

GEOMETRY					
A		B		C	
D		E		K	
L		M		R	
S		T		V	
W					

SHAPE	
A	
N	
T	
W	
R	

THICKNESS	
01	s=1,59
T1	s=1,97
02	s=2,38
03	s=3,18
T3	s=3,97
04	s=4,76
05	s=5,56
06	s=6,35
07	s=7,94
09	s=9,52

RADIUS	
00	r=0,0
01	r=0,1
03	r=0,3
02	r=0,2
04	r=0,4
08	r=0,8
10	r=1,0
12	r=1,2

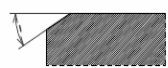
C C M T 06 02

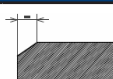
CLEARENCE ANGLE	
N	
B	
C	
P	
O	SPECIFIC DESCRIPTION

TOLERANCE CLASS					
CATEGORY	INSCRIBED CIRCLE	d	m	s	r
H		± 0,013	± 0,013	± 0,025	± 0,02
G		± 0,025	± 0,025	± 0,130	± 0,03
K	3,970	± 0,050			
	5,560				
	6,350	± 0,050			
	9,525				
	12,700	± 0,080			
	15,875	± 0,100			
	19,050				
M	3,970				
	5,560	± 0,050	± 0,050		
	6,350				
	9,525				
	12,700	± 0,080	± 0,080		
	15,875	± 0,100	± 0,150		
	19,050				
U	3,970				
	5,560	± 0,080	± 0,080		
	6,350				
	9,525				
	12,700	± 0,130	± 0,013		
	15,875	± 0,180	± 0,180		
	19,050				

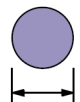
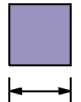
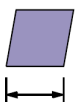
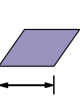
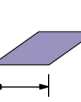
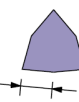
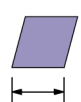
INSERT TYPE		
-	STANDARD	
R	RIGHT	
L	LEFT	
E	ECO	
D	2 EDGES	
F	2 ECO EDGES	
H	FULL TOP	
S	SOLID	

FINISH		
--	STANDARD	
FI	CHIP BREAKER FINISHING	
RO	CHIP BREAKER ROUGHING	
WL	WIPER LH	
WR	WIPER RH	

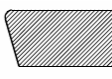
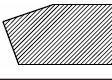
CHAMFER ANGLE		
		
A	=	05°
B	=	10°
C	=	15°
D	=	20°
E	=	25°
F	=	30°

CHAMFER THICKNESS		
		
A	=	0,05mm
B	=	0,10 mm
C	=	0,15 mm
D	=	0,20 mm
E	=	0,25 mm
F	=	0,30 mm
G	=	0,40 mm

04 R FI PA F - A - A

INSERT DIMENSION								
								
D (mm)	R	S	T	C	D	V	W	E
3,970		03	06	03	04	07	02	
4,760			08	04				04
5,000	05...M0							
5,560	05...00	05	09	05	06		03	05
6,000	06...M0							
6,350	06...00	06	11	06	07	11	04	06
7,940		07	13	08	09	13	05	
7,970								08
8,000	08...M0							
9,000	09...M0							
9,525	09...00	09	16	09	11	16	06	09
10,000	10...M0							
12,000	12...M0							
12,700	12...00	12	22	12	15	22	08	
15,875	15...00	15	27	16	19		10	
16,000	16...M0							
19,050	19...M0	19	33	19				

MATERIAL *	
PCD GRAIN	
PB	MIXED
PA	MEDIUM
PJ	FINE

EDGE PREPARATION**	
F	
E	
T	

***MATERIAL**
PCD

PJ: very fine grain used for special finishes;
PA: medium grain, good compromise used for most applications;
PB: coarse grain for high resistance to wear.

****PREPARATION**

F- standard PCD preparation commonly used for aluminum and other non-ferrous materials.
E-brushed: protect the cutting edge from breakages and chipping. Advantages are especially visible in case of finishes with tight tolerance and low feeds.
T-chamfer: increases the cutting edge stability but also the cutting forces.