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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 15306.2-2008

Replacing GB/T 15306.2-1994

**Indexable inserts for cutting tools -- Ceramic inserts with
rounded corners -- Part 2: Dimensions of inserts with
cylindrical fixing hole**

陶瓷可转位刀片 第2部分：带孔刀片尺寸
(English Translation)

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Foreword

GB/T 15306 "Ceramic indexable insert" is divided into four parts.

- Part 1. nonporous blade size (class G);
- Part 2. perforated blade size;
- Part 3. nonporous blade size (U level);
- Part 4. Technical specifications.

This section GB/T Part of 215,306.

The partial modification of the use of ISO 9361-2. PART 21991 "cutting tools with indexable tip rounded ceramic indexable insert Score. with cylindrical fixing hole blade size "(in English).

This section according to ISO 9361-2:1991 redrafted.

This part of ISO 9361-2:1991 compared to modify the following technical differences and editorial.

- "This International Standard" be replaced by "this section";
- With a decimal point instead of a comma as the decimal point, "";
- Deleted international standards foreword;
- Increase the marked examples and technical conditions.

This part is GB/T 15306.2-1994 "ceramic indexable inserts with hole size" amendment.

This Part replaces GB/T 15306.2-1994.

Section compared with the GB/T 15306.2-1994 The main changes are as follows.

- Canceled a standard 6.1 text. You can also choose K, P-type;

--- Modify the cutting edge cross-sectional shape of the symbol S, K (formerly standard 6.2 Figure 1 cutting edge cross-sectional shape symbol S is amended as K, the symbol K Modify S);

--- Increasing the cross-sectional shape of the cutting edge symbol K (the original standard 6.2 Figure 2);

--- Cancel the circular blade size Note the value of the symbol m1 (formerly standard 9.5 Table 7);

--- Modify the markup example (the original standard markup example in Chapter 10 grades modify material code);

--- Modify the name of measuring instruments Appendix A (Appendix A of the original block gauge modify the amount of blocks, dial gauge modify instruction sheet).

This part of the Annex A, Annex B and Annex C is informative appendix.

This part is proposed by China Machinery Industry Federation.

National Standardization Technical Committee of the tool part (SAC/TC91) centralized.

This section is drafted. Chengdu Tool Institute.

1 Scope

GB/T 15306 provisions of this part of the rounded tip with cylindrical fixing hole method backward angle is 0° , made of ceramic cutting materials Indexable insert size. The main blade and the hole from the top, or just through the hole in the clamp and turning Boring Bars.

This section applies to all kinds of perforated ceramic cutting material indexable inserts.

Ceramic cutting material consists of a variety of oxides, nitrides and carbides and metal components. For example, such ceramic materials are. Oxidation Ceramic material (composed mainly of aluminum oxide Al_2O_3) oxide - carbide ceramics (mainly composed of other materials such as alumina and titanium carbide TiC group A), nitride ceramics (typically made of silicon nitride Si_3N_4 , and other materials such as aluminum oxide and yttrium oxide Y_2O_3).

2 Normative references

The following documents contain provisions which, through reference GB/T 15306 in this section constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest

versions apply to this section.

GB/T 2075 Classification and use of cutting large groups and groups of application of hard cutting materials classification code (GB/T 2075-2007, ISO 513:2004, IDT) GB/T 2076 Rules of cutting tools represented by indexable insert size (GB/T 2076-2007, ISO 1832:2004, MOD) GB/T 15306.4 Ceramic indexable inserts - Part 4. Technical conditions

3 Blade type

Ceramic indexable inserts of the type specified in this standard are as follows.

TN. Law backward blade angle of 0° of the equilateral triangle;

SN. Act backward square blade angle of 0° ;

CN. France back angle is 0° and 80° nose angle of the diamond blade;

DN. France back angle is 0° and 55° nose angle of the diamond blade;

RN. circular blade method backward angle of 0° .

This Part of the blade without chip breaker.

Usually you should use ceramic inserts with a chamfer or rounding the cutting edge of the cutting edge, see Chapter 6.

Appendix C in Table C. 1 shows the insert size range.

4 Tolerance

This section provides a ceramic indexable insert G and M grade level accuracy available under GB/T 2076 regulations.

According to GB/T 2076 predetermined allowable deviation values are listed in Appendix A, Table A. 1, other tolerances are shown in Tables 3 to 7.