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

**Part 4:
Style D**

*Porte-plaquette à queue rectangulaire pour plaquettes amovibles —
Partie 4: Forme D*

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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 5610-4 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 5610-4, together with ISO 5610-1, ISO 5610-2, ISO 5610-3, ISO 5610-5, ISO 5610-6, ISO 5610-7, ISO 5610-8, 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*

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Tool holders with rectangular shank for indexable inserts —

Part 4: Style D

1 Scope

This part of ISO 5610 specifies tool holders with rectangular shank, style D, i.e. with straight shank and cutting edge angle $\kappa_r = 45^\circ$ for side cutting.

These tool holders are primarily intended for indexable inserts made of hardmetal or other cutting materials intended to be mounted by clamping and 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 D for square indexable insert shape S

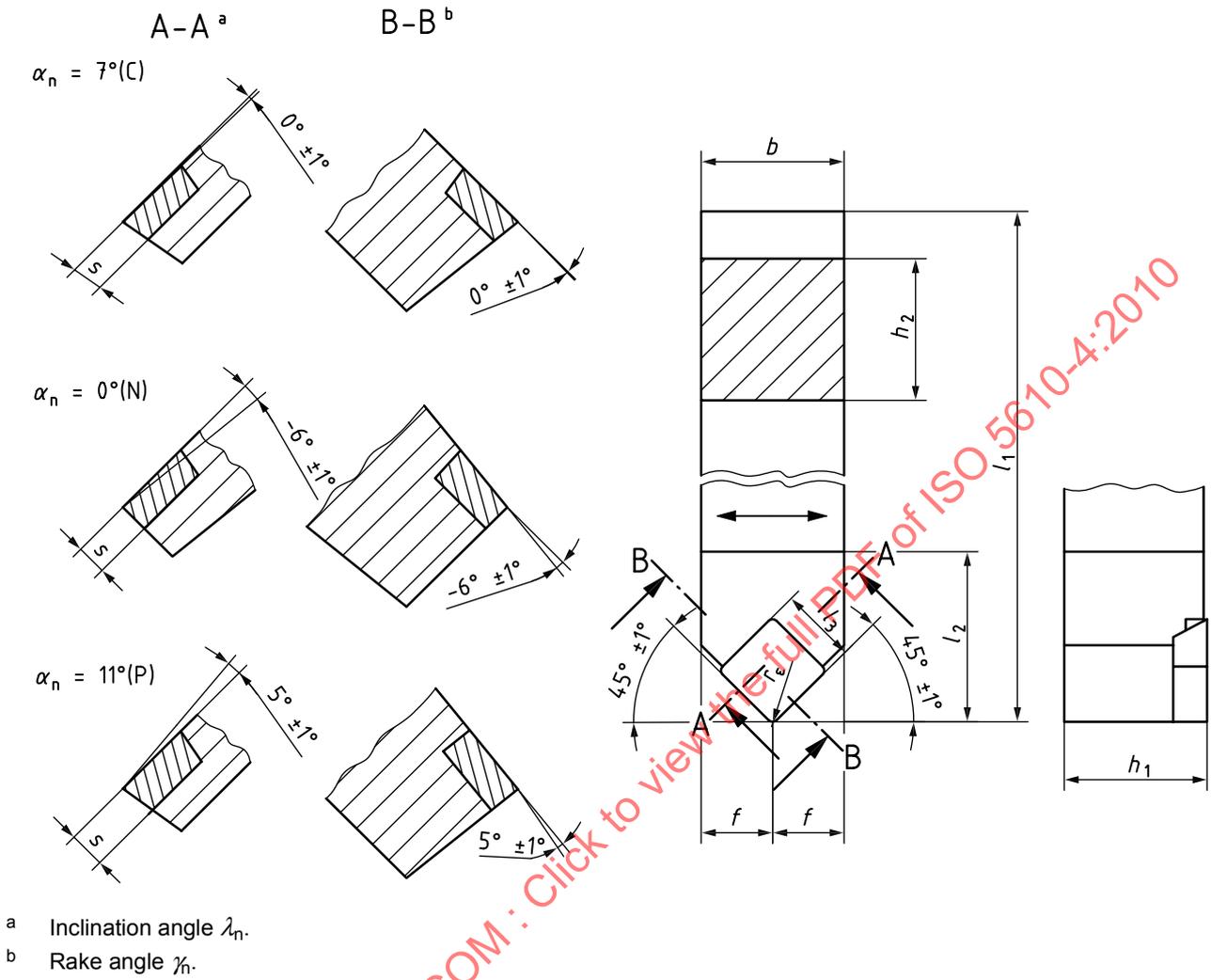


Figure 1 — Tool holder style D for square indexable insert — S

Table 1

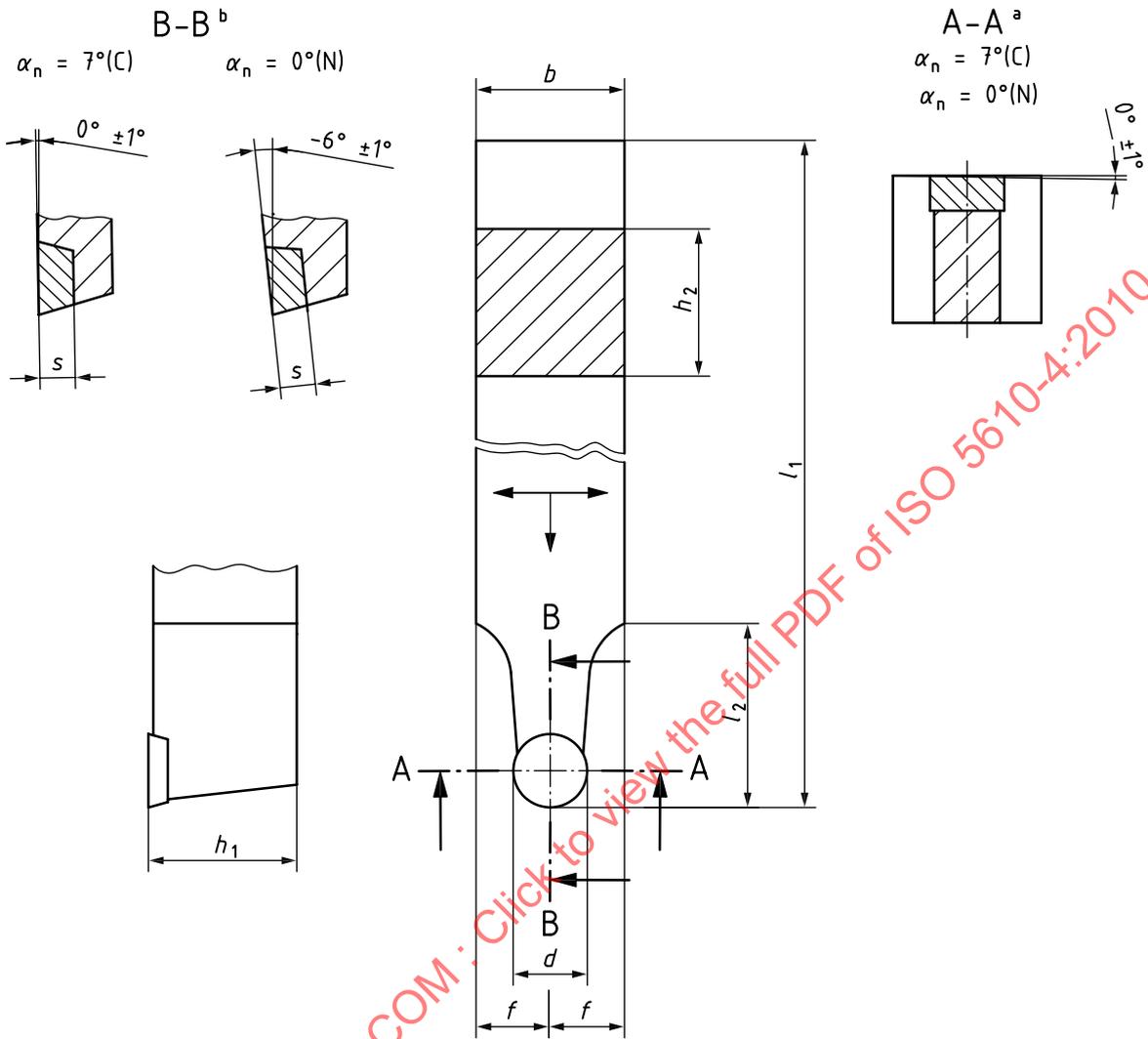
Dimensions in millimetres

Symbol ^a	h_1 js13	b h13	l_3	f $\pm 0,25$	h_2 h13	l_1^a k16	l_2 max.	s^b
SSDCN 1212 — 09	12	12	9,52	6	12	—	32	3,97
PSDNN 1212 — 09								3,18
CSDPN 1212 — 09								
SSDCN 1616 — 09	16	16	9,52	8	16	—	32	3,97
PSDNN 1616 — 09								3,18
CSDPN 1616 — 09								
SSDCN 2020 — 12	20	20	12,7	10	20	—	36	4,76
PSDNN 2020 — 12								3,18
CSDPN 2020 — 12								
CSDNN 2525 — 12	25	25	12,7	12,5	25	—	36	7,94
SSDCN 2525 — 12								4,76
PSDNN 2525 — 12								3,18
CSDPN 2525 — 12								
CSDNN 3225 — 12	32	25	12,7	12,5	32	—	36	7,94
SSDCN 3225 — 12								4,76
PSDNN 3225 — 12								3,18
CSDPN 3225 — 12								
SSDCN 3232 — 19	32	32	19,05	16	32	—	45	6,35
PSDNN 3232 — 19								
CSDPN 3232 — 19								4,76

^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 the letter symbols identifying the tool length, see ISO 5608:1995, Table 6.

^b Insert thickness without shim, if any.

3.3 Tool holder style D for round indexable insert shape R



- a Inclination angle λ_n .
- b Rake angle γ_n .

Figure 2 — Tool holder style D for round indexable insert — R

Table 2

Dimensions in millimetres

Symbol ^a	h_1 js13	b h13	d	f $\pm 0,25$	h_2 h13	l_1^a k16	s^b					
SRDCN 0808 — 06	8	8	6	4	8	—	2,38					
PRDCN 0808 — 06												
SRDCN 1010 — 06	10	10	6	5	10	—	2,38					
PRDCN 1010 — 06												
SRDCN 1010 — 08			8					3,18				
PRDCN 1010 — 08	12	12	6	6	12	—	2,38					
SRDCN 1212 — 06			8					3,18				
PRDCN 1212 — 06			16				16	6	8	16	—	2,38
SRDCN 1616 — 06								8				
PRDCN 1616 — 06	16	16	8	8	16	—	3,18					
SRDCN 1616 — 08			10					3,97				
PRDCN 1616 — 08			20					20	6	10	20	—
SRDCN 2020 — 06	8	3,18										
PRDCN 2020 — 06	10	3,97										
SRDCN 2020 — 08	12	4,76										
PRDCN 2020 — 08	25	25		6	12,5	25	—		2,38			
SRDCN 2525 — 06				8								
PRDCN 2525 — 06			9,52	4,76								
SRDCN 2525 — 08			10	3,97								
PRDCN 2525 — 08			12	4,76								
CRDNN 2525 — 09			12,7	7,94								
SRDCN 2525 — 10			16	6,35								
PRDCN 2525 — 10			32	25				12	12,5	32	—	4,76
SRDCN 3225 — 12	12,7	7,94										
PRDCN 3225 — 12	15,88	6,35										
CRDNN 3225 — 12	16											
SRDCN 3225 — 15	32	32	19,05	16	32	—	7,94					
PRDCN 3225 — 15			20				6,35					
CRDNN 3225 — 15			40				40	25	20	40	—	7,94
SRDCN 4040 — 25	25,4											
PRDCN 4040 — 25	40	40		25	20	40		—				7,94
SRDCN 4040 — 25			25,4									

^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 5610-4;
- 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 horizontally mounted bore-clamped (P) square indexable insert shape S (S), tool holder style D (D), for normal clearance of indexable insert $\alpha_n = 0^\circ$ (N), cutting on both sides (N), with height $h_1 = 32$ mm and width $b = 25$ mm (3225), length $l_1 = 170$ mm (P), for cutting edge length $l_3 = 12,7$ mm (12) is designated as follows:

Tool holder ISO 5610-4 - PSDNN 3225 P12

EXAMPLE 2 Tool holder for countersink screw-clamped (S) round indexable insert shape R (R), tool holder style D (D), for normal clearance of indexable insert $\alpha_n = 7^\circ$ (C), cutting on both sides (N), with height $h_1 = 25$ mm and width $b = 25$ mm (2525), length $l_1 = 150$ mm (M), for diameter $d = 12$ mm (12) is designated as follows:

Tool holder ISO 5610-4 - SRDCN 2525 M12

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_c

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 Table 1 and any corner radius, r_c .

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
9,52	0,8
12,7	
19,05	1,2
NOTE The values given for r_ϵ are nominal values. The accurate values converted from the inch dimensions are 0,794 mm and 1,191 mm.	

For indexable inserts with corner radii, r_ϵ , other than those specified in Table 3, the dimensions of f 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

The 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 5610-4:2010, shall be given on the packaging.