

# CRAFTSMAN CRIB SHEET

## ISO (Metric) Milling Identification

Our example insert is SEKT 1204AEEN.

By David Wynn, Director of Technical Services, PMPA

Watch **Dave & Davey** video



1 Insert Shape		2 Relief Angle				3 Tolerance																		
Symbol	Insert Shape	Symbol	Relief Angle	Symbol	Relief Angle	class	A	C	E	G	H	J	K	M	U									
A	Parallelogram 85°	A	3°	F	25°	Tol. 'm'(mm)	0.005	0.013	0.025	0.025	0.013	0.050	0.013	.08-180	.13-38									
B	Parallelogram 82°	B	5°	G	30°	Tol. 's'(mm)	0.025	0.025	0.025	0.130	0.025	0.025	0.025	0.130	0.130									
C	Rhombic 80°	C	7°	N	0°	Tol. 'd'(mm)	0.025	0.025	0.025	0.025	0.013	.05-13	.05-13	.05-13	.08-25									
H	Hexagon	D	15°	P	11°																			
L	Rectangle	E	20°	O	Special																			
M	Rhombic 86°	5 Cutting Edge Length L (mm)						4 Fixing / Chip Breaker																
O	Octagon	A	B	C	H	L	M	Symbol	Feature	Symbol	Feature													
P	Pentagon							A		Q														
R	Round	O	P	R	S	T	W	B		R														
S	Square							F		T														
T	Triangle							M		W														
W	Trigon							N		X	Special													
6 Thickness							9 Edge				10 Direction of Cutting													
Symbol	02	03	T3	04	05	06	Symbol	Figure	R Right Rotation			L Left Rotation		N Neutral Right & Left Rotation										
Thickness (S)	2.38	3.18	3.97	4.76	5.56	6.35	E																	
7 Cutting Angle							F																	
Symbol	A	D	E	F	P	X	Z	S																
Cutting Angle α	45°	60°	75°	85°	90°	65°	Special	T																
8 Relief													SEKT 1204AEEN											
Symbol	A	B	C	D	E	F	G	N	P	R	S	T	U	Z	1	2	3	4	5	6	7	8	9	10
Relief	3°	5°	7°	15°	20°	25°	30°	0°	11°	10°	14°	22°	23°	Special	↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
													(mm)											