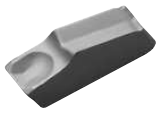
для заказа - kyocera@kyocera-tools.ru

CUT-OFF INSERTS

TKN / TKR/L

Classification of Usage												
◕ : Light Interruption / 1st Choice ◔ : Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice	P	Carbon Steel / Alloy Steel	○		◕			○		Ref. Page for Toolholder
	M	Stainless Steel			◔	◕		○		
	K	Cast Iron							◕	
	N	Non-ferrous Metals							◕	

NEW: ○ (CR9025), ◕ (PR1535)

Insert (Right-handed Insert Shown)	Part Number	Dimmensions (in) W inch	W mm	rε	Angle (°) θ	Cermet TN620	Cermet TN90	CVD Coated Carbide CR9025	MEGACOAT NANO PR1535	PVD Coated Carbide PR660	PVD Coated Carbide PR930	Carbide KW10	Ref. Page for Toolholder
	TKN 1.6	0.063	1.6	0.006	-		●	●	○	●	○	○	
	2	0.087	2.2	0.008		○	○	●	○	●	○	●	
	2.4	0.094	2.4	0.008		○	●	○	○	●	○	●	
	3	0.122	3.1	0.010		○	○	●	●	●	○	●	→ H28 → H30
	4	0.161	4.1	0.012		○	○	●	●	●	○	●	
	4.8	0.189	4.8	0.012				●	○				
	5	0.201	5.1	0.012				●	●	●	●	●	
	6	0.252	6.4	0.014				●	○	○		○	
	8	0.315	8.0	0.016				○	○	○			→ H28
	9	0.378	9.6	0.018				○	○	○			
 Low Feed	TKN 1.6-P	0.063	1.6	0.008	-			○	○	○		○	
	2-P	0.087	2.2	0.008		○	○	○	○	○	○	○	→ H28 → H30
	3-P	0.122	3.1	0.010		○	○	●	●	●	○	○	
 With Lead Angle	TKR/L 1.6	0.063	1.6	0.006	8°		Ⓡ	Ⓡ	○	●	Ⓡ	Ⓛ	
	2	0.087	2.2	0.008		Ⓡ	Ⓡ	○	○	Ⓡ	Ⓡ	Ⓡ	
	2.4	0.094	2.4	0.008				○	○	●	Ⓡ	Ⓡ	
	3	0.122	3.1	0.010		Ⓡ	Ⓡ	●	●	Ⓡ	○	Ⓡ	
	4	0.161	4.1	0.012		Ⓡ	○	Ⓡ	●	○		○	
	5	0.201	5.1	0.012				●	●	●		Ⓡ	→ H28 → H30
 Low Feed / Lead Angle	TKR/L 1.6-P	0.063	1.6	0.008	8°				Ⓡ	Ⓡ			
	2-P	0.087	2.2	0.008			Ⓡ	Ⓡ	○	○	Ⓡ	Ⓡ	
	3-P	0.122	3.1	0.010		Ⓡ	Ⓡ	Ⓡ	●	Ⓡ	Ⓡ	Ⓡ	

Recommended Cutting Condtions → H32

Cut-Off Tools

Name	Chipbreaker		Advantages
General Cut-Off	Standard (No Indication)		General cut-off type for feed rates over 0.004ipr Superior chip evacuation
Low Feed Cut-Off	P		Chipbreaker specially designed for low feed machining on automatic lathes, etc. Chips are controlled at feed rates between 0.0012~0.0032ipr

Insert's Edge Shape (CERACUT Cut-Off)

	Chamfered + Honed	Sharp Edge	Honed Cutting Edge
Edge Preparation			
Standard Chipbreaker	TN90 CR9025 / PR660	PR1535 PR930 / KW10	-
P-Chipbreaker	-	-	TN620 / TN90 / CR9025 / PR1535 PR660 / PR930 / KW10

• Sharp edge can reduce cutting resistance by 40%, compared with chamfered edge.

TKN / TKR/L Setup

1. Tap the insert lightly with a plastic hammer to push it tight enough that it cannot be removed by hand. **(Fig.1)**
2. Remove the insert with the supplied wrench. **(Fig.2)**

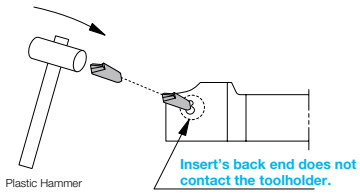


Fig. 1 How to Attach Inserts

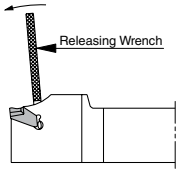


Fig. 2 How to Detach Inserts

Inserts are sold in 10 piece boxes

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www.kyocera-tools.ru

● : U.S. Stock Ⓡ : U.S. Stock (R-hand Only) Ⓛ : U.S. Stock (L-hand Only)
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