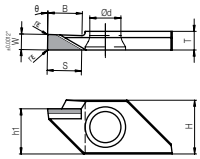
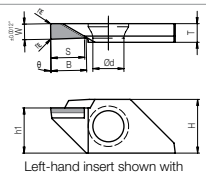
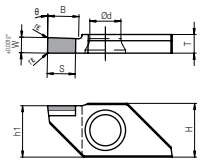
Grooving
1 - Edge

How to read this page B13

Edge Prep.		N	Non-Ferrous Metals (with Interruption)	●
All PCD Items	Sharp Edge		Non-Ferrous Metals (without Interruption)	●
		S	Titanium Alloys (with Interruption)	●
			Titanium Alloys (without Interruption)	●

Insert	ANSI Part Number	W±0.0012 (in)	W±0.03 (mm)	B	+0.00 -0.05 rε	T	H	h1	Ød	S	Angle (°) θ	No. of Edges	PCD KPD001	Toolholder Page
Turning Grooving  	TKF12R/L 200-AS	0.079	2.0	5.0	0.1	3	8.7	7.3	5	5.5	0°	1	®	E12
	250-AS	0.098	2.5	5.0	0.1	3	8.7	7.3	5	5.5			○	
	TKF16R/L 250-AS	0.098	2.5	8.0	0.1	4	9.5	8.0	5	6.5	0°	1	○	
Turning Grooving NEW   Left-hand insert shown with right-hand PCD edge	TKF12R/L 200-ASR	0.079	2.0	5.0	0.1	3	8.7	7.3	5	5.5	0°	1	Ⓛ	
	250-ASR	0.098	2.5	5.0	0.1	3	8.7	7.3	5	5.5			Ⓛ	
	TKF16R/L 250-ASR	0.098	2.5	8.0	0.1	4	9.5	8.0	5	6.5	0°	1	Ⓛ	
External Grooving (Turning is Possible)  	TKF12R/L 150-NB	0.059	1.5	3.5	0.1	3	8.7	8.3	5	2.0	0°	1	○	
	200-NB	0.079	2.0	4.0	0.1	3	8.7	8.3	5	3.0			○	
	250-NB	0.098	2.5	4.0	0.1	3	8.7	8.3	5	3.0			®	
	250-NB4.5	0.098	2.5	5.0	0.1	3	8.7	8.3	5	4.5			®	

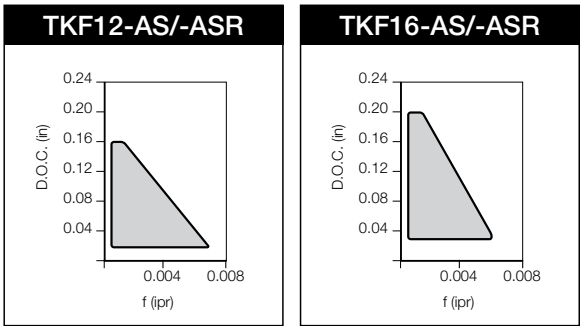
- Lead angle (front cutting edge angle: θ) shows the angle when installed into toolholder
- TKF PCD inserts are only for turning and grooving
- Cut-off is not recommended.
- Dimension B shows available grooving depth

Insert Identification System

TKF	12	R	200	-	AS	
TKF	12	L	200	-	AS	R

- Insert Type: TKF
- Insert Size: 12
- Insert Hand: R : Right-hand; L : Left-hand
- Width (Edge Width): 200
- Name of Chipbreaker: AS : AS Chipbreaker; NB : Without Chipbreaker
- PCD Insert Hand: Without Indication: The edge hand is the same as the insert hand.; R : Right-hand

Applicable Range



- TKF PCD inserts are only for turning and grooving
- Cut-off is not recommended

Note) 1. The cutting edge of the TKF-AS/-ASR will be 0.04" lower than the center line when attached to the KTKF toolholder (Ref. **Fig.1**). Adjust the height by making NC lathe parameter settings or inserting a plate.

2. If the 0.04" adjustment is not possible on your automatic lathe, use the TKF-NB (Ref. **Fig.2**).

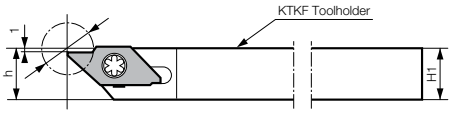


Fig.1 When a TKF-AS/-ASR insert is attached
(The cutting edge is 0.04" lower than the center line.)

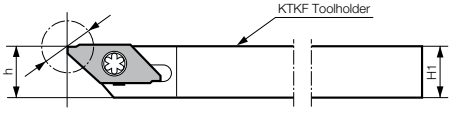


Fig.2 When a TKF-NB insert is attached

● : 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)