для заказа - kyocera@kyocera-tools.ru

Indication of Description (See Table 1)

TKFT 12 R A 60 00

- TKFT: Name of Insert
- 12: Insert Size
- R: Insert Hand (R: Right-hand, L: Left-hand)
- A: Location of Edge
- 60: Angle of Thread Shape
- 00: Corner-R (rε)

Table 1

R-hand Inserts		
Type-A  TKFT12RA..	Type-B  TKFT12RB..	Type-N  TKFT12RN..
L-hand Inserts		
Type-A  TKFT12LA..	Type-B  TKFT12LB..	Type-N  TKFT12LN..

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade			
	MEGACOAT NANO	MEGACOAT	PVD Coated Carbide	Carbide
	PR1425/PR1535	PR1225	PR1025	KW10
Carbon Steel	Vc (sfm) = 230-560		Vc (sfm) = 200-490	-
	First D.O.C. (Radial) under 0.0079"		First D.O.C. (Radial) under 0.0079"	
Alloy Steel	Vc (sfm) = 230-560		Vc (sfm) = 200-490	-
	First D.O.C. (Radial) under 0.0079"		First D.O.C. (Radial) under 0.0079"	
Stainless Steel	Vc (sfm) = 200-330		Vc (sfm) = 160-260	-
	First D.O.C. (Radial) under 0.0079"		First D.O.C. (Radial) under 0.0079"	
Cast Iron	-		-	Vc (sfm) = 330
				First D.O.C. (Radial) under 0.0079"
Aluminum	-		-	Vc (sfm) = 490-1310
				First D.O.C. (Radial) under 0.0079"
Brass	-		-	Vc (sfm) = 490-980
				First D.O.C. (Radial) under 0.0079"

- Coolant is recommended.
- In case of threading stainless steel, please set two to three passes more than <D.O.C. - passes> listed above.

D.O.C. & Number of Passes

60° / 55° Partial Profile

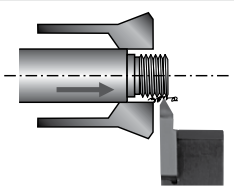
(D.O.C. shows the value of radial ap.)

Thread Type		Pitch mm & TPI	Part Number	rε	Total D.O.C.	No. of Passes	1 Pass	2 Pass	3 Pass	4 Pass	5 Pass	6 Pass	7 Pass	8 Pass	9 Pass	10 Pass	11 Pass	12 Pass
Metric	External Threading	0.20mm	TKFT 12R/L A/B6000	Max 0.05 Flat	0.15	4	0.06	0.04	0.03	0.02								
		0.25mm			0.19	4	0.07	0.06	0.04	0.02								
		0.30mm			0.23	4	0.08	0.07	0.06	0.02								
		0.35mm			0.27	5	0.08	0.07	0.06	0.04	0.02							
		0.40mm			0.30	5	0.10	0.08	0.06	0.04	0.02							
		0.45mm			0.34	6	0.10	0.08	0.06	0.04	0.04	0.02						
		0.50mm	TKFT 12R/L A/B6000	Max 0.05 Flat	0.38	6	0.10	0.10	0.07	0.05	0.04	0.02						
			12R/L A/B60005	0.05	0.33	5	0.10	0.10	0.07	0.04	0.02							
		0.60mm	TKFT 12R/L A/B6000	Max 0.05 Flat	0.45	7	0.10	0.10	0.08	0.06	0.05	0.04	0.02					
			12R/L A/B60005	0.05	0.40	6	0.10	0.10	0.08	0.06	0.04	0.02						
		0.70mm	TKFT 12R/L A/B60005	0.05	0.48	6	0.10	0.10	0.10	0.10	0.06	0.02						
		0.75mm		0.05	0.52	7	0.10	0.10	0.10	0.08	0.07	0.05	0.02					
		0.80mm		0.05	0.56	7	0.10	0.10	0.10	0.10	0.08	0.06	0.02					
		1.00mm	TKFT 12R/L A/B60005 12R/L N6001	0.05	0.71	8	0.15	0.15	0.12	0.10	0.08	0.06	0.03	0.02				
				0.10	0.66	7	0.18	0.15	0.12	0.10	0.06	0.03	0.02					
		1.25mm		0.05	0.90	9	0.20	0.18	0.13	0.10	0.10	0.07	0.05	0.05	0.02			
				0.10	0.85	8	0.20	0.18	0.13	0.10	0.10	0.07	0.05	0.02				
		1.50mm	TKFT 12R/L N6001	0.10	1.04	10	0.20	0.18	0.14	0.12	0.10	0.10	0.08	0.05	0.05	0.02		
Parallel Pipe	External Threading	28 TPI	TKFT 12R/L A/B55005	0.0020	0.0264	7	0.007	0.006	0.005	0.004	0.002	0.002	0.001					
		19 TPI		0.0020	0.0398	9	0.008	0.007	0.006	0.005	0.005	0.004	0.003	0.002	0.001			
Whitworth	External Threading	24 TPI	TKFT 12R/L A/B55005	0.0020	0.0311	8	0.007	0.007	0.005	0.004	0.003	0.003	0.002	0.001				
		20 TPI		0.0020	0.0378	9	0.008	0.008	0.006	0.004	0.004	0.003	0.002	0.002	0.001			
		18 TPI		0.0020	0.0421	10	0.008	0.007	0.006	0.005	0.004	0.004	0.003	0.003	0.002	0.001		
		16 TPI		0.0020	0.0476	11	0.008	0.007	0.006	0.006	0.005	0.004	0.004	0.003	0.003	0.002	0.001	

Swiss Tool Automatic Lathe (Guide Bush System)

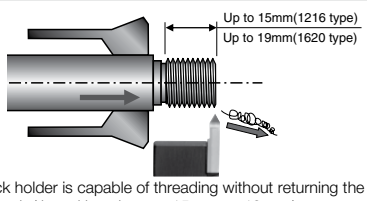
Goose-neck Holder is applicable to automatic lathes whose toolholder does not move in longitudinal direction (Z-axis diretion)

Conventional Threading Tool



Chips may come into the guide bush and scratch the thread surface.

Goose-neck Holder (for Threading)



Goose-neck holder is capable of threading without returning the thread part into the guide bush (thread length up to 15 mm or 19 mm).

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