Grand Sea offer round, square, radius, and diamond shaped carbide inserts and cutters that fit many of the commercial woodturning lathes and tools.

All of our inserts and cutters are manufactured to our specifications using high grade carbide with micro-grain size of 0.7-1.0 µm. These micro-grains are combined with a 10% binder that yields a hardness of 1650 HV10. They are then finely ground to a razor cutting edge with toughness and durability for long-lasting, smooth cutting in the most dense hardwoods.

1	2	3	4	5	6	7	8	9	10
C	N	M	G	12	04	08	(E)	(N)-	MP

1. Insert Shape

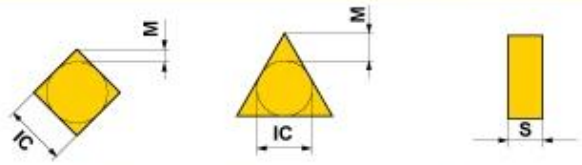
1. Insert Shape	
Symbol	Insert Shape
H	Hexagonal
O	Octagonal
P	Pentagonal
S	Square
T	Triangular
C	Rhombic 80°
D	Rhombic 55°
E	Rhombic 75°
F	Rhombic 50°
M	Rhombic 86°
V	Rhombic 35°
W	Trigon
L	Rectangular
A	Parallelogram 85°
B	Parallelogram 82°
K	Parallelogram 55°
R	Round
X	Special Design

2. Relief Angle

2. Relief Angle	
Symbol	Normal Clearance
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Other Relief Angle
Major Relief Angle	

3. Tolerance Class

3. Tolerance Class



Triangular insert with a facet (Secondary Cutting Edge)

3. Tolerance Class

Symbol	Tolerance of Nose Height **M** (mm)	Tolerance of Inscribed Circle **IC** (mm)	Tolerance of Thickness **S** (mm)
A	±0.005	±0.025	±0.025
F	±0.005	±0.013	±0.025
C	±0.013	±0.025	±0.025
H	±0.013	±0.013	±0.025
E	±0.025	±0.025	±0.025
G	±0.025	±0.025	±0.13
J	±0.005	±0.05−±0.15	±0.025
K*	±0.013	±0.05−±0.15	±0.025
L*	±0.025	±0.05−±0.15	±0.025
M*	±0.08−±0.18	±0.05−±0.15	±0.13
N*	±0.08−±0.18	±0.05−±0.15	±0.025
U*	±0.13−±0.38	±0.08−±0.25	±0.13

The surface of insert with * mark is sintered.

Detail of M Class Insert Tolerance

●Tolerance of Nose Height **M** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.08	±0.08	±0.08	±0.11	±0.16	–
9.525	±0.08	±0.08	±0.08	±0.11	±0.16	–
12.70	±0.13	±0.13	±0.13	±0.15	–	–
15.875	±0.15	±0.15	±0.15	±0.18	–	–
19.05	±0.15	±0.15	±0.15	±0.18	–	–
25.40	–	±0.18	–	–	–	–
31.75	–	±0.20	–	–	–	–

●Tolerance of Inscribed Circle **IC** (mm)

D.I.C.	Triangular	Square	Rhombic 80°	Rhombic 55°	Rhombic 35°	Round
6.35	±0.05	±0.05	±0.05	±0.05	±0.05	–
9.525	±0.05	±0.05	±0.05	±0.05	±0.05	±0.05
12.70	±0.08	±0.08	±0.08	±0.08	–	±0.08
15.875	±0.10	±0.10	±0.10	±0.10	–	±0.10
19.05	±0.10	±0.10	±0.10	±0.10	–	±0.10
25.40	–	±0.13	–	–	–	±0.13
31.75	–	±0.15	–	–	–	±0.15

4. Chipbreaker and Clamping System

4. Chipbreaker and Clamping System

Metric

Symbol	Hole	Hole Configuration	Chip Breaker	Figure	Symbol	Hole	Hole Configuration	Chip Breaker	Figure
W	With Hole	Cylindrical Hole + One Countersink (40−60°)	No		**A**	With Hole	Cylindrical Hole	No	
T	With Hole		One Sided		**M**	With Hole	Cylindrical Hole	Single Sided	
Q	With Hole	Cylindrical Hole + Double Countersink (40−60°)	No		**G**	With Hole	Cylindrical Hole	Double Sided	
U	With Hole		Double Sided		**N**	Without Hole	–	No	
B	With Hole	Cylindrical Hole + One Countersink (70−90°)	No		**R**	Without Hole	–	Single Sided	
H	With Hole		One Sided		**F**	Without Hole	–	Double Sided	
C	With Hole	Cylindrical Hole + Double Countersink (70−90°)	No		**X**	–	–	–	Special Design
J	With Hole		Double Sided						

5. Insert Size

5. Insert Size							
Symbol							Diameter of Inscribed Circle (mm)
R	W	V	D	C	S	T	
	02		04	03	03	06	3.97
	L3	08	05	04	04	08	4.76
	03	09	06	05	05	09	5.56
06							6.00
	04	11	07	06	06	11	6.35
	05	13	09	08	07	13	7.94
08							8.00
09	06	16	11	09	09	16	9.525
10							10.00
12							12.00
12	08	22	15	12	12	22	12.70
15	10		19	16	15	27	15.875
16							16.00
19	13		23	19	19	33	19.05
20							20.00
			27	22	22	38	22.225
25							25.00
25			31	25	25	44	25.40
31			38	32	31	54	31.75
32							32.00

6. Insert Thickness

6. Insert Thickness

*Thickness is from the bottom of the insert to the top of the cutting edge.

Symbol	Thickness (mm)
S1	1.39
01	1.59
T0	1.79
02	2.38
T2	2.78
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

7. Insert Corner Configuration

7. Insert Corner Configuration	
Symbol	Corner Radius (mm)
00	Sharp Nose
V3	0.03
V5	0.05
01	0.1
02	0.2
04	0.4
08	0.8
12	1.2
16	1.6
20	2.0
24	2.4
28	2.8
32	3.2
00 : Inch M0 : Metric	Round Insert

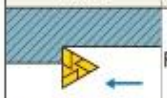
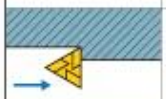
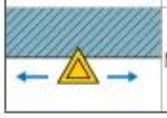
8. Cutting Edge Condition

8. Cutting Edge Condition

Figure	Cutting Edge	Symbol
	Sharp Cutting Edges	F
	Round Cutting Edges	E
	Chamfered Cutting Edges	T
	Chamfered and Rounded Cutting Edges	S

Mitsubishi Materials omit the honing symbol.

9. Cutting Direction

9. Cutting Direction		
Figure	Hand	Symbol
	Right	R
	Left	L
	Neutral	N

10. Chip Breaker

10. Chip Breaker		
LP	MP	RP
LM	MM	RM
LK	MK	RK
LS	MS	RS
FP	LP	MP
MA	SW	MW
HZ	HX	HV