



ISO identificatie tabel - Wisselplaten

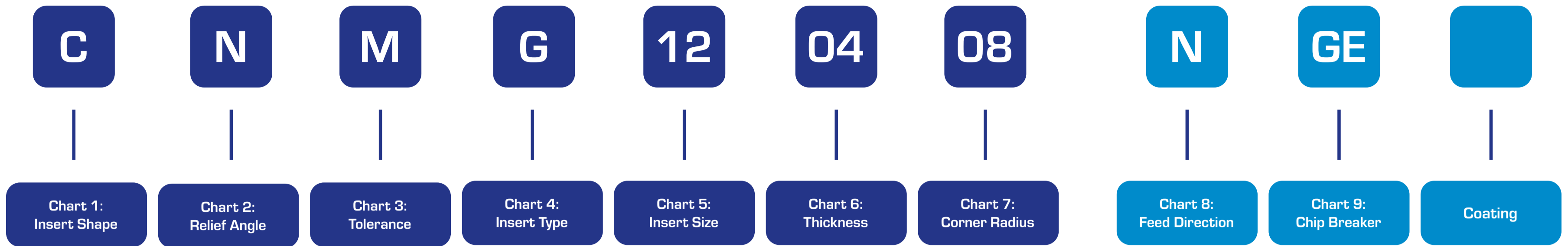


Chart 1: Insert Shape

Symbol	Insert Shape	Angle
C		80°
D		55°
E		75°
F		50°
V		35°
R	Round	-
S	Square	90°
T	Triangle	60°
W	Trigon	80°
A	Parallelogram	85°
B		82°
K		55°
H	Hexagonal	120°
O	Octagonal	135°
P	Pentagonal	108°
L	Rectangular	90°
M	Rhombic	86°

Chart 2: Relief Angle

Symbol	Relief Angle
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P*	11°
O	Others

* Inserts with a 10° relief angle are sometimes considered as "P"

Chart 4: Insert Hole or Breaker

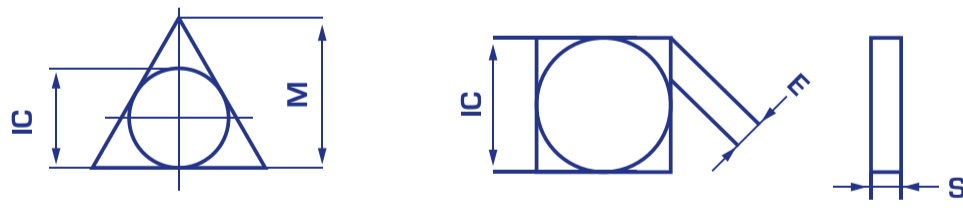
Symbol	Hole	Hole Style	Chip Breaker	Shape	Symbol	Hole	Hole Style	Chip Breaker	Shape
N	No Hole	-	Nil		A	With Hole	Straight Hole	Nil	
R	No Hole	-	One Face		M	With Hole	Straight Hole	One Face	
F	No Hole	-	Both Faces		G	With Hole	Straight Hole	Both Faces	
W	With Hole	Straight hole with top end counter-sink (40°-60°)	Nil		B	With Hole	Straight hole with top end counter-sink (70°-90°)	Nil	
T	With Hole	Straight hole with top end counter-sink (40°-60°)	One Face		H	With Hole	Straight hole with top end counter-sink (70°-90°)	One Face	
Q	With Hole	Straight hole with top end counter-sink (40°-60°)	Nil		C	With Hole	Straight hole with top end counter-sink (70°-90°)	Nil	
U	With Hole	Straight hole with top end counter-sink (40°-60°)	Both Faces		J	With Hole	Straight hole with top end counter-sink (70°-90°)	Both Faces	
					X	-	-	-	Special

Chart 5: Cutting Edge Length (mm)

Shape	Symbol	Cutting Edge	Angle	Shape	Symbol	Cutting Edge	Inscribed Circle	Shape	Symbol	Cutting Edge Neg.	Pos.	Inscribed Circle Neg.	Pos.	
C	03	3.55	3.50	D	07	7.7	6.35	W	03	3.8		5.56		
	04	4.97	4.30		09	9.7	7.94		04	4.3		6.35		
	06	6.4	6.35		11	11.6	9.525		05	5.4		7.94		
	08	8.0	7.94		15	15.5	12.70		06	6.5		9.525		
	09	9.7	9.525		19	19.4	15.875		08	8.7		12.70		
	12	12.9	12.70		08	8.3	4.76		10	10.9		15.875		
	16	16.1	15.875		09	9.7	5.56		11		4.3		6.35	
	19	19.3	19.05		11	11.1	6.35		16		6.5		9.525	
	25	25.8	25.4		16	16.6	9.525		08	8.0		8.0		
					22	22.1	12.7		10	10.0		10.0		
S	06	6.35	6.35	06	6.9	3.97	12	12.0		12.0				
	S7	7.14	7.14	08	8.2	4.76	12	12.70		12.70				
	07	7.94	7.94	09	9.6	5.56	15	15.875		15.875				
	09	9.525	9.525	11	11.0	6.35	16	16.0		16.0				
	12	12.70	12.70	13	13.7	7.94	19	19.05		19.05				
	15	15.875	15.875	16	16.5	9.525	20	20.0		20.0				
	19	19.05	19.05	22	22.0	12.70	24	24.0		24.0				
	25	25.40	25.40	27	27.5	15.875	25	25.0		25.0				
	31	31.75	31.75	33	33.0	19.05	25	25.40		25.40				
							32	32.0		32.0				

Chart 3: Tolerance (mm)

Symbol	Nose Height	Inscribed Circle	Thickness
A	± 0.005	± 0.025	± 0.025
F	± 0.005	± 0.013	± 0.025
C	± 0.013	± 0.025	± 0.025
H	± 0.013	± 0.013	± 0.025
E	± 0.025	± 0.025	± 0.025
G	± 0.025	± 0.025	± 0.013
J*	± 0.005	±0.05 - ±0.15	± 0.025
K*	± 0.013	±0.05 - ±0.15	± 0.025
L*	± 0.025	±0.05 - ±0.15	± 0.025
M*	±0.08 - ±0.2	±0.05 - ±0.15	± 0.013
N*	±0.08 - ±0.2	±0.05 - ±0.15	± 0.025
U*	±0.13 - ±0.38	±0.08 - ±0.25	± 0.013



The height "m" on sharp corner.

Tolerance of Nose Height (m-Class)

Inscribed Circle	Triangle	Square	80° Diamond	55° Diamond	35° Diamond	Round
635	± 0.08	± 0.08	± 0.08	± 0.11	-	-
9.525	± 0.08	± 0.08	± 0.08	± 0.11	± 0.16	
1.270	± 0.13	± 0.13	± 0.13	± 0.15		
15.875	± 0.15	± 0.15	± 0.15	± 0.18		
1.905	± 0.15	± 0.15	± 0.15	± 0.18		
2.540	± 0.18	± 0.18	± 0.18			
3.175	-	± 0.20				

Tolerance of Nose Height (m-Class)

Inscribed Circle	Triangle	Square	80° Diamond	55° Diamond	35° Diamond	Round
635	± 0.05	± 0.05	± 0.05	± 0.05	-	-
9.525	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05	± 0.05
1.270	± 0.08	± 0.08	± 0.08	± 0.08	-	± 0.08
15.875	± 0.10	± 0.10	± 0.10	± 0.10	-	± 0.10
1.905	± 0.10	± 0.10	± 0.10	± 0.10	-	± 0.10
2.540	± 0.13	± 0.13	± 0.13	-	-	± 0.10
3.175	-	± 0.15	-	-	-	± 0.12

Chart 6: Thickness

Symbol	Thickness (mm)
X1	*
01	159
02	238
T2	278
03	318
T3	397
04	476
05	556
06	635
07	794
09	952

(*):
CCET03X1 Insert thickness: 1.40
CCET04X1 Insert thickness: 1.80

Chart 7: Nose Radius

Symbol	Nose Radius (mm)
00	Sharp Point
003	003
008	008
01	01
015	015
018	018
02	02
035	035
04	04
08	08
10	10
12	12
16	16
20	20
24	24
32	32
MO	Round Insert (Metric)
OO	Round Insert (Imperial)

An "M" after the nose radius indicates a negative tolerance
Example: CCGT 09T302 M NSI AC520U

Chart 8: Feed Direction

Symbol	Direction
R	Right-hand
L	Left-hand
N	Neutral

Chart 9: Chip Breaker

Symbol	Process	Bumpy Type	Standard	Handed	Other Specials
F	Fine Finishing to Finishing	FA. FL. FE. FB. FC FK. FP		FT. FX. FZ FY. FW	Wide Chipbreaker W For Countersink C
S	Light Cut	SE. SEW. SI. SC. SF. SP. SU. SX LU. LUW. LB		SD SDW ST	For Round insert RD, RP, RX, RH For Exotic Alloy EF, EG, EX, EM
L					For Aluminium AW, AG, AX, AY, LD, GD
G	General	GE. GU. GUW UG. UP US. UX	GZ UZ	UM	For Hardened Steel FV, LV, GH
U					For Carburized Layer Removal SV
M	Rough	MP. MU. MX. ME	MC	MM HM	For Stainless Steel EF, EG, EM
H	Heavy	HG. HP. HF	HU HW		