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**Tool holders with rectangular shank for  
indexable inserts —**

**Part 8:  
Style K**

*Porte-plaquette à queue rectangulaire pour plaquettes amovibles —*

*Partie 8: Forme K*

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ISO 5610-8:2010

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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 5610-8 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with cutting edges made of hard cutting materials*.

This first edition of ISO 5610-8, together with ISO 5610-1, ISO 5610-2, ISO 5610-3, ISO 5610-4, ISO 5610-5, ISO 5610-6, ISO 5610-7, ISO 5610-9, ISO 5610-10, ISO 5610-11, ISO 5610-12, ISO 5610-13, ISO 5610-14 and ISO 5610-15, cancels and replaces ISO 5610:1998.

ISO 5610 consists of the following parts, under the general title *Tool holders with rectangular shank for indexable inserts*:

- <https://standards.iteh.ai/catalog/standards/sist/b54fb974-ccfc-4e25-9829-41e11f63275e/iso-5610-8:2010>
- Part 1: General survey, correlation and determination of dimensions
  - Part 2: Style A
  - Part 3: Style B
  - Part 4: Style D
  - Part 5: Style F
  - Part 6: Style G
  - Part 7: Style J
  - Part 8: Style K
  - Part 9: Style L
  - Part 10: Style N
  - Part 11: Style R
  - Part 12: Style S
  - Part 13: Style T
  - Part 14: Style H
  - Part 15: Style V

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# Tool holders with rectangular shank for indexable inserts —

## Part 8: Style K

### 1 Scope

This part of ISO 5610 specifies tool holders with rectangular shank, style K, i.e. with offset shank and cutting edge angle  $\kappa_r = 75^\circ$  for end cutting.

These tool holders are primarily intended for indexable inserts made of hardmetal or other cutting materials to be mounted by clamping and to be used for turning operations.

NOTE The symbols for the dimensions shown in the tables of this part of ISO 5610 and the corresponding preferred symbols of properties defined in ISO/TS 13399-2 and ISO/TS 13399-3 are given in ISO 5610-1:2010, Table A.1.

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### 2 Normative references (standards.iteh.ai)

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 5608:1995, *Turning and copying tool holders and cartridges for indexable inserts — Designation*

ISO 5610-1:2010, *Tool holders with rectangular shank for indexable inserts — Part 1: General survey, correlation and determination of dimensions*

### 3 Dimensions

#### 3.1 General

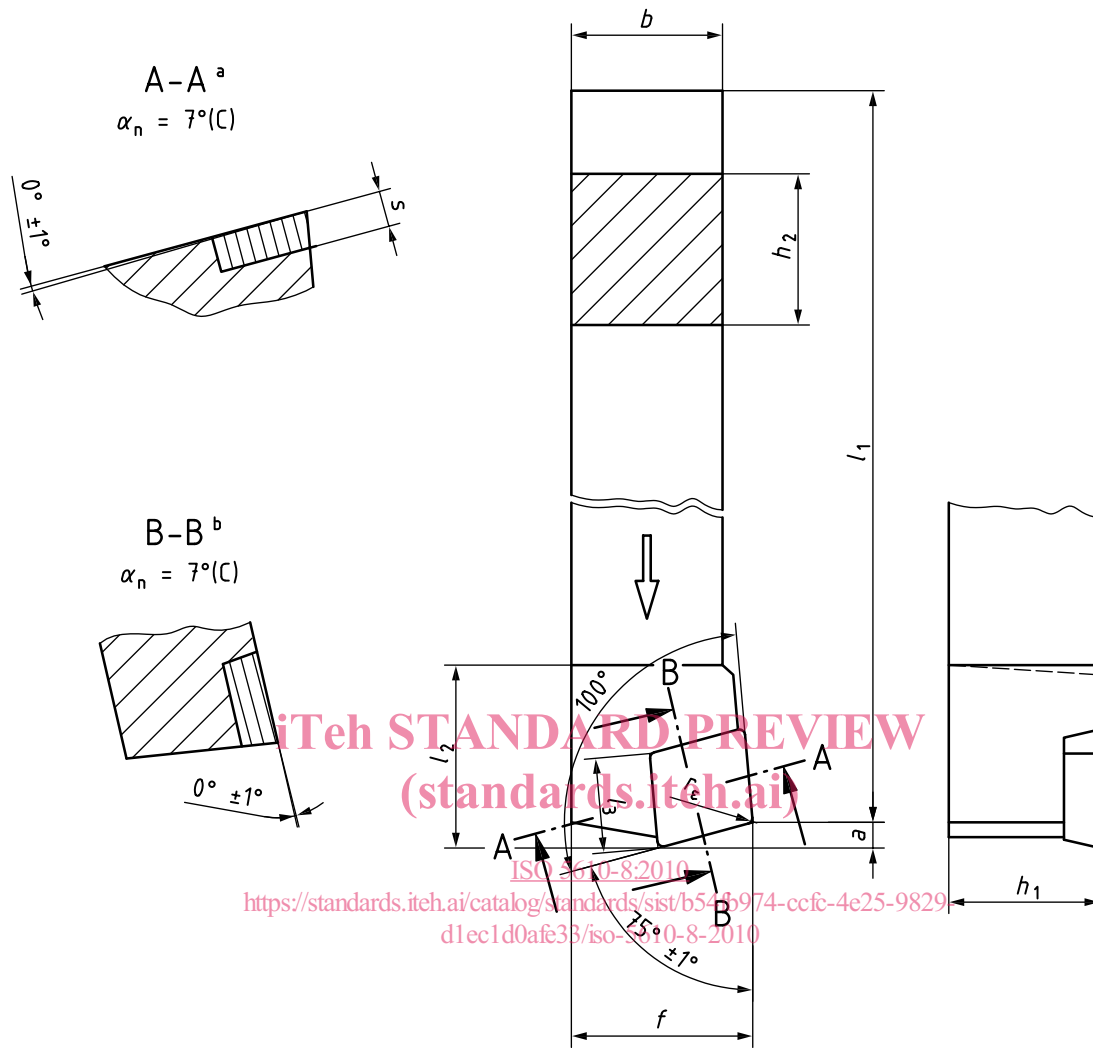
It is not necessary for tool holders to comply with the pictorial representation; only the dimensions given shall be observed.

For determination of dimensions  $h_1$ ,  $f$  and  $l_1$ , see ISO 5610-1.

For explanation of the designation code for tool holders, see ISO 5608.

NOTE The values of rake angles and inclination angles shown in the figures are recommended values; they can vary according to the application.

3.2 Tool holder style K for rhombic indexable insert shape C



NOTE This figure shows a right-hand tool holder (R); left-hand tool holder (L) laterally reversed.

<sup>a</sup> Inclination angle  $\lambda_n$ .

<sup>b</sup> Rake angle  $\gamma_n$ .

Figure 1 — Tool holder style K for rhombic indexable insert — C

Table 1

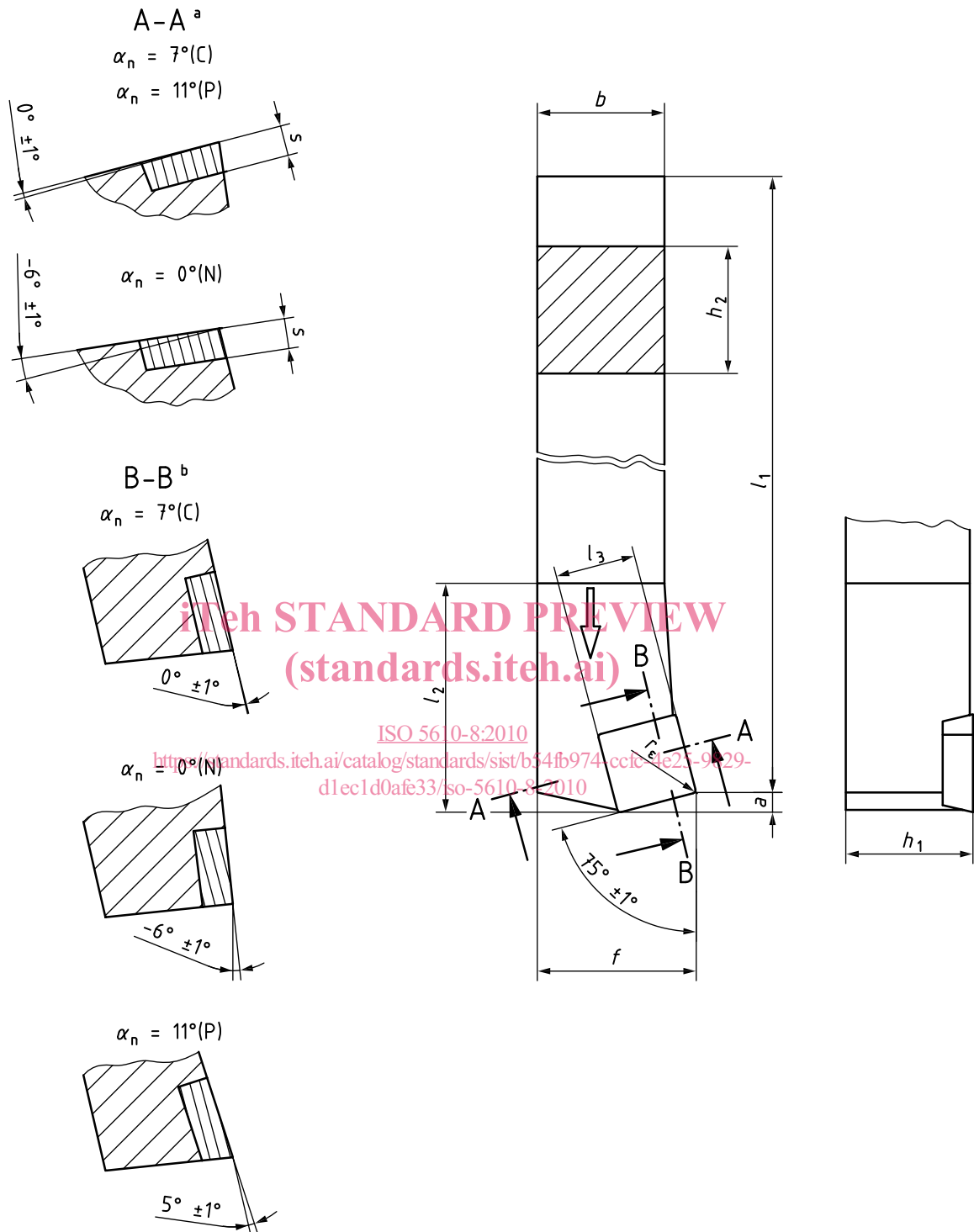
Dimensions in millimetres

Symbol <sup>a</sup>	$h_1$ js13	$b$ h13	$l_3$ ≈	$a$	$f$ +0,5 0	$h_2$ h13	$l_1^a$ k16	$l_2$ max.	$s^b$
SCKCR 0808 — 06	8	8	6,4	1,6	10	8	—	12	2,38
SCKCL 0808 — 06									
SCKCR 1010 — 06	10	10	6,4	1,6	12	10	—	12	2,38
SCKCL 1010 — 06									

<sup>a</sup> For the selection of length,  $l_1$ , the en-dash can be replaced by the dimensions of ISO 5610-1:2010, Table 2. For letter symbols identifying the tool length, see ISO 5608:1995, Table 6.

<sup>b</sup> Insert thickness without shim, if any.

3.3 Tool holder style K for square indexable insert shape S



NOTE This figure shows a right-hand tool holder (R); left-hand tool holder (L) laterally reversed.

a Inclination angle  $\lambda_n$ .

b Rake angle  $\gamma_n$ .

Figure 2 — Tool holder style K for square indexable insert — S

Table 2

Dimensions in millimetres

Symbol <sup>a</sup>	$h_1$ js13	$b$ h13	$l_3$ ≈	$a$	$f$ $\begin{matrix} +0,5 \\ 0 \end{matrix}$	$h_2$ h13	$l_1^a$ k16	$l_2$ max.	$s^b$
SSKCR 1212 — 09	16	16	9,52	2,2	16	12	—	32	3,97
SSKCL 1212 — 09									3,18
PSKNR 1212 — 09									
PSKNL 1212 — 09									
CSKPR 1212 — 09									
CSKPL 1212 — 09									
SSKCR 1616 — 09	16	16	9,52	2,2	20	16	—	32	3,97
SSKCL 1616 — 09									3,18
PSKNR 1616 — 09									
PSKNL 1616 — 09									
CSKPR 1616 — 09									
CSKPL 1616 — 09									
SSKCR 1616 — 12	16	16	12,7	3,1	20	16	—	36	4,76
SSKCL 1616 — 12									3,18
PSKNR 1616 — 12									
PSKNL 1616 — 12									
CSKPR 1616 — 12									
CSKPL 1616 — 12									
SSKCR 2020 — 12	20	20	12,7	3,1	25	20	—	36	4,76
SSKCL 2020 — 12									3,18
PSKNR 2020 — 12									
PSKNL 2020 — 12									
CSKPR 2020 — 12									
CSKPL 2020 — 12									
SSKCR 2525 — 12	25	25	12,7	3,9	32	25	—	36	4,76
SSKCL 2525 — 12									3,18
PSKNR 2525 — 12									
PSKNL 2525 — 12									
CSKPR 2525 — 12									
CSKPL 2525 — 12									
SSKCR 2525 — 15	25	25	15,88	4,6	32	25	—	40	5,56
SSKCL 2525 — 15									6,35
PSKNR 2525 — 15									
PSKNL 2525 — 15									

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Table 2 (continued)

Dimensions in millimetres

Symbol <sup>a</sup>	$h_1$	$b$	$l_3$	$a$	$f$	$h_2$	$l_1^a$	$l_2$	$s^b$
	js13	h13	≈		$^{+0,5}_0$	h13	k16	max.	
CSKPR 2525 — 19	25	25	19,05	4,6	32	25	—	45	4,76
CSKPL 2525 — 19									
SSKCR 3225 — 12	32	25	12,7	3,9	32	32	—	36	4,76
SSKCL 3225 — 12									
PSKNR 3225 — 12									
PSKNL 3225 — 12									
CSKPR 3225 — 12									
CSKPL 3225 — 12									3,18
SSKCR 3225 — 15	32	25	15,88	4,6	32	32	—	40	5,56
SSKCL 3225 — 15									
PSKNR 3225 — 15									
PSKNL 3225 — 15									
CSKPR 3225 — 19	32	25	19,05	4,6	32	32	—	45	4,76
CSKPL 3225 — 19									
SSKCR 3232 — 19	32	32	19,05	4,6	40	32	—	45	6,35
SSKCL 3232 — 19									
PSKNR 3232 — 19									
PSKNL 3232 — 19									
CSKPR 3232 — 19									
CSKPL 3232 — 19									
SSKCR 4040 — 19	40	40	19,05	4,6	50	40	—	45	6,35
SSKCL 4040 — 19									
PSKNR 4040 — 19									
PSKNL 4040 — 19									
CSKPR 4040 — 19									
CSKPL 4040 — 19									4,76
PSKNR 4040 — 25	40	40	25,4	5,9	50	40	—	50	7,94
PSKNL 4040 — 25									

<sup>a</sup> See Table 1.

<sup>b</sup> See Table 1.