
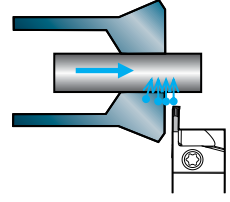
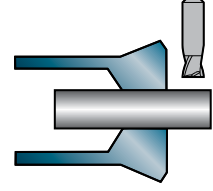
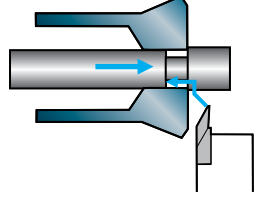
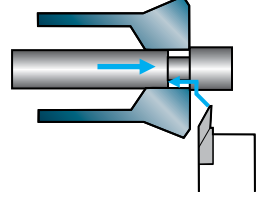
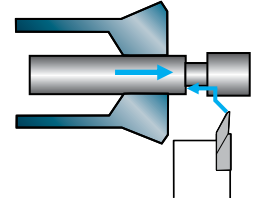
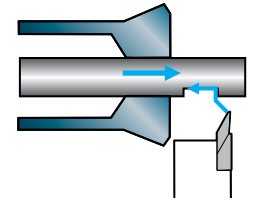


BACK TURNING TOOLHOLDERS [TKFB INSERT]

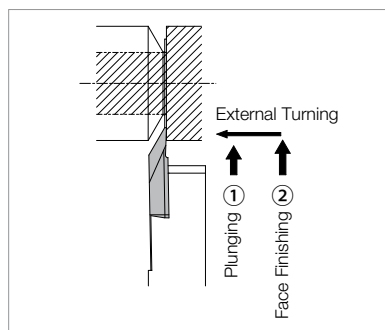
Chip Control Improvement During Back Turning

	① Chip control improvement by tool pass changes	② Chip control improvement by tool pass changes
<p>Roughing / Pre-Stage Machining</p> 	<p>● Roughing (1) GMM2420-020MW (Grooving)</p> 	<p>● Pre-stage Machining is Processed with Solid End Mill (1) 2FESW040-040-04 (Solid End Mill)</p> 
<p>Finishing (Countermeasure 1) Use Right-Hand Toolholder</p>	<p>(1) When Using TKFB12R28010M (Back Turning / Right-hand)</p>  <p>Advantages : Smooth Surface Finish Disadvantages : If machining pass is long, the guide bushing can not support the workpiece</p>	<p>(1) When Using TKFB12R28010M (Back Turning / Right-hand)</p>  <p>Advantages : 1. Minimal deflection during long machining passes 2. Chips are broken into small pieces, though the workpiece material is elastic. Disadvantages : The pre-stage machining may cause fractures, because of interruption</p>
<p>Finishing (Countermeasure 2) Use Left-Hand Toolholder</p>	<p>(2) When Using TKFB12L28010M (Back Turning / Left-hand)</p>  <p>Advantages : 1. Smooth Surface Finish 2. High precision cutting if the machined portion does not contact the guide bushing Disadvantages : If machining pass is long, the guide bushing can not support the workpiece</p>	<p>(2) When Using TKFB12L28010M (Back Turning / Left-hand)</p>  <p>Advantages : 1. Minimal deflection during long machining passes 2. Chips are broken into small pieces, though the workpiece material is elastic 3. High precision cutting if the machined portion does not contact the guide bushing Disadvantages : The pre-stage machining may cause fractures, because of interruption</p>

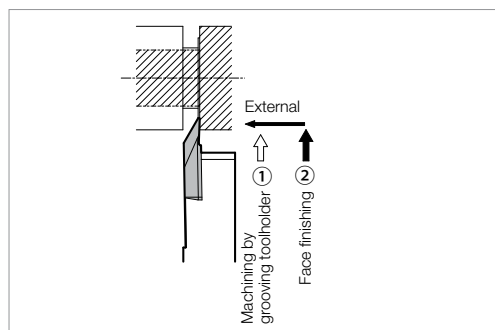
Peeled Surface Countermeasures During Face Back Turning

When peeled surface occurs on the workpiece face, please apply the countermeasures below.

● Countermeasure 1 (Face Finishing)



● Countermeasure 2 (Face Finishing After Grooving)



GRADES	A
INSERTS	B
CBN & POD	C
TOOLHOLDERS	D
SMALL TOOLS	E
BORING	F
GROOVING	G
CUT-OFF	H
THREADING	J
HSK TOOLING	N
SPARE PARTS	P
TECHNICAL	R
INDEX	T