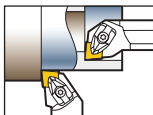
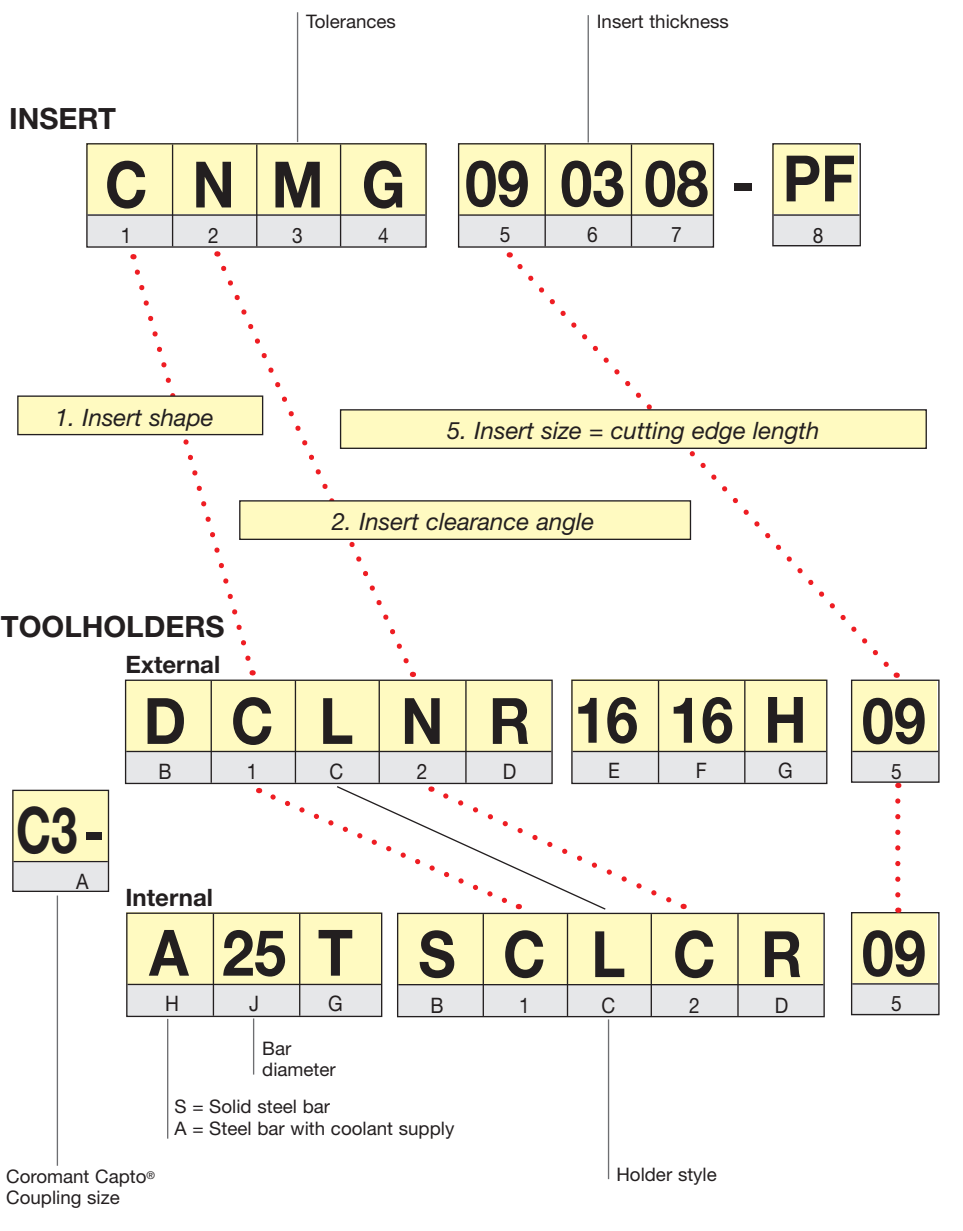


# TURNING



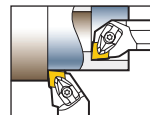
## Turning tools

Code key for inserts and toolholders  
Extract from ISO 1832—1991



## Turning tools

Code key for inserts and toolholders  
Extract from ISO 1832—1991



1. INSERT SHAPE							2. INSERT CLEARANCE ANGLE														
80° <b>C</b>	55° <b>D</b>	<b>R</b>	<b>S</b>	<b>T</b>	35° <b>V</b>	80° <b>W</b>	<b>B</b>	<b>C</b>	<b>N</b>												
4. INSERT TYPE				5. INSERT SIZE = CUTTING EDGE LENGTH																	
<b>A</b>	<b>G</b>	<b>M</b>	<b>T</b>	 <i>l mm:</i> 06—19 07—15 06—12 09—19 06—22 11—16 06—08																	
7. NOSE RADIUS																					
 04 $r_n = 0.4$ 08 $r_n = 0.8$ 12 $r_n = 1.2$ 16 $r_n = 1.6$ 24 $r_n = 2.4$				<b>First choice nose radius recommendations:</b> <table><thead><tr><th></th><th>T-MAX P</th><th>CoroTurn 107</th></tr></thead><tbody><tr><td>FINISHING</td><td>08</td><td>04</td></tr><tr><td>MEDIUM</td><td>08</td><td>08</td></tr><tr><td>ROUGHING</td><td>12</td><td>08</td></tr></tbody></table>							T-MAX P	CoroTurn 107	FINISHING	08	04	MEDIUM	08	08	ROUGHING	12	08
	T-MAX P	CoroTurn 107																			
FINISHING	08	04																			
MEDIUM	08	08																			
ROUGHING	12	08																			
8. GEOMETRY — MANUFACTURER'S OPTION																					
The manufacturer may add further two symbols to the code describing the insert geometry e. g. -PF = ISO P Finishing -MR = ISO M Roughing																					
B. CLAMPING SYSTEM																					
<b>D</b>  Rigid clamping (RC)	<b>M</b>  Top and hole clamping	<b>P</b>  Hole clamping	<b>S</b>  Screw clamping																		
D. HAND OF TOOL			E. SHANK HEIGHT		G. TOOL LENGTH																
<b>R</b>  Right hand style	<b>L</b>  Left hand style	<b>N</b>  Neutral	 h		<i>Tool length = <math>l_1</math> in mm</i>  <table><tbody><tr><td>H = 100</td><td>S = 250</td></tr><tr><td>K = 125</td><td>T = 300</td></tr><tr><td>M = 150</td><td>U = 350</td></tr><tr><td>P = 170</td><td>V = 400</td></tr><tr><td>Q = 180</td><td>W = 450</td></tr><tr><td>R = 200</td><td>Y = 500</td></tr></tbody></table>					H = 100	S = 250	K = 125	T = 300	M = 150	U = 350	P = 170	V = 400	Q = 180	W = 450	R = 200	Y = 500
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			F. SHANK WIDTH  b																		