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Skärhållare för innersvarvning med cylindriskt fäste – Del 2: Typ F (ISO 5609-2:2012, IDT)

**Tool holders for internal turning with cylindrical shank for
indexable inserts –
Part 2: Style F (ISO 5609-2:2012, IDT)**

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Den internationella standarden ISO 5609-2:2012 gäller som svensk standard. Detta dokument innehåller den officiella engelska versionen av ISO 5609-2:2012.

Denna standard ersätter SS-ISO 5609, utgåva 3.

The International Standard ISO 5609-2:2012 has the status of a Swedish Standard. This document contains the official version of ISO 5609-2:2012.

This standard supersedes the Swedish Standard SS-ISO 5609, edition 3.

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Denna standard är framtagen av kommittén för Skärande verktyg, SIS/TK 273.

Har du synpunkter på innehållet i den här standarden, vill du delta i ett kommande revideringsarbete eller vara med och ta fram andra standarder inom området? Gå in på www.sis.se - där hittar du mer information.

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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 5609-2 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 5609-2, together with ISO 5609-1, ISO 5609-3, ISO 5609-4, ISO 5609-5 and ISO 5609-6, cancels and replaces ISO 5609:1998, which has been technically revised.

ISO 5609 consists of the following parts, under the general title *Tool holders for internal turning with cylindrical shank for indexable inserts*:

Part 1: Designation, styles, dimensions and calculation for corrections

Part 2: Style F

Part 3: Style K

Part 4: Style L

Part 5: Style U

Part 6: Style Q

Tool holders for internal turning with cylindrical shank for indexable inserts —

Part 2: Style F

1 Scope

This part of ISO 5609 specifies the characteristics of tool holders for internal turning with cylindrical shank, style F, i.e. with reduced shank and cutting edge angle $\kappa_r = 90^\circ$.

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

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5609-1, *Tool holders for internal turning with cylindrical shank for indexable inserts — Part 1: Designation, styles, dimensions and calculation for corrections*

3 Dimensions

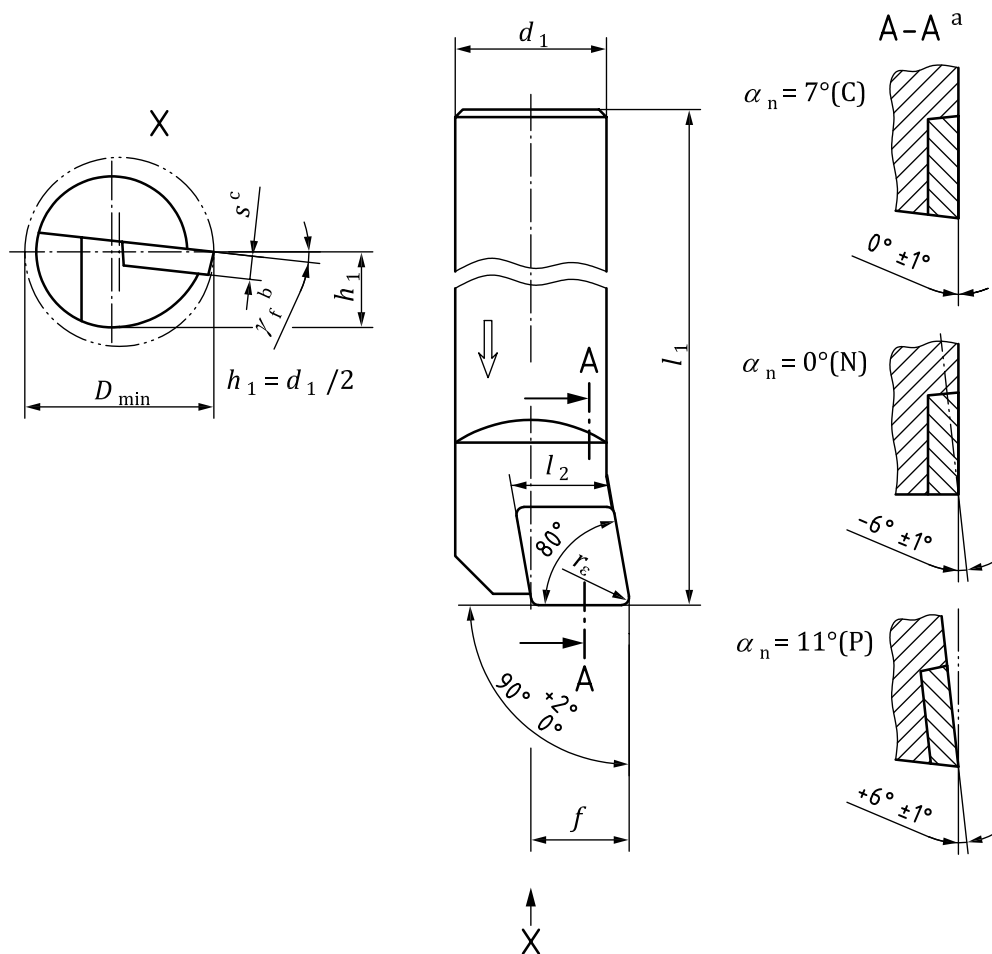
3.1 General dimensions

The symbols for dimensions shown in the figures/illustrations in the tables of this part of ISO 5609 and the corresponding preferred symbols of properties defined in ISO 13399 (all parts) are in accordance with Table A.1 of ISO 5609-1:2012.

The tool holders need not comply with the pictorial representation; only the dimensions given shall be observed.

The determination of dimensions, f and l_1 and an explanation of the designation code for tool holders are given in ISO 5609-1.

3.2 Tool holder, style F, for rhombic indexable, shape C



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

a Orthogonal rake angle, γ_o , with indexable insert for:

— $\alpha_n = 7^\circ$ (C);

— $\alpha_n = 0^\circ$ (N);

— $\alpha_n = 11^\circ$ (P).

b γ_f is dependent on D_{min} and the indexable insert.

c See Table 1.

Figure 1 — Tool holder, style F, for rhombic indexable insert, shape C

Table 1 —

Dimensions in millimetres

Symbol ^a	d_1	l_1	l_2	f	D_{min}	s^b
		g7	k16	≈	$\begin{matrix} 0 \\ -0,25 \end{matrix}$	
• 08F — SCFCR 06 • 08F — SCFCL 06	8	80	6,4	6	11	2,38
• 10H — SCFCR 06 • 10H — SCFCL 06	10	100	6,4	7	13	2,38

^a For the supplementary symbol, see 6.1.

^b For indexable insert thickness without shim, if any, see 6.4.