

Turning Inserts

1

Insert Shape

H 120°	O 135°	P 108°	R -	S 90°	T 60°	W 80°
C 80°	D 55°	E 75°	M 86°	V 35°		
L 90°	A 85°	B 82°	K 55°	Z 86°		

2

Relief Angle

Symbol	Relief Angle	
A	3°	<p>Relief Angle</p>
B	5°	
C	7°	
D	15°	
E	20°	
F	25°	
G	30°	
N	0°	
P	11°	

C
1

N
2

M
3

G
4

3

Tolerance

Symbol	Nose Height	Thickness	Inscribed Circle
A	±.0002	±.001	±.001
F	±.0002	±.001	±.0005
C	±.0005	±.001	±.001
H	±.0005	±.001	±.0005
E	±.001	±.001	±.001
G	±.001	±.005	±.001
J	±.0002	±.001	±.002 ~ ±.005
K*	±.0005	±.001	±.002 ~ ±.005
L*	±.001	±.001	±.002 ~ ±.005
M*	±.003 ~ ±.007	±.005	±.002 ~ ±.005
U*	±.005 ~ ±.015	±.005	±.003 ~ ±.010

4

Type of Insert

Symbol	Shape	Symbol	Shape
A		N	
B		R	
F		T	
G		W	
H		X	Special Design
M			

Turning Inserts

5 Sizes (I.C.)

I.C.	Symbol	
	Normal	Small
5/32	-	5
3/16	-	6
7/32	-	7
1/4	2	8
5/16	-	0
3/8	3	-
1/2	4	-
5/8	5	-
3/4	6	-
7/8	7	-
1	8	-
1 1/4	0	-

6 Thickness

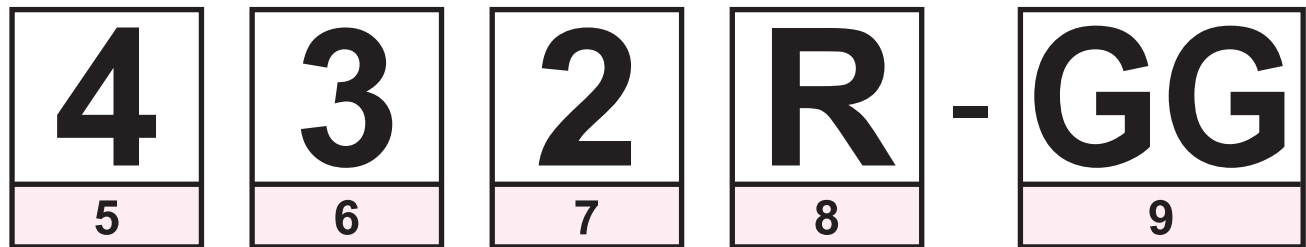
Thickness	Symbol	
	Normal	Small
1/16	-	2
3/32	-	3
1/8	2	4
5/32	-	5
3/16	3	6
1/4	4	-
5/16	5	-
3/8	6	-

7 Radius

Radius	Symbol
-	0
1/64	1
1/32	2
3/64	3
1/16	4
5/64	5
3/32	6
7/64	7
1/8	8

8 Feed Direction

Symbol	Feed Direction
R	Right Hand
L	Left Hand
N	Neutral



9 Chip Breakers

For finishing ← For light cutting For heavy cutting →

PF	UA	FT	SF	SG	UR	UT	PG	UB	GG	UD