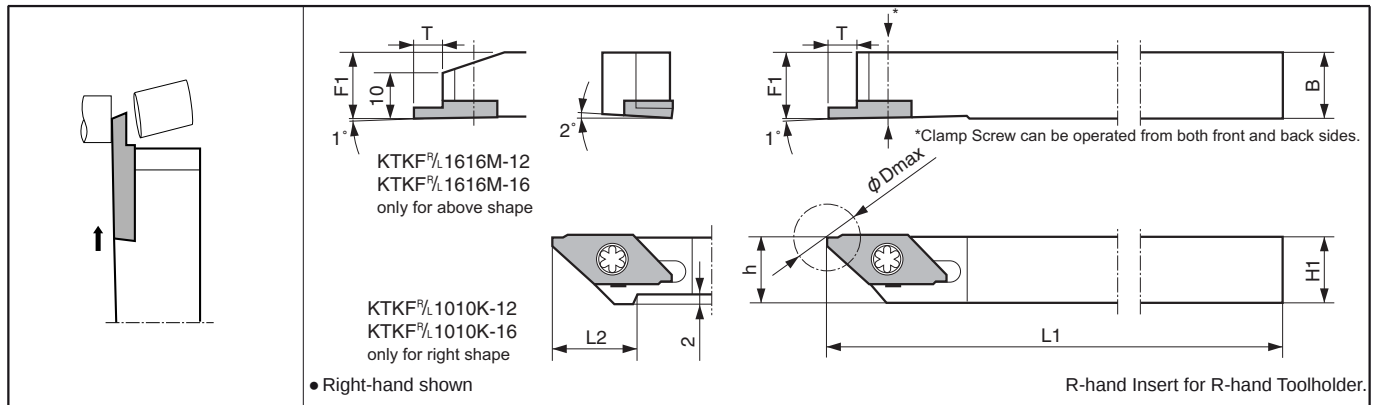


Cut-Off Toolholders (for small diameter)

KTKF (For small diameter cut-off)



Toolholder Dimensions

Description	Std.		Cutting Dia.	Dimension (mm)						Spare Parts		Applicable Inserts H7
	R	L		H1=h	B	L1	L2	F1	T	Clamp Screw	Wrench	
KTKF ^{R/L} 1010K-12 1212F-12 1212M-12 1616M-12	●	●	12	10	10	125	15	10	6	SB-4590TRWN	LTW-10S	TKF12 ^{R/L} ...
	●	●		12	12	85	-	12				
	●	●		16	16	150	-	16				
	●	●		10	10	125	20	10				
KTKF ^{R/L} 1010K-16 1212F-16 1212M-16 1616M-16	●	●	16	10	10	125	20	10	8	SB-4590TRWN	LTW-10S	TKF16 ^{R/L} ...
	●	●		12	12	85	-	12				
	●	●		16	16	150	-	16				
	●	●		10	10	125	20	10				

• Dimension T shows the distance from the Toolholder to the cutting edge. H7 for the actual cutting diameter.

Note: Cutting diameter of -12 type toolholder(ϕD_{max}) depends on the insert grooving width.

For recommended cutting conditions, see page H7

When using Main Spindle only

Workpiece maximum $\phi D1$ (Fig.1)= ϕD_{max}

Even if the cutting edge runs beyond the center line, the insert does not contact the workpiece, since the workpiece falls off.

(The clearance between the insert and the workpiece is 0.2mm)

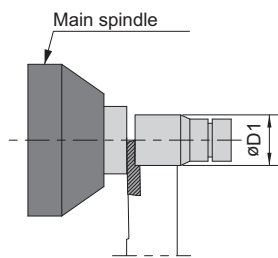


Fig.1

(When the edge is at the center)

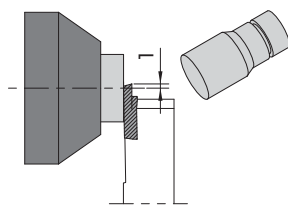


Fig.2

(When the edge is 1mm beyond the center)

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, $\phi D2$ (Fig.4) = [$\phi D_{max} - 1\text{mm} \times 2$] (mm)

(The clearance between the insert and the workpiece is 0.2mm)

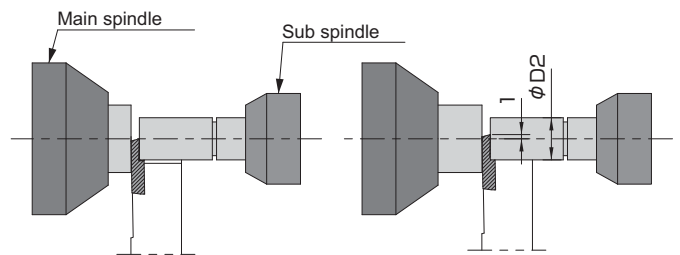


Fig.3

(When the edge is at the center)

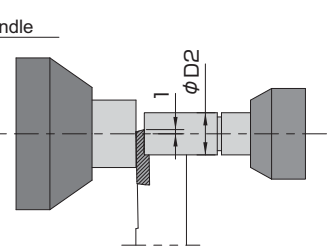


Fig.4

(When the edge is 1mm beyond the center)

Identification of Description (See Table.1)

TKF 12 R 050—S—16D R

Name of Insert

Insert Size

Groove Width

Insert Hand

R: R-hand

L: L-hand

Name of breaker

S: S-Chipbreaker

NB: Without Chipbreaker

Lead angle (θ)

(Front cutting edge angle)

Lead Angle Hand

R: R-hand

L: L-hand

Table1

Toolholder	R-hand (R)	Toolholder	L-hand (L)
Insert	R-hand (R)	Insert	L-hand (L)
Lead Angle	R-hand (R)	Lead Angle	R-hand (R)