















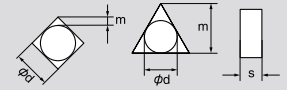


ISO / ASA insert designation

1 Shape

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

3 Tolerance Class









Symbol	d(mm)	m(mm)	S(mm)
	D	M	S
A	± 0.025	± 0.005	± 0.025
C	± 0.025	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
F	± 0.013	± 0.005	± 0.025
G	± 0.025	± 0.025	± 0.013
H	± 0.013	± 0.013	± 0.025
	J	M	S
	± 0.05 a ± 0.15	± 0.005	± 0.025
	± 0.05 a ± 0.15	± 0.013	± 0.025
	± 0.05 a ± 0.15	± 0.025	± 0.025
	± 0.05 a ± 0.15	± 0.08 a ± 0.20	± 0.13
	± 0.05 a ± 0.15	± 0.08 a ± 0.20	± 0.025
	± 0.08 a ± 0.25	± 0.13 a ± 0.38	± 0.13

METRIC











S	E	K	T
1	2	3	4
S	E	K	T

INCH

2 Clearances

N		0°
B		5°
C		7°
P		11°
D		15°
E		20°

4 Type

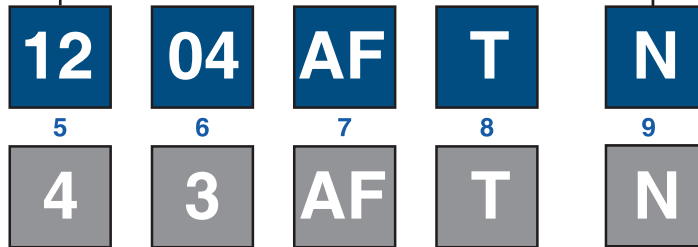
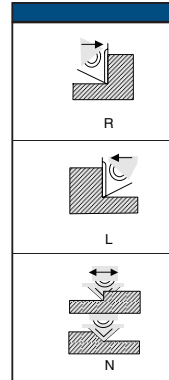
Type	Symbol	Type	Symbol
	N (E)		H
	F		B
	R		T
	A		W
	G		
	M		
Special design	x		



5 Cutting Edge Length

Inscribed Circle (inch)	Inch	Metric					
		C	D	R	S	T	W
1/4"	2	06	07	06	11	11	04
3/8"	3	09	11	09	16	16	06
1/2"	4	12	15	12	22	22	08
5/8"	5	16	19	15	27	27	10
3/4"	6	19	23	19	33	33	13
1"	8	25	31	25	44	44	17

9 Cutting direction



6 Thickness

Thickness S (inch)	Inch	Metric
3/32"	1.5	02
1/8"	2	03
5/32"	2.5	T3
3/16"	3	04
1/4"	4	06
5/16"	5	07
3/8"	6	09
1/2"	8	12

7 Nose Radius / Corner configuration

Corner Radius	Inch		Metric		AF	
	Inch	Metric	Inch	Metric		
	1/64"	1	04			
	1/32"	2	08	45°	A	3°
				60°	D	5°
	3/64"	3	12	75°	E	7°
				85°	F	15°
				90°	P	20°
	1/16"	4	16	Other angle	Z	25°
					N	30°
	5/64"	5	20		N	0°
					P	11°
	3/32"	6	24		Z	Other angle
1/8"	8	32				

8 Edge preparation

