

# MAPAL turning inserts with PCBN

Key to reference codes

**C N G A 1 2 0 4 0 4**

Insert form	
C	80°
D	55°
S	90°
T	60°
V	35°
W	80°
E	75°
R	

Standard clearance angle	
B	5°
C	7°
N	0°
P	11°

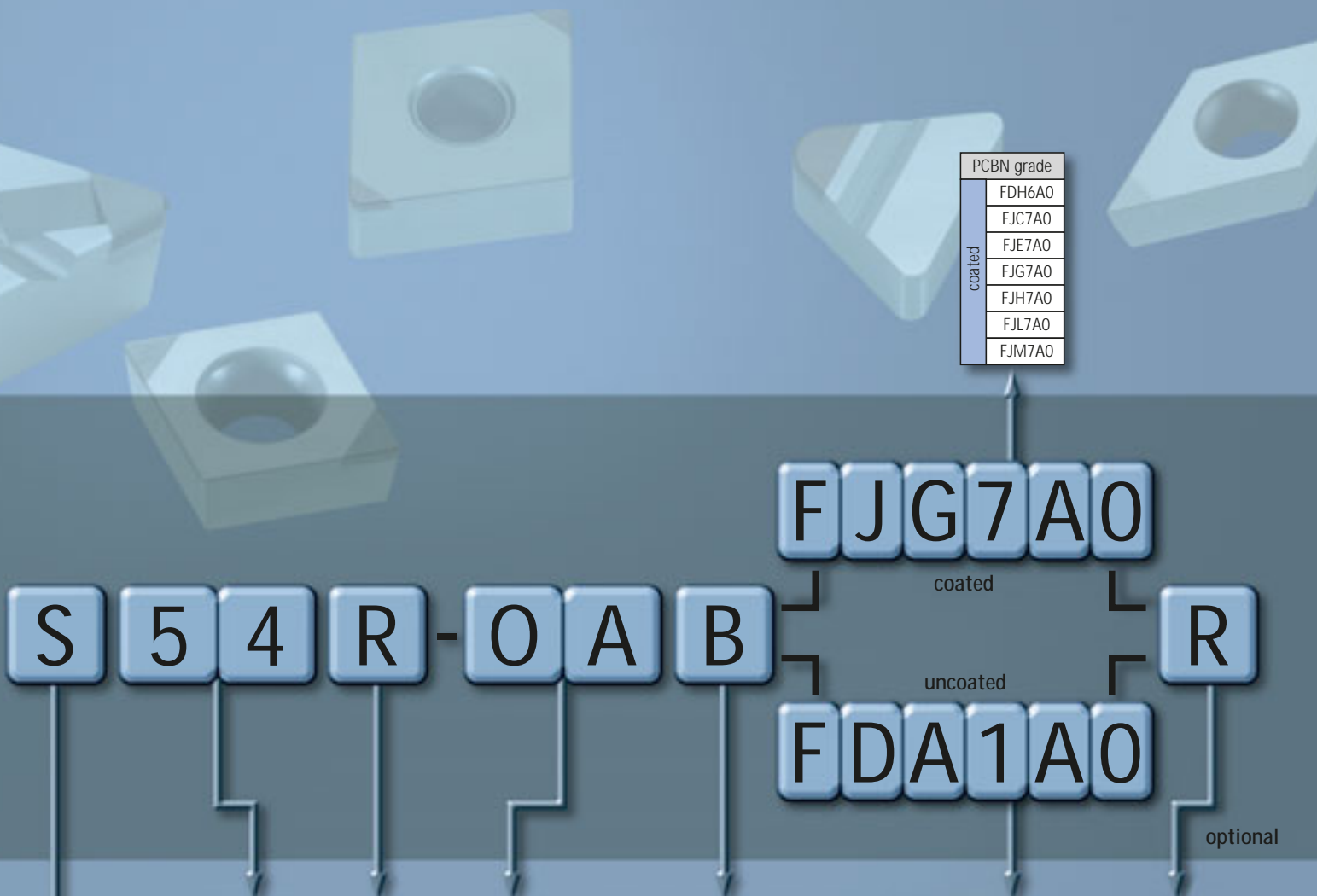
Tolerance	
G	G class
M	M class
H	H class

Chipbreaker, hole		
Symbol	Hole	Chipbreaker
A	with hole	no
B	with hole	no
N	no hole	no
T	with hole	with chipbreaker
W	with hole	no
X	special design	
F	no hole	with chipbreaker
G	with hole	with chipbreaker

in-scribed circle	Insert size							
3.57	03							
3.97				06	07	02		
4.37	04							
4.76	04		08				04	
5.56	05		09				05	
6.0								06
6.35	06	07		11	11		06	06
7.94	08				13		08	
8.0								08
9.2						06		
9.52	09	11	09	16	16			09
10.0								10
12.0								12
12.7	12	15	12	22		08		12

Insert thickness	
S1	1.39
01	1.59
T0	1.79
02	2.38
03	3.18
T3	3.97
04	4.76
06	6.35

Corner radius	
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6



S

5

4

R

-

0

A

B

F J G 7 A 0

coated

R

uncoated

F D A 1 A 0

optional

PCBN grade	
coated	FDH6A0
	FJC7A0
	FJE7A0
	FJG7A0
	FJH7A0
	FJL7A0
	FJM7A0

Type of edge	
E	01-08
F	01
T	51
S	01, 51-60
W	01, 20, 35-60

Direction	
R	right
L	left
N	neutral

Chip groove	
OA	no
5H	7°
5F	5°

Layout	
S	robust
F	full cutting face on one side
E	full cutting face on both sides
A	fitted on one side, one corner
B	fitted on one side, two corners
C	fitted on one side, three corners
D	fitted on one side, four corners
K	fitted on two sides, one corner
L	fitted on two sides, two corners
M	fitted on two sides, three corners
N	fitted on two sides, four corners
T	fitted over full thickness, one corner
U	fitted over full thickness, two corners
V	fitted over full thickness, three corners
W	fitted over full thickness, four corners
AX	fitted on one side, whole cutting edge
TX	fitted over full thickness, whole cutting edge

CBN grade	
uncoated	FDA1A0
	FDC1A0
	FDG1A0
	FJC1A0
	FJD1A0
	FJE1A0
	FJF1A0
	FJG1A0
	FJH1A0
	FJJ1A0
	FJK1A0
	FJL1A0
FJM1A0	

Can be reground	
R	regrindable

Cutting edge	
F	sharp cutting edges
E	rounded cutting edges
T	chamfered cutting edges
S	chamfered and rounded cutting edges
K	double chamfered cutting edges
P	double chamfered and rounded cutting edges
W	wipers