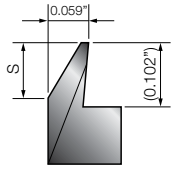
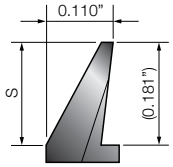
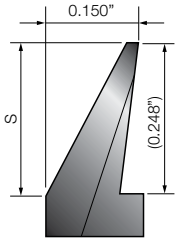
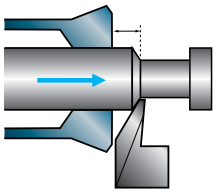
Edge Tips Details and Selection Guide

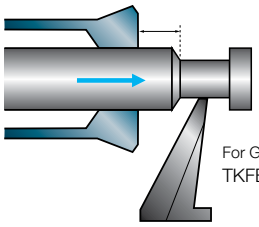
Cutting Edge Shape

For Small D.O.C.		For General Purpose		For Large D.O.C.	
					
Part Number	Cutting Edge Length **S**	Part Number	Cutting Edge Length **S**	Part Number	Cutting Edge Length **S**
TKFB12R15..	0.083"	**TKFB12R28..**	0.165"	**TKFB16R38..**	0.228"
-	-	**TKFB12L28..**	0.173"	**TKFB16L38..**	0.244"
For small diameter workpieces or short length Minimum overhang length of toolholder, stable machining		For general purpose Good chip control		D.O.C. per pass is large.	

How to Select



For Small D.O.C.
TKFB12R15..

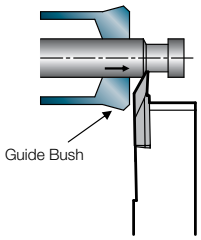
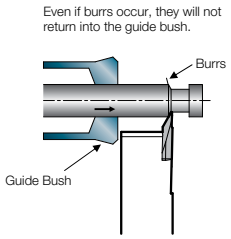


For General Purpose
TKFB12R28..

In case D.O.C. is same, if insert with narrower edge width is used, overhang length from guide bushing is shorter, which enables better stability due to less workpiece vibration.

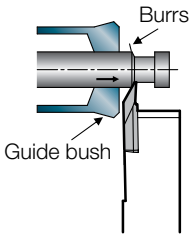
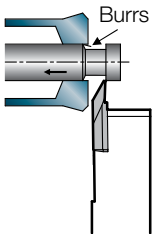
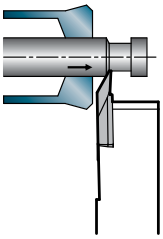
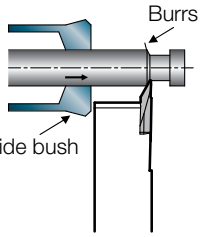
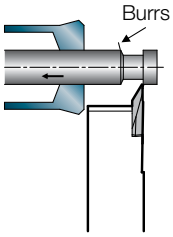
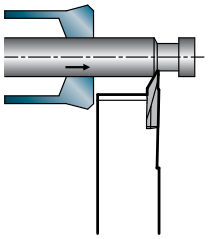
➡High Precision Cutting

Choosing Hand of Back Turning Toolholder

(R) Right-hand		Cutting close to guide bushing is possible Since TKFB12R15005M has a narrow cutting edge (width=0.059"), cutting close to guide bushing is possible ➡Good for small parts and high precision cutting
(L) Left-hand		Cutting with distance from guide bushing Good chip control due to large space between the guide bushing and the tool. ➡How to improve chip control for roughing to finishing In case of using a left-hand toolholder in finishing, the burred portions of workpiece do not return into the guide bushing, which enables stability of external diameter. Also, a Left-hand toolholder prevents wear of guide bushing due to chip biting.

Workpiece Material Motion & How to Select Hand of Tool

When Roughing, Medium, & Finishing

	Roughing	Workpiece position after roughing	Finishing
(R) Right-hand			
(L) Left-hand			

※Good dimensional accuracy: If a Left-hand toolholder is used, burrs on workpiece generated during roughing do not damage the guide bushing during finishing.