

KTKF / KTKF GOOSE-NECK HOLDER

■ Indication of Description (See Table 1) ◆ Recommended Cutting Conditions

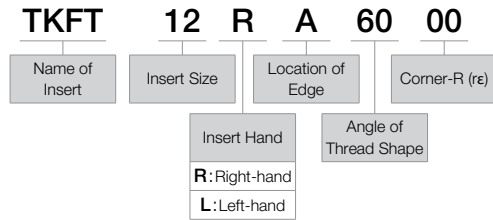
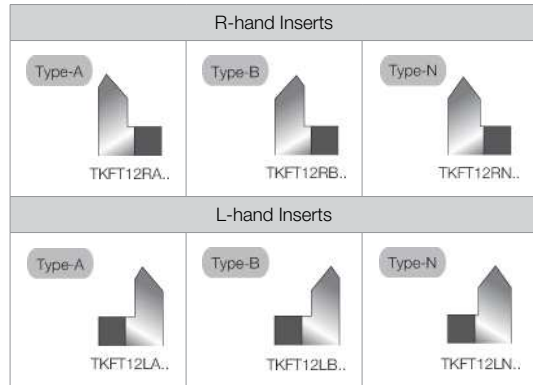


Table 1



Workpiece Material	Recommended Insert Grade			
	MEGACOAT NANO	MEGACOAT	PVD Coated Carbide	Carbide
	PR1425/PR1535	PR1225	PR1025	KW10
Carbon Steel	Vc (sfm) = 230-560		Vc (sfm) = 200-490	
	First D.O.C. (Radial)	under 0.0079"	First D.O.C. (Radial)	under 0.0079"
Alloy Steel	Vc (sfm) = 230-560		Vc (sfm) = 200-490	
	First D.O.C. (Radial)	under 0.0079"	First D.O.C. (Radial)	under 0.0079"
Stainless Steel	Vc (sfm) = 200-330		Vc (sfm) = 160-260	
	First D.O.C. (Radial)	under 0.0079"	First D.O.C. (Radial)	under 0.0079"
Cast Iron	-		-	
	-		-	
Aluminum	-		-	
	-		-	
Brass	-		-	
	-		-	

- Coolant is recommended.
- In case of threading stainless steel, please set two to three passes more than <D.O.C. - passes> listed above.

■ D.O.C. & Number of Passes

● 60° / 55° Partial Profile

(D.O.C. shows the value of radial ap.)

Thread Type	Pitch mm & TPI	Part Number	rε	Total D.O.C.	No. of Passes	1 Pass	2 Pass	3 Pass	4 Pass	5 Pass	6 Pass	7 Pass	8 Pass	9 Pass	10 Pass	11 Pass	12 Pass		
						Metric	External Threading	0.20mm	TKFT 12R/L A/B6000	Max 0.05 Flat	0.15	4	0.06	0.04	0.03	0.02			
		0.25mm	0.19	4	0.07	0.06	0.04	0.02											
		0.30mm	0.23	4	0.08	0.07	0.06	0.02											
		0.35mm	0.27	5	0.08	0.07	0.06	0.04			0.02								
		0.40mm	0.30	5	0.10	0.08	0.06	0.04			0.02								
		0.45mm	0.34	6	0.10	0.08	0.06	0.04			0.04	0.02							
		0.50mm	TKFT 12R/L A/B6000	Max 0.05 Flat	0.38	6	0.10	0.10	0.07	0.05	0.04	0.02							
		0.50mm	12R/L A/B60005	0.05	0.33	5	0.10	0.10	0.07	0.04	0.02								
		0.60mm	TKFT 12R/L A/B6000	Max 0.05 Flat	0.45	7	0.10	0.10	0.08	0.06	0.05	0.04	0.02						
		0.60mm	12R/L A/B60005	0.05	0.40	6	0.10	0.10	0.08	0.06	0.04	0.02							
		0.70mm	TKFT 12R/L A/B60005	0.05	0.48	6	0.10	0.10	0.10	0.10	0.06	0.02							
		0.75mm		0.05	0.52	7	0.10	0.10	0.10	0.08	0.07	0.05	0.02						
		0.80mm	TKFT 12R/L A/B60005	0.05	0.56	7	0.10	0.10	0.10	0.10	0.08	0.06	0.02						
		1.00mm		0.05	0.71	8	0.15	0.15	0.12	0.10	0.08	0.06	0.03	0.02					
		1.00mm	12R/L N6001	0.10	0.66	7	0.18	0.15	0.12	0.10	0.06	0.03	0.02						
		1.25mm		0.05	0.90	9	0.20	0.18	0.13	0.10	0.10	0.07	0.05	0.05	0.02				
		1.25mm	TKFT 12R/L N6001	0.10	0.85	8	0.20	0.18	0.13	0.10	0.10	0.07	0.05	0.02					
		1.50mm		0.10	1.04	10	0.20	0.18	0.14	0.12	0.10	0.10	0.08	0.05	0.05	0.02			
Parallel Pipe	External Threading	28 TPI	TKFT 12R/L A/B55005	0.0020	0.0264	7	0.007	0.006	0.005	0.004	0.002	0.002	0.001						
		19 TPI		0.0020	0.0398	9	0.008	0.007	0.006	0.005	0.005	0.004	0.003	0.002	0.001				
Whitworth	External Threading	24 TPI	TKFT 12R/L A/B55005	0.0020	0.0311	8	0.007	0.007	0.005	0.004	0.003	0.003	0.002	0.001					
		20 TPI		0.0020	0.0378	9	0.008	0.008	0.006	0.004	0.004	0.003	0.002	0.002	0.001				
		18 TPI		0.0020	0.0421	10	0.008	0.007	0.006	0.005	0.004	0.004	0.003	0.003	0.002	0.001			
		16 TPI		0.0020	0.0476	11	0.008	0.007	0.006	0.006	0.005	0.004	0.004	0.003	0.003	0.002	0.001		

■ TKFT How to use the Goose-neck Holder on automatic lathe (guide bushing system) See J4

Goose-neck Holder is applicable to automatic lathes whose toolholder does not move in longitudinal direction (Z-axis direction)