Symbol	Insert
T	Triangle
C	80° Rhombic
D	55° Rhombic
J	70° Rhombic
V	35° Rhombic
W	80° Trigon

Shown angle stands for acute angle for rhombic and parallelogram inserts.

① Shape Symbol

Symbol	Relief Angle
B	5°
C	7°
N	0°
P	11°

② Relief Angle Symbol

Symbol (Class)	Tolerance					
	Corner Height		Thickness		I.C. Size	
	ANSI (±inch)	ISO (±mm)	ANSI (±inch)	ISO (±mm)	ANSI (±inch)	ISO (±mm)
E	0.0010	0.025	0.0010	0.025	0.0010	0.025
G			0.0005	0.130		
K※	0.0005	0.013	0.0010	0.025	0.002~0.006	0.05~0.15
M※	0.003~0.007	0.080~0.180	0.0005	0.130		

※ Insert's periphery is as fired.
Tolerance difference depends on size and shape of insert

③ Tolerance Symbol

Symbol	Hole	Hole Shape	Chipbreaker	Insert
A	Yes	With Hole	No	
M			One Side	
G			Two Sides	
W		With Hole and One Countersink 40°~60° One Side	No	
T			One Side	
U		With Hole and One Countersink 40°~60° Two Sides	Two Sides	
B		With Hole and One Countersink 70°~90° One Side	No	
H			One Side	

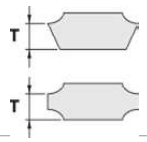
④ Hole / Chipbreaker Symbol

	①	②	③	④	⑤	⑥	⑦	⑧
ISO (metric)	C	C	M	T	06	02	02	GK
ANSI (inch)	C	C	M	T	2	15	05	GK

⑤ Edge Length Symbol (ISO)					I.C. Size (mm)	I.C. Size (ANSI)	
C	D	T	V	W		I.C. Size (inch)	Symbol
03	04	06			3.97	5/32	12
04	05	08	08		4.76	3/16	15
05	06	09		03	5.56	7/32	18
06	07	11	11	04	6.35	1/4	2
08	09	13		05	7.94	5/16	25
09	11	16	16	06	9.525	3/8	3
12	15	22	22	08	12.7	1/2	4

• Expressed as edge length for ISO.
• ANSI expresses the inscribed circle diameter in inches.

⑥ Thickness Symbol			
ISO		ANSI	
Thickness (mm)	Symbol	Thickness (inch)	Symbol
1.59	01	1/16	1
1.98	T1	5/64	1.2
2.38	02	3/32	1.5
2.78	T2	-	-
3.18	03	1/8	2
3.97	T3	5/32	2.5
4.76	04	3/16	3



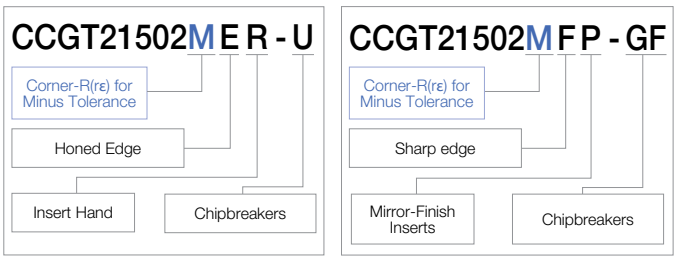
Thickness displayed as the distance between bottom surface and highest point on cutting edge.

⑦ Corner-R(rε) Symbol			
ISO		ANSI	
Corner-R(rε) (mm)	Symbol	Corner-R(rε) (inch)	Symbol
Sharp Corner	00	0.000	00
0.03	003	0.001	0.1
0.05	005	0.002	0.13
0.1	01	0.004	0.2
0.2	02	0.008	0.5
0.4	04	1/64	1
0.8	08	1/32	2
1.2	12	3/64	3

⑧ Manufacturer's Option
Hand Symbol, Chipbreaker, Symbol, Etc

● Positive Insert Identification System

(e.g. of (8) Manufacturer's Option)



● When a minus tolerance is specified for the corner-R(rε)

• If a minus tolerance is specified for the corner-R(rε) as shown in the Fig.1, using an insert with corner-R(rε) = 0.008" may result in larger radius than specified.

• Use an insert the corner of which R(rε) has a minus tolerance.

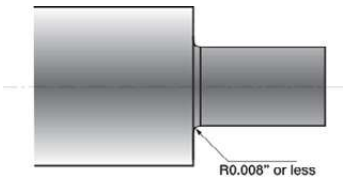


Fig.1 Example of a specified corner-R in the drawing

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