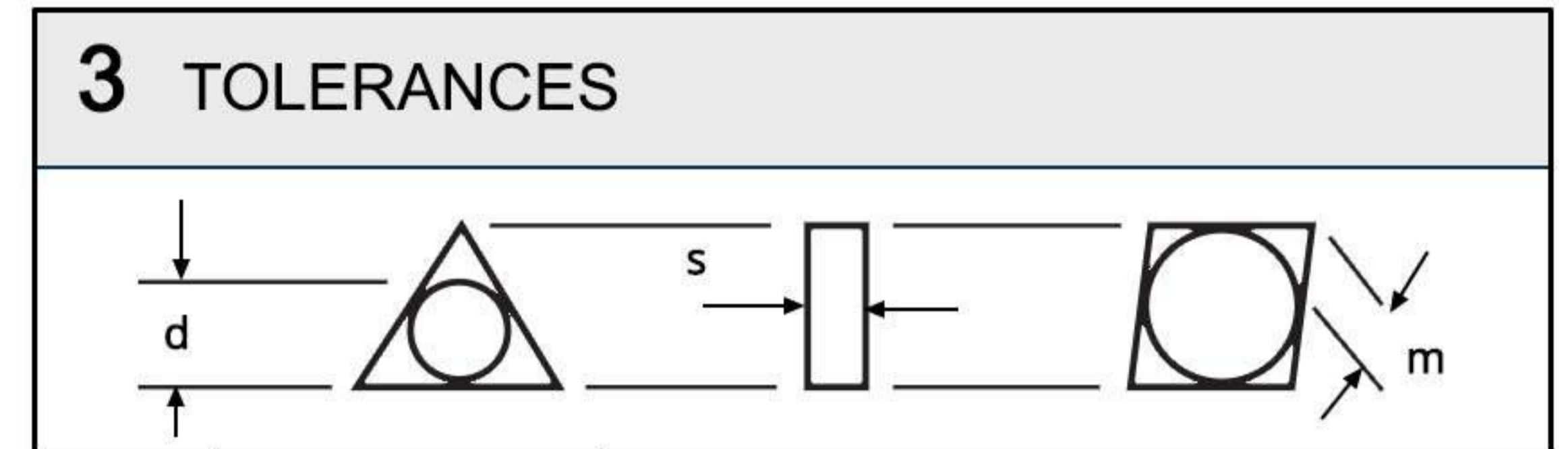


1 INSERT SHAPE

C		E	
R		S	
T		W	

2 CLEARANCE ANGLE

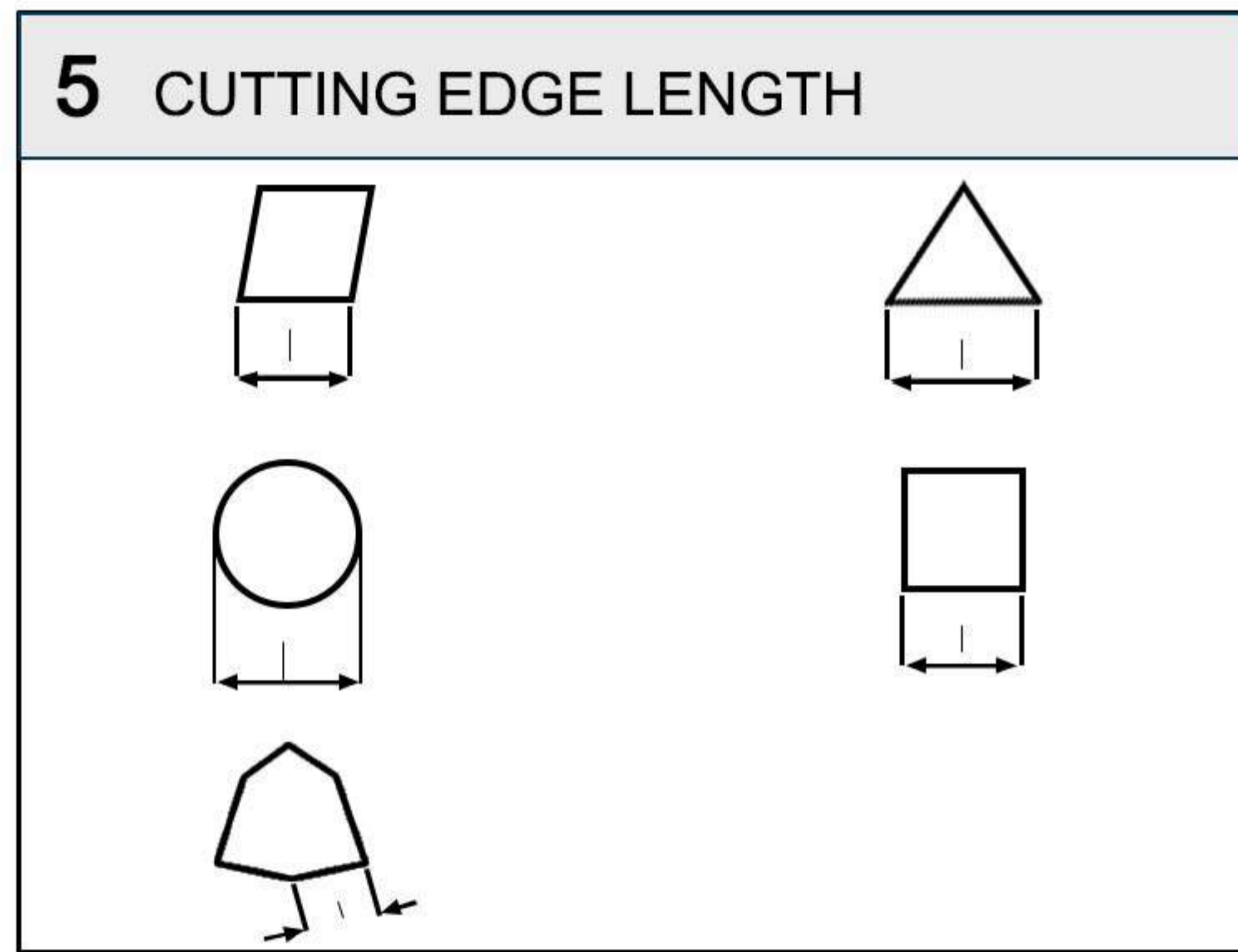
B		C	
D		E	
N		P	



Tolc'e class	For insert I.C.	Tolerance mm/inch		
		d ±	s ±	m ±
A	all	0,025 .001	0,025 .001	0,005 .0002
C	all	0,025 .001	0,025 .001	0,013 .005
E	all	0,025 .001	0,025 .001	0,025 .001
G	all	0,025 .001	0,13 .005	0,025 .001
H	all	0,013 .0005	0,025 .001	0,013 .0005
J	3,97 - 10,0 .156 - .394	0,05 .002	0,025 .001	0,005 .0002
	12,0 - 12,7 .472 - .500	0,08 .0032	0,025 .001	0,005 .0002
	15,875 - 20,0 .625 - .787	0,10 .004	0,025 .001	0,005 .0002
	25,0 - 25,4 .984 - 1,000	0,13 .005	0,025 .001	0,005 .0002
K	3,97 - 10,0 .156 - .394	0,05 .002	0,025 .001	0,013 .0005
	12,0 - 12,7 .472 - .500	0,08 .0032	0,025 .001	0,013 .0005
	15,875 - 20,0 .625 - .787	0,10 .004	0,025 .001	0,013 .0005
	25,0 - 25,4 .984 - 1,000	0,13 .005	0,025 .001	0,013 .0005
M	3,97 - 10,0 .156 - .394	0,05 .002	0,13 .005	0,08 .0032
	12,0 - 12,7 .472 - .500	0,08 .0032	0,13 .005	0,13 .005
	15,875 - 20,0 .625 - .787	0,10 .004	0,13 .005	0,15 .006
	25,0 - 25,4 .984 - 1,000	0,13 .005	0,13 .005	0,18 .007
U	3,97 - 10,0 .156 - .394	0,08 .0032	0,13 .005	0,13 .005
	12,0 - 12,7 .472 - .500	0,13 .005	0,13 .005	0,20 .008
	15,875 - 20,0 .625 - .787	0,18 .007	0,13 .005	0,27 .011
	25,0 - 25,4 .984 - 1,000	0,25 .010	0,13 .005	0,38 .015

4 INSERT TYPE

A		G	
M		N	
R		T	
W		X	SPECIAL DESIGN

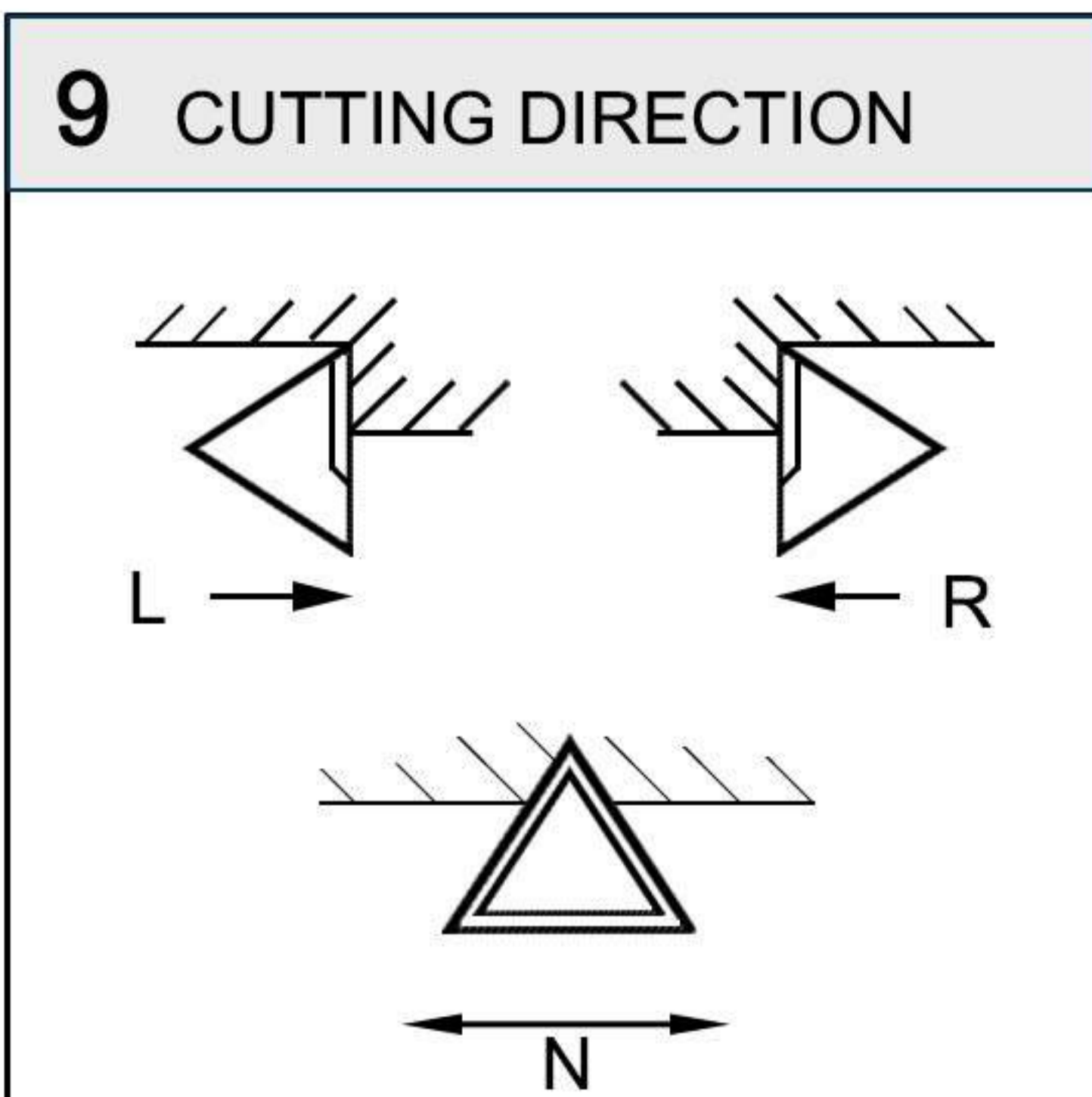


7 INSERT NOSE RADIUS

00 = 0
 01 = 0,1 = .004"
 02 = 0,2 = .008"
 04 = 0,4 = .016"
 08 = 0,8 = .031"
 12 = 1,2 = .047"
 16 = 1,6 = .063"
 24 = 2,4 = .095"
 32 = 3,2 = .125"
 NOTE -- ROUND INSERTS
 00 IF d = inches
 M0 IF d = m.m.

6 INSERT THICKNESS

01	= 1,5	= 1/16"
T1	= 1,98	= 5/64"
02	= 2,38	= 3/32"
03	= 3,18	= 1/8"
T3	= 3,97	= 5/32"
04	= 4,76	= 3/16"
05	= 5,56	= 7/32"
06	= 6,35	= 1/4"
07	= 7,94	= 5/16"
09	= 9,52	= 3/8"



10

MANUFACTURERS OPTION FOR SPECIAL CHIP-GROOVE SHAPES.

8 CUTTING EDGE CONDITION

	F SHARP EDGE
	E HONED EDGE
	T NEGATIVE LAND
	S NEGATIVE LAND & HONED