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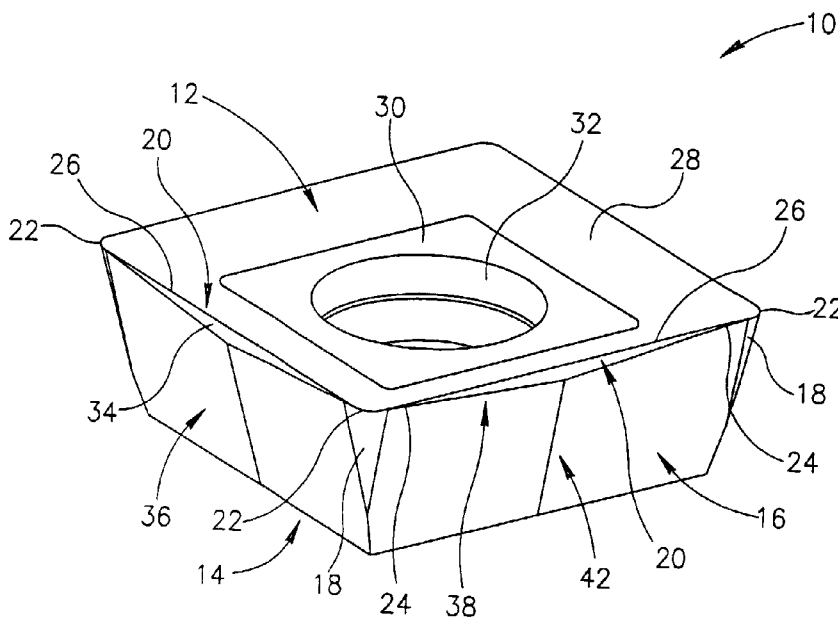
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(54) Title: CUTTING INSERT



(57) Abstract: A generally square-shaped indexable cutting insert (10) with four cutting edges (20) for mounting in milling cutters (52, 54) for either slotting operations or for left-hand and right-hand face milling of right-angled corners in a metal workpiece. The cutting edge is parallel to the bottom surface (14) and has a primary cutting edge (26) extending between two wipers (24), each wiper being adjacent a corner edge (22). A first relief surface (34) adjacent the primary cutting edge has a first relief angle (α_1) and a second relief adjacent the two wipers has a second relief angle (α_2) that is greater than the first relief angle. The first relief surface has a width dimension measured perpendicularly to the cutting edge that has a minimum value proximal to the two wipers and a maximum value at a central region (42) of the cutting edge.



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