INTERNATIONAL STANDARD

ISO 6986

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Side and face milling (slotting) cutters with indexable inserts — Dimensions

Fraises trois tailles à plaquettes amovibles — Dimensions

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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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2. www.iso.org/directives

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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with cutting edges made of hard cutting materials*.

This second edition cancels and replaces the first edition (ISO 6986:1983), of which it constitutes a minor revision.

Side and face milling (slotting) cutters with indexable inserts — Dimensions

1 Scope

This International Standard specifies the dimensions of side and face milling (slotting) cutters with indexable inserts.

The shape and dimensions of the inserts are left to the discretion of the manufacturer.

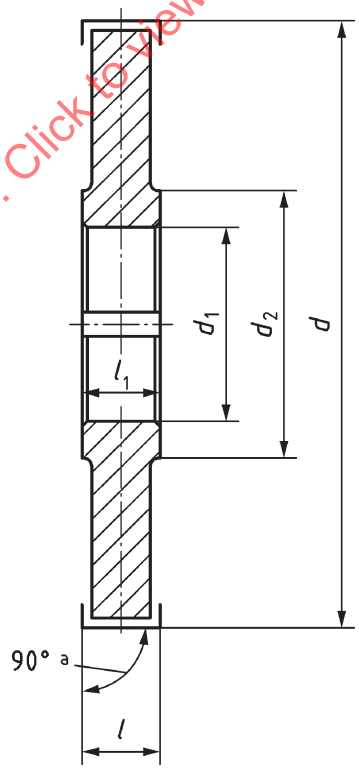
2 Normative references

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

ISO 240, *Milling cutters — Interchangeability dimensions for cutter arbors or cutter mandrels*

3 Dimensions

See Figure 1 and Table 1.



a The value of 90° is the nominal cutting edge angle of the insert.

Figure 1 — Dimensions

Table 1 — Dimensions

Dimensions in millimetres

d j_s16	d_1[b] H7	d_2 min.	l	l_1 $^{+2}_{0}$
80	27	41	10	10
100	32	47	10	10
			12	12
125	40	55	12	12
			16	16
160	40	55	16	16
			20	20
200	50	69	20	20
			25	25

[b] The dimensions of the bore and key shall be in accordance with ISO 240.

Annex A
(informative)

Relationship between designations in this International Standard and ISO 13399 (all parts)

For the relationship between designations in this International Standard and preferred symbols according to the ISO 13399 series, see Table A.1.

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

Symbol in this International Standard (ISO 6986)	**Reference in this International Standard** (ISO 6986)	**Property name in the** ISO 13399 **series**	**Symbol in the** ISO 13399 **series**	**Reference in the** ISO 13399 **series**
d	Figure 1 and Table 1	Cutting diameter	DC	ISO/TS 13399-3 71D084653E57F
d_1	Figure 1 and Table 1	Connection diameter	DCON	ISO/TS 13399-3 71EBDBF5060E6
d_2	Figure 1 and Table 1	Hub diameter	DHUB	ISO/TS 13399-3 71D087D3B17B0
l	Figure 1 and Table 1	Cutting width	CW	ISO/TS 13399-3 71CEAEBE2B825
l_1	Figure 1 and Table 1	Hub thickness	THUB	ISO/TS 13399-3 71D087D3F5E07
90°	Figure 1	Tool cutting edge angle	KAPR	ISO/TS 13399-3 71D078F683C9B

Bibliography

[1] ISO 13399 (all parts), *Cutting tool data representation and exchange*

