для заказа - kyocera@kyocera-tools.ru

Tool Selection

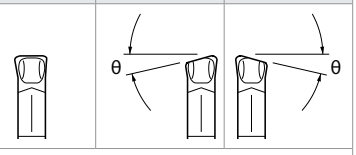
		Small Diameter Cut-Off	KGD	KGM	KTKB / KTKH
Insert	1. Insert's Edge Number 1-edge Insert··· For Larger Dia. Workpiece (Max. 4.724" / Ø120mm)	-	-	-	✓
	2-edge Insert··· For Smaller Dia. Workpiece Cost per corner is reduced	✓	✓	✓	-
	2. Use a neutral angle insert if there is no restriction to the size of boss left on part. (See **Fig.3** Below)	TKF...S TKF...NB TKFS...S	GDM GDMS	GMM	TKN
	3. Use an angled insert to reduce the size of the remaining boss.	TKF...DR	GDM-R/L (Fig. 2)	GMM-R/L (Fig. 2)	TKR/L (Fig. 1)
	4. Use a sharp-cornered lead-angled insert to make the remaining boss much smaller when machining small parts and thin parts.	TKF...DR	-	GMM-R/L (Fig. 2)	-
	5. Use the minimum width insert suitable for the machining.	✓	✓	✓	✓
Tololholder	1. Use a suitable toolholder (blade) for the workpiece dia.	✓	✓	✓	✓
	2. Use a more rigid toolholder (blade).	✓	✓	✓	✓
	3. Use a side screw or self clamp toolholder if there is no space for clamping tools from top side (for small tools).	✓	-	-	-

How to Select Cut-Off Inserts

1) Use a neutral angle insert, when remaining boss is not a concern. (See **Fig.1**)

2) Use an angled insert to reduce the remaining boss. (See **Fig.2**)

3) Use a sharp-edged insert with lead angle to minimize the remaining boss when cutting small parts and thin parts. (See **Fig.3**)

Lead Angle Hand	N (Neutral)	R (Right-Hand)	L (Left-Hand)
			

- Angled (θ) insert can reduce burr when cutting off.
- When using a larger lead angle (θ), cutting resistance becomes smaller. The feed rate should be reduced.

Fig.1

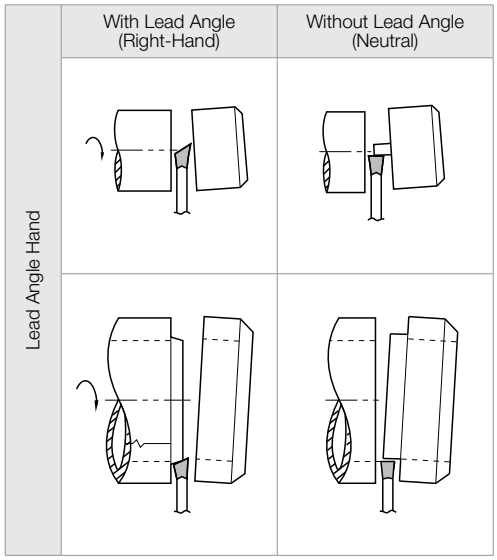


Fig.2

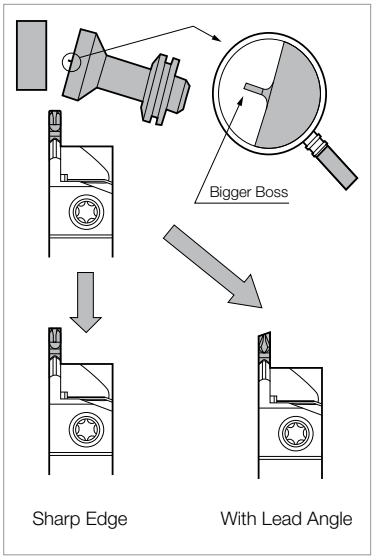


Fig.3

Caution

1) Set the cutting edge height 0.004"-0.008" above the center height
2) Always apply sufficient coolant to the cutting edge
3) Constant spindle revolution is recommended to obtain stable tool life
4) Cut-off as close to the chuck as possible
5) Decrease the feed rate from 1/2 to 1/3 when diameter is same as cut-off width

- Overuse of insert and toolholder (blade) may cause insert breakage and toolholder (blade) damage.
- Do not rework the insert and toolholder (blade) to prevent damage
- Clean the insert pocket well with compressed air when replacing insert

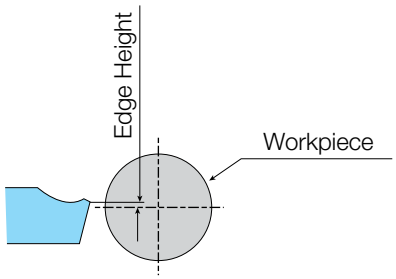


Fig.4

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