

W	N	M	G
1	2	3	4

4	3	2	E	GN
5	6	7	8	9

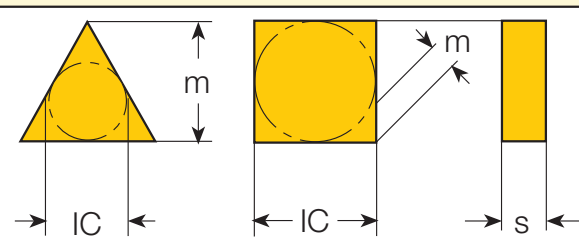
1. Shape

	75°		80°	
	55°			
	35°		55°	
	25°		80°	

2. Clearance Angle

	0°		7°
	5°		11°
	Other		

3. Tolerance



	m	T	IC
E	±.001	±.001	±.001
G	±.001	±.005	±.001
M	fr.	±.003	fr.
	to	±.007 ⁽¹⁾	to
U	fr.	±.005	fr.
	to	±.015 ⁽¹⁾	to

⁽¹⁾ Exact tolerance depends on insert size

di	Tolerance in Inch			
	On m		On di	
	Class M	Class U	Class M	Class U
1/4	±.003	±.005	±.002	±.003
3/8	±.003	±.005	±.002	±.003
1/2	±.005	±.008	±.003	±.005
5/8	±.006	±.011	±.004	±.007
3/4	±.006	±.011	±.004	±.007
1	±.007	±.015	±.005	±.010

4. Type

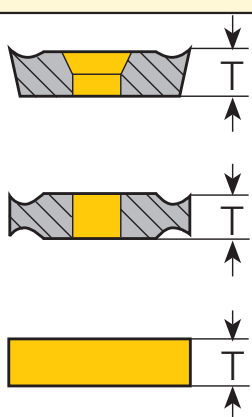
	A	Without chipbreaker, with hole
	G	Chipbreaker on both sides, with hole
	M, S	Chipbreaker on one side, with hole
	R	Chipbreaker on one side, without hole
	B, W	Countersink on one side, with hole
	T, H	Chipbreaker on one side, with hole and countersink
	P	Neg./pos. on one or both sides, with hole
	Z,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

6. Thickness



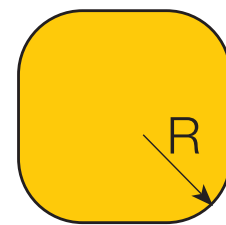
Symbol ANSI	ISO	Thickness inch
1(2)*	01	.063
-(3)**	02	.094
2	03	.125
-	T3	.156
3	04	.187
-	05	.218
4	06	.250
5	07	.312

* For WBMT 520

** For TPMP 731

Note: Inch symbol in parentheses for small inserts (under .25" IC)

7. Corner Radius



given in 1/64"

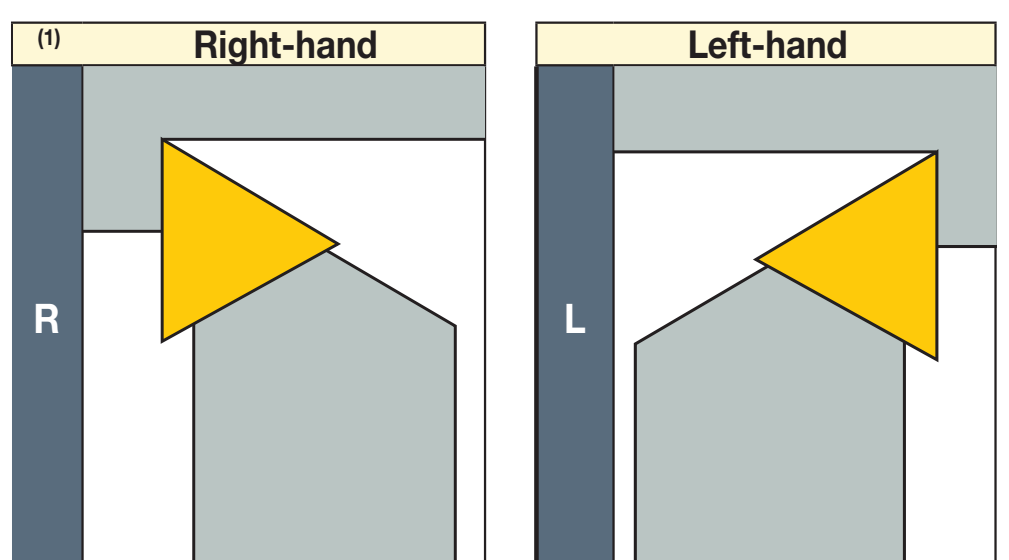
0	=	.000-.005
1	=	1/64
2	=	1/32
3	=	3/64
4	=	1/16
5	=	5/64
6	=	3/32

8. Cutting Edge (Optional)

	F	Sharp
	E	Honed (Rounded)
	T	Chamfered (Negative Land)
	S	Chamfered + Honed

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. Application

		Feed (ipr)	a _p (in)
F	Finishing	.003-.008	.012-.06
M	Medium	.006-.018	.028-.177
R	Roughing	.014-.028	.118-.276
H	Heavy Roughing	.024-.060	.236-.787
T	Turn Feed	.020-.100	.040-.120

2. Chip Load

2	For special cases
3	General recommendation for all applications
4	For special cases

ASA Standard Designation

CNMG	4	3	2
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1	2	3	4
M	3	P	W

3. Workpiece Material Group

P	Steel
M	Stainless Steel
K	Cast Iron
N	Nonferrous & Aluminum
S	High Temperature Alloys

4. Wiper Geometry

	Without wiper
W	Wiper Geometry