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

**Part 8:
Style K**

*Porte-plaquette à queue rectangulaire pour plaquettes amovibles —
Partie 8: Forme K*



Reference number
ISO 5610-8:2010(E)

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Foreword

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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*:

- *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*

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.

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 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

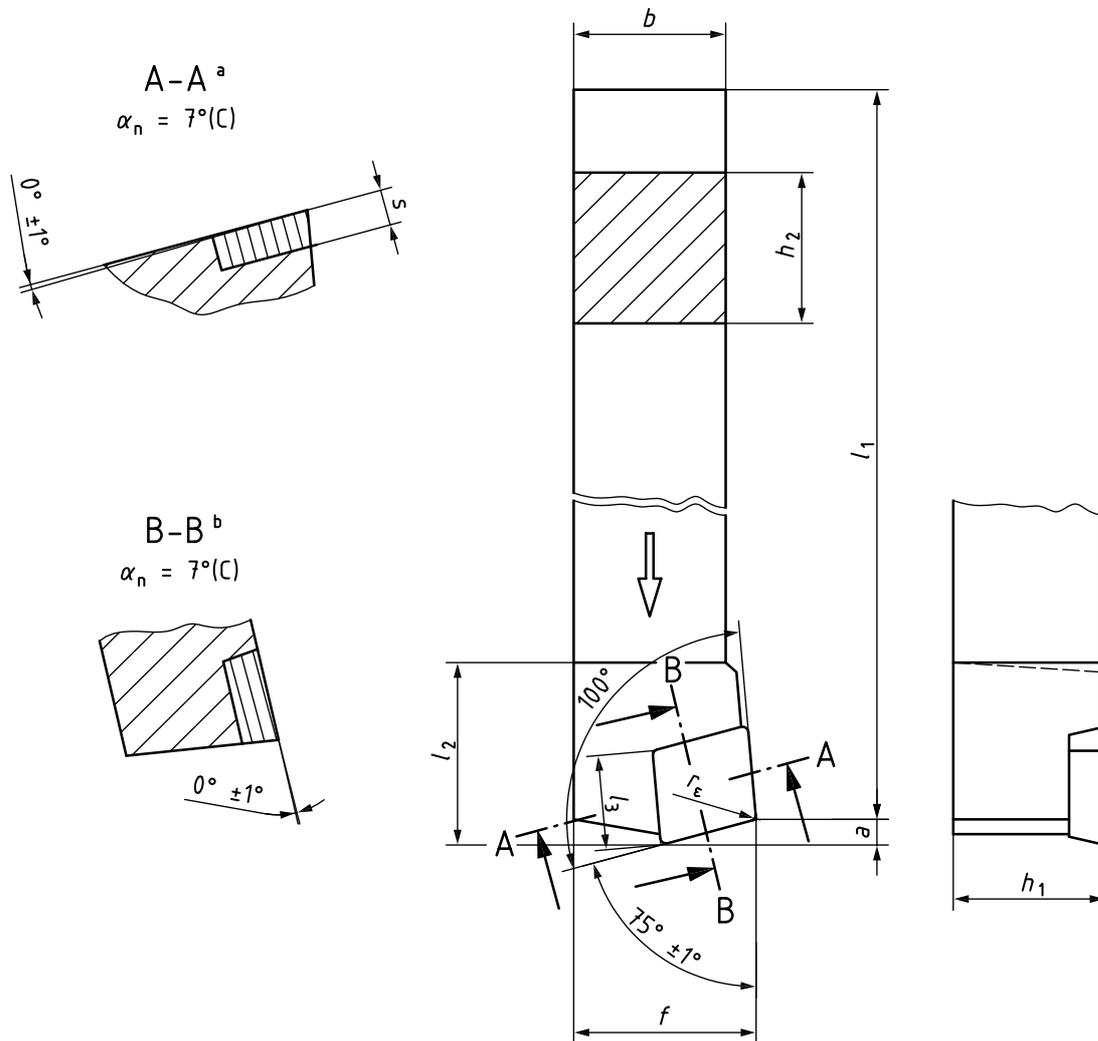
It is not necessary for tool holders to comply with the pictorial representation; only the dimensions given shall be observed.

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.

^a Inclination angle λ_n .

^b Rake angle γ_n .

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

Table 1

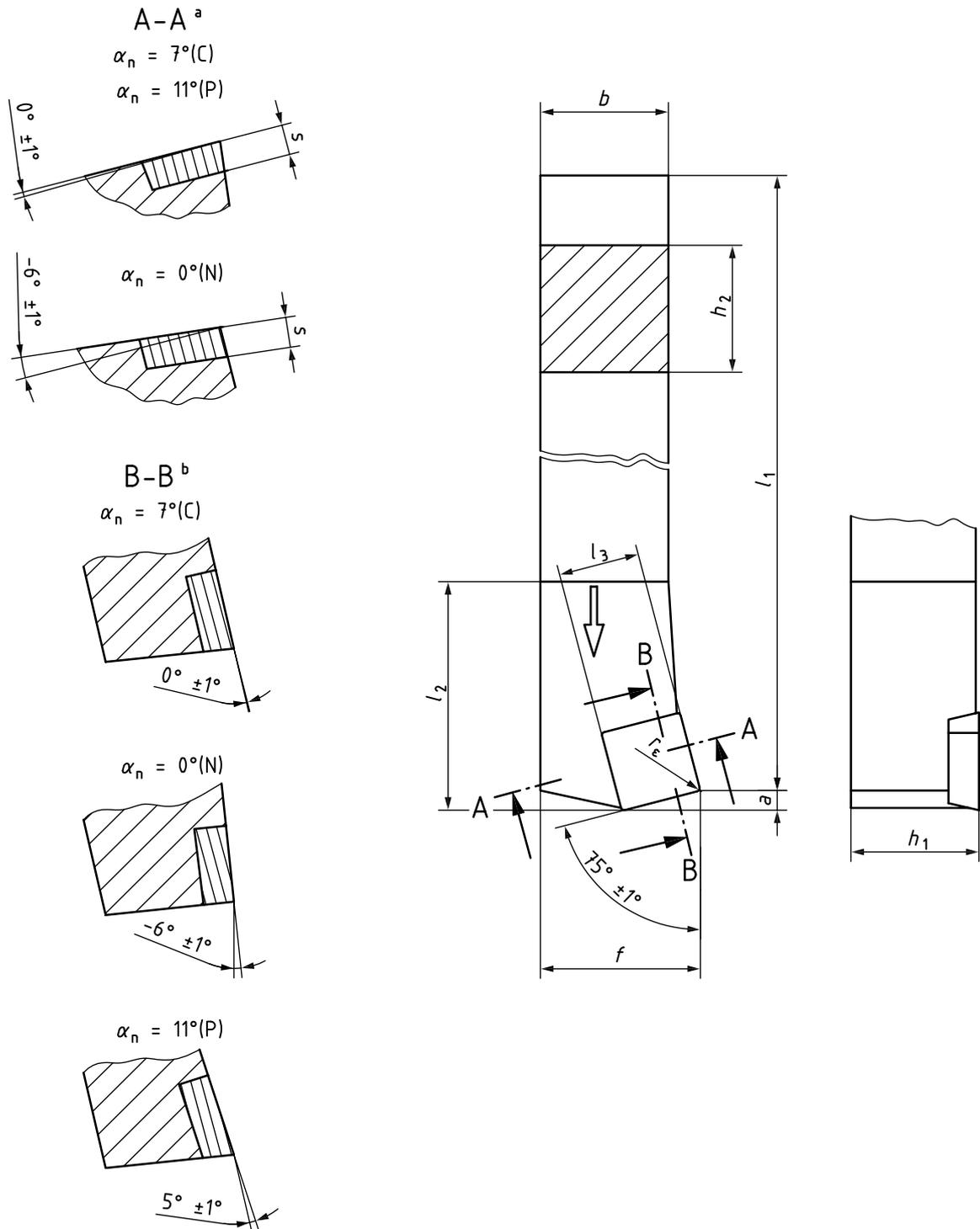
Dimensions in millimetres

Symbol ^a	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									

^a 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.

^b 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 λ_n .
- b Rake angle γ_n .

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

Table 2

Dimensions in millimetres

Symbol ^a	h_1 js13	b h13	l_3 ≈	a	f $\begin{smallmatrix} +0,5 \\ 0 \end{smallmatrix}$	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									16
SSKCR 1616 — 09	3,18								
SSKCL 1616 — 09									
PSKNR 1616 — 09									
PSKNL 1616 — 09									
CSKPR 1616 — 09	16	16	12,7	3,1	20	16	—	36	
SSKCR 1616 — 12									3,18
SSKCL 1616 — 12									
PSKNR 1616 — 12									
PSKNL 1616 — 12									
CSKPR 1616 — 12									20
SSKCR 2020 — 12	3,18								
SSKCL 2020 — 12									
PSKNR 2020 — 12									
PSKNL 2020 — 12									
CSKPR 2020 — 12	25	25	12,7	3,9	32	25	—	36	
SSKCR 2525 — 12									3,18
SSKCL 2525 — 12									
PSKNR 2525 — 12									
PSKNL 2525 — 12									
CSKPR 2525 — 12									25
SSKCR 2525 — 15	6,35								
SSKCL 2525 — 15									
PSKNR 2525 — 15									
PSKNL 2525 — 15									

Table 2 (continued)

Dimensions in millimetres

Symbol ^a	h_1 js13	b h13	l_3 ≈	a	f $^{+0,5}_0$	h_2 h13	l_1^a k16	l_2 max.	s^b
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									
^a See Table 1.									
^b See Table 1.									

4 Designation

A tool holder in accordance with this part of ISO 5610 shall be designated by:

- a) "Tool holder";
- b) reference to this part of ISO 5610, i.e. ISO 5610-8;
- c) type of mounting, in accordance with ISO 5608;
- d) symbol for indexable insert shape, in accordance with ISO 5608;
- e) symbol for tool style, in accordance with ISO 5608;
- f) symbol for the indexable insert normal clearance, in accordance with ISO 5608;
- g) symbol for hand of tool, in accordance with ISO 5608;
- h) its height, h_1 , width, b , and length, l_1 (symbol for tool length in accordance with ISO 5608);
- i) its cutting edge length, l_3 .

EXAMPLE 1 Tool holder for a screw-clamped (S) rhombic indexable insert shape C (C), tool holder style K (K), for normal clearance of indexable insert $\alpha_n = 7^\circ$ (C), right-hand type (R), with height $h_1 = 10$ mm and width $b = 10$ mm (1010), length $l_1 = 70$ mm (E), for cutting edge length $l_3 = 6,4$ mm (06) is designated as follows:

Tool holder ISO 5610-8 - SCKCR 1010 E06

EXAMPLE 2 Tool holder for a horizontally mounted, top-clamped (C) square indexable insert shape S (S), tool holder style K (K), normal clearance of indexable insert $\alpha_n = 11^\circ$ (P), right-hand type (R), with height $h_1 = 32$ mm and width $b = 25$ mm (3225), length $l_1 = 170$ mm (P), for cutting edge length $l_3 = 19,05$ mm (19) is designated as follows:

Tool holder ISO 5610-8 - CSKPR 3225 P19

5 Material

The material should be steel with a tensile strength of at least 1 200 N/mm².

6 Design

6.1 Type of mounting

Standard design of tool holders with indexable insert shall be mounted in accordance with Tables 1 and 2.

Other types of mounting may be left to the manufacturer's discretion or upon agreement. The letter symbol in the designation, symbol 1, shall then be replaced by the respective symbol for the chosen or agreed-upon type of mounting in accordance with ISO 5608.

For the modified type of mounting deviating from Tables 1 and 2, the relevant indexable insert thickness shall also be considered.

6.2 Corner radius, r_ϵ

Tool holders in accordance with this part of ISO 5610 may be equipped with indexable inserts with cutting edge lengths, l_3 , as specified in Tables 1 and 2 and any corner radius, r_ϵ .

The values for l_1 given in ISO 5610-1:2010, Table 2, apply to tool holders with indexable inserts having corner radii, r_ϵ , in accordance with Table 3.

Table 3

Dimensions in millimetres

l_3	r_ϵ
6,4	0,4
9,52	0,8
12,7	
15,88	1,2
19,05	
25,4	2,4
NOTE The values given for r_ϵ are nominal values. The accurate values converted from the inch dimensions are 0,397 mm, 0,794 mm, 1,191 mm and 2,381 mm.	

For indexable inserts with corner radii, r_ϵ , other than those specified in Table 3, the dimensions of a , f and l_1 shall be determined in accordance with ISO 5610-1.

The tolerances on h_1 , f and l_1 refer to dimensions measured with master indexable insert and master shim, if any.

6.3 Thickness, s , of indexable insert

The values for thickness, s , given in Tables 1 and 2, apply to indexable inserts without shim and for the standard design of tool holders.

For tool holders for indexable inserts with thicknesses deviating from the specified values, the thickness shall be indicated when ordering or upon delivery (in the handbook).

7 Extent of delivery

Tool holders shall be delivered complete with clamping device, but without indexable insert(s).

8 Marking

Tool holders shall be marked with the letter symbol and the name or trademark of the manufacturer.

Additional marking may be left to the manufacturer's discretion or upon agreement.

Deviations in marking shall be agreed upon.

A reference to this part of ISO 5610, i.e. ISO 5610-8:2010, shall be given on the packaging.

Bibliography

- [1] ISO 883, *Indexable hardmetal (carbide) inserts with rounded corners, without fixing hole — Dimensions*
- [2] ISO 3002-1, *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*
- [3] ISO 3364, *Indexable hardmetal (carbide) inserts with rounded corners, with cylindrical fixing hole — Dimensions*
- [4] ISO 6987, *Indexable hard material inserts with rounded corners, with partly cylindrical fixing hole — Dimensions*
- [5] ISO/TS 13399-2, *Cutting tool data representation and exchange — Part 2: Reference dictionary for the cutting items*
- [6] ISO/TS 13399-3, *Cutting tool data representation and exchange — Part 3: Reference dictionary for tool items*

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