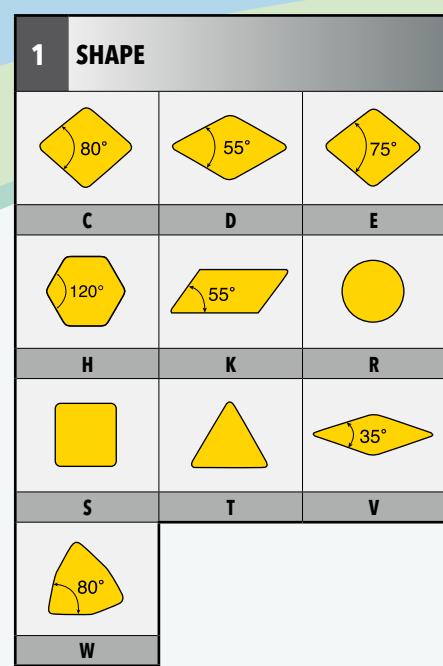


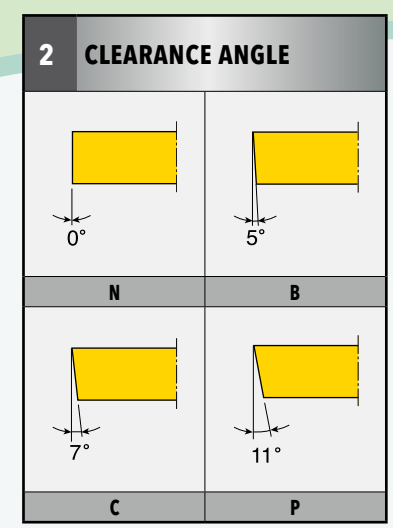
# TURNING INSERT NOMENCLATURE

### 1 SHAPE



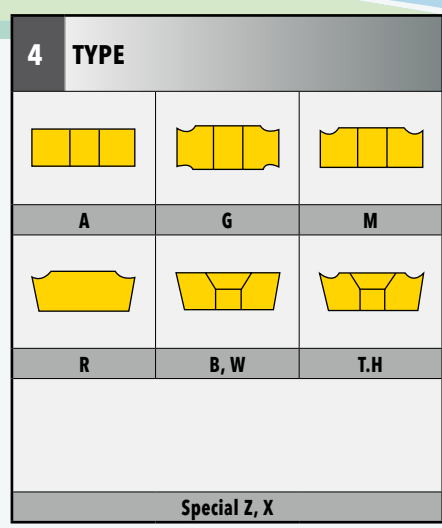
**C** **D** **E**  
**H** **K** **R**  
**S** **T** **V**  
**W**

### 2 CLEARANCE ANGLE



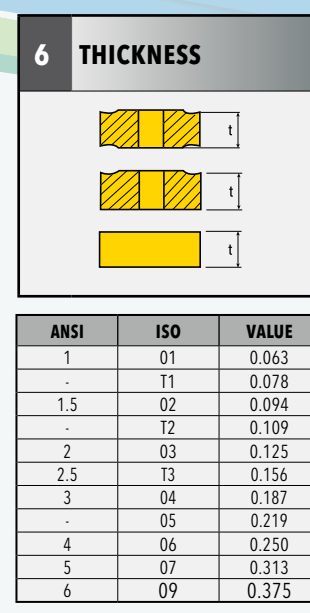
**N** **B**  
**C** **P**

### 4 TYPE



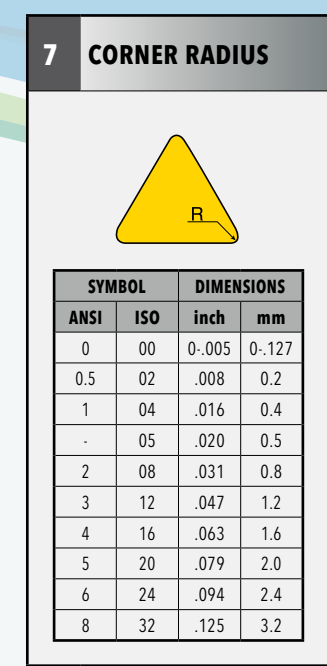
**A** **G** **M**  
**R** **B, W** **T, H**  
 Special Z, X

### 6 THICKNESS



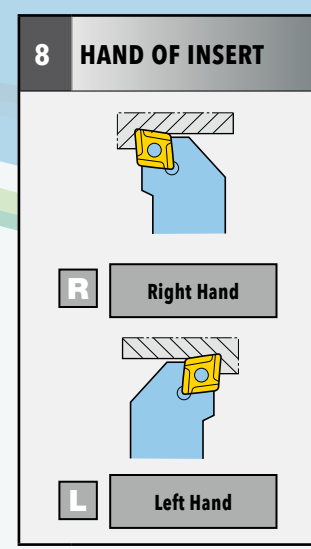
ANSI	ISO	VALUE
1	01	0.063
-	T1	0.078
1.5	02	0.094
-	T2	0.109
2	03	0.125
2.5	T3	0.156
3	04	0.187
-	05	0.219
4	06	0.250
5	07	0.313
6	09	0.375

### 7 CORNER RADIUS



SYMBOL		DIMENSIONS	
ANSI	ISO	inch	mm
0	00	0-.005	0-.127
0.5	02	.008	0.2
1	04	.016	0.4
-	05	.020	0.5
2	08	.031	0.8
3	12	.047	1.2
4	16	.063	1.6
5	20	.079	2.0
6	24	.094	2.4
8	32	.125	3.2

### 8 HAND OF INSERT



**R** Right Hand  
**L** Left Hand

### 9 CHIPBREAKER DESIGNATION\*

FF	Super finishing	P, M, S
FA	Super finishing	P
EA	Super finishing	M, S
FGS	Super finishing	S
FLP	Finishing	P
FS	Finishing	P
FG	Finishing	P
SL	Finishing	P, M, S
SA	Finishing	P, M, S
SM	Finishing	P, M, S
SH	Finishing	P, M, S
FX	Finishing	P
FC	Finishing	P, M
FM	Medium	P
MLP	Medium	P
MC	Medium	P
FT	Medium	P
GF	Medium	P, M, S

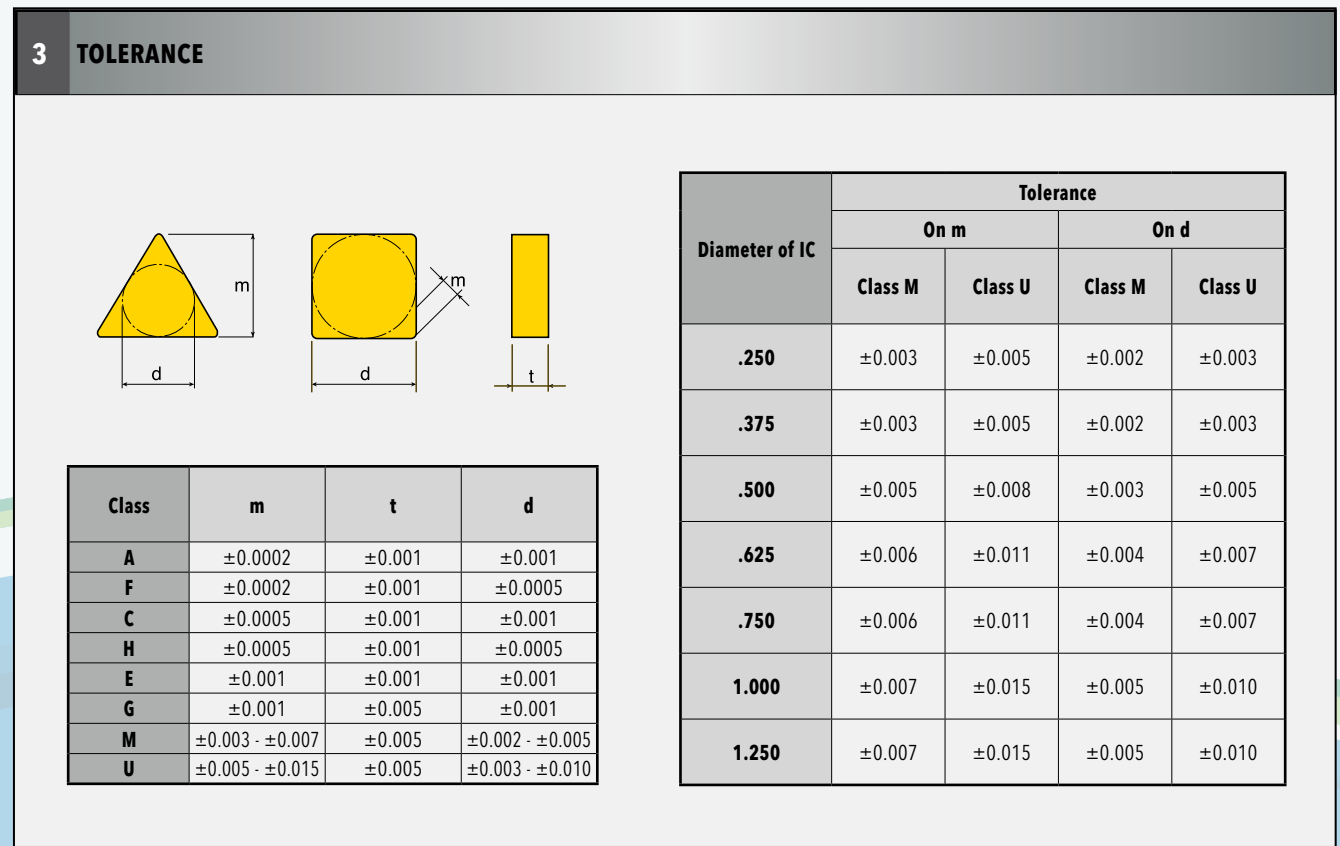
### 9 CHIPBREAKER DESIGNATION

FL	Medium	N
VF	Medium	P, M
MGS	Medium	S
ML	Medium	P, M, S
MP	Medium	M, S
MM	Medium	P, M
MGP	Medium	P
PC	Medium	P
MT	Medium	P, M, K
ET	Roughing	M, S
RGP	Roughing	P
RT	Roughing	P, M, K
KT	Roughing	K
RX	Roughing	P
WA	Wiper finishing	P, K
WS	Wiper finishing	P, M, K
GW	Wiper medium	P, M, S
WT	Wiper medium	P, M, K, S

**C** **N** **M** **G**      ANSI **4** **3** **2**      **(R)** **MP**  
 1      2      3      4      5      6      7      8      9

\*P-Steel, M-Stainless Steel, K-Cast Iron, S-High Temp Alloys, N-Non-Ferrous

### 3 TOLERANCE



Class	m	t	Tolerance	
			Diameter of IC	
			On m	On d
	Class M	Class U	Class M	Class U
<b>A</b>	±0.0002	±0.001	±0.001	
<b>F</b>	±0.0002	±0.001	±0.0005	
<b>C</b>	±0.0005	±0.001	±0.001	
<b>H</b>	±0.0005	±0.001	±0.0005	
<b>E</b>	±0.001	±0.001	±0.001	
<b>G</b>	±0.001	±0.005	±0.001	
<b>M</b>	±0.003 - ±0.007	±0.005	±0.002 - ±0.005	
<b>U</b>	±0.005 - ±0.015	±0.005	±0.003 - ±0.010	

Diameter of IC	Tolerance			
	On m		On d	
	Class M	Class U	Class M	Class U
<b>.250</b>	±0.003	±0.005	±0.002	±0.003
<b>.375</b>	±0.003	±0.005	±0.002	±0.003
<b>.500</b>	±0.005	±0.008	±0.003	±0.005
<b>.625</b>	±0.006	±0.011	±0.004	±0.007
<b>.750</b>	±0.006	±0.011	±0.004	±0.007
<b>1.000</b>	±0.007	±0.015	±0.005	±0.010
<b>1.250</b>	±0.007	±0.015	±0.005	±0.010

### 5 CUTTING EDGE LENGTH

I.C.				C	D	E	R	S	T	V	W	K	H
ANSI SYMBOL	ISO SYMBOL	inch	mm										
1.2 (5)*		0.156	3.97	03	04			03	06		02		
1.5 (6)*		0.188	4.76	04	05			04	08	08			
1.8 (7)*		0.219	5.56	05				05	09	09	03		
2		0.250	6.35	06	07			06	11	11	04		
2.5		0.313	7.94	08	09			07	13	13	05		
			8.00				08						
3		0.375	9.52	09	11			09	16	16	06	16	
			10.00				10						
			12.00				12						
4		0.500	12.70	12	15	13		12	22	22	08		05
5		0.625	15.88	16	19		15	15	27	27	10		
			16.00				16						
6		0.750	19.05	19	23		19	19	33	33	13		10
			20.00				20						
			25.00				25						
8		1.000	25.40	25	31		25	25	44	44	17		
10		1.250	31.75	32	38		31	31	54	54	21		
			32.00				32						

\*As measured in 1/32" increments