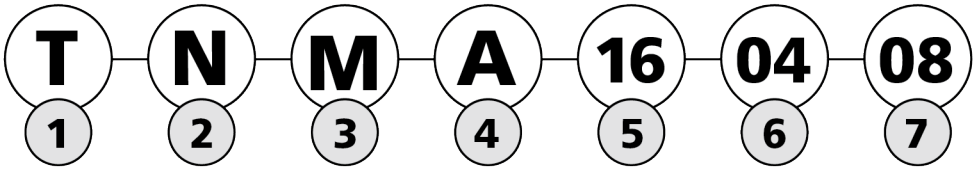
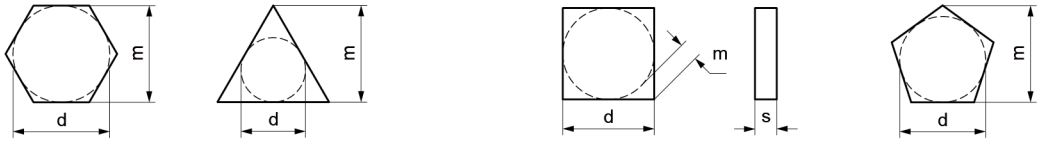
ISO-Codes für Wendeschneidplatten
Norme ISO pour les plaquettes
ISO-Codes for Inserts



1 Grundform / **Forme de base** / *Basic Shape*				2 Freiwinkel / **Angle de dépouille** / *Clearance angle*		
A 85°	B 82°	C 80°	D 55°	A 3°	B 5°	C 7°
E 75°	H 120°	K 55°	L 90°	D 15°	E 20°	F 25°
M 86°	O 135°	P 108°	R	G 30°	N 0°	P 11°
S 90°	T 60°	V 35°	W 85°			

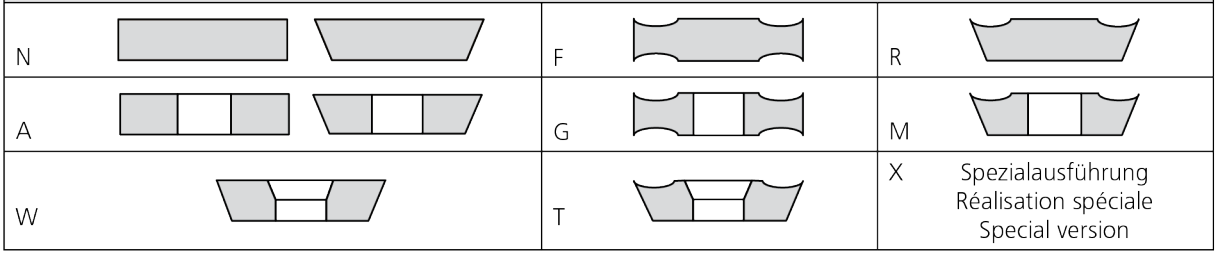
3 Toleranz / **Tolérance** / *Tolerance* (mm)



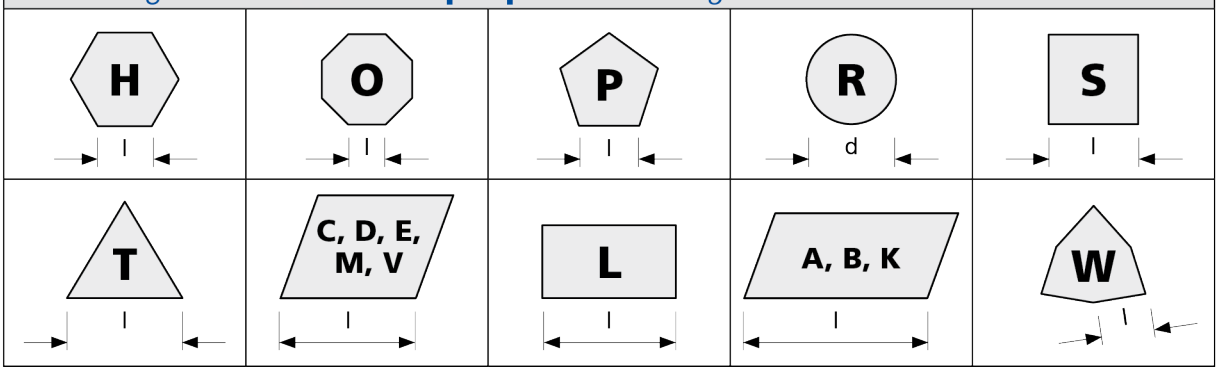
	m	s	d		m	s	d
A	±0.005	±0.025	±0.025	J	±0.005	±0.025	±0.05 – ±0.15
F	±0.005	±0.025	±0.013	K	±0.013	±0.025	±0.05 – ±0.15
C	±0.013	±0.025	±0.025	L	±0.025	±0.025	±0.05 – ±0.15
H	±0.013	±0.025	±0.013	M[1)]	±0.08 – ±0.20	±0.130	±0.05 – ±0.15
E	±0.005	±0.025	±0.025	N[1)]	±0.08 – ±0.20	±0.25	±0.05 – ±0.15
G	±0.025	±0.130	±0.025	U[1)]	±0.13 – ±0.38	±0.130	±0.08 – ±0.15

[1)] Die genaue Toleranz ist von der Grösse der Platte abhängig.

4 Plattentyp / **Type de plaquette** / *Insert type*

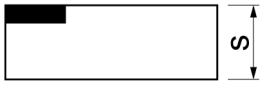


5 Plattengrösse / **Taille de la plaquette** / *Cutting insert size*



6 Dicke / **Épaisseur** / *Thickness (mm)*

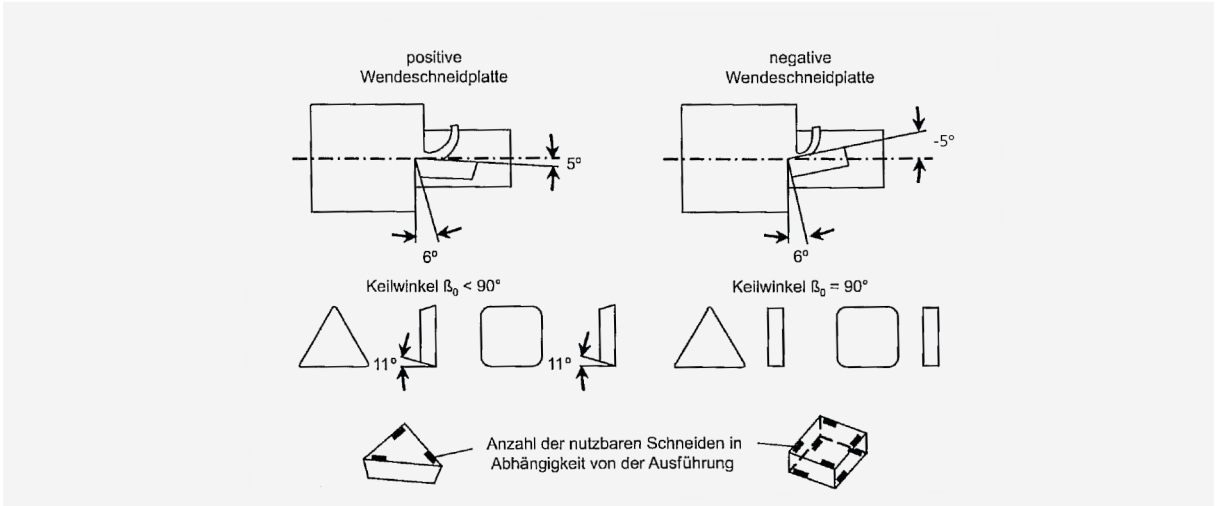
01 s = 1.59
T1 s = 1.98
02 s = 2.38
03 s = 3.18
T3 s = 3.97
04 s = 4.76
05 s = 5.56
06 s = 6.35



Bei Ziffern unter 10 wird eine Null vorgesetzt. Dezimalstellen bleiben unberücksichtigt. (Beispiel: 3.18 = 03)
On ajoute un zéro devant les nombres inférieurs à 10. Les décimales ne sont pas prises en compte (par ex.: 3,18 = 03).
A zero is put in front of numbers under 10. Decimal places are not taken into account. (e.g.: 3.18 = 03)

7 Schneideecke / **Point d'attaque** / *Cuttiing corner*

1) Radius / **Rayon** / *Radius*	
00 = scharfe Ecke / **angle vif** / *sharp angle*	
02 = 0.2	
04 = 0.4	
08 = 0.8	
12 = 1.2	
16 = 1.6	
00 = runde Platte (inch) / **plaquette ronde (en pouces)** / *round insert (inches)*	
M0 = runde Platte (Metr.) / **plaquette ronde (métrique)** / *round insert (metric)*	
2) Fräsgeometrie / **Géométrie du fraisage** / *Milling geometry*	
Einstellwinkel der Hauptschneide zur Planschneide **Angle entre tranchant principal et plat de planage** *Angle of adjustment of main cutting edge to face cutting edge*	Freiwinkel der Planschneide **Angle de dépouille du plat de planage** *Clearance angle of face cutting edge*
A – 45°	A – 3°
D – 60°	D – 5°
E – 75°	E – 7°
F – 85°	F – 15°
P – 90°	P – 20°



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