

Wohlhaupter Insert Nomenclature

Reference Key

Symbol	Insert Type
▼	Roughing - Main Application
▽	Roughing - Extended Application
▼▼	Universal - Main Application
▽▽	Universal - Extended Application
▼▼▼	Finishing - Main Application
▽▽▽	Finishing - Extended Application

Reference Key

Symbol	Machining Conditions
●	Good - Main Application
○	Good - Extended Application
●	Average - Main Application
○	Average - Extended Application
⚙	Difficult - Main Application
⚙	Difficult - Extended Application

Reference Key

Symbol	Wohlhaupter Insert Grades
WHW	Uncoated carbide (HW)
WHC	Coated carbide (HC)
WHT	Uncoated cermet (HT)
WTC	Coated cermet (HC)
WCN	Ceramic cutting material (CN)
WBN	Cubic boron nitride CBN (BN)
WBC	Coated CBN (BC)
PCD	Polycrystalline diamond PCD (DP)

Wohlhaupter Inserts

F101	04	M	N	-	158	W	D
1	2	3	4		5	6	7

1. Wohlhaupter Insert Form	
211	262
20	264
161	112
163	113
47	114
101	04
103	05
104	89
105	90
123	91
124	304
39	325
75	

2. Corner Radius	
Metric (mm)	
005 = 0.05 mm	
01 = 0.10 mm	
02 = 0.20 mm	
03 = 0.30 mm	
04 = 0.40 mm	
06 = 0.60 mm	
08 = 0.80 mm	
12 = 1.20 mm	
16 = 1.60 mm	
20 = 2.00 mm	
24 = 2.40 mm	

3. Tolerance Group		
Metric (mm)		
G	Length of edge	±0.025
	IC	±0.025
M	Thickness	±0.13
	Length of edge	±0.08-0.15*
F	IC	±0.05-0.10*
	Thickness	±0.13
C	Length of edge	±0.013
	IC	±0.005
F	Thickness	±0.025
	Length of edge	±0.13
C	IC	±0.025
	Thickness	±0.025

*Varies upon insert size

4. Machining Direction	
N = Neutral	
L = Left	
R = Right	

5. Geometry						
Carbide	Carbide	Tangential	Ceramic	PCD	CBN	
108	155	880	711	720	741	
109	158	811		730	742	
112	161			735	745	
114	174W				747	
121	192				748	
122	199				749	
126	200				768	
127	650					
128	711					
129	840					
145	850					
146	860					

6. / 7. Optional Information	
W = Wiper Geometry	
D = Double Tipped	
T = Triple Tipped	

ISO Insert Nomenclature

DIN ISO 1832

C	C	M	T	09	T3	02
1	2	3	4	5	6	7

1. Basic Insert Form	2. Clearance Angle	3. Tolerance Group	4. Mounting Style
<p>C = Rhomboid 80°</p> <p>D = Rhomboid 55°</p> <p>L = Rectangular</p> <p>R = Round</p> <p>S = Square</p> <p>T = Triangular</p> <p>V = Rhomboid 35°</p> <p>W = Trigon</p>	<p>B = 5°</p> <p>C = 7°</p> <p>N = 0°</p> <p>P = 11°</p> <p>O = 10°</p>	<p>Metric (mm)</p> <p>Length of edge ±0.025</p> <p>G IC ±0.025</p> <p>Thickness ±0.13</p> <hr/> <p>Length of edge ±0.08-0.15*</p> <p>M IC ±0.05-0.10*</p> <p>Thickness ±0.13</p> <hr/> <p>Length of edge ±0.013</p> <p>F IC ±0.005</p> <p>Thickness ±0.025</p> <hr/> <p>Length of edge ±0.13</p> <p>C IC ±0.025</p> <p>Thickness ±0.025</p> <p>*Varies upon insert size</p>	<p>T = One-sided countersunk Cylindrical fixing hole Countersunk 40° - 60°</p> <p>H = One-sided chipbreaker Cylindrical fixing hole Countersunk 70° - 90°</p> <p>W = Without chipbreaker Cylindrical fixing hole Countersunk 40° - 60°</p> <p>X = Special design Special insert design</p> <p>A = Without chipbreaker Cylindrical fixing hole Without countersunk</p>

5. Insert Size / Cutting Edge							
Metric (mm)	C	D	R	S	T	V	W
3.97 mm					006		03
5.00 mm					F20		
6.00 mm					F21		
6.35 mm	06				11	11	
7.94 mm				07			
9.52 mm	09	11		09	16	16	
10.00 mm		10					
12.00 mm	12	12					
12.70 mm	16	15		12			
15.87 mm			15	15			
16.00 mm			16				
19.05 mm		19		19			
20.00 mm			20				
25.00 mm			25				
25.40 mm				25			

6. Insert Thickness
Metric (mm)
01 = 1.59 mm
02 = 2.38 mm
T2 = 2.78 mm
03 = 3.18 mm
T3 = 3.97 mm
04 = 4.76 mm
05 = 5.56 mm
06 = 6.35 mm
07 = 7.94 mm

7. Corner Radius
Metric (mm)
005 = 0.05 mm
01 = 0.10 mm
02 = 0.20 mm
03 = 0.30 mm
04 = 0.40 mm
06 = 0.60 mm
08 = 0.80 mm
12 = 1.20 mm
16 = 1.60 mm
20 = 2.00 mm
24 = 2.40 mm