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**Cartridges, type A, for indexable  
inserts —**

**Part 8:  
Style S**

*Cartouches du type A, à plaquettes amovibles —*

*Partie 8: Forme S*



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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 (see [www.iso.org/directives](http://www.iso.org/directives)).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

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

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 9, *Tools with defined cutting edges, cutting items*.

This first edition of ISO 5611-8, together with ISO 5611-1, ISO 5611-2, ISO 5611-3, ISO 5611-4, ISO 5611-5, ISO 5611-6, ISO 5611-7, ISO 5611-9, ISO 5611-10, ISO 5611-11 and ISO 5611-12, cancels and replaces ISO 5611:1995, which has been technically revised.

ISO 5611 consists of the following parts, under the general title *Cartridges, type A, for indexable inserts*:

- *Part 1: General survey, correlation and determination of dimensions*
- *Part 2: Style F*
- *Part 3: Style G*
- *Part 4: Style J*
- *Part 5: Style K*
- *Part 6: Style L*
- *Part 7: Style R*
- *Part 8: Style S*
- *Part 9: Style T*
- *Part 10: Style U*
- *Part 11: Style W*
- *Part 12: Style Y*

# Cartridges, type A, for indexable inserts —

## Part 8: Style S

### 1 Scope

This part of ISO 5611 applies for cartridges type A, with hole(s) for fastening screw(s), of style S, i.e. with cutting edge angle  $\kappa_r = 45^\circ$  for end cutting.

Cartridges are intended to be used with indexable inserts made of hard metal, ceramic, or other cutting materials and are primarily mounted to be used for internal turning of 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 dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 1832, *Indexable inserts for cutting tools — Designation*

ISO 5608, *Turning and copying tool holders and cartridges for indexable inserts — Designation*

ISO 5611-1, *Cartridges, type A, for indexable inserts — Part 1: General survey, correlation and determination of dimensions*

### 3 Dimensions

Cartridges type A need not comply with the pictorial representation, only the dimensions given shall be observed.

For determination of dimensions  $h_1$ ,  $f$ , and  $l_1$ , see ISO 5611-1. For explanation of the designation code for cartridges, see ISO 5608.

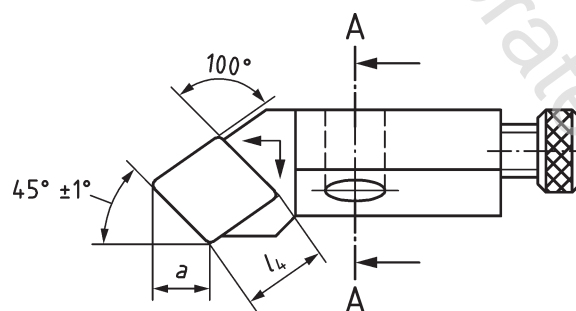


Figure 1 — Style S with height  $h_1 = 6$  mm and 8 mm with rhombic indexable insert