

TURNING INSERTS (BACK TURNING)

How to read this page **B13**

Back Turning

Turning Inserts (Small Tools)

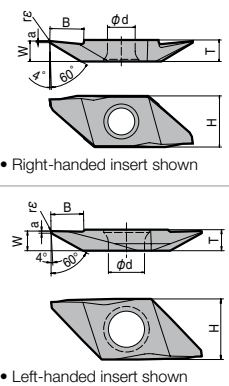
NEW

| | | | | | | | |
|----------|--|---|---|---|---|---|---|
| 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

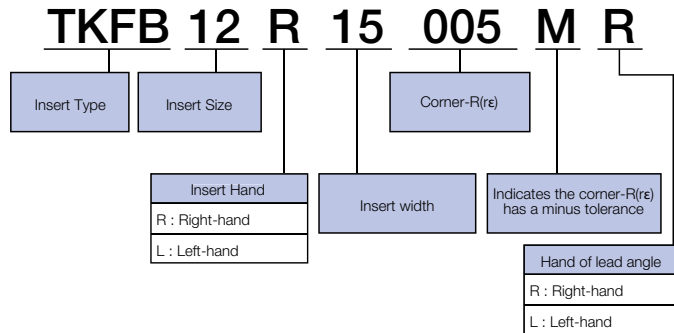
| W | a | B | Corner Radius (in) rε | T | H | Ød | Dimension (mm) | | | PVD Coated Carbide | Carbide | Toolholder Page | |
|--|-----|------|-----------------------|--------|-----|-----|----------------|---------|---------|--------------------|---------|-----------------|-----|
| | | | | | | | MEGACOAT NANO | PR1 425 | PR1 535 | | | | |
| TKFB 12R15005M 12R28005M 12R28010M | 1.5 | 0.25 | 2.6 | <0.002 | 3.0 | 8.7 | 5.2 | PR1 425 | PR1 535 | PR1 225 | PR1 025 | KW10 | E12 |
| | 2.8 | 0.30 | 4.6 | <0.002 | 3.0 | 8.7 | 5.2 | ● | ● | ● | ○ | ○ | |
| | 2.8 | 0.30 | 4.6 | <0.004 | 3.0 | 8.7 | 5.2 | ● | ● | ● | ● | ○ | |
| TKFB 16R38005M 16R38010M | 3.8 | 0.30 | 6.3 | <0.002 | 4.0 | 9.5 | 5.2 | ● | ● | ● | ○ | ○ | |
| | 3.8 | 0.30 | 6.3 | <0.004 | 4.0 | 9.5 | 5.2 | ● | ● | ● | ○ | ○ | |
| TKFB 12L28005MR 12L28010MR | 2.8 | 0.30 | 4.6 | <0.002 | 3.0 | 8.7 | 5.2 | | ● | ● | | | |
| | 2.8 | 0.30 | 4.6 | <0.004 | 3.0 | 8.7 | 5.2 | | ● | ● | | | |
| TKFB 16L38005MR 16L38010MR | 3.8 | 0.30 | 6.3 | <0.002 | 4.0 | 9.5 | 5.2 | | ● | ● | | | |
| | 3.8 | 0.30 | 6.3 | <0.004 | 4.0 | 9.5 | 5.2 | | ● | ● | | | |



• Right-handed insert shown
• Left-handed insert shown

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

Insert Identification System (See Tables Below)



| Small Depths of Cut | General Purpose | Large Depths of Cut |
|---------------------|--------------------|---------------------|
| <p>TKFR12R15</p> | <p>TKFB12R28..</p> | <p>TKFB16R38..</p> |

| Toolholder | Right-hand (R) | Toolholder | Left-hand (L) |
|------------|----------------|------------|----------------|
| Insert | Right-hand (R) | Insert | Left-hand (L) |
| Lead Angle | Right-hand (R) | Lead Angle | Right-hand (R) |
| | | | |