

Standard Inserts

When you order standard inserts, kindly specify the following information:

-----Shape, Clearance Angle, Tolerance, Type, I.C., Thickness, Corner Radius, etc

1 Shape

2 Clearance Angle

4 Type

6 Thickness

ANSI	ISO	Inch	mm
1	01	0.062	1.59
1.2	T1	0.078	1.98
1.5	02	0.094	2.38
2	03	0.125	3.18
2.5	T3	0.156	3.97
3	04	0.188	4.76
3.5	05	0.219	5.56
4	06	0.250	6.35
5	07	0.313	7.94
6	09	0.375	9.52
8	12	0.500	12.7

7 Corner Radius

ANSI	ISO	Inch	mm
0	00	Sharp Edge	Sharp Edge
0.5	02	0.008	0.2
1	04	0.016	0.4
2	08	0.031	0.8
3	12	0.047	1.2
4	16	0.062	1.6
5	20	0.078	2
6	24	0.094	2.4
7	28	0.109	2.78
8	32	0.125	3.18
0	0	Round Insert	Round Insert

T
1

N
2

M
3

G
4

4
5

3
6

4
7

R
8

E
9

3 Tolerance

Symbol	I.C. (Inscribed Circle)	Thickness	B
A	±.001	±.001	±.005
C	±.001	±.001	±.0005
E	±.001	±.001	±.001
F	±.0005	±.001	±.0002
G	±.001	±.005	±.001
H	±.001	±.001	±.005
M*	±.002 - ±.004	±.005	±.002-.010
U*	±.005 - ±.010	±.005	±.005-.012
N*	±.002 - ±.004	±.001	±.002-.010

Symbol	d (Inscribed Circle)	s (Thickness)	m
A	±0.075	±0.025	±0.605
C	±0.025	±0.025	±0.013
E	±0.025	±0.025	±0.025
F	±0.013	±0.025	±0.005
G	±0.025	±0.13	±0.025
H	±0.013	±0.025	±0.013
M*	±0.05 - ±0.15	±0.13	±0.08 - ±0.20
N	±0.05 - ±0.13	±0.025	±0.08 - ±0.18
U*	±0.08 - ±0.25	±0.13	±0.13 - ±0.38

*Exact tolerance is determined by size of insert

8 Direction

9 Chipbreaker Designation

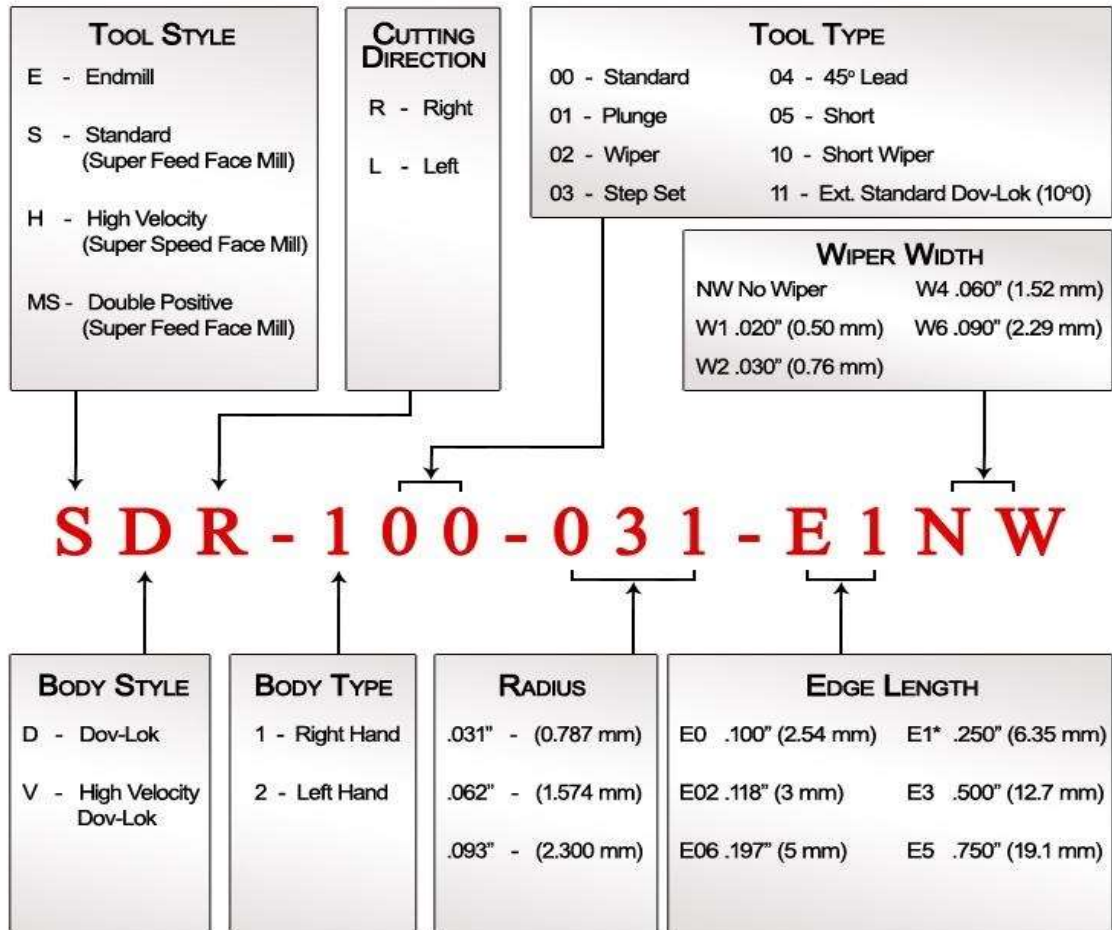
5 I.C. and Code For Metric Cutting Edge Length

Symbol	I.C.		C	D	M	R	S	T	V	W
	Inch	mm								
1.25	0.156	3.97	S4	04	03	03	03	06		
1.5	0.188	4.76	04	05	04	04	04	08		S3
1.8	0.219	5.56	05	06	05	05	05	09	08	03
2	0.250	6.35	06	07	06	06*	06	11	11	04
2.5	0.313	7.94	08	09	07	07	07	13	13	05
3	0.375	9.525	09	11	09	09	09	16	16	06
4	0.500	12.70	12	15	12	12	12	22	22	08
5	0.625	15.875	16	19	15	15	15	27		10
6	0.750	19.05	19	23	19	19	19	33	33	13
8	1.000	25.40	25	31	25	25	25	44	44	17
10	1.250	31.75	32	38	31	31	31	53		



How to order

----- When you order, kindly specify the following information:



Other Custom Radii, Features & Options available upon request.

* End Mill E1 = .150" (3.81 mm)



How to Order ...

When Ordering, kindly specify the following information:

UC: Ultra-Mill

UE: Endmill

MS: 90 Deg Mount

WS: Wedge Style

D: PCD

B: Borazon

C: Carbide

R: Right Hand

L: Left Hand

Example: UCDR 32-01

3: Nose Radius	0 = 0.000	1 = 0.010
	2 = 0.030	3 = 0.060
	4 = 0.090	5 = 0.016
	6 = 0.100	
2: Wiper Flat	0 = No Wiper	1 = 0.060
	2 = 0.080	3 = 0.100
	4 = 0.120	
0: Cartridge Style	0 = Standard	1 = Two Phase
	2 = Long Edge	3 = Boring
	4 = Short	5 = Chip Guard
	6 = No Drag	
1: Max DOC	0 = 0.200	1 = 0.250
	2 = 0.375	3 = 0.500
	4 = 0.625	

*Recommended cartridge for all standard purposes is UCDR33-00

*If cutter body has Set Height of under 2" use UCDR33-40 short cartridge

*Any special Radius or Wiper use the cutter No. w/-5 (Ex. UTXXXX-5)

*Long Edge insert is 0.12 wide