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Single point cutting tools — Corner radii

Outils de coupe à partie active unique — Rayons de pointe

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Foreword

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The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This second edition cancels and replaces the first edition (ISO 3286:1976), of which it constitutes a minor revision.

Single point cutting tools — Corner radii

1 Scope

This International Standard lays down the values for the corner radius of single point cutting tools. It applies to all types of single point cutting tools (with or without inserts), the corner of which is rounded.

2 Dimensions

Corner radii shall have the dimensions given in [Table 1](#).

3 Tolerances

Tolerance on the corner radius will be given in particular tool standards, if necessary.

Table 1

Corner radius, r_E	
mm	in
0,2	0,008
0,4	1/64
0,8	1/32
1,2	3/64
1,6	1/16
2,0	5/64
2,5 ^a	3/32
3,2	1/8

^a For indexable (throwaway) inserts, corner radius 2,4 mm instead of 2,5 mm is to be used.

Annex A (informative)

Relationship between designations in this International Standard and ISO 13399

For relationship between designations in this International Standard and preferred symbols according to ISO 13399, see [Table A.1](#).

Table A.1 — Relationship between designations in this International Standard and the ISO 13399-series

Symbol in this International Standard	Reference in this International Standard	Property name in ISO 13399	Symbol in ISO 13399	Reference in ISO 13399
r_E	Clause 3 Table 1	corner radius	RE	ISO/TS 13399-2 71DD6C8ACA503

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