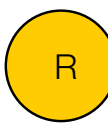

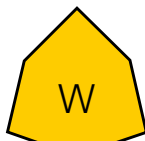

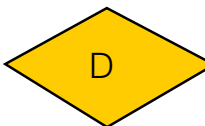

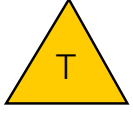
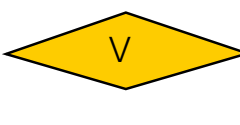
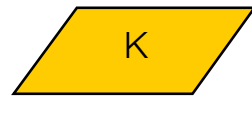
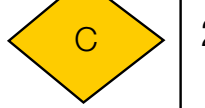
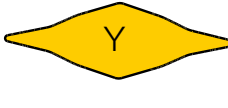

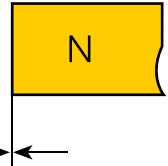
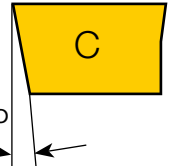
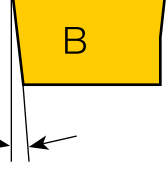
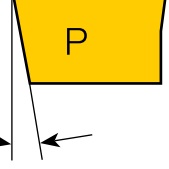
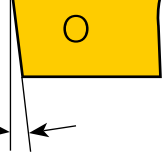
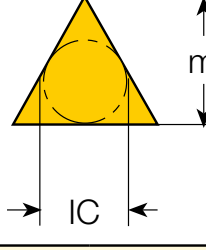
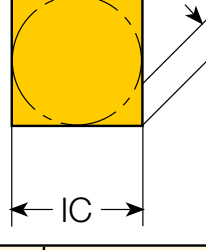



W	N	M	G
1	2	3	4

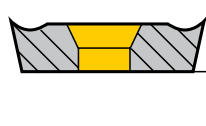
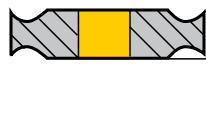
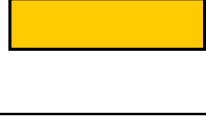
1. Shape					
		75°		80°	
90°		55°			
60°		35°		55°	
80°/100°		25°		80°	

2. Clearance Angle	
	
	
	

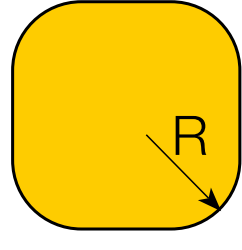
3. Tolerance			
			
	IC	IC	s
	m	s	IC
E		±0.025	±0.025
G		±0.025	±0.13
M	from	±0.08	±0.13
	to	±0.18 ⁽¹⁾	to ±0.13 ⁽¹⁾
U	from	±0.13	±0.13
	to	±0.38 ⁽¹⁾	to ±0.25 ⁽¹⁾





⁽¹⁾ Exact tolerance depends on insert size

IC	Tolerance in mm			
	On m		On IC	
	Class M	Class U	Class M	Class U
6.35	±0.08	±0.13	±0.05	±0.08
9.52	±0.08	±0.13	±0.05	±0.08
12.70	±0.13	±0.20	±0.08	±0.13
15.87	±0.15	±0.27	±0.10	±0.18
19.05	±0.15	±0.27	±0.10	±0.18
25.40	±0.18	±0.38	±0.13	±0.25

6. Thickness	
	T
	T
	T

01	=	1.59 mm
T1	=	1.98 mm
02	=	2.38 mm
03	=	3.18 mm
T3	=	3.97 mm
04	=	4.76 mm
06	=	6.35 mm
07	=	7.94 mm

7. Corner Radius	
	R
02	= 0.2 mm
04	= 0.4 mm
08	= 0.8 mm
12	= 1.2 mm
16	= 1.6 mm
20	= 2.0 mm
24	= 2.4 mm

8. Cutting Edge (Optional)	
	F Sharp
	E Honed (Rounded)
	T Chamfered (Negative Land)
	S Chamfered + Honed

Chipformer Code Key

The chipformer code key consists of three characters (and an optional fourth character).








For example: CNMG 120408-**M3P**

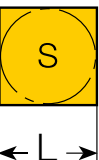
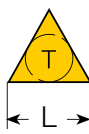
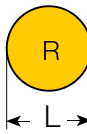
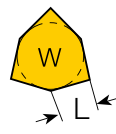
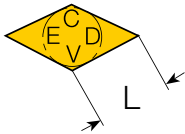
1. Application			
		Feed (mm/rev)	a _p (mm)
F	Finishing	0.08-0.20	0.30-1.50
M	Medium	0.15-0.45	0.70-4.50
R	Roughing	0.35-0.70	3.00-7.00
H	Heavy Roughing	0.60-1.50	6.00-20.0

ISO Standard Designation			
CNMG	12	04	08

3. Workpiece Material Group	
P	Steel
M	Stainless Steel
K	Cast Iron
N	Nonferrous & Aluminum
S	High Temperature Alloys

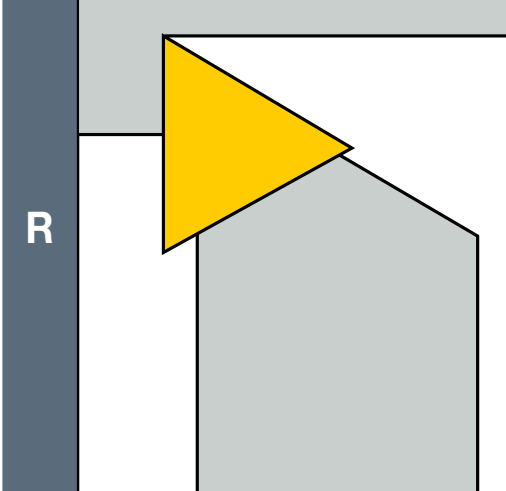
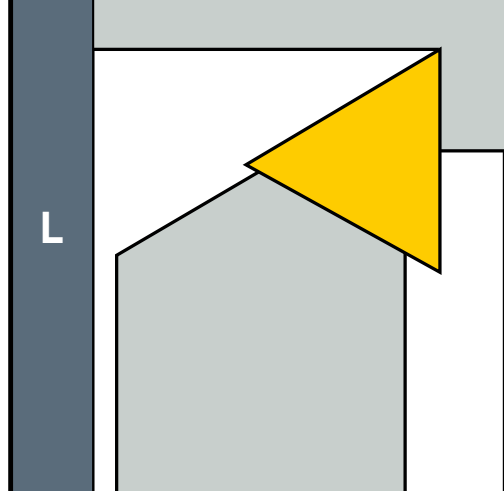
08	04	08	E	GN
5	6	7	8	9

4. Type	
	A Without chipbreaker, with hole
	G Chipbreaker on both sides, with hole
	M, S Chipbreaker on one side, with hole
	R Chipbreaker on one side, without hole
	B, W Countersink on one side, with hole
	T, H Chipbreaker on one side, with hole and countersink
	P Neg./pos. on one or both sides, with hole
Z, X	Special

5. Cutting Edge Length									
									
IC		Symbol (L)							
inch	mm	C	D	R	S	T	V	W	Q
5/32	3.97		04		03	06	06	02 ⁽¹⁾	
7/32	5.56	05				09			
1/4	6.35	06	07			11	11		
9/32	7.15						12		
	8.00			08					
3/8	9.52	09	11		09	16	16	06	09
	10.00			10					
	12.00			12					
1/2	12.70	12	15		12	22	22	08	12
5/8	15.88	16			15	27			
	16.00			16					
3/4	19.05	19			19	33		13	
	20.00			20					
	25.00			25					
1	25.40				25				

⁽¹⁾ WBMT 06...

9. Chipformer Designation			
SF	AS/AF	TF	NM
PF	../Z-RF/LF ⁽¹⁾	PP	TNM
NF	WF	GN	NR
SM	WG	NMS	RP
14	VL		

⁽¹⁾ Right-hand		Left-hand	
	R		L