



























ISO standard

T N M G 22 04 08 (N) – DM




1 2 3 4 5 6 7 8 9

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















1

Clearance angle	
A 	B 
C 	D 
E 	F 
G 	N 
P 	O Special









2

Tolerance class			
			
Code	I.C [mm]	m [mm]	S [mm]
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	±0.130
H	±0.013	±0.013	±0.025
J	±0.05–0.15	±0.005	±0.025
K	±0.05–0.15	±0.013	±0.025
L	±0.05–0.15	±0.025	±0.025
M	±0.05–0.15	±0.08–0.20	±0.130
N	±0.05–0.15	±0.08–0.20	±0.025
U	±0.08–0.25	±0.13–0.38	±0.130

3

Fastening features (metric)	
Insert shape	
A 	B 
C 	F 
G 	H 
J 	M 
N 	Q 
R 	T 
U 	W 
X Special	

4

Cutting edge length l [mm]								
I.C [mm]	Insert shape							
								
3.97	06							
5.0	05							
5.56	09							
6.0	06							
6.35	06	07			11	11		
8.0	08							
9.525	09	11	09	09	16	16	06	16
10.0	10							
12.0	12							
12.7	12	15	12	12	22	22	08	
15.875	16		15	15	27			
16.0	19							
19.05	19		19	19	33			
20.0	20							
25.0	25	25	25					
25.4	25							
31.75	31							
32	32							

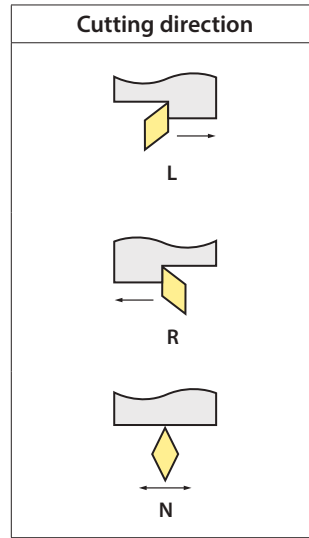
5

Insert thickness S [mm]			
Code	S	Code	S
00	0.79	T5	5.95
T0	0.99	06	6.35
01	1.59	T6	6.75
T1	1.98	07	7.94
02	2.38	09	9.52
T2	2.58	T9	9.72
03	3.18	11	11.11
T3	3.97	12	12.70
04	4.76		
T4	4.96		
05	5.56		

6

Nose radius r [mm]	
Code	r
00	–
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
32	3.2
X	Special
MO	Round inserts

7

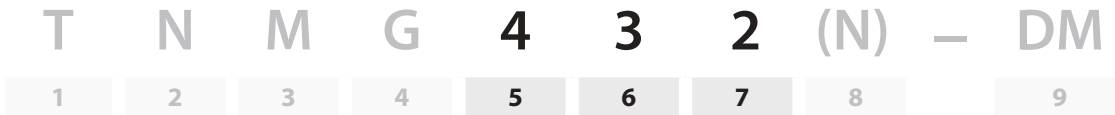


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Chip breaker overview
(on page A16)

9

ANSI standard



Inner circle		
Code	mm	Inch
2	6.35	0.250
3	9.525	0.375
4	12.7	0.500
5	15.875	0.625
6	19.05	0.750
8	25.4	1.000

5

Insert thickness		
Code	mm	Inch
2	3.18	0.125
3	4.76	0.187
4	6.35	0.250
5	7.94	0.313
6	9.52	0.375

6

Nose radius		
Code	mm	Inch
0	0.2	0.008
1	0.4	0.016
2	0.8	0.031
3	1.2	0.047
4	1.6	0.063
5	2.0	0.079
6	2.4	0.094

7

A

Turning

B

Milling

C

Drilling

D

Technical Information

E

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