

CRAFTSMAN CRIBSHEET

ISO (Inch) Milling Identification

Our example insert is SEKT 33AEEN.

By David Wynn, Director of Technical Services, PMPA

Watch
Dave & Davey video

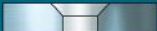
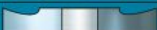


1	Insert Shape
Symbol	Insert Shape
A	Parallelogram 85°
B	Parallelogram 82°
C	Rhombic 80°
H	Hexagon
L	Rectangle
M	Rhombic 86°
O	Octagon
P	Pentagon
R	Round
S	Square
T	Triangle
W	Trigon

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

3	Tolerance									
Class	A	C	E	G	H	J	K	M	U	
Tol. $\pm$ "M" (inch)	.0002	.0005	.001	.001	.0005	.0002	.0005	.003 ~ .008	.005 ~ .015	
Tol. $\pm$ "T" (inch)	.001	.001	.001	.005	.001	.001	.001	.005	.001	
Tol. $\pm$ "d" (inch)	.001	.001	.001	.001	.0005	.002 ~ .006	.002 ~ .006	.002 ~ .006	.002 ~ .010	

5	Insert Size (Dia. of insc. circle)	
		
Symbol	Insc. Circle	Fraction
1.2	0.156"	5/32"
1.5	0.187"	3/16"
1.8	0.219"	7/32"
2	0.250"	1/4"
2.5	0.313"	5/16"
3	0.375"	3/8"
4	0.500"	1/2"
5	0.625"	5/8"
6	0.750"	3/4"
8	1.000"	1"

4 Fixing / Chip Breaker			
Symbol	Feature	Symbol	Feature
A		Q	
B		R	
F		T	
M		W	
N		X	Special

9	EDGE*
Symbol	Figure
E	Hone
F	Sharp
S	Chamfer + Hone
T	Chamfer

6	Thickness										
Symbol	1	1.2	1.5	2	2.5	3	3.5	4	5	6	8
Thickness (T)	1/16"	5/64"	3/32"	1/8"	5/32"	3/16"	7/32"	1/4"	5/16"	3/8"	1/2"

7	Cutting						
Symbol	A	D	E	F	P	X	Z
Cutting $\angle$ (α)	45°	60°	75°	85°	90°	65°	Special

8	Relief 								
Symbol	A	B	C	D	E	F	G	N	P
Relief $\angle$ (β)	3°	5°	7°	15°	20°	25°	30°	0°	11°

10 Direction of Cutting		
R	L	N
Right Rotation	Left Rotation	Neutral Right & Left Rotation

S	E	K	T	3	3	A	E	E	N
↑	↑	↑	↑	↑	↑	↑	↑	↑	↑
①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩
(mm)									