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NATIONAL STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

GB/T 6119-2012

Replacing GB/T 6119.1-1996; GB/T 6119.2-1996

Side and face milling cutter

三面刃铣刀

(English Translation)

Issued on: March 9, 2012 **Implemented on: July 1, 2012**

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Foreword

This standard is drafted in accordance with the rules given in GB/T 1.1-2009.

This standard is used instead of GB/T 6119.1-1996 "Three-blade cutter type and size" and GB/T 6119.2-1996 " Knife technical conditions ".

The main changes in this standard compared with GB/T 6119.1 and GB/T 6119.2 are as follows.

- merge the two parts of the original standard into one standard;

--- canceled the GB/T 6119.2-1996 in the "Chapter 6 performance test";

- Amend the original standard "Appendix A (Reference)" to "Appendix A (Normative Appendix)".

This standard uses the re-drafting method to modify the use of ISO 2587. 1972 "with straight hole and plain key transmission of the three-edge cutter milling system" (English version).

This standard has the following editorial changes and technical differences as compared with ISO 2587. 1972, and the terms involved in these differences have been the vertical single line (-) of the position on the outside margin is marked.

- the word "international standard" is changed to "this standard";

--- replace the comma as a decimal point with a decimal point. " - the preamble of the international standard was removed;

--- modified the normative reference file;

--- modified the Chinese standard name of the international standard;

--- canceled the original "international standard Article 1 of the scope of the outer diameter series from the ISO 523 cutter outside the recommended series" the original ISO 523 standard is now void;

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--- Added "4.2 mark example";

--- increased the "location tolerance, appearance and surface roughness, materials and hardness, marking and packaging" and other technical requirements of the project;

--- Added "Appendix A (normative appendage) three-edge cutter round beating detection method".

This standard is proposed by the China Machinery Industry Federation.

This standard is under the jurisdiction of the National Tool Standardization Technical Committee (SAC/TC91).

This standard is responsible for the drafting unit. Wenling Wenxi Engineering Cutting Tool Technology Service Center Co., Ltd., Chengdu Tools Research Institute Co., Ltd.

1 Scope

This standard specifies the type and size of the straight and misaligned three-blade cutter, position tolerance, appearance and surface roughness, material and hardness.

Chi and packaging and other basic requirements.

This standard applies to the diameter of 50mm ~.200mm straight and wrong teeth three blade cutter.

2 Normative reference documents

The following documents are indispensable for the application of this document. For dated references, only the dated edition applies to this article Pieces. For undated references, the latest edition (including all modifications) applies to this document.

GB/T 6132 Interchangeable dimensions of milling cutter and milling cutter (GB/T 6132-2006, ISO 240.:1994, IDT)

3 Symbols

d - three blade cutter outer diameter;

D - three edge cutter hole diameter;

d1 --- three side cutter diameter;

L --- three blade cutter thickness.

4 Type and size

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4.1

The type and size of the three-edge cutter are specified in Figures 1, 2 and 1. Keyway size according to GB/T 6132 requirements.

Figure 1 straight tooth three blade cutter Figure 2 wrong teeth three blade cutter

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