### Definition of Modifications

#### Sizing
Looking at the top of the insert, sizing is the width of the cutting edge.

#### Radius
Looking at the top of the insert, the radii are the rounded corners of the cutting edge. A full radius means each radius is one half the width of the insert.

#### Depth of Cut
Looking at the top of the insert, depth of cut is the depth the insert will cut into part before edge(s) drag.

#### Chamfer
Looking at the top of the insert, chamfer is a secondary cutting edge. Standard angle is 45°.

#### Lead Angle
Looking at the top of the insert, lead angle is the angle along the cutting edge of the insert.

#### Included Angle
Looking at the top of the insert, the included angle is the angle between the cutting edges.

#### Top Rake
Looking at the side of the insert, top rake is the angle between the top of the insert and the cutting edge.

#### Chipbreaker
Looking at the side of the insert, a chipbreaker is a 1/32" radius ground .005" back from the cutting edge.

#### Back Clearance
Looking at the top of the insert, back clearance is the angle behind the cutting edge.

#### Side Clearance
Looking at the front of the insert, side clearance is the angle from the top of the insert to the bottom of the insert.
<table>
<thead>
<tr>
<th>Sketch Area</th>
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</table>

Submitting this form will generate a quotation within 48 hours which will include price, delivery and CAD drawing(s) for your review and approval. If you would like additional assistance include your application print or sketch.

Return quotation to:

Name: ________________________________

Company: _____________________________

Address: _____________________________

______________________________

Phone: (_____) - _______ - ____________

Fax: (_____) - _______ - ______________

Email Address: _______________________

<table>
<thead>
<tr>
<th>Left Hand Side Geometry</th>
<th>Right Hand Side Geometry</th>
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<tbody>
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</table>

- Insert Width in .xxx”
- Tolerance in + .xxx”/- .xxx”
  (± .001” standard)
- Full Radius
- Corner Radius in .xxx”
  Tolerance in + .xxx”/- .xxx”
  (± .002” standard)
- Total Depth of Cut in .xxx”
- Total Depth of Cut in .xxx”
- Chamfer Angle in x°
- Total Depth of Chamfer required in .xxx”
  Tolerance in + .xxx”/- .xxx”
  (± .001” standard)
- Lead Angle in x°
  Tolerance in +x”/-x”
  (± .5° standard)
- Included Angle in x°
  Tolerance in +x”/-x”
  (± .5° standard)
- Top Rake Angle in x°
  Positive
  Tolerance in +x”/-x”
  (± .5° standard)
- Back Clearance in x°
  Tolerance in +x”/-x”
  (± .5° standard)
- Side Clearance in x°
  Tolerance in +x”/-x”
  (± .5° standard)

1/32” Radius Chipbreaker with .005” land

TiN
TiCN
TiAIN
Diamond

Square
Straight
Right Hand
Round
90°
Left Hand

Clockwise
Counter-Clockwise