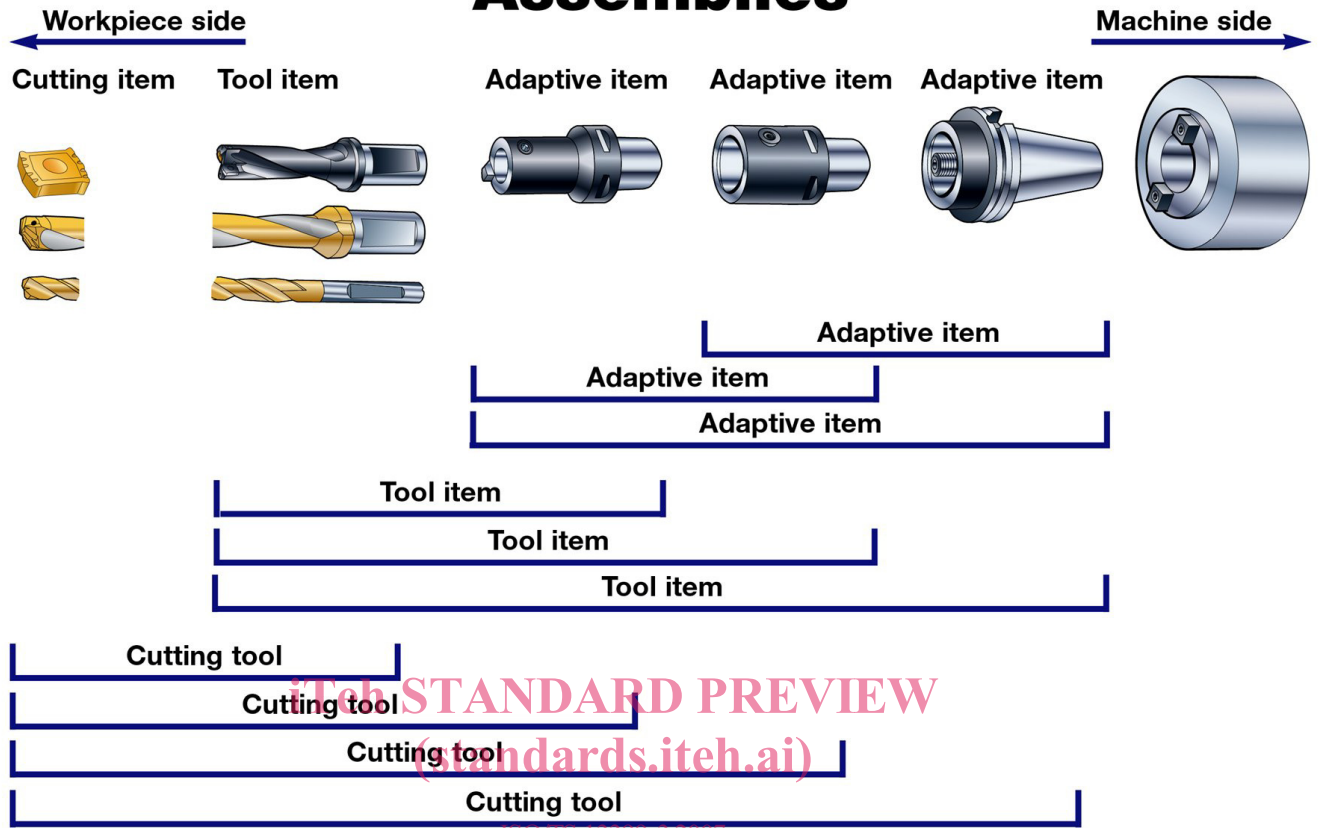
ISO 13399 is intended for use by manufacturers, tool vendors or producers, and developers of manufacturing software, among others. It provides a common structure for exchanging data about cutting tools (see Figure 1), and is intended to allow or improve several capabilities, including

- provision of a common set of definitions for use in describing cutting tools and cutting tool assemblies,
- the integration and sharing of cutting tool and assembly data between software applications,
- direct import of vendor cutting tool data into customer databases or applications, and
- a reduction in the level of effort required for manufacturers to maintain accurate and current cutting tool information from multiple sources and for multiple applications.

Different companies use different business models to determine their need for the communication of information about their products. For example, one cutting tool manufacturer could regrind its customers' tools while another could allow its customers to do the regrinding and provide the information to enable them to do so. Therefore, the two cutting tool manufacturers could have a different set of cutting tool properties to communicate using the information model and dictionaries provided by ISO 13399.

ISO 13399 defines only that information which could be communicated; it does not specify what information must be communicated.

# Assemblies



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Figure 1 — Examples of different types of assemblies of items

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# Cutting tool data representation and exchange —

## Part 3: Reference dictionary for tool items

### 1 Scope

This part of ISO 13399 specifies a reference dictionary for tool items, together with their descriptive properties and domains of values.

This part of ISO 13399 specifies a reference dictionary that contains

- a) definitions and identifications of the classes of tool items and their features, with an associated classification scheme,
- b) definitions and identifications of the data element types that represent the properties of tool items and their features,
- c) definitions and identifications of domains of values for describing the above data element types.

Each class, property or domain of values of this application domain constitutes an entry of the reference dictionary defined in this part of ISO 13399. It is associated with a computer-sensible and human-readable definition, and with a computer-sensible identification. Identification of a dictionary entry allows unambiguous reference to it from any application that implements the information model defined in ISO 13399-1.<sup>1)</sup>

The following is within the scope of this part of ISO 13399:

- standard data that represent the various classes of tool items and tool item features;
- standard data that represent the various properties of tool items and tool item features;
- standard data that represent domains of values used for properties of tool items and tool item features;
- a single implementation method by which the standard data defined in this part ISO 13399 can be exchanged (see ISO 10303-21).

The following is not within its scope:

- specialized or expert knowledge on the design and use of cutting tools;
- rules used to determine the information that should be communicated;
- applications where these standard data may be stored or referenced;

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1) Definitions and identifications of dictionary entries are defined by means of standard data that consist of instances of the EXPRESS entity data types defined in the common dictionary schema, resulting from a joint effort between ISO TC 184/SC 4 and IEC SC 3D, and in its extensions according to ISO 13584-24 and ISO 13584-25.

- implementation methods other than the one defined in this part of ISO 13399 by which the standard data can be exchanged and referenced;
- information models for cutting tools;
- definitions of classes and properties for cutting items, adaptive items, assembly items, reference systems and common concepts, or for connection systems, these being covered by other parts of ISO 13399.

## 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/TS 13399-100, *Cutting tool data representation and exchange — Part 100: Definitions, principles and methods for reference dictionaries*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO/TS 13399-100 and the following apply.

### 3.1 applicable property

property that is defined for some family of items and that applies to any member of this family

[ISO 13584-24]

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### 3.2 basic semantic unit

entity that provides an absolute and universal identification of classes and data element types in an application domain

[ISO 13584-42]

### 3.3 chip

material removed from a workpiece by a cutting process

[ISO/TS 13399-2]

### 3.4 coordinate axis system

right-handed rectangular Cartesian coordinate system in three-dimensional space with three principal axes labelled X, Y and Z

[ISO/TS 13399-50]

### 3.5 cutting tool

device or assembly of items for removing material from a workpiece through a shearing action at the defined cutting edge or edges of the device

NOTE A cutting tool could be the assembly of one or more adaptive items, a tool item and several cutting items on a tool item. See Figure 1.

[ISO 13399-1]

**3.6  
data**

representation of facts concepts or instructions in a formal manner suitable for communication, interpretation or processing by human beings or computers

[ISO 10303-1]

**3.7  
data element type**

unit of data for which the identification, description and value representation have been specified

[ISO 13584-42]

**3.8  
data exchange**

storing, accessing, transferring and archiving of data

[ISO 10303-1]

**3.9  
data type**  
domain of values

[ISO 10303-11]

**3.10  
dictionary**

structured set of entries with one and only one meaning corresponding to each entry and one and only one entry identifying a single meaning

[ISO 13584-511]

NOTE In ISO 13399, a dictionary is a formal and computer-sensible representation of an ontology.

**3.11  
entity**

class of information defined by its attributes that establishes a domain of values defined by common attributes and constraints.

NOTE Adapted from ISO 10303-11.

**3.12  
entity data type**  
representation of an entity

[ISO 10303-11]

**3.13  
entity instance**

named unit of data that represents a unit of information within the class defined by an entity

NOTE It is a member of the domain established by an entity data type.

[ISO 10303-11]

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**3.14**

**family of items**

simple or generic family of items

[ISO 13584-42]

**3.15**

**generic family of items**

grouping of simple or generic families of items for the purpose of classification or for associating common information

[ISO 13584-42]

**3.16**

**implementation method**

means for computers to process or exchange data

[ISO 10303-1]

**3.17**

**information**

facts, concepts or instructions

[ISO 10303-1]

**3.18**

**information model**

formal description of a bounded set of information to meet a specific requirement

[ISO 10303-1]

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**3.19**

**machine side**

identification of a direction pointing towards the machine

**3.20**

**machined surface**

surface produced by the action of a cutting tool

[ISO 3002-1]

**3.21**

**mirror plane**

xz plane in the coordinate axis system

[ISO/TS 13399-50]

**3.22**

**ontology**

explicit and consensual specification of concepts of an application domain independent of any use of these concepts

[ISO 13584-511]

NOTE In ISO 13399 a dictionary is the formal and computer-sensible representation of an ontology.

**3.23****property**

characteristic of a product or process that may be represented by a data element type

NOTE Adapted from ISO 13584-42.

**3.24****simple family of items**

set of items in which each item may be described by the same group of properties

[ISO 13584-42]

**3.25****transient surface**

part of the surface which is formed on the workpiece by the cutting operation and is removed during the following cutting action either during the following revolution of the tool or the workpiece or by the following cutting edge

[ISO 3002-1]

**3.26****visible property**

property that is defined for some family of items that may or may not be applicable to the different members of the family

[ISO 13584-42]

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**3.27****workpiece**

object on which a cutting action is performed

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[ISO/TS 13399-2]

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**3.28****workpiece side**

identification of a direction pointing towards the workpiece

[ISO/TS 13399-2]

**3.29****work surface**

surface that is to be removed on the workpiece

[ISO 3002-1]

**3.30****xy plane**

plane in the coordinate axis system that contains the X and Y axes with the normal of the plane in the positive Z direction

[ISO/TS 13399-50]

**3.31****xyw plane**

plane in the coordinate axis system related to the xy plane by the rotation angle PHI about the X axis in a counter clockwise direction and located at a distance XYWD from the origin of the coordinate axis system

[ISO/TS 13399-50]

**3.32**

**xz plane**

plane in the coordinate axis system that contains the X and Z axes with the normal of the plane in the positive Y direction

[ISO/TS 13399-50]

**3.33**

**xzw plane**

plane in the coordinate axis system related to the xz plane by the rotation angle KAPPA about the Z axis in a counter clockwise direction and located at a distance XZWD from the origin of the coordinate axis system

[ISO/TS 13399-50]

**3.34**

**yz plane**

plane in the coordinate axis system that contains the Y and Z axes with the normal of the plane in the positive X direction

[ISO/TS 13399-50]

**3.35**

**yzw plane**

plane in the coordinate axis system related to the yz plane by the rotation angle RHO about the Y axis in a counter clockwise direction and located at a distance YZWD from the origin of the coordinate axis system

[ISO/TS 13399-50]

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NOTE The xzw plane, the xyw plane and the yzw plane are mutually perpendicular.

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**4 Abbreviated terms**

BSU basic semantic unit

DET data element type

**5 Representation of the ontological concepts as dictionary entries**

In the following subclauses, a concept in the ontology is identified by a name in lower-case characters. The name of a class that represents the concept in the dictionary is identified by bold, lower-case characters with multiple words joined by an underscore character.

EXAMPLE “tool item type” is the name of a concept in the ontology: **tool\_item\_type** is the identifier of the class in the dictionary that represents the concept.

Data for tool items are grouped into two main classes: **tool\_item\_feature** and **tool\_item\_type**. The items in the classification of **tool\_item\_type** are identified by a label that is derived from the main application of a tool. However, it should be recognised that a tool may be used for more than one type of cutting operation. A **tool\_item\_feature** is an aspect of a **tool\_item\_type** that could not exist in isolation from the **tool\_item\_type**.

Some of the definitions of properties that are applicable to tool items are defined in terms of a coordinate axis system. The coordinate system is the same for adaptive items, cutting items and tool items and is defined in ISO/TS 13399-50. The applications of this coordinate system to tool items are described in this part of. All functional dimensions of a tool item that uses replaceable cutting items are defined on the assembly of the tool item and the master insert. The convention followed is “the tool in hand”.

Each entry in the dictionary, whether a class or a property, is identified with a numerical code (BSU) that is generated at random when the dictionary is compiled. A BSU can be made unique by the addition of a code that is a reference to the supplier of the dictionary. Each classified item in the following subclauses is associated with its definition from the dictionary.

The structure of the classification is summarized in Annex B. The complete definitions of the tool item classes are provided in Annex C. The properties applicable to tool item classes are defined in Annex D.

## 5.1 tool\_item\_feature

**tool\_item\_feature** is a generic family of characteristics of a tool item that cannot exist independently of the tool item. **tool\_item\_feature** has the following subclasses:

- **chip\_management**;
- **drill\_point**;
- **guide\_pilot\_feature**;
- **pilot\_drill\_feature**;
- **tool\_hub**;

### 5.1.1 chip\_management

**chip\_management** is a generic class of features of the tool body or assembly to control the direction of motion of the chip.

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### 5.1.2 drill\_point

[ISO/TS 13399-3:2007](#)

[https://standards.iteh.ai/catalog/standards/sist/bc9fcc6a-1cb2-432f-bbf3-](https://standards.iteh.ai/catalog/standards/sist/bc9fcc6a-1cb2-432f-bbf3-316a40e58150-iso-ts-13399-3-2007)

A **drill\_point** is the part of a drill that first makes contact with the workpiece.

### 5.1.3 guide\_pilot\_feature

A **guide\_pilot\_feature** is a portion of a cylindrical tool in front of the cutting portion that acts to limit the sideways movement of the tool in operation.

### 5.1.4 pilot\_drill\_feature

A **pilot\_drill\_feature** is part of a larger drill for guiding the main cutting operation.

### 5.1.5 tool\_hub

A **tool\_hub** is the central part of a disk-shaped tool item with increased thickness.

## 5.2 tool\_item\_type

A **tool\_item\_type** is a generic family of items that support or hold one or more cutting items in a cutting operation. **tool\_item\_type** has the following subclasses:

- **broach**;
- **burr\_tool**;
- **cartridge**;