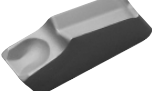
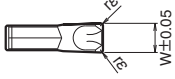
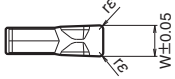
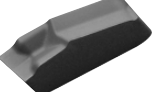


# Cut-Off Inserts

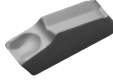
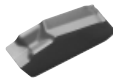
## TKN / TK<sup>R/L</sup>

| 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                  |   |                              |   |   |   |   |

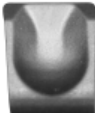
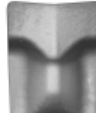
| Insert                                                                              | Description                                                                         | Dimension (mm)          |     | Angle (°) | Cermet | CVD Coated Carbide | PVD Coated Carbide |       | Carbide | Ref. Page for Applicable Toolholder |
|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------|-----|-----------|--------|--------------------|--------------------|-------|---------|-------------------------------------|
|                                                                                     |                                                                                     | W                       | ℓ   | θ         |        |                    | PR660              | PR930 |         |                                     |
| Handed Insert shows Right-hand                                                      |                                                                                     |                         |     |           |        |                    |                    |       |         |                                     |
|    |    | TKN 1.6                 | 1.6 | 0.15      |        |                    |                    |       |         | H16<br>H17<br>H18                   |
|                                                                                     |                                                                                     | 2                       | 2.2 | 0.20      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 2.4                     | 2.4 | 0.20      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 3                       | 3.1 | 0.25      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 4                       | 4.1 | 0.30      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 4.8                     | 4.8 | 0.30      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 5                       | 5.1 | 0.30      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 6                       | 6.4 | 0.35      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 8                       | 8.0 | 0.40      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 9                       | 9.6 | 0.45      |        |                    |                    |       |         |                                     |
|    |    | TKN 1.6-P               | 1.6 | 0.20      |        |                    |                    |       |         |                                     |
| Low Feed                                                                            |                                                                                     | 2-P                     | 2.2 | 0.20      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 3-P                     | 3.1 | 0.25      |        |                    |                    |       |         |                                     |
|   |   | TK <sup>R/L</sup> 1.6   | 1.6 | 0.15      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 2                       | 2.2 | 0.20      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 2.4                     | 2.4 | 0.20      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 3                       | 3.1 | 0.25      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 4                       | 4.1 | 0.30      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 5                       | 5.1 | 0.30      |        |                    |                    |       |         |                                     |
| Lead Angle                                                                          |                                                                                     |                         |     | 8°        | R      |                    |                    | R     |         |                                     |
|                                                                                     |                                                                                     |                         |     |           | R      |                    |                    | R     |         |                                     |
|                                                                                     |                                                                                     |                         |     |           | R      |                    |                    | R     |         |                                     |
|  |  | TK <sup>R/L</sup> 1.6-P | 1.6 | 0.20      |        |                    |                    |       |         |                                     |
| Low Feed / Lead-Angled                                                              |                                                                                     | 2-P                     | 2.2 | 0.20      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     | 3-P                     | 3.1 | 0.25      |        |                    |                    |       |         |                                     |
|                                                                                     |                                                                                     |                         |     | 8°        | R      |                    |                    | R     |         |                                     |
|                                                                                     |                                                                                     |                         |     |           | R      |                    |                    | R     |         |                                     |
|                                                                                     |                                                                                     |                         |     |           | R      |                    |                    | R     |         |                                     |

For recommended cutting conditions, see page H20

### Cut-Off Tools

| Cutting Range    | Chipbreaker                                                                                                  | Advantage                                                                                                                             |
|------------------|--------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------|
| General Cut-Off  | Standard (No Indication)  | General cut-off type for feed rates over 0.1mm/rev.<br>Superior chip evacuation                                                       |
| Low Feed Cut-Off | P                         | Chipbreaker specially designed for low feed machining on automatic lathes, etc.<br>Chips are controlled at feed rate 0.03–0.08mm/rev. |

### Insert's Edge Shape (CERACUT Cut-Off)

| Edge Shape       | Chamfer + hone                                                                      | Sharp Edge                                                                          | Hone                                                                                 |
|------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|
|                  |  |  |  |
| Std. Chipbreaker | TN90<br>CR9025 / PR660                                                              | PR930 / KW10                                                                        | -                                                                                    |
| P-Chipbreaker    | -                                                                                   | -                                                                                   | TN90 / CR9025<br>PR660 / PR930 / KW10                                                |

• Sharp Edge Spec. can reduce cutting resistance 40% less than that of chamfer edge.

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

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Inserts are sold in 10 piece boxes

H15

H



Cut-off