
INTERNATIONAL STANDARD



242

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

Carbide tips for brazing on turning tools

Plaquettes à braser en carbures métalliques pour outils de tour

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ISO 242:1975

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UDC 621.762.1 : 621.941.025.7

Ref. No. ISO 242-1975 (E)

Descriptors : tools, carbide tools, lathe tools, dimensions.

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.

Prior to 1972, the results of the work of the Technical Committees were published as ISO Recommendations; these documents are now in the process of being transformed into International Standards. As part of this process, Technical Committee ISO/TC 29 has reviewed ISO Recommendation R 242 and found it technically suitable for transformation. International Standard ISO 242 therefore replaces ISO Recommendation R 242-1961 and Amendment 1-1966 to which it is technically identical.

<https://standards.iteh.ai/catalog/standards/sist/80cc49d3-f2c1-4eb4-898c-e9be8035fc13/iso-242-1975>

ISO Recommendation R 242 was approved by the Member Bodies of the following countries :

Austria	India	South Africa, Rep. of
Belgium	Italy	Sweden
Czechoslovakia	Mexico	Switzerland
France	Netherlands	United Kingdom
Germany	Pakistan	U.S.A.
Greece	Poland	
Hungary	Portugal	

The Member Body of the following country expressed disapproval of the Recommendation on Technical grounds :

U.S.S.R.

The Member Bodies of the following countries disapproved the transformation of ISO/R 242 into an International Standard :

Poland
U.S.A.

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1 SCOPE AND FIELD OF APPLICATION

This International Standard lays down the dimensions of carbide tips for turning tools intended to be fixed on the shanks of tools by brazing.

NOTE — Throwaway carbide indexable inserts are the subject of ISO 883.

2 REFERENCES

ISO 241, *Shanks for turning and planing tools — Types and dimensions of the section.*

ISO 513, *Application of carbides for machining by chip removal — Designation of the main groups of chip removal and groups of application.*

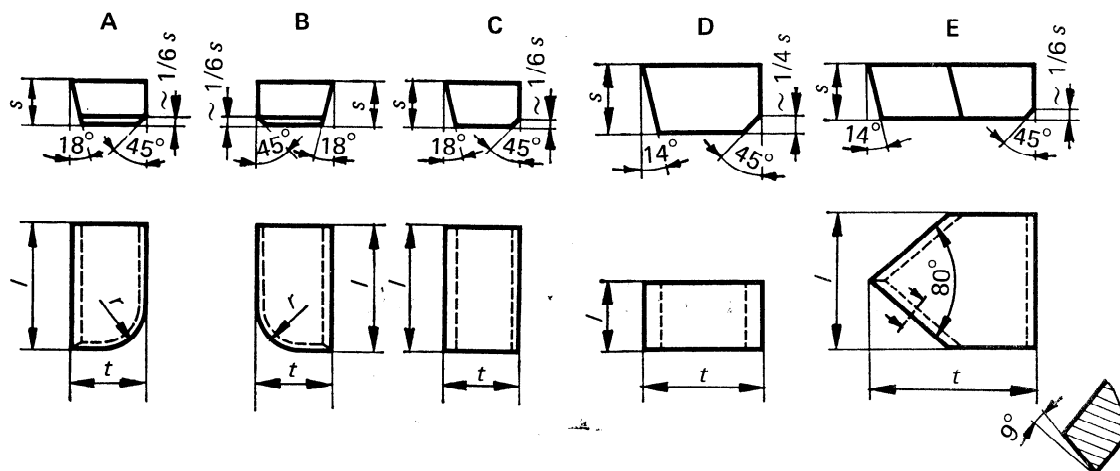
3 INTERCHANGEABILITY

The dimensions adopted are unified dimensions intended to permit interchangeability between the tips and the tool shanks on which they have to be mounted.

4 TYPES AND DIMENSIONS

Tips with a thickness s below 4 mm are supplied without a chamfer at the base and without the clearance angle; cutting edges may be slightly rounded.

Types



iTeh STANDARD PREVIEW Dimensions in millimetres

Types	A and B				C			D			E		
	l	t	s	r	l	t	s	l	t	s	l	t	s
3	—	—	—	—	—	—	—	3,5	8	3	—	—	—
4	—	—	—	—	—	—	—	4,5	10	4	4	10	2,5
5	5	3	2	2	5	3	2	5,5	12	5	5	12	3
6	6	4	2,5	2,5	6	4	2,5	6,5	14	6	6	14	3,5
8	8	5	3	3	8	5	3	8,5	16	8	8	16	4
10	10	6	4	4	10	6	4	10,5	18	10	10	18	5
12	12	8	5	5	12	8	5	12,5	20	12	12	20	6
16	16	10	6	6	16	10	6	—	—	—	16	22	7
20	20	12	7	7	20	12	7	—	—	—	20	25	8
25	25	14	8	8	25	14	8	—	—	—	25	28	9
32	32	18	10	10	32	18	10	—	—	—	32	32	10
40	40	22	12	12	40	22	12	—	—	—	—	—	—
50	50	25	14	14	50	25	14	—	—	—	—	—	—

All the dimensions given are minimum dimensions.