
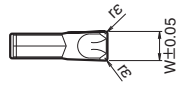
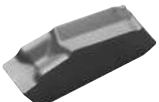
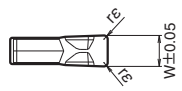

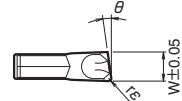

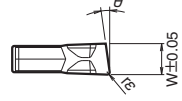


Cut-Off Inserts



TKN / TK^{R/L}

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	rε	θ			TN90	CR9025			PR660	PR930	KW10			
 Handed Insert shows Right-hand		TKN 1.6	1.6	0.15	-	●	●	●	●	●	●					
		TKN 2	2.2	0.20								●	●	●	●	●
		TKN 2.4	2.4	0.20								●	●	●	●	●
		TKN 3	3.1	0.25								●	●	●	●	●
		TKN 4	4.1	0.30								●	●	●	●	●
		TKN 4.8	4.8	0.30								●	●	●	●	●
		TKN 5	5.1	0.30								●	●	●	●	●
		TKN 6	6.4	0.35								●	●	●	●	●
		TKN 8	8.0	0.40								●	●	●	●	●
TKN 9	9.6	0.45	●	●	●	●	●									
 Low Feed		TKN 1.6-P	1.6	0.20	-	●	●	●	●	●	●					
		TKN 2-P	2.2	0.20								●	●	●	●	●
		TKN 3-P	3.1	0.25								●	●	●	●	●
 Lead Angle		TK ^{R/L} 1.6	1.6	0.15	8°	R	●	●	R	●	●					
		TK ^{R/L} 2	2.2	0.20								●	●	●	●	
		TK ^{R/L} 2.4	2.4	0.20								●	●	●	●	
		TK ^{R/L} 3	3.1	0.25								●	●	●	●	
		TK ^{R/L} 4	4.1	0.30								●	●	●	●	
 Low Feed / Lead-Angled		TK ^{R/L} 1.6-P	1.6	0.20	8°	R	●	●	R	R	R					
		TK ^{R/L} 2-P	2.2	0.20								●	●	●	●	
		TK ^{R/L} 3-P	3.1	0.25								●	●	●	●	

For recommended cutting conditions, see page **H25**

Cut-Off Tools

Cutting Range	Chipbreaker	Advantage
General Cut-Off	Standard (No Indication) 	General cut-off type for feed rates over 0.1mm/rev. Superior chip evacuation
Low Feed Cut-Off	P 	Chipbreaker specially designed for low feed machining on automatic lathes, etc. 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
Edge Shape			
Std. Chipbreaker	TN90 CR9025 / PR660	PR930 / KW10	-
P-Chipbreaker	-	-	TN90 / CR9025 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)

Inserts are sold in 10 piece boxes