INTERNATIONAL STANDARD

ISO 5610

Third edition
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AMENDMENT 1
1993-07-15

Single-point tool holders for turning and copying, for indexable inserts – Dimensions

AMENDMENT 1: Tool holders style H, J and V, with rhombic V-shape indexable inserts

Porte-plaquette de tournage et de copiage à partie active unique – Dimensions

AMENDEMENT 1: Porte-plaquette de formes H, J et V, à plaquette amovible rhombique forme V

Reference number
ISO 5610:1989/Amd.1:1993(E)

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.

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.

Amendment 1 to International Standard ISO 5610:1989 was prepared by Technical Committee ISO/TC 29, *Small tools*, Sub-Committee SC 9, *Tools with cutting edges made of hard cutting materials*.

At a later date, this amendment will be incorporated in a fourth edition of ISO 5610.

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Single-point tool holders for turning and copying, for indexable inserts – Dimensions

AMENDMENT 1: Tool holders style H, J and V, with rhombic V-shape indexable inserts

Page 2, table 3

Replace this table with table 3 as given below.

Table 3

Dimensions in millimetres

b	f				
	Series 1[1]	Series 2 $^{+0,5}_{0}$	Series 3 $^{+0,5}_{0}$	Series 4 $^{+0,5}_{0}$	Series 5 $^{+0,5}_{0}$
8	4	7	8,5	9	10
10	5	9	10,5	11	12
12	6	11	12,5	13	16
16	8	13	16,5	17	20
20	10	17	20,5	22	25
25	12,5	22	25,5	27	32
32	16	27	33	35	40
40	20	35	41	43	50
50	25	43	51	53	60
For tool holders style	D, N, V	B, T	A	R	F, G, H, J, K, L, S

1) Tolerance for symmetrical tool holders (style D and V): ± 0,25

Tolerance for non-symmetrical tool holders (style N): $^{+0,5}_{0}$

Page 3, subclause 3.4.4

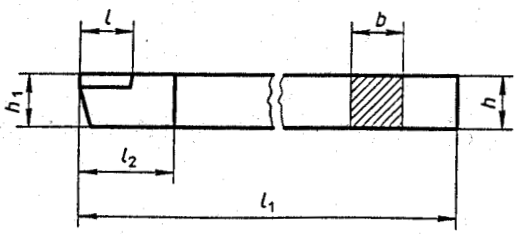
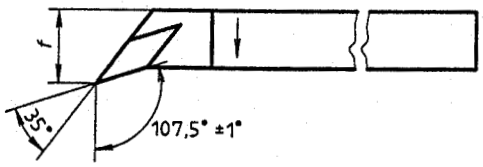
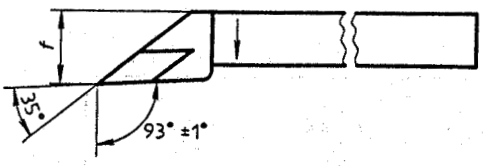
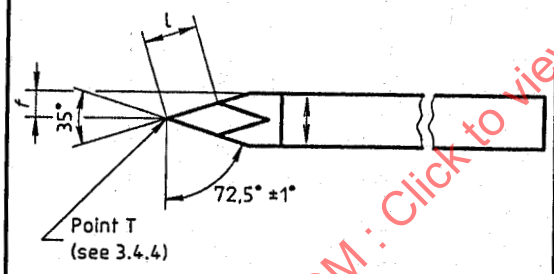
Replace the first paragraph of this subclause with the following paragraph.

3.4.4 The tolerance ± 0,25 on dimension f for series 1 refers to symmetrical tool holders (style D and V). Therefore, deviating from the definition given in 3.4.2, the values in table 3 are given in relation to the actual intersection of the cutting edges (theoretical corner T).

Pages 5 and 6, table 5

Add to this table the tool holders style H, J and V with rhombic V-shape indexable inserts as given below.

Dimensions in millimetres

Style		$h \times b$	08 08	10 10	12 12	16 16	20 20	25 25	32 25	32 32	40 32	40 32	40 40	50 50
		l_1 k16	60	70	80	100	125	150	170	170	150	200	200	250
		h_1 js14	8	10	12	16	20	25	32	32	40	40	40	50
H		$f^{+0,5}_{0}$ (serie 5)			16	20	25	32	32					
		l (designation)			11/13	11/13	13/16	16	16					
		l_2 max.			25/32	25/32	32/40	40	40					
J		$f^{+0,5}_{0}$ (serie 5)			16	20	25	32	32					
		l (designation)			11/13	11/13	13/16	16	16					
		l_2 max.			25/32	25/32	32/40	40	40					
V		f ± 0,25 (serie 1)			6	8	10	12,5	12,5					
		l (designation)			11/13	11/13	13/16	16	16					
		l_2 max.			25/32	25/32	32/40	40	40					