для заказа - kyocera@kyocera-tools.ru

2) When using both Main and Sub spindles

In this case, when the cutting edge runs beyond the center line, the insert will contact the workpiece, since the workpiece does not fall off.
Therefore the programmed distance beyond the center must be considered.
e.g. When the cutting edge is programmed to run 1mm beyond the center.
Workpiece maximum, ØD2 (**Fig.4**) = [ØDmax - 0.039"×2] (in)
(The clearance between the insert and the workpiece is 0.008")

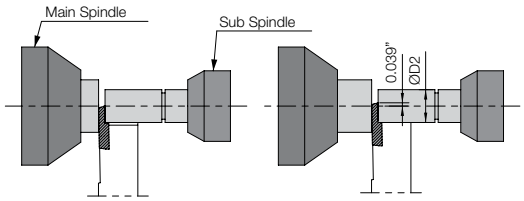
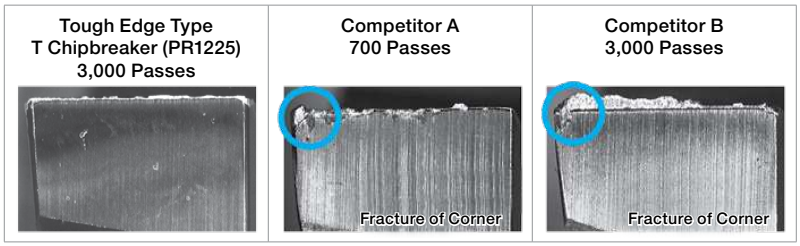


Fig.3 (When the edge is at the center)

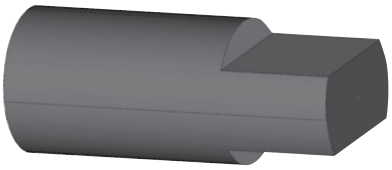
Fig.4 (When the edge is 0.008" beyond the center)

Tough Edge Type T Chipbreaker

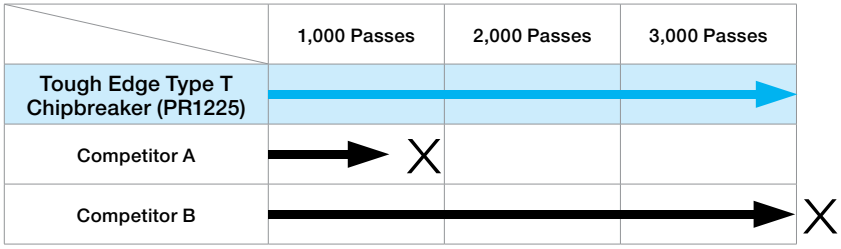
Fracture Resistance Comparison (Interrupted Machining)



Cutting Conditions
Vc=250 f=0.0020ipr (Cut-Off 0.0006ipr)
Wet W1-9 (with flat cuts on two sides)
TKF12R200-T-16DR (PR1225)



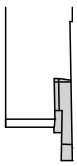
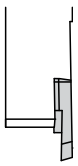
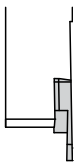
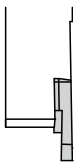
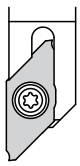
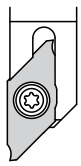
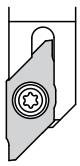
Worpiece (with flat cuts on two sides)



Compared to Competitor A and B, Tough Edge "T Chipbreaker" achieves superior fracture resistance during interrupted cutting.

How to Select Edge Preparation

Troubleshooting

Problems	Countermeasures	Countermeasures						
		Lead Angle (θ)		Edge Width		Name of Chipbreaker		
		No (0°)	Yes	Narrower	Wider	S	T	NB
								
Insert Fracture	Insert Fracture Prevention	Effective			Effective		Effective	Effective
Long Cutting Time	Cutting Time Reduction	Effective			Effective		Effective	Effective
Entangled Chips	Chip Entanglement Prevention	Effective		Effective		Effective		
Large Boss Remains	Small Boss Remains		Effective	Effective		Effective		
Ring Remains (Hollow Workpiece)	Prevention of Ring		Effective	Effective		Effective		
Deformation of thin walled workpiece (pipe)	Preventing Deformation		Effective	Effective		Effective		