

CRAFTSMAN CRIBSHEET

ISO (Metric) Turning Identification

Our example insert is CCMT 060204.

By David Wynn, Director of Technical Services, PMPA

Watch **Dave & Davey** video



1 Insert Shape	
Symbol	Insert Shape
A	Parallelogram 85°
B	Parallelogram 82°
C	Rhombic 80°
D	Rhombic 55°
E	Rhombic 75°
F	Rhombic 50°
H	Hexagon
K	Parallelogram 55°
L	Rectangle
M	Rhombic 86°
O	Octagon
P	Pentagon
R	Round
S	Square
T	Triangle
V	Rhombic 35°
W	Trigon

2 Relief Angle			
Symbol	Relief Angle	Symbol	Relief Angle
A	3°	F	25°
B	5°	G	30°
C	7°	N	0°
D	15°	P	11°
E	20°	O	Special

4 Fixing / Chip Breaker			
Symbol	Feature	Symbol	Feature
A	[Image]	N	[Image]
B	[Image]	Q	[Image]
C	[Image]	R	[Image]
F	[Image]	T	[Image]
G	[Image]	U	[Image]
H	[Image]	W	[Image]
J	[Image]	X	Special
M	[Image]		

3 Tolerance												
Class	A	C	E	F	G	H	J	K	L	M	N	U
Tol. \pm M (mm)	0.005	0.013	0.025	0.005	0.025	0.013	0.050	0.013	0.025	.08 ~ .18	.08 ~ .18	.13 ~ .38
Tol. \pm T (mm)	0.025	0.025	0.025	0.025	0.130	0.025	0.025	0.025	0.025	0.130	0.025	0.130
Tol. \pm d (mm)	0.025	0.025	0.025	0.013	0.025	0.013	.05 ~ .13	.05 ~ .13	.05 ~ .13	.05 ~ .13	.05 ~ .13	.08 ~ .25

5 Cutting Edge Length L (mm)						
A	B	C	D	E	F	K
[Image]	[Image]	[Image]	[Image]	[Image]	[Image]	[Image]
L	M	R	S	T	V	W
[Image]	[Image]	[Image]	[Image]	[Image]	[Image]	[Image]

*Letters in this chart correspond to chart 1. L is the length of the edge shown.

6 Thickness											
Symbol	01	T1	02	T2	03	T3	04	05	06	07	09
Thickness (S)	1.59	1.98	2.38	2.78	3.18	3.97	4.76	5.56	6.35	7.94	9.52

7 Radius												
Symbol	00	01	02	04	08	12	16	20	24	28	32	00 MO
Nose Rad.	Sharp Pt.	0.1	0.2	0.4	0.8	1.2	1.6	2.0	2.4	2.8	3.2	Round Insert

Edge*	Figure	[Image]	[Image]	[Image]	[Image]
8 Symbol		E	F	S	T

*Most manufacturers omit this Cutting Edge Symbol.

9 Symbol	R	L	N
		Left	Neutral
Feed# Figure	[Image]	[Image]	[Image]

* Most manufacturers omit this symbol when the insert is Neutral.

