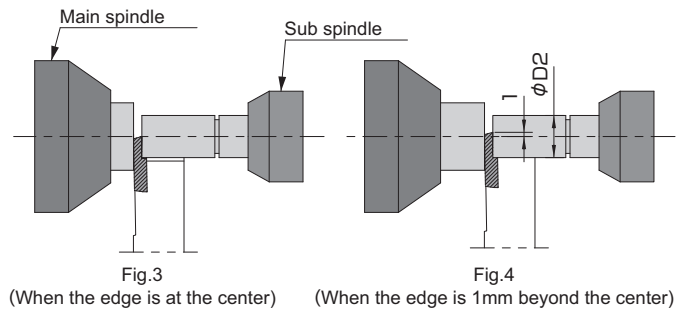


2) When using both Main and Sub spindles

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) = $[\phi Dmax - 1mm \times 2]$ (mm)
 (The clearance between the insert and the workpiece is 0.2mm)



When using TKF-AS type

The KTKF holder can be used as a multi-functional tool for non-ferrous metals and non metals when combined with a TKF-AS insert (See Fig.5).

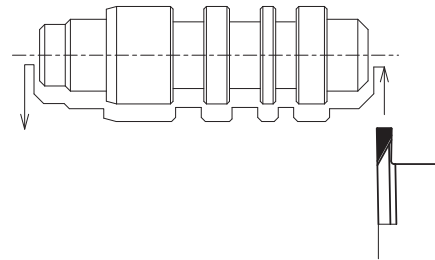


Fig.5 Example of the pass of KTKF toolholder + TKF-AS insert

Longitudinal Turning / Grooving (1-Edge insert)

Edge Preparation				Classification of usage										Applicable Toolholder	
PCD all models		Sharp Edge		● : Continuous-Low Interruption / 1st Choice ○ : Continuous-Low Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice										PCD	
Insert	Description	Dimension (mm)								Angle (°)	No. of Corners	KPD001		Applicable Toolholder	
		W	ϕD_{max}	$r\epsilon$	T	H	A	ϕd	S			R	L		
Traversing / Grooving Handed Insert shows R-hand.	TKF12 ^{R/L} 200-AS	2.0	10	0.1 ^{+0.05}	3	8.7	7.7	5	5.0	0°	1	●	●	H8	
	TKF12 ^{R/L} 250-AS	2.5	10									5.5	●		●
TKF16 ^{R/L} 250-AS	2.5	16	4	9.5	8.5	6.5	●	●							
Grooving (Traversing is possible)	TKF12 ^{R/L} 150-NB	1.5	7	0.1 ^{+0.05}	3	8.7	-	5	2.0	0°	1	●	●		
	TKF12 ^{R/L} 200-NB	2.0	8						3.0			●	●		
	TKF12 ^{R/L} 250-NB	2.5	8						3.0			●	●		
	TKF12 ^{R/L} 250-NB4.5	2.5	10						4.5			●	●		

*Lead angle shows the angle when installed in toolholder.

*Please use PCD Insert for traverse machining.

Note1) The cutting edge of the TKF..-AS will be 1 mm lower than the center line when attached to the KTKF toolholder (See Fig.6). Adjust the height by making NC lathe parameter settings or inserting a plate.

2) If the 1 mm adjustment is not possible, use the TKF. . -NB (See Fig.7).

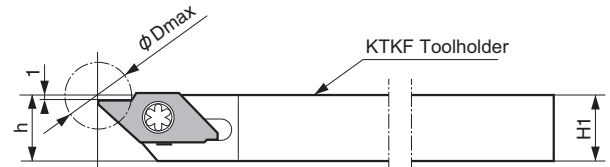


Fig.6 When a TKF-AS insert is attached (The cutting edge is 1 mm lower than the center line.)

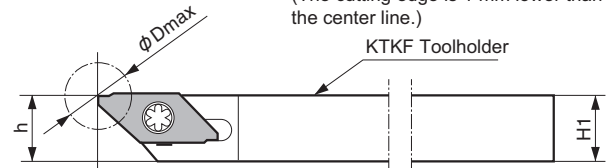


Fig.7 When a TKF-NB insert is attached

● : Std. Item

CBN & PCD Tools are sold in 1 piece boxes.

