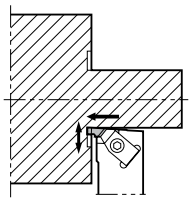
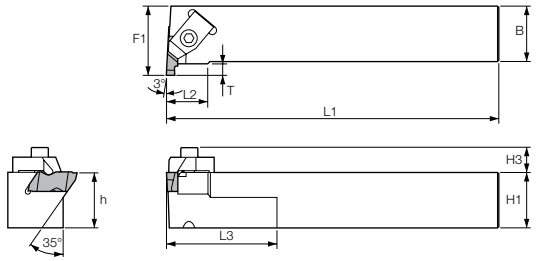
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KKCE





• Right-hand shown

• Left-hand Insert for Right-hand Toolholder, Right-hand Insert for Left-hand Toolholder

Toolholder Dimensions

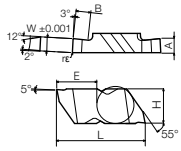
Part Number	Stock		Dimensions (inch)								Spare Parts		
											Clamp	Clamp Screw	Wrench
	R	L	H1	H3	B	L1	L2	F1	L3	T			
KKCER/L **12-3B**	●	●	0.750	0.465	0.750	4.500	0.750	1.125	2.000	0.210	CKC-3	SKC-3	LW-156
16-3D	●	●	1.000	0.465	1.000	6.000	0.750	1.250	2.000	0.210			
20-3D	●	●	1.250	0.465	1.250	6.000	0.750	1.500	2.000	0.210			

Applicable Inserts

Application	Face Grooving
Ref. Page	**Below**
Insert / Toolholder	
KKCER/L**...3**	KCF_3...

Face Grooving Limits		
Insert Part Number	Maximum Groove Depth	Minimum Groove Diameter
KCFP3...	0.060	0.940
	0.094	1.200
	0.125	1.420
	0.150	1.630

KCFP Inserts

Insert Right-handed Insert Shown		Part Number	Unit	Dimensions (in)								Insert Grade					
				W		B	rε	A	L	H	E	Cermet		PVD		Carbide	Ceramic
				(in)	(mm)							TC40	TC60	PR630	PR930	KW10	A65
		**KCFP 3125**R/L	inch	0.125	3.15	0.150	0.008	0.195	0.886	0.344	0.405				●		
		3156R/L		0.156	3.97	0.150	0.008	0.195	0.886	0.344	0.405				●		
		3189R/L		0.189	4.80	0.150	0.023	0.195	0.886	0.344	0.405				●		

• Dimension B shows available Grooving Depth.

Recommended Cutting Conditions (Cera-Notch)

Workpiece Material	Cermet Feeds (ipr)	Carbide Feeds (ipr)	Recommended Insert Grade (Vc : sfm)						
			Cermet		MEGACOAT	Carbide			Ceramic
			TC40	**TC60**	**PR1215**	**PR660**	**PR930**	**KW10**	**A65**
Carbon Steel	0.002~0.005	0.002~0.010	300~900	250~900	300~800	200~550	250~650	-	-
Alloy Steel	0.002~0.005	0.002~0.010	250~800	250~800	300~750	100~500	150~550	-	-
Stainless Steel	0.002~0.005	0.002~0.010	-	200~600	300~600	100~550	100~550	-	-
Tool Steel	0.002~0.005	0.002~0.010	200~650	200~650	300~600	-	100~550	-	-
Hardened Steel (>45Rc)	-	-	-	-	-	-	-	-	250~500*
Gray Cast Iron	0.003~0.006	0.002~0.012	200~700	-	300~700	-	-	-	500~1000
Ductile Iron	0.003~0.006	0.002~0.012	-	150~600	300~600	-	-	-	500~1000
Aluminum	0.002~0.008	0.002~0.012	150~1600	-	-	-	-	500~1600	-

Speeds & Feeds listed are for external grooving. Reduce parameters by 10% for internal grooving.
*Feeds = 0.003~0.008 ipr

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