

Code key for inserts and toolholders - METRIC

Extract from ISO 1832:1991

INSERT

Tolerances: C, N, M, G
Insert thickness: 12, 04, 08
Nose radius: PM

TOOL HOLDERS

External: D, C, L, N, R, 25, 25, M, 12
Internal: A, 25, T, D, C, L, N, R, 12

Bar diameter: 25
Holder style: D, C, L, N, R

Coromant Capto® coupling size: C4

S = Solid steel bar
A = Steel bar with coolant supply
E = Carbide shank bar
F = Dampened, carbide shank bar

1. Insert shape

80° C, 55° D, R, S, T, 35° V, 80° W

2. Insert clearance angle

C, B (5°), C (7°), P (11°), N (0°)

4. Insert type

A, M, G, T

5. Insert size = Cutting edge length

/ mm: 06-25, 07-15, 06-32, 09-25, 06-27, 11-16, 06-08

7. Nose radius

	02	RE = 0.2	First choice nose radius recommendations:	
	04	RE = 0.4	T-MAX P	CoroTurn 107
	08	RE = 0.8	Finishing	04
	12	RE = 1.2	Medium	08
	16	RE = 1.6	Roughing	08
24	RE = 2.4			

8. Geometry — manufacturer's option

The manufacturer may add a further two symbols to the code describing the insert geometry e. g.
-PF = ISO P Finishing
-MR = ISO M Roughing

B. Clamping system

D: Rigid clamping (RC), M: Top and hole clamping, P: Hole clamping, S: Screw clamping

D. Hand of tool

R: Right-hand style, L: Left-hand style, N: Neutral

E. Shank height

F. Shank width

G. Tool length

Tool length = l_1 in mm

H = 100	S = 250
K = 125	T = 300
M = 150	U = 350
P = 170	V = 400
Q = 180	W = 450
R = 200	Y = 500