

## When Using TKF-AS Inserts

KTKF toolholder is multi-functional for non-ferrous and non-metal materials when combined with a TKF-AS insert. (Fig.1)

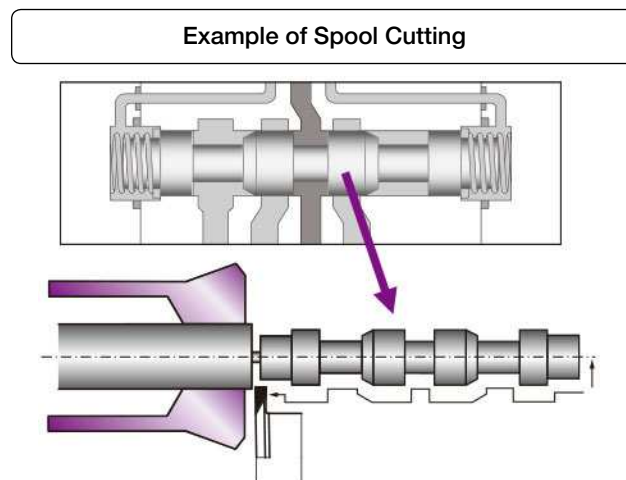
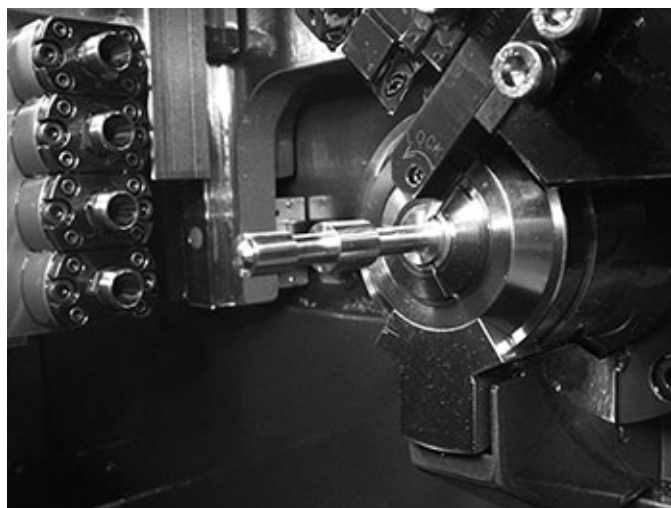


Fig.1 Example of the pass of KTKF toolholder + TKF-AS insert

## Recommended Cutting Conditions (TKF12 / TKF16)

Workpiece Material		PCD		Remarks
		KPD001		
		Grooving	Turning	
Aluminum alloys	Cutting speed Vc (sfm)	975~4925		Wet
	Feed rate f (ipr)	0.0004~0.0012	0.0008~0.0047	
Brass	Cutting speed Vc (sfm)	325~1150		
	Feed rate f (ipr)	0.0004~0.0020	0.0008~0.0059	

GRADES	<b>A</b>
INSERTS	<b>B</b>
CBN & PCD	<b>C</b>
TURNING	<b>E</b>
BORING	<b>F</b>
GROOVING	<b>G</b>
CUT-OFF	<b>H</b>
THREADING	<b>J</b>
SOLID END MILLS	<b>L</b>
MILLING	<b>M</b>
SPARE PARTS	<b>P</b>
TECHNICAL	<b>R</b>
INDEX	<b>T</b>