
International Standard



7755/1

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

**Hardmetal burrs —
Part 1: General specifications**

Fraises-limes en métaux-durs — Partie 1: Spécifications générales

First edition — 1984-12-15

UDC 621.951

Ref. No. ISO 7755/1-1984 (E)

Descriptors: tools, cutting tools, hard metals, burrs (milling cutters), classification, specifications, dimensions, designation.

Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 7755/1 was prepared by Technical Committee ISO/TC 29, *Small tools*.

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Hardmetal burrs — Part 1: General specifications

1 Scope and field of application

This part of ISO 7755 lays down the common characteristics of hardmetal burrs of various styles, in solid construction or with brazed shank.

The main dimensions of the cutting part of hardmetal burrs are dealt with individually in ISO 7755 parts 2 to 12.

2 References

ISO 7755/2, *Hardmetal burrs — Part 2: Cylindrical burrs (style A)*.

ISO 7755/3, *Hardmetal burrs — Part 3: Cylindrical round-(ball-) nose burrs (style C)*.

ISO 7755/4, *Hardmetal burrs — Part 4: Spherical burrs (style D)*.

ISO 7755/5, *Hardmetal burrs — Part 5: Oval burrs (style E)*.

ISO 7755/6, *Hardmetal burrs — Part 6: Arch round- (ball-) nose burrs (style F)*.

ISO 7755/7, *Hardmetal burrs — Part 7: Arch pointed-nose burrs (style G)*.

ISO 7755/8, *Hardmetal burrs — Part 8: Flame burrs (style H)*.

ISO 7755/9, *Hardmetal burrs — Part 9: 60° cone and 90° cone burrs (styles J and K)*.

ISO 7755/10, *Hardmetal burrs — Part 10: Conical round- (ball-) nose burrs (style L)*.

ISO 7755/11, *Hardmetal burrs — Part 11: Conical pointed-nose burrs (style M)*.

ISO 7755/12, *Hardmetal burrs — Part 12: Inverted cone burrs (style N)*.

3 Dimensions

3.1 Cutting diameter

Table 1 gives the series of cutting diameters and their related tolerances.

Table 1

Dimensions in millimetres

Cutting diameter	Tolerances*
2	$\pm 0,1$ ($\pm 0,2$)
3	$\pm 0,2$ ($\pm 0,5$)
4	
6	
8	
10	$\pm 0,3$ ($\pm 0,7$)
12	
16	

* Tolerances given in parentheses apply for a transitional period only, after which the values without parentheses should be adopted.

3.2 Cylindrical shank

Shank diameter 3 mm and 6 mm¹⁾, with tolerance h9. Shank length according to table 2. The shank length is defined as the length of the burr minus the length of the cutting part as given in ISO 7755 parts 2 to 12.

NOTE — These length ranges permit manufacture both of burrs with constant overall length and variable shank length, and of burrs with constant shank length and variable overall length. In the latter case, national standards should indicate the agreed shank length, which shall be within the limits given in table 2.

Table 2

Dimensions in millimetres

Shank diameter*	Shank length
3	20 to 35
6	25 to 50

* The values 3, 15 and 6,3 mm are acceptable for a transitional period.

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