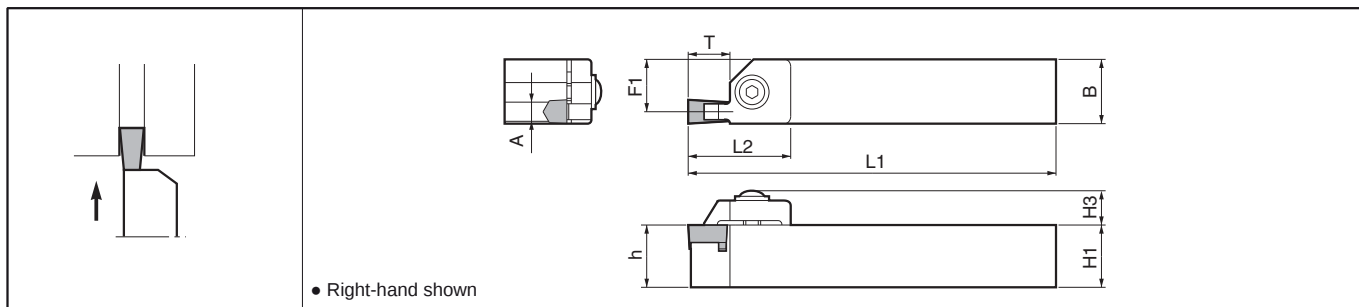


External Shallow Grooving Toolholders [Ceramic TG Insert]

0119 329433 - kyocera@kyocera-tools.ru

Top Clamp

KN91



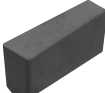
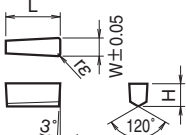
Toolholder Dimensions

Description	Std.		Dimension (mm)										Spare Parts				
	R	L	H1=h	H3	B	L1	L2	F1	A	T			Clamp	Clamp Bolt	Washer	Spring	Wrench
KN91^R/L 44-4	●	●					40	22.5	3.4	15			CE-111 / 121	BH8X30	W-8	SP-8	LW-5
44-5	●	●	25	16	25	150	42	22.5	4.4	17							
44-7	●						42	21	6.4	17			CE-131 / 141				

• Dimension T shows available grooving depth.

Clamp: KN91^R/L 44-4 / 5 ... CE-111 for Right-hand Toolholder, and CE-121 for Left-hand Toolholder.
KN91^R/L 44-7 ... CE-131 for Right-hand Toolholder, and CE-141 for Left-hand Toolholder.

Applicable Inserts

(mm)			K		Cast Iron	●		☾ : Continuous-Light Interruption / 1st Choice	
Description			N		Non-ferrous Metals			☼ : Continuous-Light Interruption / 2nd Choice	
			S		Titanium Alloy			● : Continuous / 1st Choice	
GS91-4			H		Hard materials (under 40HRC)			○ : Continuous / 2nd Choice	
GS91-5~GS91-8					Hard materials (over 40HRC)	○			
Insert		Description	Dimension (mm)		Ceramic	PVD Ceramic	Applicable Toolholder		Ref. Page for Toolholder
			W	rε	A65	A66N			
		GS	91-4	4.0	0.5			KN91 ^R /...4	G26
			91-5	5.0		●		KN91 ^R /...5	
			91-6	6.0					
			91-7	7.0	0.8				
			91-8	8.0		●		KN91 ^R /...7	

Recommended Cutting Conditions

Workpiece Material	Recommended Insert Grade (Cutting Speed m/min)	f (mm/rev)	
	Ceramic	GS91-4 GS91-5 GS91-6	GS91-7 GS91-8
Cast Iron (FC / FCD, etc.)	★ 150~300	0.03~0.07	0.04~0.08
Hard Materials	★ 40~80	0.02~0.05	0.04~0.07

★ : 1st Recommendation

Inserts are sold
in 10 piece boxes.

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

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