

Insert ISO Designation

Metric

A

1

P

2

F

3

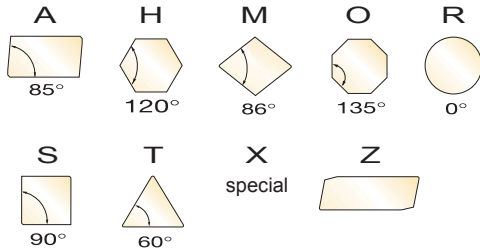
W

4

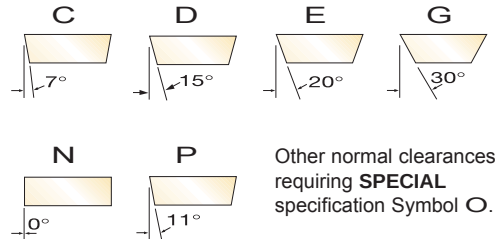
16

5

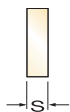
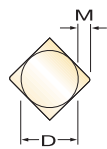
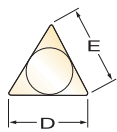
1 Shape



2 Clearance



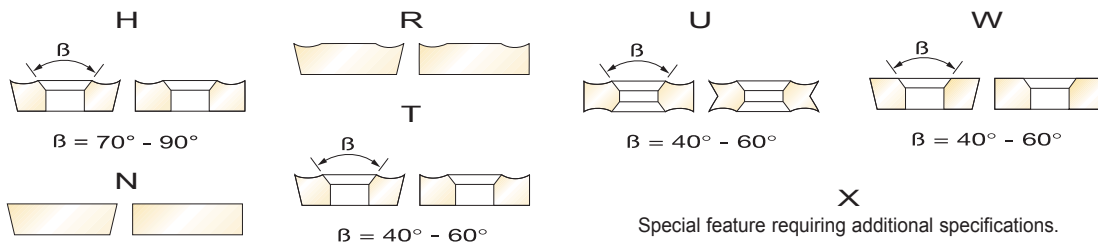
3 Tolerance



Class		D	M	S
A⁽¹⁾	mm	±0,025	±0,005	±0,025
C⁽¹⁾	mm	±0,025	±0,013	±0,025
E⁽¹⁾	mm	±0,025	±0,025	±0,025
F⁽¹⁾	mm	±0,013	±0,005	±0,025
G	mm	±0,025	±0,025	±0,130
H⁽¹⁾	mm	±0,013	±0,013	±0,025
J⁽¹⁾	mm	from ±0,050 to ±0,150	±0,005	±0,025
K⁽¹⁾	mm	from ±0,050 to ±0,150	±0,013	±0,025
L⁽¹⁾	mm	from ±0,050 to ±0,150	±0,025	±0,025
M	mm	from ±0,050 to ±0,150	from ±0,080 to ±0,200	±0,13
N	mm	from ±0,050 to ±0,150	from ±0,080 to ±0,200	±0,025
U	mm	from ±0,080 to ±0,250	from ±0,130 to ±0,380	±0,13

(1) Indexable inserts with ground wiper edges. (2) Dependent upon the insert size (see ISO 1832 standard)

4 Type



04

6

PD

7

T

8

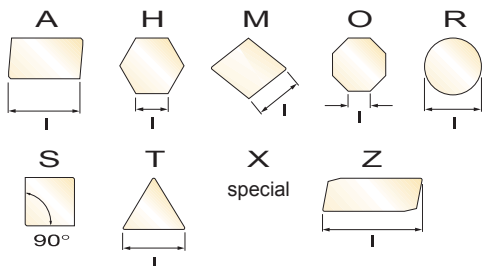
R

9

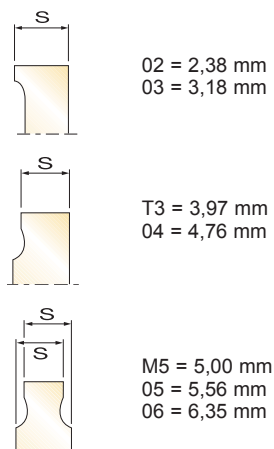
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10

5 Size



6 Thickness



7 Corner



Rounded Corner Inserts

Value of corner radius given in 1/10 mm

Note: For sharp corner
Symbol = 00

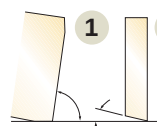


Rounded Inserts

Symbol = 00
If the Ø is converted from an inch value.

Symbol = M0
If the Ø is converted from a metric value.

7 Corner continued



Inserts With Wiper Edges.

Two Letter Symbol:

1 For cutting edge angle χ_r

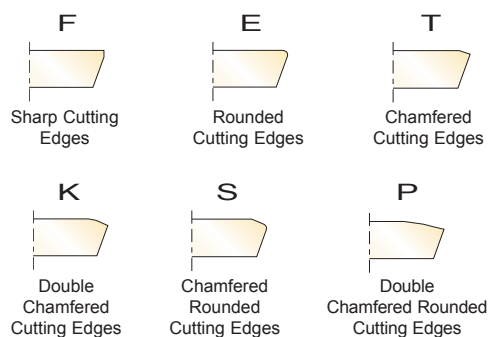
A = 45°
D = 60°
E = 75°
F = 85°
P = 90°

2 For wiper edge normal clearance

A = 3°
B = 5°
C = 7°
D = 15°
E = 20°
F = 25°
G = 30°
N = 0°
P = 11°

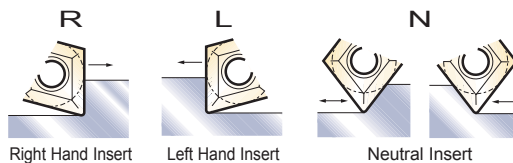
Z = Any other wiper edge clearance.

8 Edge Condition



OPTIONAL SYMBOL

9 Cutting Direction



OPTIONAL SYMBOL

10 Optional

Manufacturers optional symbol consisting of numbers or letters; shall be separated from the standardized designation by a dash (-).

OPTIONAL SYMBOL