

## A.N.S.I. Identification for Turning and Boring Inserts

Roll Dim.	I.C.	Thickness
B	A	T
A	0.0002 <sup>(2)</sup>	0.001
B	0.0002	0.001
C	0.0005	0.001
D	0.0005	0.001
E	0.001	0.001
F	0.0002 <sup>(2)</sup>	0.0005
G	0.001	0.001
H	0.0005	0.0005
J	0.0002 <sup>(2)</sup>	0.002-0.005
K	0.0005	0.002-0.005
L	0.001	0.002-0.005
M	0.002-0.010 <sup>(3)</sup>	0.002-0.004 <sup>(3)</sup>
U	0.005-0.012 <sup>(3)</sup>	0.005-0.010 <sup>(3)</sup>
N	0.002-0.010 <sup>(3)</sup>	0.002-0.004 <sup>(3)</sup>

**Tolerance Class <sup>(1)</sup>**

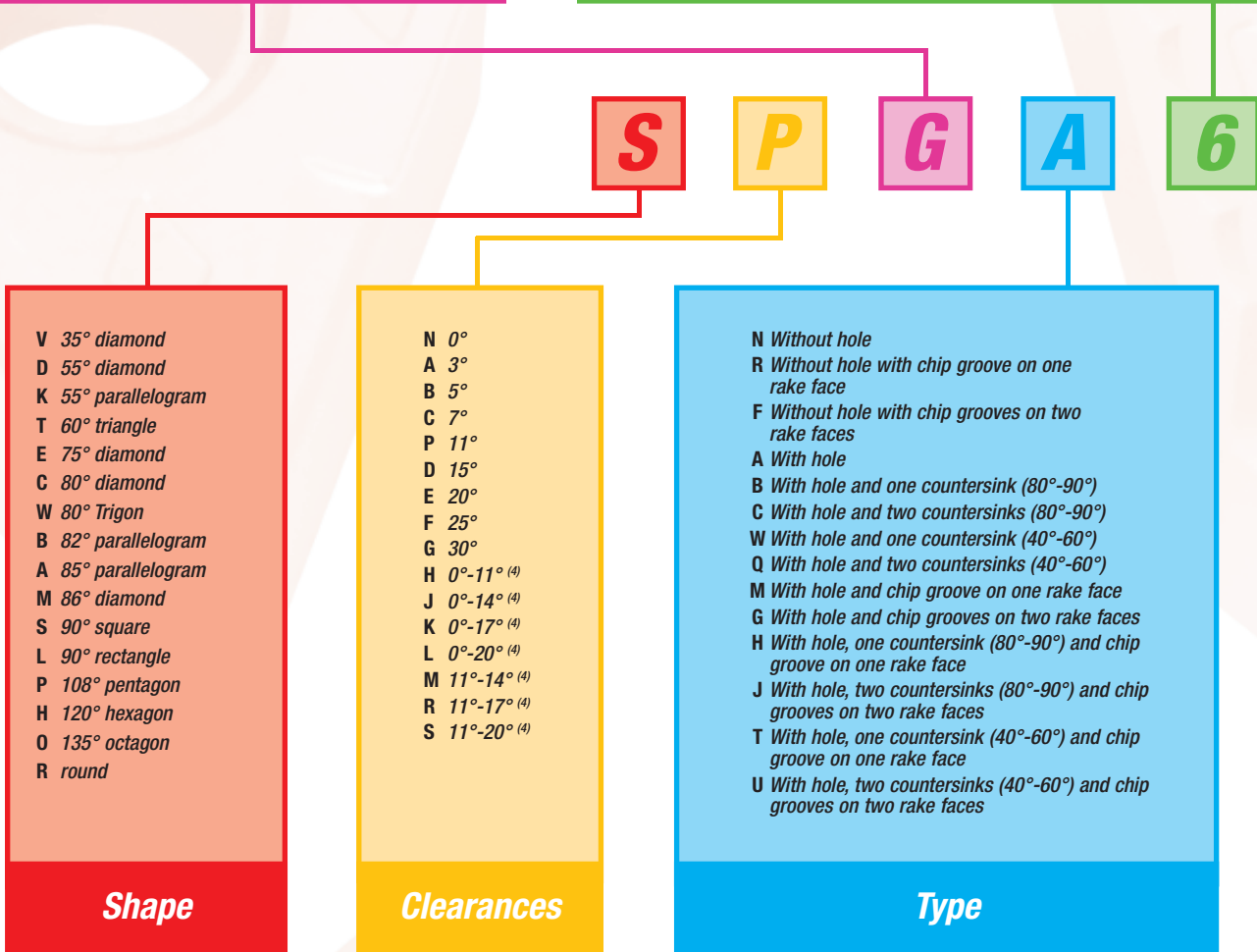
**Regular polygons and diamonds**  
Number of 1/8ths of an inch in the inscribed circle as per table below:

**Example:**

5/32" I.C.	1.2
3/16" I.C.	1.5
7/32" I.C.	1.8
1/4" I.C.	2.0
5/16" I.C.	2.5
3/8" I.C.	3.0
1/2" I.C.	4.0
5/8" I.C.	5.0
3/4" I.C.	6.0
7/8" I.C.	7.0
1" I.C.	8.0
1-1/4" I.C.	10.0

**Rectangles and parallelograms**  
Use two digits to size  
1st digit: Number of 1/8ths of an inch in width  
2nd digit: Number of 1/4ths of an inch in length

**Size (I.C.)**



**Regular polygons, diamonds, rectangles and parallelograms:**  
 Number of 1/64ths of an inch in thickness as per table below:

**Example:**

3/32" I.C.	1.5
1/8" I.C.	2.0
5/32" I.C.	2.5
3/16" I.C.	3.0
7/32" I.C.	3.5
1/4" I.C.	4.0
5/16" I.C.	5.0
3/8" I.C.	6.0
7/16" I.C.	7.0
1/2" I.C.	8.0

**Thickness**

Only used following a letter in the seventh position.  
 Number of 1/64ths of an inch in the primary facet length.

**Special Cutting Point Definition**<sup>(5)</sup>

R Right  
 L Left

**Hand**<sup>(5)</sup>

**3**

**3**

**A**

0	Sharp Corner
1	1/64" radius
2	1/32" radius
3	3/64" radius
4	1/16" radius
5	5/64" radius
6	3/32" radius
7	7/64" radius
8	1/8" radius

A Square insert with 45° chamfer  
 D Square insert with 30° chamfer  
 E Square insert with 15° chamfer  
 F Square insert with 3° chamfer  
 K Square insert with 30° double chamfer  
 L Square insert with 15° double chamfer  
 M Square insert with 3° double chamfer  
 N Truncated triangular insert  
 P Flatted corner triangle – 90°

**Cutting Point Configuration**

A	Honed (0.0005 to 0.001")
B	Honed (0.001 to 0.002")
C	Honed (0.005 to less than 0.007")
D	Honed (0.007" and over)
J	Polished to 4 microinch AA (rake face only)
T	Chamfered – manufacturer's standard (negative land – rake face only)

**Other Conditions**<sup>(5)</sup>

<sup>(1)</sup> Tolerances given are plus and minus from nominal.  
<sup>(2)</sup> These tolerances normally apply to indexable inserts with facets (secondary cutting edges).  
<sup>(3)</sup> The tolerance depends on the size and shape of the insert and should be shown in the standards for the corresponding shapes and sizes (see ANSI B94.25).  
<sup>(4)</sup> Secondary facet angle may vary by +1°.  
<sup>(5)</sup> Shall only be used when required.