для размещения заказа - info@ceratizit.su



# Designation system to ISO 1832

Inserts

| X | D | K | T | 11 | T3 | 08 | S | R | - | F50 |
|---|---|---|---|---|---|---|---|---|---|---|
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | 10 |

| Z | N | H | W | 12 | 05 | PO | S | R | - | 15 | 06 | - | R |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | | 11 | 12 | | 13 |

1

## Insert shape

| | | |
|---|---|---|
| A | 85° | |
| B | 82° | |
| K | 55° | |
| H | 120° | |
| L | 90° | |
| O | 135° | |
| P | 108° | |
| C | 80° | |
| D | 55° | |
| E | 75° | |
| M | 86° | |
| V | 35° | |
| R | - | |
| S | 90° | |
| T | 60° | |
| W | 80° | |
| X | Special shapes | |
| Z | | |

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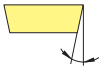
## Clearance angle



| | α |
|---|---|
| A | 3° |
| B | 5° |
| C | 7° |
| D | 15° |
| E | 20° |
| F | 25° |
| G | 30° |
| N | 0° |
| P | 11° |
| O | Special version |

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## Tolerances

| | d [±mm] | m [±mm] | s [±mm] | d=6,35/9,52 | d=12,7 | d=15,8/19,05 |
|---|---|---|---|---|---|---|
| A | 0,025 | 0,005 | 0,025 | ● | ● | ● |
| C | 0,025 | 0,013 | 0,025 | ● | ● | ● |
| E | 0,025 | 0,025 | 0,025 | ● | ● | ● |
| F | 0,013 | 0,005 | 0,025 | ● | ● | ● |
| G | 0,025 | 0,025 | 0,13 | ● | ● | ● |
| H | 0,013 | 0,013 | 0,025 | ● | ● | ● |
| | 0,05 | 0,005 | 0,025 | ● | | |
| J | 0,08 | 0,005 | 0,025 | | ● | |
| | 0,10 | 0,005 | 0,025 | | | ● |
| | 0,05 | 0,013 | 0,025 | ● | | |
| K | 0,08 | 0,013 | 0,02 | | ● | |
| | 0,10 | 0,013 | 0,02 | | | ● |

| | d [±mm] | m [±mm] | s [±mm] | d=6,35/9,52 | d=12,7 | d=15,8/19,05 |
|---|---|---|---|---|---|---|
| | 0,05 | 0,08 | 0,13 | ● | | |
| M | 0,08 | 0,13 | 0,13 | | ● | |
| | 0,10 | 0,15 | 0,13 | | | ● |
| | 0,05 | 0,08 | 0,025 | ● | | |
| N | 0,08 | 0,13 | 0,025 | | ● | |
| | 0,10 | 0,15 | 0,025 | | | ● |
| | 0,08 | 0,13 | 0,13 | ● | | |
| U | 0,13 | 0,20 | 0,13 | | ● | |
| | 0,18 | 0,27 | 0,13 | | | ● |

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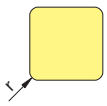
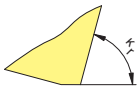
## Facet, corner radius



Radius

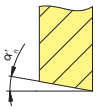
| | r [mm] |
|---|---|
| M0* | |
| 02 | 0,2 |
| 04 | 0,4 |
| 08 | 0,8 |
| 12 | 1,2 |

* Shape R only



1st sign

| | $\kappa_r$ |
|---|---|
| A | 45° |
| D | 60° |
| E | 75° |
| F | 85° |
| P | 90° |
| Z | Others |



2nd sign

| | $\alpha'_n$ |
|---|---|
| A | 3° |
| B | 5° |
| C | 7° |
| D | 15° |
| E | 20° |
| F | 25° |
| G | 30° |
| N | 0° |
| P | 11° |
| Z O | Others |

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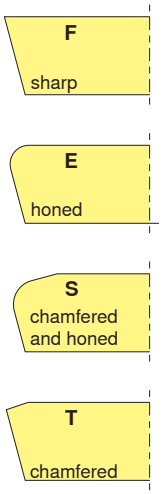
## Cutting edge

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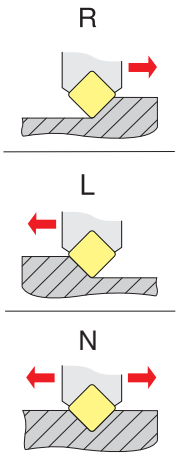
## Cutting direction



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