

ICS 25.100.20

CCS J 41



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

GB/T 6122-2017

Corner-rounding cutters

Issued on: December 29, 2017

Implemented on: July 1, 2018

**Issued by: General Administration of Quality Supervision, Inspection and
Quarantine of the People's Republic of China, Standardization
Administration of the People's Republic of China**

Table of Contents

Foreword

1 Scope

2 Normative references

3 type and size

Foreword

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

This standard replaces GB/T 6122.1-2002 "Fillet cutter Part 1. Type and size" and GB/T 6122.2-2002 "fillet

Milling cutter Part 2. Technical conditions ". This standard compared with GB/T 6122.1-2002, GB/T 6122.2-2002, in addition to editorial changes

The main technical changes are as follows.

- The front surface roughness of the upper limit by Rz6.3 revised Ra0.8;
- Inner surface roughness of the upper limit Ra1.6 revised Ra0.8;
- Table 3 in .5 μm ≤ 12.5 , $12\mu\text{m} \leq 20$; $12.5\mu\text{m} \leq 20$;
- Increased high-performance high-speed steel materials and hardness requirements;
- Added Appendix A in Figure A.1 test equipment labeling instructions.

This standard uses the redrafted law to amend the use of ISO 3860.2011 "flat key drive straight hole milling cutter with a fixed profile milling

Knife".

This standard compared with ISO 3860.2011 in the structure there are more adjustments.

- Removed the international standards 3.1, 3.2, 3.3, only the contents of 3.4, corresponding to this standard 3.1;
- Added 3.2, Chapter 4, Chapter 5.

This standard and ISO 3860.2011 technical differences and the reasons are as follows.

- On normative references, this standard made a technical difference with the adjustment to adapt to China's technical conditions, adjust the situation

Concentration reflected in Chapter 2 "Normative references", the specific adjustments are

as follows.

* Replaced ISO 240 with GB/T 6132 modified to adopt international standards.

--- Deleted the international standards of other types of cutter size requirements.

--- Increased thickness of the tolerance e.

--- Added a tag example, technical requirements, logo packaging.

This standard made the following editorial changes.

--- Change the standard name;

--- According to domestic facts, figures and symbols made a small amount of editorial changes;

--- Added information appendix A.

This standard is proposed by the China Machinery Industry Federation.

This standard by the National Standardization Technical Committee Tool (SAC/TC91) centralized.

This standard was drafted unit. Taizhou Zhejiang Institute of Tool and Tool Testing and Deep Processing Technology Research Key Laboratory, Chengdu Tool Research Institute Limited, Wenling Heavenly Creations cutting tool technology service center Limited.

1 Scope

This standard specifies the type and size of fillet cutter, technical requirements, signs and packaging.

This standard applies to the processing of fillet radius of 1mm ~ 20mm fillet cutter.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version applies to this article

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

GB/T 6132 cutter and milling cutter shank interchangeable size (GB/T 6132-2006, ISO 240.1994, MOD)

3 type and size

3.1 Rounded milling cutter type shown in Figure 1, the size given by Table 1. The size of the key slot according to the provisions of GB/T 6132.

figure 1

chinastandards.org · PREVIEW