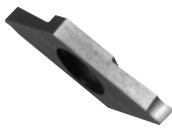


● Applicable Inserts

● Applicable Inserts		Classification of usage							P	Carbon Steel and Alloy Steel		●		
		● : Continuous-Low Interruption / 1st Choice							M	Stainless Steel		●		
		⏻ : Continuous-Low Interruption / 2nd Choice							K	Cast Iron			●	
		● : Continuous / 1st Choice							N	Non-ferrous Metals			●	
		○ : Continuous / 2nd Choice												
Insert	Description	Dimension (mm)							Angle (°)	PVD Coated Carbide	Carbide	PCD	Applicable Toolholder	
		W	∅Ds max	rε	T	H	∅d	θ						
														PR1025
Handed insert indicates Left-hand										R	L	R	L	
	TKFS12 ^{R/L}	100-S	1.0	6	0.05	2.2	8.7	4.4	0°	●	●	●	●	
		150-S	1.5	9						●	●	●	●	
		200-S	2.0	12						●	●	●	●	
	TKFS16 ^{R/L}	150-S	1.5	14	0.05	2.2	9.5	4.4	0°	●	●	●	●	
		200-S	2.0	16						●	●	●	●	

• As Fig.2 of H8 shows, the cutting diameter of the insert is indicated when the top of the cutting edge progresses 1mm from the center.

• Lead angle shows the angle when installed in toolholder.

◆ Recommended Cutting Conditions (For TKFS12)

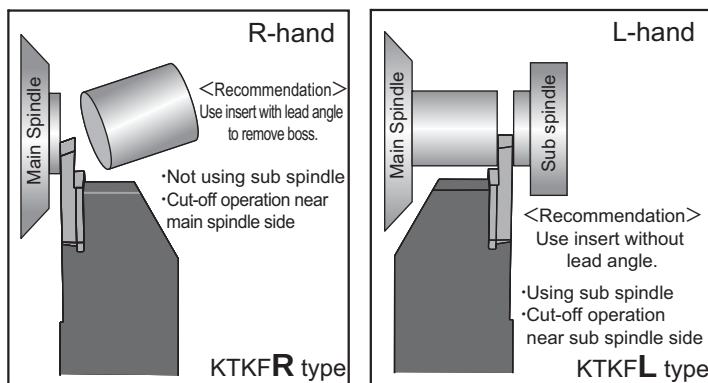
Workpiece Material	Recommended Insert Grade (Vc: m/min)		Width (mm)			Remarks
	PVD Coated Carbide	Carbide	1.0	1.5	2.0	
	PR1025	KW10	f (mm/rev)			
Carbon Steel	60~130	-	0.01~0.03	0.01~0.03	0.01~0.03	Coolant
Alloy Steel	60~130	-	0.01~0.03	0.01~0.03	0.01~0.03	
Stainless Steel	50~100	-	0.01~0.02	0.01~0.02	0.01~0.03	
Cast Iron	-	50~100	0.01~0.03	0.01~0.03	0.01~0.03	
Non-ferrous Metals	-	200~450	0.01~0.03	0.01~0.03	0.01~0.03	

◆ Recommended Cutting Conditions (For TKFS16)

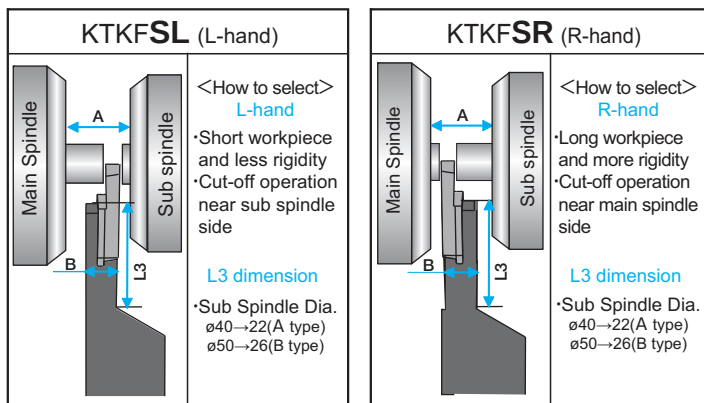
Workpiece Material	Recommended Insert Grade (Vc: m/min)		Width (mm)		Remarks
	PVD Coated Carbide	Carbide	1.5	2.0	
	PR1025	KW10	f (mm/rev)		
Carbon Steel	60~130	-	0.01-0.03	0.01-0.03	Coolant
Alloy Steel	60~130	-	0.01-0.03	0.01-0.03	
Stainless Steel	50~100	-	0.01-0.02	0.01-0.03	
Cast Iron	-	50~100	0.01-0.03	0.01-0.03	
Non-ferrous Metals	-	200~450	0.01-0.03	0.01-0.03	

■ How to use small diameter cut-off tool

- Both Right-hand and Left-hand types are applicable to gang tool post.
- Basically Left-hand type is used at cut-off operation using sub-spindle.



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



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

kyocera@kyocera-tools.ru
www.kyocera-tools.ru

Inserts are sold in 10 piece boxes.