



1

Inserts Shape



2

Relief Angle



3

Tolerance



4

Chipbreaker and Clamping system

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Inserts Shape				
C	D	E	K	L
R	S	T	V	W

Relief Angle			
B	C	D	E
			Special Type
F	N	P	O

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Tolerance

d: Inscribed circle
s: Thickness
m: Nose height

Class	d	m	s
A	±0.025	±0.005	±0.025
C	±0.025	±0.013	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.05 ~ ±0.13	±0.005	±0.25
K	±0.05 ~ ±0.13	±0.013	±0.25
L	±0.05 ~ ±0.13	±0.025	±0.025
M	±0.05 ~ ±0.13	±0.08 ~ ±0.018	±0.13
N	±0.05 ~ ±0.13	±0.08 ~ ±0.018	±0.025
U	±0.08 ~ ±0.25	±0.13 ~ ±0.038	±0.13

Tolerance on C,E,H,M,O,P,R,S,T,W Inserts Shape (Exceptional case)

d	Tolerance on d		Tolerance on m	
	J,K,M,N	U	M,N	U
6.35	±0.05	±0.08	±0.08	±0.13
9.525	±0.05	±0.08	±0.08	±0.13
12.7	±0.08	±0.13	±0.13	±0.20
15.875	±0.10	±0.18	±0.15	±0.27
19.05	±0.10	±0.18	±0.15	±0.27
25.4	±0.13	±0.25	±0.18	±0.38

Tolerance on D Inserts Shape (Exceptional case)

d	Tolerance on d	Tolerance on m
6.35	±0.05	±0.11
9.525	±0.05	±0.11
12.7	±0.08	±0.15
15.875	±0.10	±0.18
19.05	±0.10	±0.18

Chipbreaker and clamping system

A	B	C
	C'Sink 70°~90°	C'Sink 70°~90°
F	G	H
		C'Sink 70°~90°
J	M	N
C'Sink 70°~90°		
Q	R	T
C'Sink 40°~60°		C'Sink 40°~60°
U	W	X
C'Sink 40°~60°	C'Sink 40°~60°	Special Type

General Turning Inserts Code Key (ISO)

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04

08

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DM

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Cutting Edge Length
Diameter of Incribed Circle

Inserts Thickness

Nose Radius

Chipbreaker Code

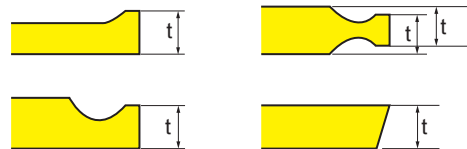
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Cutting Edge Length/Diameter of Incribed Circle

Symbol							Code (Inch)	Diameter I.C. (mm)
Code (metric)								
03	04	03	06	03		02	1.2	3.97
04	05	04	08	04	08		1.5	4.76
05	06	05	09	05	09	03	1.8	5.56
				06				6.00
06	07	06	11	06	11	04	2	6.35
08	09	07	13	07	13	05	2.5	7.94
				08				8.00
09	11	09	16	09	16	06	3	9.525
				10				10.00
11	13	11	19	11	19	07	3.5	11.11
				12				12.00
12	15	12	22	12	22	08	4	12.70
14	17	14	24	14	24	09	4.5	14.29
16	19	15	27	15	27	10	5	15.875
				16				16.00
17	21	17	30	17	30	11	5.5	17.46
19	23	19	33	19	33	13	6	19.05
				20				20.00
22	27	22	38	22	38	15	7	22.225
				25				25.00
25	31	25	44	25	44	17	8	25.4
32	38	31	54	31	54	21	10	31.75
				32			10	32.00

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Inserts Thickness (Height of Cutting Edge)



Symbol (Code)		Height of Cutting Edge (t)	
Metric	Inch	mm	Inch
T0	0.6	0.99	0.040
01	1	1.59	0.063
T1	1.2	1.98	0.078
02	1.5	2.38	0.094
T2	1.75	2.58	0.109
03	2	3.18	0.125
T3	2.5	3.97	0.156
04	3	4.76	0.156
05	3.5	5.56	0.156
06	4	6.35	0.219
07	5	7.94	0.313
09	6	9.52	0.375
11	7	11.11	0.438
12	8	12.70	0.500

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Nose Radius (Nose R)



Symbol (Code)		Corner Radius	
Metric	Inch	Metric(mm)	Inch
01	0	0.1	0.004
02	0.5	0.2	0.008
04	1	0.4	0.016
08	2	0.8	0.031
12	3	1.2	0.047
16	4	1.6	0.063
20	5	2.0	0.079
24	6	2.4	0.094
28	7	2.8	0.109
32	8	3.2	0.125
00		Round inserts (Inch)	
MO		Round inserts (Metric)	

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Chipbreaker Code

DF	DM	DR	PM	LR
EF	EM	ER	NF	NM
HF	HM	HR	SF	LC

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