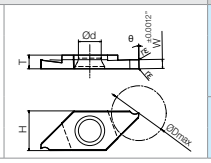
для заказа - kyocera@kyocera-tools.ru

NEW ITEMS!

Applicable Inserts

Classification of Usage
● : Light Interruption / 1st Choice
◔ : Light Interruption / 2nd Choice
● : Continuous / 1st Choice
○ : Continuous / 2nd Choice

		NEW				
P	Carbon Steel / Alloy Steel	●	◔	◔	◔	
M	Stainless Steel	◔	●	◔	◔	
K	Cast Iron					●
N	Non-ferrous Metals					●

Insert (Right-handed Insert Shown)	Part Number	Dimensions (in) W inch	W mm	ØD Max	rε	T	H	Ød	Angle θ	MEGACOAT NANO PR1425	MEGACOAT NANO PR1535	MEGACOAT PR1225	PVD Coated Carbide PR1025	Carbide KW10
	TKFS12R/L 100-S	0.039	1.0	0.236	0.002	0.087	0.343	0.173	0°	●	●	●	○	○
	TKFS12R/L 150-S	0.059	1.5	0.354	0.002	0.087	0.343	0.173	0°	●	●	●	○	○
	TKFS12R/L 200-S	0.079	2.0	0.472	0.002	0.087	0.343	0.173	0°	●	●	●	○	○
	TKFS12R/L 150-S	0.059	1.5	0.551	0.002	0.087	0.374	0.173	0°	●	●	●	○	○
	TKFS12R/L 200-S	0.079	2.0	0.630	0.002	0.087	0.374	0.173	0°	●	●	●	○	○

• Lead angle shows the angle when installed in the toolholder.
• As Fig.1 of ➔ **H10** shows, the cutting diameter of the insert is measured when the lead edge passes 0.039" past the center line of part.

Recommended Cutting Conditions

Workpiece Material	Recommended Grade (Vc sfm) MEGACOAT NANO PR1425	MEGACOAT NANO PR1535	MEGA COAT PR1225	PVD Coated Carbide PR1025	Carbide KW10	TKFS12 Width 0.039" (1.0mm)	TKFS12 Width 0.059" (1.5mm)	TKFS12 Width 0.079" (2.0mm)	TKFS16 Width 0.059" (1.5mm)	TKFS16 Width 0.079" (2.0mm)	Notes
						Feed Rate (ipr)			Feed Rate (ipr)		
Carbon Steel	★ 225~550	☆ 230~490	☆ 225~500	☆ 200~425	-	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	Wet
Alloy Steel	★ 225~550	☆ 230~490	☆ 225~500	☆ 200~425	-	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	
Stainless Steel	☆ 200~450	★ 200~400	☆ 200~400	☆ 175~325	-	0.0004~0.0008	0.0004~0.0008	0.0004~0.0012	0.0004~0.0008	0.0004~0.0012	
Cast Iron	-		-	-	★ 175~325	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	
Aluminum	-		-	-	★ 650~1475	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	0.0004~0.0012	
Brass	-		-	-	★ 325~650	0.0004~0.0016	0.0004~0.0016	0.0004~0.0016	0.0004~0.0016	0.0004~0.0016	

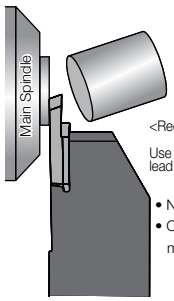
★ : 1st Recommendation ☆ : 2nd Recommendation

KTKF / KTKFS Selection Reference

KTKF

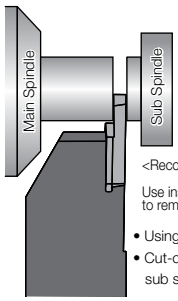
• Both Right-hand and Left-hand types are applicable to gang tool post
• Left-hand type is used during cut-off operations using sub spindle

KTKFR Right-Hand Toolholder



<Recommendation>
Use insert without lead angle.
• Not Using Sub Spindle
• Cut-off operation near main spindle side

KTKFL Left-Hand Toolholder

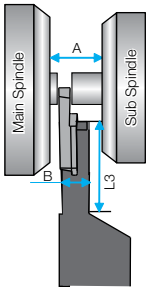


<Recommendation>
Use insert with lead angle to remove boss.
• Using Sub Spindle
• Cut-off operation near sub spindle side

KTKFS

• When machining workpiece with small diameter, use KTKFS to reduce overhang distance from the main spindle

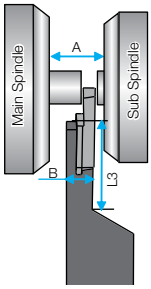
KTKFSR Right-Hand Toolholder



<How to Select> R-Hand
• Long workpiece and more rigidity
• Cut-off operation near main spindle side

<How to Select> L3 Dimension
• Sub Spindle Dia. Ø40mm→22 (A type) Ø50mm→26 (B type)

KTKFSL Left-Hand Toolholder



<How to Select> L-Hand
• Short workpiece and less rigidity
• Cut-off operation near main spindle side

<How to Select> L3 Dimension
• Sub Spindle Dia. Ø40mm→22 (A type) Ø50mm→26 (B type)

Inserts are sold in 10 piece boxes