

● 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 Handed insert indicates Left-hand	Description	Dimension (mm)						Angle (°)	PVD Coated Carbide	Carbide	PCD	Applicable Toolholder
		W	∅Ds max	rε	T	H	∅d					
		PR1025		KW10		KPD001						
	TKFS12^{R/L}	100-S	1.0	6	0.05	2.2	8.7	4.4	0°	●	●	KTKFS^{R/L} ----12
		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)

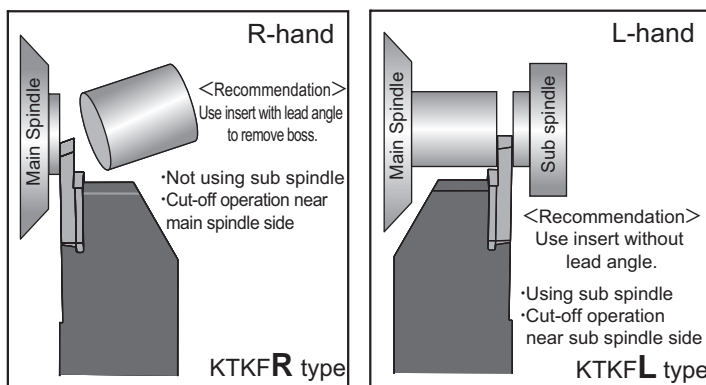
Workpiece Material	Recommended Insert Grade (Vc: m/min)		Width (mm)			Remarks
	PVD Coated Carbide	Carbide	1.0	1.5	2.0	
	PR1025	KW10	f (mm/rev)			
Carbon Steel	60~130	-	0.01-0.03	0.01-0.03	0.01-0.03	Coolant
Alloy Steel	60~130	-	0.01-0.03	0.01-0.03	0.01-0.03	
Stainless Steel	50~100	-	0.01-0.02	0.01-0.02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

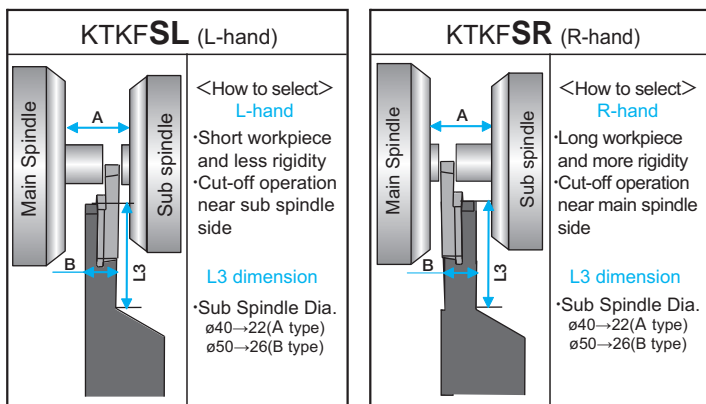
Workpiece Material	Recommended Insert Grade (Vc: m/min)		Width (mm)		Remarks
	PVD Coated Carbide	Carbide	1.5	2.0	
	PR1025	KW10	f (mm/rev)		
Carbon Steel	60~130	-	0.01-0.03	0.01-0.03	Coolant
Alloy Steel	60~130	-	0.01-0.03	0.01-0.03	
Stainless Steel	50~100	-	0.01-0.02	0.01-0.03	
Cast Iron	-	50~100	0.01-0.03	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-handed and Left-handed types are applicable to gang tool post.
- Basically the Left-handed type is used for cut-off operations using a sub-spindle.



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



● : Std. Item □ : Check Availability

Inserts are sold in 10 piece boxes.