



Technical Data

Milling & Turning Insert Identification

A	B	C
D	E	F
G	H	I
2 Relief angle		

tolerances						
IC: theoretical diameter of the insert inscribed circle T: thickness B: see figure below						
tolerance class	tolerance on "IC"		tolerance on "B"		tolerance on "T"	
	in	mm	in	mm	in	mm
C	±0.010	±0.025	±0.0005	±0.013	±0.001	±0.025
H	±0.005	±0.013	±0.0005	±0.013	±0.001	±0.025
E	±0.010	±0.025	±0.0010	±0.025	±0.001	±0.025
G	±0.010	±0.025	±0.0010	±0.025	±0.005	±0.13
M	see tables at right		see tables at right		±0.005	±0.13
U	see tables at right		see tables at right		±0.005	±0.13
3 tolerance						

H	O	P	R	S
T	C	D	E	M
V	L	A	B	K
1 Shape				

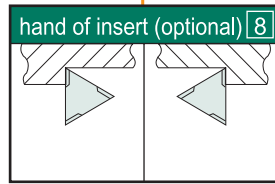
N		T	
R		Q	
F		U	
A		B	
M		H	
G		C	
W		J	
4 Insert type			

inch	C	N	M	G	—	4	3	2			
(metric)	C	N	M	G		12	04	08			
position	1	2	3	4		5	6	7	8	9	10

5 Size										
inch	IC		metric cutting edge length							
	in	mm	C	D	R	S	T	V	W	
1.2 (5)	5/22	3.97	-	04	03	03	06	-	-	-
1.5 (6)	3/16	4.76	04	05	04	04	08	08	-	-
1.8 (7)	7/22	5.56	05	06	05	05	09	09	03	-
-	0.236	6.00	-	-	06	-	-	-	-	-
2	1/4	6.35	06	07	06	06	11	11	04	-
2.5	5/16	7.94	08	09	07	07	13	13	05	-
-	0.315	8.00	-	-	08	-	-	-	-	-
3	3/8	9.52	09	11	09	09	16	16	06	-
-	0.394	10.00	-	-	10	-	-	-	-	-
3.5	1/16	11.11	11	13	11	11	19	19	07	-
-	0.472	12.00	-	-	12	-	-	-	-	-
4	1/2	12.70	12	15	12	12	22	22	08	-
4.5	9/16	14.29	14	17	14	14	24	24	09	-
5	5/8	15.88	16	19	15	15	27	27	10	-
-	0.630	16.00	-	-	16	-	-	-	-	-
5.5	11/16	17.46	17	21	17	17	30	30	11	-
6	3/4	19.05	19	23	19	19	33	33	13	-
-	0.787	20.00	-	-	20	-	-	-	-	-
7	7/8	22.22	22	27	22	22	38	38	15	-
-	0.984	25.00	-	-	25	-	3	-	-	-
8	1	25.40	25	31	25	25	44	44	17	-
10	1-1/4	31.75	32	38	31	31	54	54	21	-
-	1.260	32.00	-	-	32	-	-	-	-	-

6 thickness			
thickness		symbol	
in	mm	inch	metric
1/32	0.79	0.5(1)	-
1/16	1.59	1(2)	01
5/64	1.98	1.2	T1
3/32	2.38	1.5(3)	02
1/8	3.18	2	03
5/22	3.97	2.5	T3
3/16	4.76	3	04
7/32	5.56	3.5	05
1/4	6.35	4	06
5/16	7.94	5	07
3/8	9.52	6	09
7/16	11.11	7	11
1/2	12.70	8	12

NOTE: Inch sizes in parenthesis for "Alternate sizes" D or E (under 1/4 inch IC.)



7 corner radius			
corner radius		symbol	
in	mm	inch	metric
.004	0.1	0	01
.008	0.2	0.5	02
1/64	0.4	1	04
1/32	0.8	2	08
3/64	1.2	3	12
1/16	1.6	4	16
5/64	2.0	5	20
3/32	2.4	6	24
7/64	2.8	7	28
1/8	3.2	8	32
round insert (inch)	-	-	00
round insert (metric)	-	-	M0

9 & 10	
cutting edge condition or chip control features (optional)	
T	- negative land
K	- light feed chip control. double sided Kenloc insert
M	- heavy feed chip control. deep floor Kenloc
N	- narrow land Kenloc insert with chip control on one side
W	- heavy-duty chip control. wide land Kenloc insert one side
J	- polished to 4-microinch A4 (rake face only)
UF	- ultra-fine finishing. See Technical Section for additional conditions and chip control features

NOTE: Inch sizes in parenthesis for "alternate sizes" D or E (under 1/4 inch IC.)