PART NUMBER MATRIX FOR REGULAR TOOLS

N N 60 RXXXm L E C XX - SHANK/INSERT

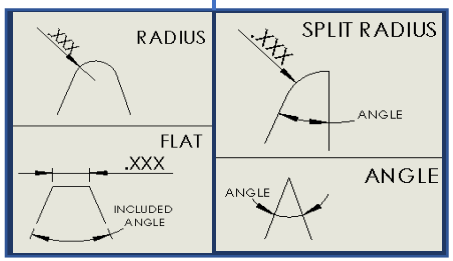
TYPE OF DIAMOND
N = NATURAL
M = MONODIE
P = PCD
B = PCBN
D = PCVD
C = CARBIDE
L = MCC-CVD

WAVINESS:
N ≤ 2.00 µm
C1 ≤ 1.00 µm
C2 ≤ 0.50 µm
C3 ≤ 0.25 µm
U1 ≤ 0.10 µm
U2 ≤ 0.05 µm
U3 ≤ 0.02 µm

INCLUDED ANGLE

R = RADIUS
F = FLAT
S = SPLIT
A = ANGLE (NO DIMS.)

SIZES (R, F and S):
X.XX mm IN mm
X.XX µm IN MICRON
.XXX inch IN inch



FIRST CLEARANCE

A= 35°	T= 12.5°
P= 33°	F= 12°
N= 32°	G= 10°
M= 31°	H= 8°
B= 30°	W= 7°
C= 25°	Q= 6°
S= 20°	J= 5°
Z= 18°	K= 4°
D= 17°	X= 3°
E= 15°	L= 2°

RAKE ANGLE

POSITIVE:	NEGATIVE:	NEGATIV:
F= +12°	M= -2.5°	W= -25°
G= +10°	E= -3°	X= -30°
H= +7.5°	Q= -4°	Y= -35°
J= +5°	N= -5°	Z= -40°
K= +2.5°	O= -7°	P= -45°
C= +3°	D= -8°	S= -50°
L= +0°	R= -10°	U= -55°
	T= -15°	B= -65°
	V= -20°	A= -75°

TYPE OF CLEARANCE:
C = CONICAL
IF NOT STATED = CYLINDRICAL

DIAMOND SECONDARY CLEARANCE
xx = ANGLE
OPTIONAL

INSERTS: **xxxx = insert size**
KDxxxx= 55° INSERT
KVxxxx= 35° INSERT
KTxxxx= 60° INSERT
KCxxxx= 80° INSERT
KLxxxx = RECTANGULAR INSERT
KXxxxx = SPECIAL INSERT
KRxxxx = ROUND INSERT

SHANKS: **M S 0001**

MATERIAL:
MO = MOLY
C = CARBIDE
S = STEEL
M = METAL MATRIX

ORIENTATION:
S = STRAIGHT
L = LEFT
R= RIGHT
T= TURNING
(ROUND SHANK)

SHANK SIZE:
0xxx = ■ 6.35mm - 1/4 in
1xxx = ■ 8mm - 5/16 in
2xxx = ■ 10mm – 3/8 in
3xxx = ■ 11mm – 7/16 in
4xxx = ■ 12mm – 1/2 in
5xxx = ■ 20mm – 3/4 in
6xxx = ■ 25mm – 1 in
7xxx = ■ 6.35mm x 10.5mm STEP
8xxx = SPECIAL SIZE

T0xxx= ø 2mm – 1/16 in
T1xxx= ø 3mm – 1/8 in
T2xxx= ø 4mm – 5/32 in
T3xxx= ø 6mm – 1/4 in
T4xxx= ø 8mm – 5/16 in
T5xxx= ø 10mm – 3/8 in
T6xxx= ø 11mm – 7/16 in
T8xxx= ø 12mm – 1/2 in and bigger sizes