

# ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

## ISO RECOMMENDATION R 513

### APPLICATION OF CARBIDES FOR MACHINING BY CHIP REMOVAL

DESIGNATION OF THE MAIN GROUPS  
OF CHIP REMOVAL AND GROUPS OF APPLICATION

1st EDITION

November 1966

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Printed in Switzerland

Also issued in French and Russian. Copies to be obtained through the national standards organizations.

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## BRIEF HISTORY

The ISO Recommendation R 513, *Application of Carbides for Machining by Chip Removal — Designation of the Main Groups of Chip Removal and Groups of Application*, was drawn up by Technical Committee ISO/TC 29, *Small Tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1953 and led, in 1961, to the adoption of a Draft ISO Recommendation.

In April 1964, this Draft ISO Recommendation (No. 726) was circulated to all the ISO Member Bodies for enquiry. It was approved by the following Member Bodies:

Australia	Germany	Poland
Austria	Greece	Portugal
Belgium	Hungary	Spain
Brazil	India	Sweden
Chile	Italy	Switzerland
Colombia	Japan	Turkey
Czechoslovakia	Korea, Rep. of	United Kingdom
Denmark	Netherlands	U.S.S.R.
France	New Zealand	Yugoslavia

Two Member Bodies opposed the approval of the Draft:

Canada  
U.S.A.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in November 1966, to accept it as an ISO RECOMMENDATION.

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## APPLICATION OF CARBIDES FOR MACHINING BY CHIP REMOVAL

### DESIGNATION OF THE MAIN GROUPS OF CHIP REMOVAL AND GROUPS OF APPLICATION

#### INTRODUCTION

The variety of ways in which different manufacturers produce carbides with differing characteristics makes it impossible at the present time to standardize carbides graded in accordance with these characteristics.

This ISO Recommendation is therefore limited to a classification of carbides based on their application and to a method of designation (colour marking and distinguishing symbols) for the main types of chip removal and the groups of application which constitute this classification.

As indicated by the title, the present ISO Recommendation relates solely to the application of carbides for machining by chip removal.

All other uses (such as, for example, mining and other percussion tools, wire drawing dies, tools operating by deformation of the metal, comparator contact tips, etc.) are therefore outside the scope of this ISO Recommendation.

#### 1. CLASSIFICATION

Carbides are classified in the Table, page 6, according to their application, in main groups of chip removal and these groups are subdivided into groups of application.

The groups of application are designated by a letter (*P*, *M* or *K*) indicating the relevant main group followed by a distinguishing number and these groupings define the fields of application within which carbide manufacturers may classify their own particular grades of carbides.

The letters *P*, *M* and *K* are thus intended exclusively for the general classification of carbides and should never be used, either separately or in conjunction with another letter, as a commercial designation for a particular grade.

##### 1.1 Main groups of chip removal

This ISO Recommendation provides for three main groups of chip removal, based on three broad classes of material to be machined, as indicated in the Table, which are designated by the letters *P*, *M* and *K* respectively.

These letters are purely conventional and have no other significance in themselves; they are not the initials of particular words.

Each of these groups has a corresponding distinctive colour marking, blue, yellow or red.\*

##### 1.2 Groups of application

Each main group is subdivided into groups of application based on the working conditions in which it is used.

These working conditions are expressed in the Table in very general terms and carbide manufacturers may possibly describe them, for their own purposes, in terms more directly related to the fields of use for the carbides which they manufacture.

The groups of application are designated by the letter for the main group to which they belong, followed by a distinguishing number.

\* The references given in the table for these colours are those of the RAL colour register issued by the Deutscher Normenausschuss Committee for delivery and quality specifications, " Ausschuss für Lieferbedingungen und Gütesicherung. "

TABLE. — Classification of carbides according to use

Main groups of chip removal		Groups of application				Direction of increase in characteristic	
Symbol	Broad categories of material to be machined	Designation	Material to be machined	Use and working conditions	of cut	of carbide	
<i>P</i>	Ferrous metals with long chips	<i>P 01</i> <i>P 10</i> <i>P 20</i> <i>P 30</i> <i>P 40</i> <i>P 50</i>	Steel, steel castings	Finish turning and boring; high cutting speeds, small chip section, accuracy of dimensions and fine finish, vibration-free operation. Turning, copying, threading and milling, high cutting speeds, small or medium chip sections. Turning, copying, milling, medium cutting speeds and chip sections, planing with small chip sections Turning, milling, planing, medium or low cutting speeds, medium or large chip sections, and machining in unfavourable conditions.* Turning, planing, slotting, low cutting speeds, large chip sections with the possibility of large cutting angles for machining in unfavourable conditions * and work on automatic machines. For operations demanding very tough carbide: turning, planing, slotting, low cutting speeds, large chip sections, with the possibility of large cutting angles for machining in unfavourable conditions * and work on automatic machines.	Increasing speed → ← Increasing feed → ←	Wear resistance ← → Toughness → ←	
			Steel, steel castings				
			Steel, steel castings Malleable cast iron with long chips				
			Steel, steel castings Malleable cast iron with long chips				
			Steel Steel castings with sand inclusion and cavities				
<i>M</i>	Ferrous metals with long or short chips and non-ferrous metals	<i>M 10</i> <i>M 20</i> <i>M 30</i> <i>M 40</i>	Steel, steel castings, manganese steel Grey cast iron, alloy cast iron	Turning, medium or high cutting speeds. Small or medium chip sections. Turning, milling. Medium cutting speeds and chip sections. Turning, milling, planing. Medium cutting speeds, medium or large chip sections. Turning, parting off, particularly on automatic machines.	Increasing speed → ← Increasing feed → ←	Wear resistance ← → Toughness → ←	
			Steel, steel castings, austenitic or manganese steel, grey cast iron				
			Steel, steel castings, austenitic steel, grey cast iron, high temperature resistant alloys				
			Mild free cutting steel, low tensile steel Non-ferrous metals and light alloys				
<i>K</i>	Ferrous metals with short chips, non-ferrous metals and non-metallic materials	<i>K 01</i> <i>K 10</i> <i>K 20</i> <i>K 30</i> <i>K 40</i>	Very hard grey cast iron, chilled castings of over 85 Shore, high silicon aluminium alloys, hardened steel, highly abrasive plastics, hard cardboard, ceramics	Turning, finish turning, boring, milling, scraping. Turning, milling, drilling, boring, broaching, scraping. Turning, milling, planing, boring, broaching, demanding very tough carbide. Turning, milling, planing, slotting, for machining in unfavourable conditions * and with the possibility of large cutting angles. Turning, milling, planing, slotting, for machining in unfavourable conditions * and with the possibility of large cutting angles.	Increasing speed → ← Increasing feed → ←	Wear resistance ← → Toughness → ←	
			Grey cast iron over 220 Brinell, malleable cast iron with short chips, hardened steel, silicon aluminium alloys, copper alloys, plastics, glass, hard rubber, hard cardboard, porcelain, stone.				
			Grey cast iron up to 220 Brinell, non-ferrous metals: copper, brass, aluminium				
			Low hardness grey cast iron, low tensile steel, compressed wood				
			Soft wood or hard wood Non-ferrous metals				

\* Raw material or components in shapes which are awkward to machine: casting or forging skins, variable hardness etc., variable depth of cut, interrupted cut, work subject to vibrations.