

TURNING INSERTS (BACK TURNING)

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Back Turning

Turning Inserts

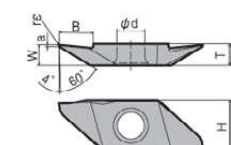
Usage Classification

- * Interruption / 1st Choice
 - ⊗ Interruption / 2nd Choice
 - Light Interruption / 1st Choice
 - Light Interruption / 2nd Choice
 - Continuous / 1st Choice
 - Continuous / 2nd Choice
- (Hardness Under 45HRC)

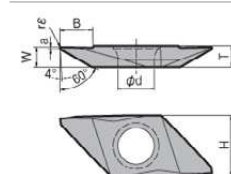
P	Free-Cutting Steel Carbon Steel / Alloy Steel	●	●	○	
M	Stainless Steel	●	○	○	
K	Gray Cast Iron Nodular Cast Iron				●
N	Non-ferrous Metals				○
S	Heat-Resistant Alloys Titanium Alloy	●	○	○	
H	Hard materials				●

TKFB Inserts
(for KTKF Toolholders)ANSI
Part Number

Dimension (mm)							MEGACOAT NANO		PVD Coated Carbide	Carbide	Toolholder Page
W	a	B	Corner Radius (in) rε	T	H	Ød	PR1425	PR1225	PR1025	KW10	
1.5	0.25	2.6	<0.002	3.0	8.7	5.2	●	●	○	○	E12
2.8	0.3	4.6	<0.002	3.0	8.7	5.2	●	●	○	○	
2.8	0.3	4.6	<0.004	3.0	8.7	5.2	●	●	●	○	
3.8	0.3	6.3	<0.002	4.0	9.5	5.2	●	●	○	○	
3.8	0.3	6.3	<0.004	4.0	9.5	5.2	●	●	○	○	
2.8	0.3	4.6	<0.002	3.0	8.7	5.2		●			
2.8	0.3	4.6	<0.004	3.0	8.7	5.2		●			
3.8	0.3	6.3	<0.002	4.0	9.5	5.2		●			
3.8	0.3	6.3	<0.004	4.0	9.5	5.2		●			



• Right-handed insert shown

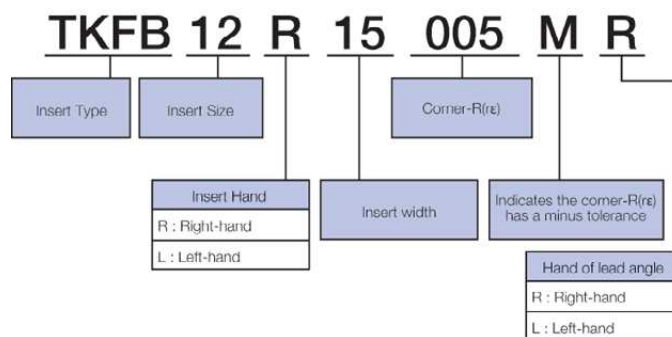


• Left-handed insert shown

• Insert whose corner R(rε) dimension expressed with less than sign (e.g. <0.002, <0.004, <0.008 etc.) indicate models with minus tolerance for corner R (rε).

Insert Identification System

(See tables below)



Small Depths of Cut		General Purpose		Large Depths of Cut		Toolholder	Right-hand (R)	Toolholder	Left-hand (L)
						Insert	Right-hand (R)	Insert	Left-hand (L)
						Lead angle	Right-hand (R)	Lead angle	Left-hand (R)
Part Number	Cutting Edge Length (S)	Part Number	Cutting Edge Length (S)	Part Number	Cutting Edge Length (S)				
TKFB12R15..	2.1mm	TKFB12R28..	4.2mm	TKFB16R38..	5.8mm				
-	-	TKFB12L28..	4.4mm	TKFB16L38..	6.2mm				

● : U.S. Stock Ⓡ : U.S. Stock (R-hand Only) Ⓛ : U.S. Stock (L-hand Only)

○ : World Express (Shipping: 7-10 Business Days) Ⓢ : World Express (R-hand Only) Ⓣ : World Express (L-hand Only)

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Inserts sold in 10 piece boxes.

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