



JCT Series

Coolant-Through Holders for Small Parts Machining



Excellent Chip Control and Long Tool Life with High Pressure Coolant

Capable of Pressure up to 2,900 psi

Large Holder Lineup for Turning, External Grooving and Cut-off

NEW *New Inch Size Holders Now Available!*

Turning:

Screw-Clamp-JCT (C / D / V Styles)

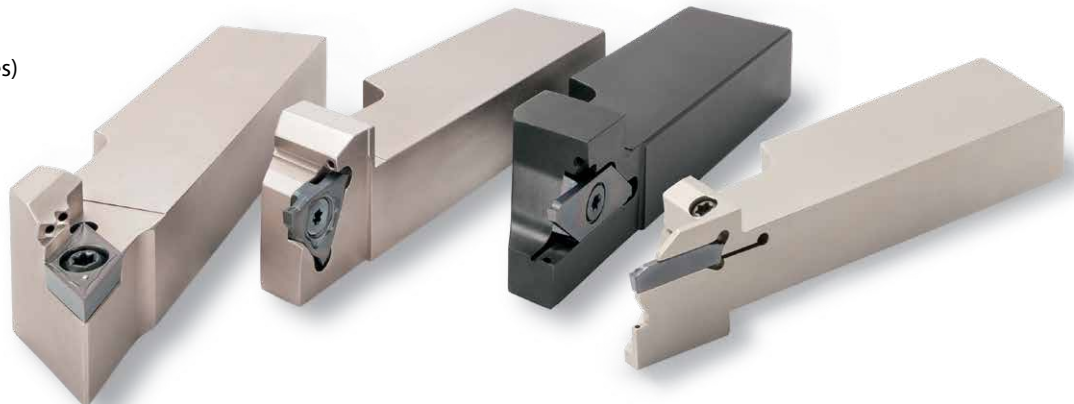
External Grooving:

KGBF-JCT

Cut-Off:

KGD-JCT **NEW**

KTKF-JCT



JCT Series

Coolant-Through Holders for Small Parts Machining

Capable of Pressure up to 2,900 psi and Improves Chip Control Performance

Large Holder Lineup for Turning, External Grooving and Cut-off



NEW *New Inch Size Holders Now Available!*

Turning Screw-Clamp-JCT

⊕ P.6



External Grooving KGBF-JCT

⊕ P.10



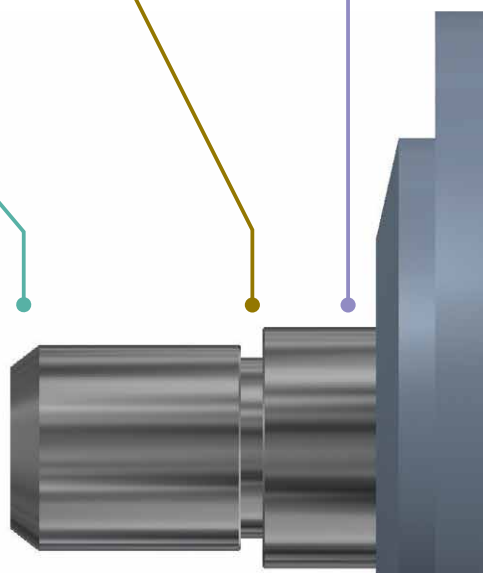
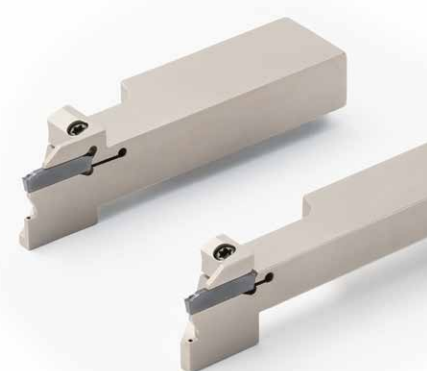
Cut-Off KTKF-JCT

⊕ P.18



Grooving / Cut-Off KGD-JCT

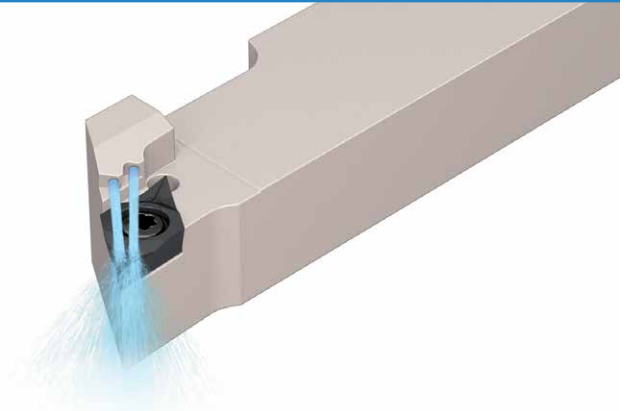
⊕ P.14



Unique Coolant System for Various Machining Applications

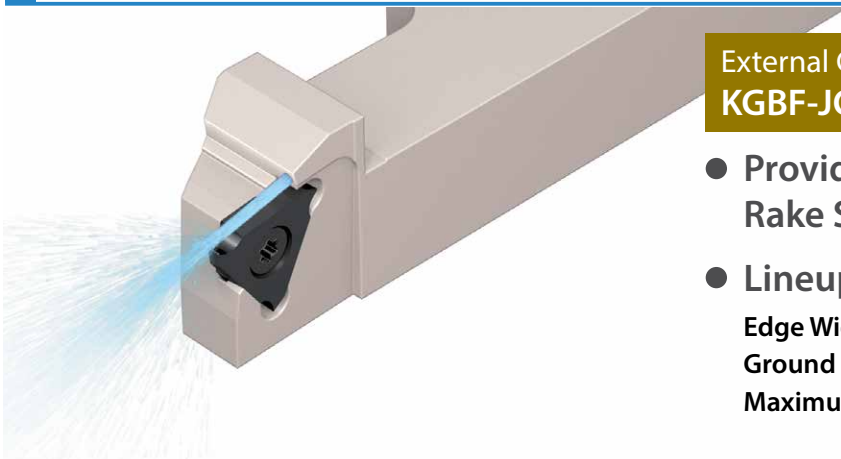
Turning Screw-Clamp-JCT

- **Double Coolant Holes**
Double coolant holes provide coolant toward the cutting edge surface of the insert
- **Lineup**
SCLC-JCT
SDJC-JCT
SVJB-JCT
SVJP-JCT



External Grooving KGBF-JCT

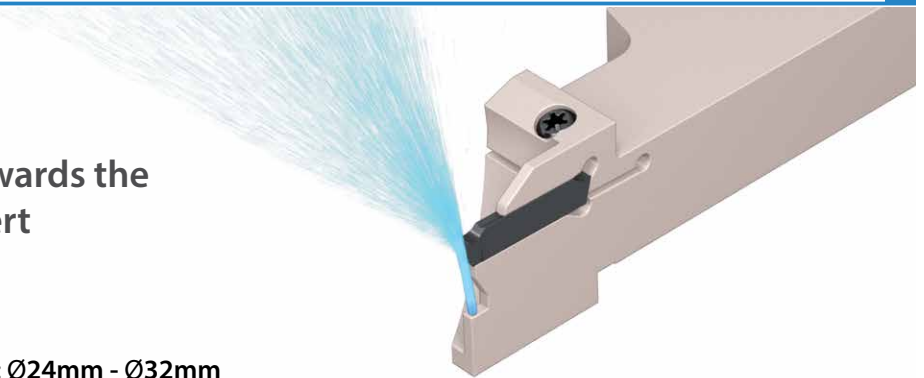
- **Provides Coolant towards the Rake Surface of Insert**
- **Lineup**
Edge Width: 0.25mm - 3mm
Ground Chipbreaker / GL Chipbreaker
Maximum Depth: 3mm



Grooving / Cut-Off KGD-JCT

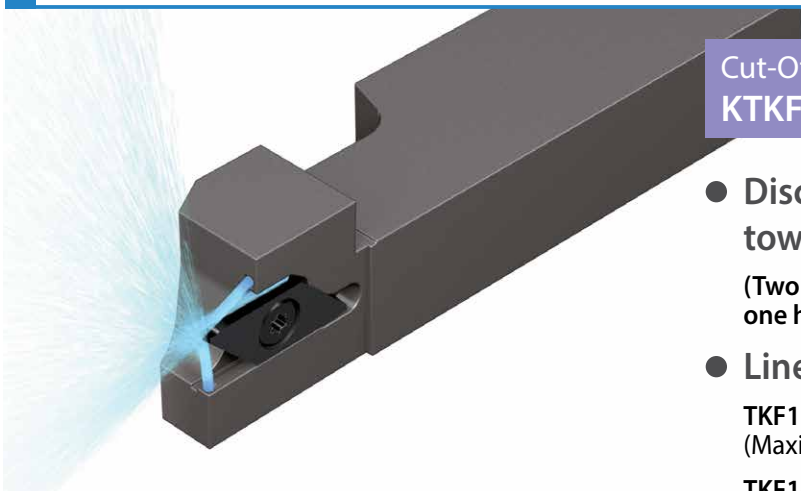
NEW

- **Provides Coolant towards the Flank Surface of Insert**
- **Lineup**
Edge Width: 2mm - 4mm
Maximum Cut-Off Diameter: $\varnothing 24\text{mm}$ - $\varnothing 32\text{mm}$



Cut-Off KTKF-JCT

- **Discharges Coolant in Three Directions toward Rake Surface of Insert**
(Two holes toward the rake face and one hole towards the flank face of the insert)
- **Lineup**
TKF12 Type
(Maximum Cut-Off Diameter: $\varnothing 5\text{mm}$ - $\varnothing 12\text{mm}$)
TKF16 Type
(Maximum Cut-Off Diameter: $\varnothing 16\text{mm}$)



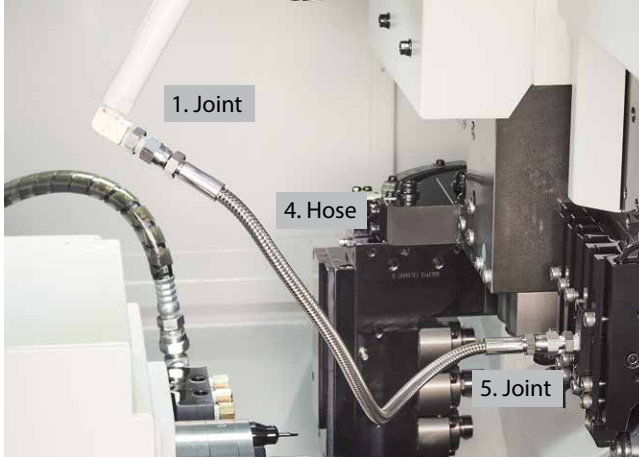
Easy Coolant Connections

Pipe parts will be required separately if internal coolant is used

Pump Pressure: up to 2,900 psi

Pump Pressure: up to 1,090 psi if couplers are used

Without Coupler (Pump Pressure: up to 2,900 psi)



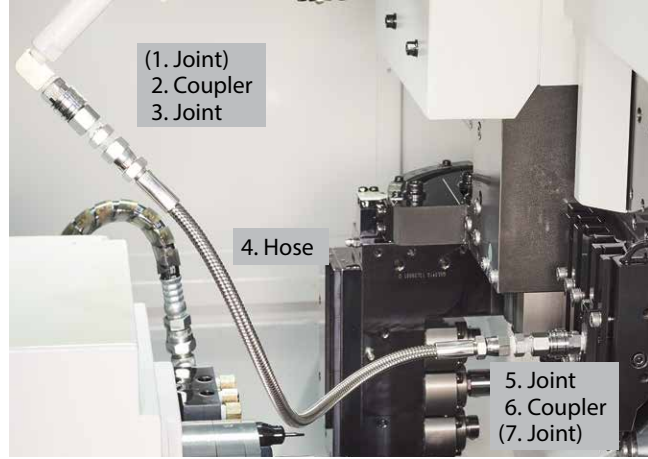
Combination Part Number (Example)

Part	Part Number
1. Joint	J-ST-R1/8-G1/8
4. Hose	HS-G1/8-G1/8-500
5. Joint	J-ST-R1/8-G1/8

Convert the thread standards on the machine's side (Rc1/4, Rc1/8, NPT1/8, etc.) to the thread standard on the hose side (G1/8) for use.

Use sealing agents such as seal tapes when installing piping parts.

With Coupler (Pump Pressure: Up to 1,090 psi)



Combination Part Number (Example)

Part	Part Number
(1. Joint)	-
2. Coupler	CP-ST-R1/8, P-ST-RC1/8
3. Joint	J-ST-R1/8-G1/8
4. Hose	HS-G1/8-G1/8-500
5. Joint	J-ST-R1/8-G1/8
6. Coupler	P-ST-RC1/8, CP-ST-R1/8
(7. Joint)	-

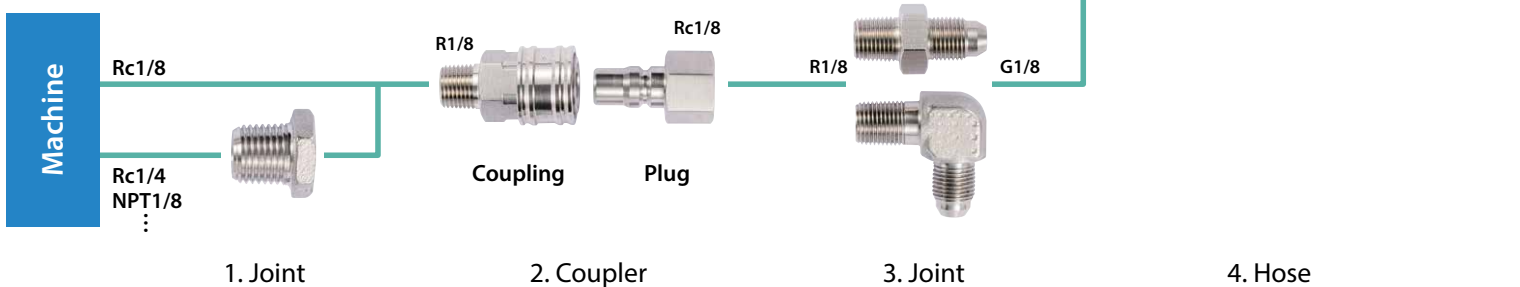
Convert the thread standards on the machine's side (Rc1/4, Rc1/8, NPT1/8, etc.) to thread standards of the coupler (Rc1/8, etc.) or hose (G1/8) for use.

Use sealing agents such as seal tapes when installing piping parts.

Without Coupler (Pump Pressure: up to 2,900 psi)



With Coupler (Pump Pressure: up to 1,090 psi)



Piping Installation Parts Description

Joint (1, 3, 5, 7) Pressure Resistance: up to 2,900 psi

(Unit: mm)

Shape	Part Number	Stock	Ød1	Ød2	L	L1	L2	T1	T2
	J-ST-R1/4-G1/8	●	5.5	4.0	34	13	13	R1/4	G1/8
	J-ST-NPT1/8-G1/8	●	3.5	3.5	29	10	13	NPT1/8	G1/8
	J-ST-R1/8-G1/8	●	4.0	4.0	29	10	13	R1/8	G1/8
	J-AN-R1/8-G1/8	●	4.0	4.0	27	14	13	R1/8	G1/8
	J-ST-R1/4-RC1/8	●	-	-	17	12	-	R1/4	Rc1/8
	J-ST-NPT1/8-RC1/8	●	3.5	-	30	10	-	NPT1/8	Rc1/8
	J-ST-R1/8-RC1/8	●	3.5	-	33	13	-	R1/8	Rc1/8

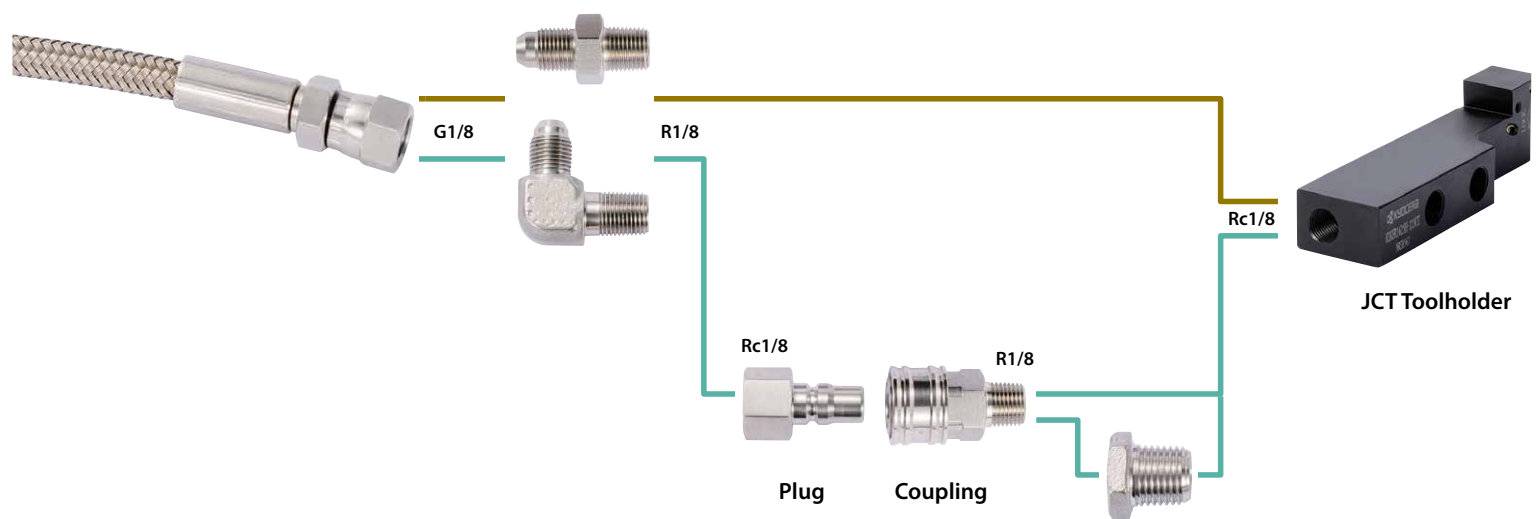
Coupler (2, 6) Pressure Resistance: up to 1,090 psi (Unit: mm)

Hose (4) Pressure Resistance: up to 2,900 psi

(Unit: mm)

Shape	Part Number	Stock	Shape	Part Number	Stock	L
	CP-ST-R1/8	●		HS-G1/8-G1/8-200	●	200
		P-ST-RC1/8		●	HS-G1/8-G1/8-300	●
				HS-G1/8-G1/8-400	●	400
		HS-G1/8-G1/8-500		●	500	
		HS-G1/8-G1/8-600		●	600	
		HS-G1/8-G1/8-800		●	800	

● : Standard Item



4. Hose

5. Joint

6. Coupler

7. Joint (Extension Joint)

Screw-Clamp-JCT

Turning

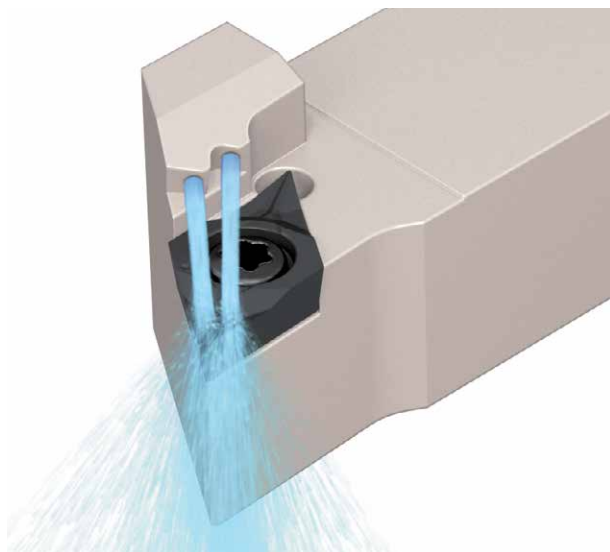
Coolant-Through Turning Holders for Small Parts Machining

Double Coolant Hole Design Delivers an Ample Supply of Coolant to the Cutting Edge
Excellent Chip Control and Longer Tool Life

1 Superior Chip Control Performance

2 Sufficient Cooling of the Cutting Edge Leads to Longer Tool Life

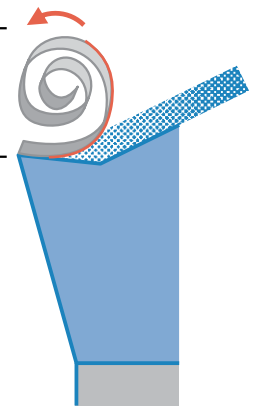
Double coolant hole design provides coolant to the insert cutting edge surface



Double Coolant Holes

Provides stable chip curls for superior chip control

The cutting edge stays cool increasing tool life

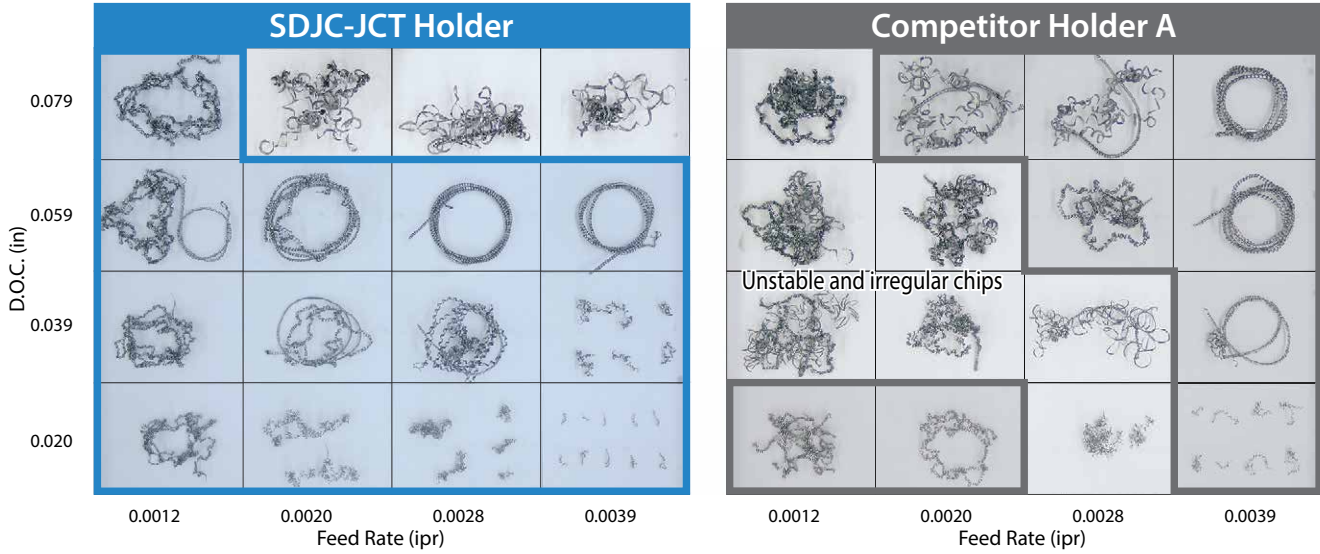


Insert cross-section

Coolant System Comparison (Internal Evaluation)

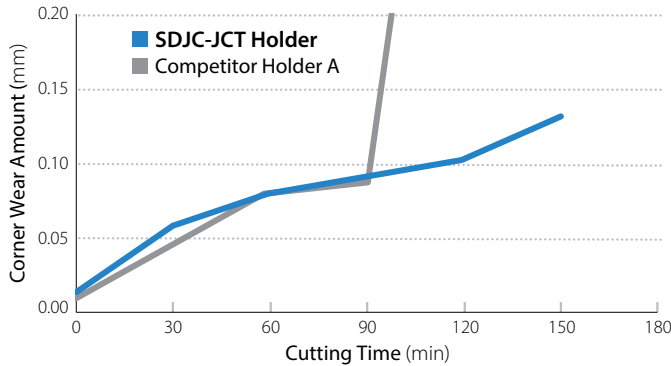
	Screw-Clamp-JCT Holder	Competitor A Holder
Coolant System	<p>Discharges coolant towards the rake surface of insert</p>	<p>Discharges coolant down onto the chip forcing the chip into the part</p>
Superior Chip Control	Excellent : Provides stable chip curls	Poor : Chip becomes unstable
Coolant Effects	Excellent : Ensures proper cooling of the cutting edge	Poor : Chip can cause interference with the workpiece

SDJC-JCT holder allows excellent chip control in a wide range of cutting conditions



Cutting Conditions: $V_c = 260$ sfm, DCGT32505MP-CK PR1535 (Same inserts were used) Workpiece: Ti-6Al-4V External and Internal Coolant (218 psi) Turning

Great for High Pressure Coolant Wear Resistance Comparison (Internal Evaluation)



Cutting Conditions: $V_c = 660$ sfm, External Turning: D.O.C. = 0.079", $f = 0.0020$ ipr, Facing: D.O.C. = 0.008", $f = 0.0012$ ipr DCGT32505MFP-GQ PR1535 (Same inserts were used) Workpiece: 304 External and Internal Coolant (218 psi) External Turning and Facing

Cutting Edge

SDJC-JCT Holder (After Machining 150 min)



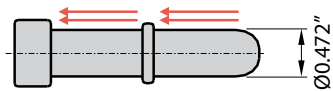
Competitor A Holder (After Machining 106 min)



Case Studies

Pipe - Stainless Steel

$V_c = 525$ sfm
D.O.C. = 0.035" / 0.047"
 $f = 0.007$ ipr
Wet (Internal Coolant: 14MPa)
DCMT3251 Insert



Chip Control

SDJC-JCT Holder (Internal Coolant)



Competitor Holder B (Internal Coolant)

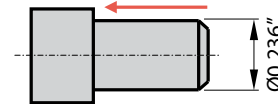


Change to SDJC-JCT improved chip control and tool life.

(User Evaluation)

Pin - Tool Steel

$V_c = 590$ sfm
D.O.C. = 0.055"
 $f = 0.005$ ipr
Wet
DCMT3251 Insert



Chip Control

SDJC-JCT Holder (Internal Coolant: 360 psi)



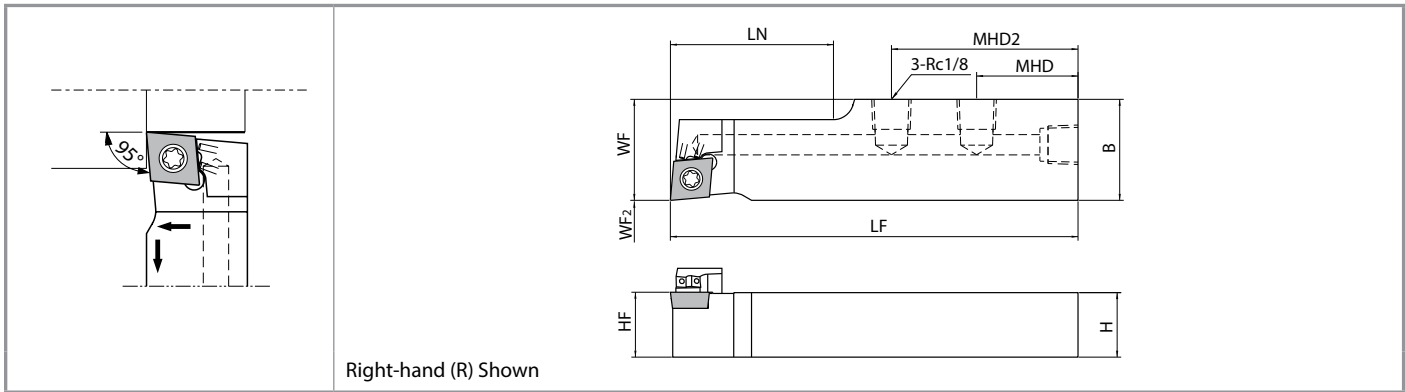
Conventional Holder (External Coolant)



SDJC-JCT holder with internal coolant improved chip control. Reduced chip entanglement

(User Evaluation)

SCLC-JCT (Small Parts Turning)

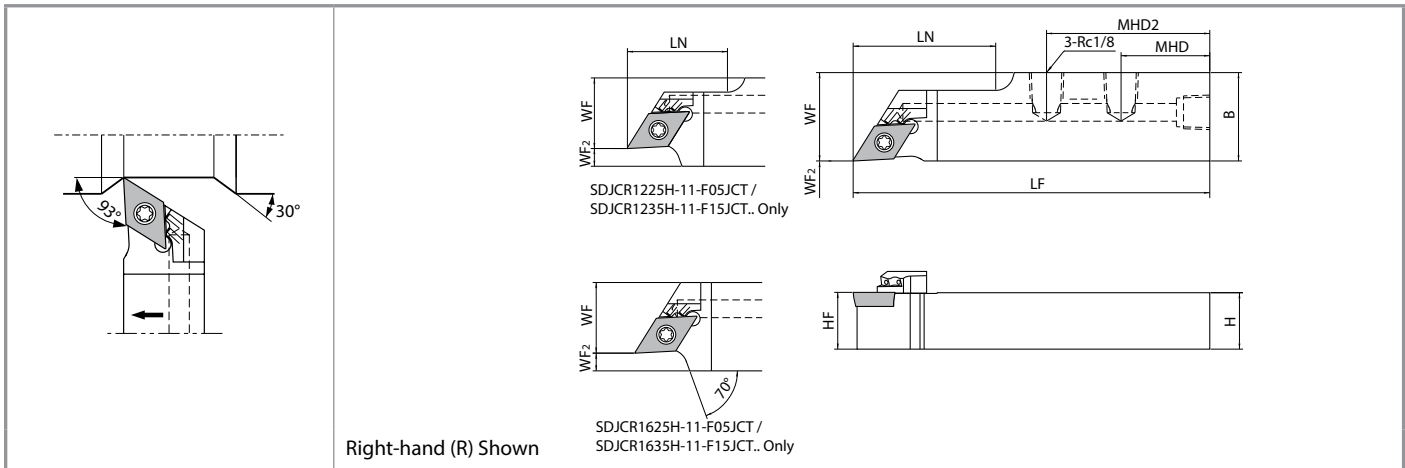


Toolholder Dimensions

Part Number	Stock		Unit	Dimensions									Standard Corner-R (RE)	Spare Parts			Applicable Inserts
	R	L		H	HF	B	LF	LN	WF	WF ₂	MHD	MHD2		Insert Screw	Wrench	Plug	
SCLCR 62-3FFJCT	●		in	0.500	0.500	0.750	4.750	1.110	0.750	0.000	1.378	-	0.008	SB-4085TR	FT-15	GP-1	CC..325 Sizes
82.5-3FFJCT	●			0.625	0.625	1.000	4.750	1.582	1.000	0.000	0.984	1.811					
SCLCR 1220H-09FFJCT	●		mm	12	12	20	100	28	20		35	-	0.2	SB-4085TR	FT-15	GP-1	
1625H-09FFJCT	●			16	16	25	100	40	25	0	25	46					
2025H-09FFJCT	●			20	20	25	100	40	25		25	46					

● : Standard Item

SDJC-JCT (Small Parts Turning)

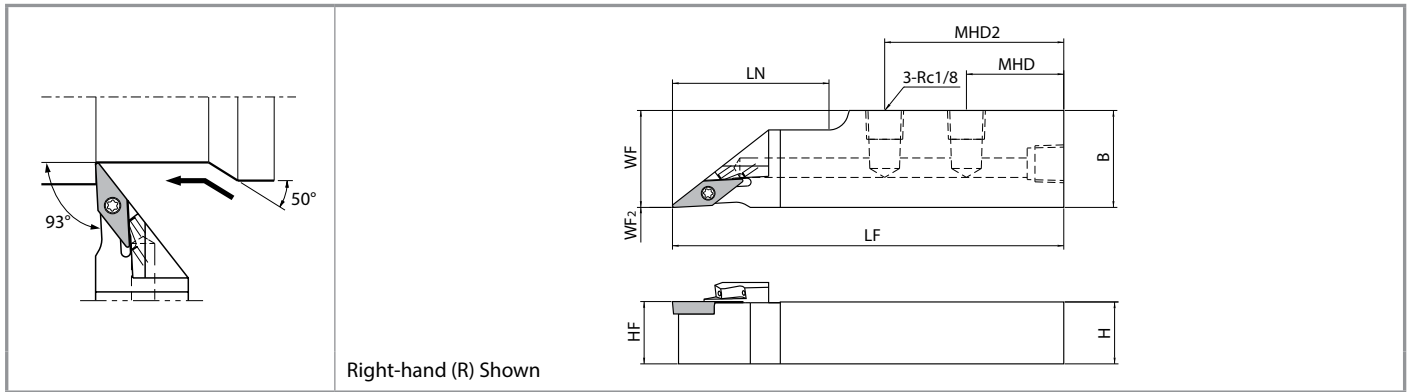


Toolholder Dimensions

Part Number	Stock		Unit	Dimensions									Standard Corner-R (RE)	Spare Parts			Applicable Inserts
	R	L		H	HF	B	LF	LN	WF	WF ₂	MHD	MHD2		Insert Screw	Wrench	Plug	
SDJCR 62-3FFJCT	●		in	0.500	0.500	0.750	4.750	1.110	0.750	0.000	1.378	-	0.008	SB-4085TR	FT-15	GP-1	DC..325 Sizes
82.5-3FFJCT	●			0.625	0.625	1.000	4.750	1.582	1.000	0.000	0.984	1.811					
SDJCR 1220H-11FFJCT	●		mm	12	12	20		28	20		35	-	0.2	SB-4085TR	FT-15	GP-1	
1625H-11FFJCT	●			16	16	25	100	40	25	0	25	46					
2025H-11FFJCT	●			20	20	25		40	25		25	46					
SDJCR 1225H-11-F05JCT	●		mm	12	12	25		28	20	5	35	-	0.2	SB-4085TR	FT-15	GP-1	
1235H-11-F15JCT	●			12	12	35	100	28	20	15	35	-					
SDJCR 1625H-11-F05JCT	●			16	16	25		-	20	5	25	46					
1635H-11-F15JCT	●		16	16	35	100	-	20	15	25	46						

● : Standard Item

SVJB-JCT / SVJP-JCT (Small Parts Turning)



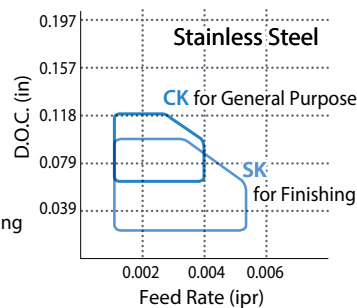
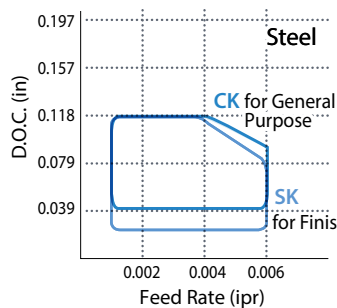
Toolholder Dimensions

Part Number	Stock		Unit	Dimensions										Standard Corner-R (RE)	Spare Parts			Applicable Inserts
	R	L		H	HF	B	LF	LN	WF	WF ₂	MHD	MHD2	Insert Screw		Wrench	Plug		
NEW SVJBR 62-2FFJCT 82.5-2FFJCT	●		in	0.500	0.500	0.750	4.750	1.110	0.750	0.000	1.378	-	1/64	SB-2570TR	FT-8	GP-1	VB..22 Sizes	
	●			0.625	0.625	1.000	4.750	1.110	1.000	0.000	0.984	1.811						
SVJBR 1220H-11FFJCT 1625H-11FFJCT 2025H-11FFJCT	●		mm	12	12	20	100	28	20	0	35	-	0.4	SB-2570TR	FT-8	GP-1	VB..22 Sizes	
	●			16	16	25		40	25		25	46						
	●			20	20	25		40	25		25	46						
SVJPR 1220H-11FFJCT 1625H-11FFJCT 2025H-11FFJCT	●		mm	12	12	20	100	28	20	0	35	-	0.2	SB-2570TR	FT-8	GP-1	VP..22 Sizes	
	●			16	16	25		40	25		25	46						
	●			20	20	25		40	25		25	46						

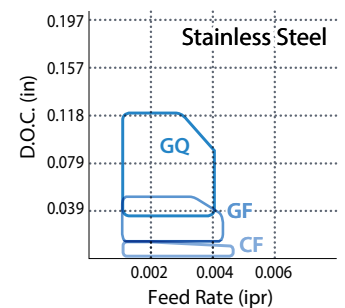
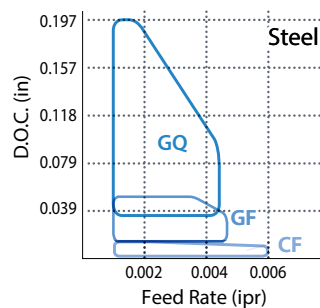
● : Standard Item

Chipbreaker Application Maps

Low Cutting Force Oriented



Chip Control Oriented



More chipbreakers are available.
 For more details, see the KYOCERA general product catalog.

KGBF-JCT

External Grooving

Coolant-Through Grooving Holders for Small Parts Machining

KGBF-JCT can Direct Coolant Closer to the Cutting Edge from the Top of the Insert
Delivers Improved Chip Control and Longer Tool Life while Grooving

1 Excellent Chip Control

2 Superior Cooling Action Improves Tool Life

Discharges coolant from the top of the insert to deliver superior chip control and longer tool life

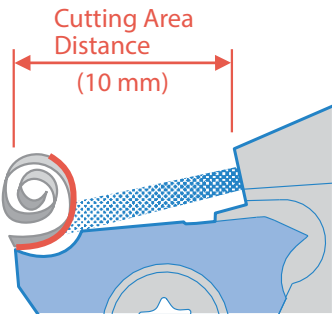


Coolant Hole

Coolant hole discharges coolant to the cutting edge and prevents coolant stream spreading which slows the coolant flow

Coolant Direction

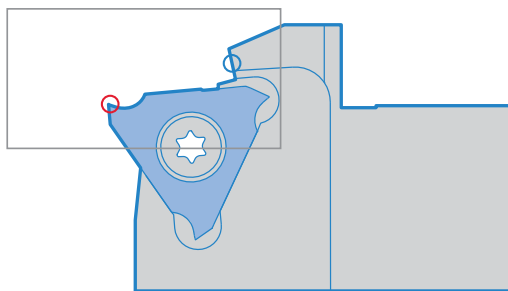
Sufficient coolant between the chipbreaker and the chips to provide stable chip curls and sufficient cooling of the insert



Coolant Discharge Comparison (Internal Evaluation)

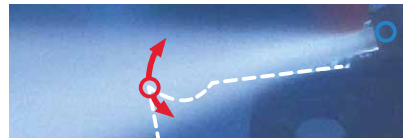
KGBF-JCT can direct coolant closer to the cutting edge than competitor C

- Cutting Edge
- Coolant Hole



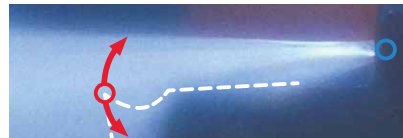
KGBF-JCT

Coolant Spread: Narrow
Coolant Density: High



Competitor C

Coolant Spread: Wide
Coolant Density: Low



Small chips and better cooling of the insert leads to longer tool life

Chip Control Comparison (Internal Evaluation)

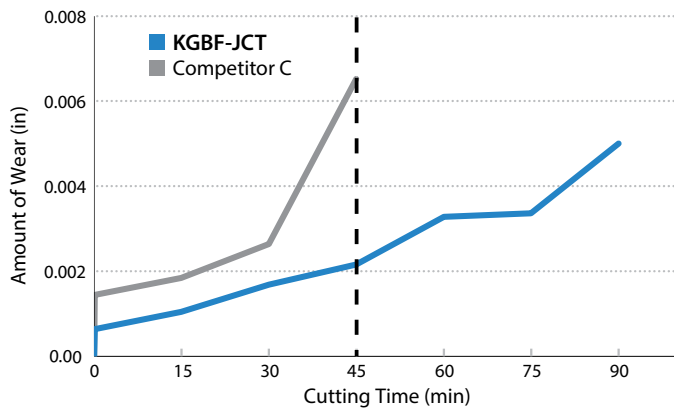
KGBF-JCT provided much better chip control



Cutting Conditions: $V_c = 330$ sfm, D.O.C. = 0.098", GBF32R200-010 PR1535, KGBFR1625H-16FJCT
 Workpiece: Ti-6Al-4V External and Internal Coolant (218 psi) External Grooving

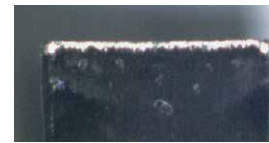
Wear Resistance Comparison (Internal Evaluation)

KGBF-JCT Showed Superior Wear Resistance



Cutting Edge

KGBF-JCT



Competitor C



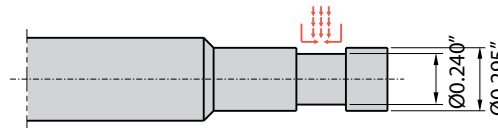
Cutting Conditions: $V_c = 490$ sfm, D.O.C. = 0.071", $f = 0.0024$ ipr, GBF32R100-005GL PR1535, KGBFR1625H-16FJCT
 Workpiece: 304 External and Internal Coolant (218 psi) External Grooving

Case Studies

Nozzle Parts - Stainless Steel

$V_c = 180$ sfm
 D.O.C. = 0.010"
 $f = 0.0012$ ipr
 Wet (Internal Coolant: 218 psi)

KGBFR1220H-16FJCT
 GBF32R100-005GL PR1535



Tool Life

KGBF-JCT
 (Internal Coolant)

1,200 pcs/edge

Tool Life

x1.6

Competitor D
 (Internal Coolant)

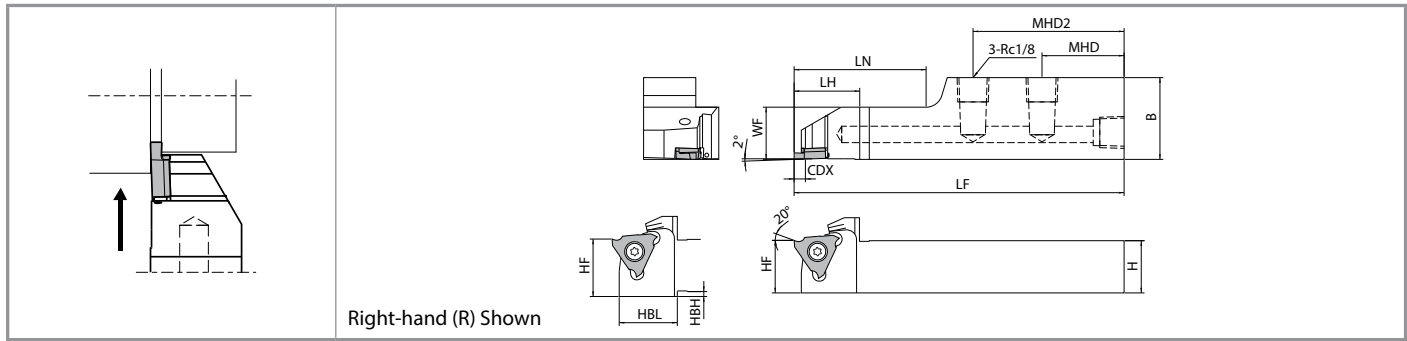
750 pcs/edge

KGBF-JCT provided much better chip control than competitor with internal coolant and a molded chipbreaker.

The KGBF-JCT lengthened tool life by 66%

(User Evaluation)

KGBF-JCT (Small Parts Grooving)



Toolholder Dimensions (Metric Size)

Part Number	Stock		Dimensions (mm)											Spare Parts		
	R	L	H=HF	HBH	B	LF	HBL	LH	LN	WF	CDX*	MHD	MHD2	Insert Screw	Wrench	Plug
KGBFR 1220H-16FJCT	●		12	1.5	20	100	20	20	28	12	3	35	-	SB-4070TRW	FT-8	GP-1
1625H-16FJCT	●		16	-	25	100	-	20	40	16	3	25	46			
2025H-16FJCT	●		20	-	25	100	-	20	40	20	3	25	46			

* Dimension CDX shows the distance from the toolholder to the cutting edge. Dimension CDX of Insert shows available grooving depth.

● : Standard Item

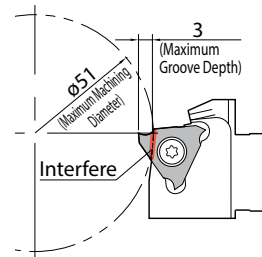
Caution

GBF and GBA Compatibility

- GBF will fit KGBA/KGBAS holders
Caution: The maximum groove depth for KGBA/KGBAS holders is 2.5mm
- GBA inserts will also fit KGBF-JCT holders
Caution: The rake angle after installation in the toolholder is 11°

KGBF-JCT Holder with GBF Insert Maximum Machining Diameter

- 3mm groove depth is available on workpiece diameters up to Ø51mm
- 2.7mm groove depth is available on workpiece diameters up to Ø100mm
- 2.5mm groove depth is available on workpiece diameters up to Ø200mm
- The workpiece will interfere with the holder at maximum cutting diameters or larger



Recommended Cutting Conditions ★ 1st Recommendation ☆ 2nd Recommendation

Workpiece	Recommended Insert Grade (Cutting Speed Vc: sfm)			[1] Grooving Feed Rate (ipr) [2] Traversing Feed Rate (ipr) [3] Max D.O.C. for Traversing (in)			
	MEGACOAT	MEGACOAT NANO	Carbide	GBF32R 025 - 053	GBF32R 065 - 095	GBF32R 100 - 145	GBF32R 150 - 300
	PR1215	PR1535	GW15				
Carbon Steel	★ 260 - 590	☆ 230 - 530	-	[1] 0.0004 - 0.0020 [2] Not Recommended [3] Not Recommended	[1] 0.0008 - 0.0028 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079
Alloy Steel	★ 260 - 590	☆ 230 - 530	-	[1] 0.0004 - 0.0016 [2] Not Recommended [3] Not Recommended	[1] 0.0008 - 0.0024 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0028 [2] 0.0008 - 0.0020 [3] MAX. 0.0079	[1] 0.0012 - 0.0028 [2] 0.0008 - 0.0020 [3] MAX. 0.0079
Stainless Steel	☆ 200 - 430	★ 160 - 390	-	[1] 0.0004 - 0.0016 [2] Not Recommended [3] Not Recommended	[1] 0.0008 - 0.0024 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0028 [2] 0.0008 - 0.0020 [3] MAX. 0.0079	[1] 0.0012 - 0.0028 [2] 0.0008 - 0.0020 [3] MAX. 0.0079
Cast Iron	-	-	★ 200 - 330	[1] 0.0004 - 0.0020 [2] Not Recommended [3] Not Recommended	[1] 0.0008 - 0.0028 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079
Aluminum Alloy	-	-	★ 490 - 1,310	[1] 0.0004 - 0.0020 [2] Not Recommended [3] Not Recommended	[1] 0.0008 - 0.0028 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079
Brass	-	-	★ 490 - 980	[1] 0.0004 - 0.0016 [2] Not Recommended [3] Not Recommended	[1] 0.0008 - 0.0028 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0028 [2] 0.0008 - 0.0020 [3] MAX. 0.0079	[1] 0.0012 - 0.0028 [2] 0.0008 - 0.0020 [3] MAX. 0.0079

GBF-GL

Workpiece	Recommended Insert Grade (Cutting Speed Vc: sfm)		[1] Grooving Feed Rate (ipr) [2] Traversing Feed Rate (ipr) [3] Max D.O.C. for Traversing (in)			
	MEGACOAT	MEGACOAT NANO	GBF32R 075 (GL)	GBF32R 095 - 100 (GL)	GBF32R 150 - 200 (GL)	GBF32R 300 (GL)
	PR1215	PR1535				
Carbon Steel	★ 260 - 590	☆ 230 - 530	[1] 0.0008 - 0.0028 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0012 - 0.0031 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0016 - 0.0039 [2] 0.0016 - 0.0031 [3] MAX. 0.0197
Alloy Steel	★ 260 - 590	☆ 230 - 530	[1] 0.0008 - 0.0024 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0028 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0012 - 0.0028 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0016 - 0.0035 [2] 0.0016 - 0.0031 [3] MAX. 0.0197
Stainless Steel	☆ 200 - 430	★ 160 - 390	[1] 0.0008 - 0.0024 [2] Not Recommended [3] Not Recommended	[1] 0.0012 - 0.0028 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0012 - 0.0028 [2] 0.0012 - 0.0024 [3] MAX. 0.0079	[1] 0.0016 - 0.0035 [2] 0.0016 - 0.0031 [3] MAX. 0.0197

KGBF-JCT Applicable Inserts

Part Number	IC	S	D1	Dimensions (mm)			MEGACOAT	MEGACOAT NANO	Carbide	
Shape	Part Number		CW	CDX	RE	PR1215	PR1535	GW15		
	GBF32	9.525	3.18	4.4						
	GBF32R	025-005	0.25	0.60	0.05	●	●	●		
		030-005	0.30	0.80		●	●	●		
		033-005 ^{※1}	0.33			●	●	●		
		043-005 ^{※2}	0.43	1.00		●	●	●		
		050-005	0.50	1.20		●	●	●		
		053-005 ^{※3}	0.53			●	●	●		
		065-005	0.65			●	●	●		
		075-005	0.75	2.00		●	●	●		
		080-005	0.80			●	●	●		
		095-005	0.95			●	●	●		
		100-005	1.00			●	●	●		
		110-005	1.10			●	●	●		
		120-005	1.20			●	●	●		
		125-010	1.25	2.70		0.10	●	●	●	
		130-010	1.30				●	●	●	
		140-010	1.40		●		●	●		
		145-010	1.45		●		●	●		
		150-010	1.50		●		●	●		
		165-010	1.65		●		●	●		
		170-010	1.70	3.00	0.10	●	●	●		
		175-010	1.75			●	●	●		
		200-010	2.00			●	●	●		
		225-010	2.25			●	●	●		
		250-010	2.50	3.00	0.10	●	●	●		
		300-010	3.00			●	●	●		
			GBF32R	075-005GL	0.75	2.00	0.05	●	●	
				095-005GL	0.95			●	●	
				100-005GL	1.00			●	●	
				150-010GL	1.50	2.70	0.10	●	●	
				200-010GL	2.00	3.00		●	●	
300-010GL	3.00			●	●					

The maximum machining diameter is Ø51 mm (Please check caution on [Page 12](#))

● : Standard Item

※1 : The edge width (CW) tolerance of GBF32R 033-005 : $0.33^{+0.015mm}_{-0.025mm}$

※2 : The edge width (CW) tolerance of GBF32R 043-005 : $0.43^{+0.015mm}_{-0.025mm}$

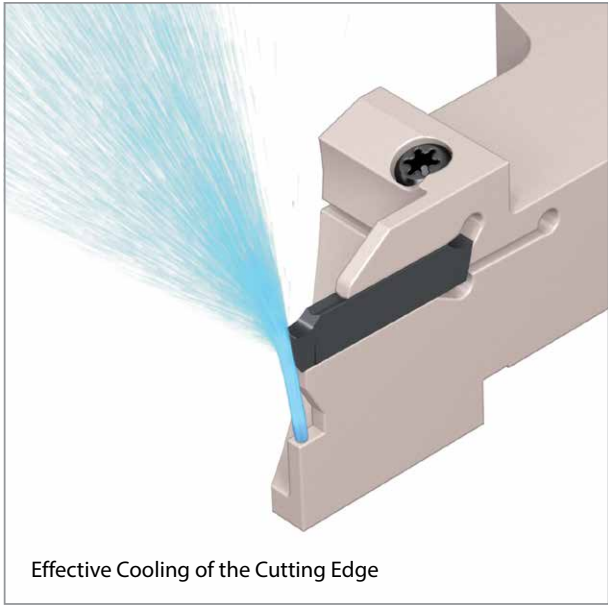
※3 : The edge width (CW) tolerance of GBF32R 053-005 : $0.53^{+0.015mm}_{-0.025mm}$

KGD-JCT NEW

Grooving / Cut-Off

Coolant-Through Cut-Off Holders for Small Parts Machining

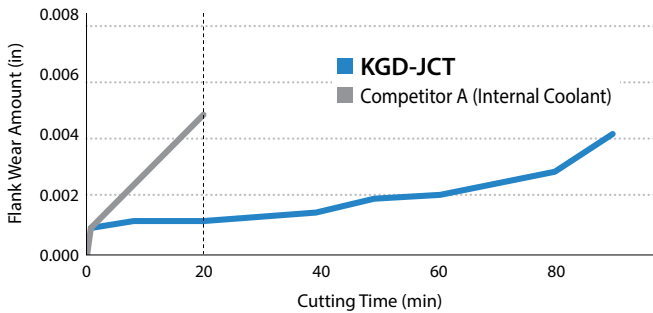
KGD-JCT Cut-Off Holder Lineup Expansion
Improved Tool Life Lowers Machining Costs



1 Optimized Coolant Hole Position

2 Discharges Coolant towards the Flank Face of the Insert

Wear Resistance Comparison
(Internal Evaluation)

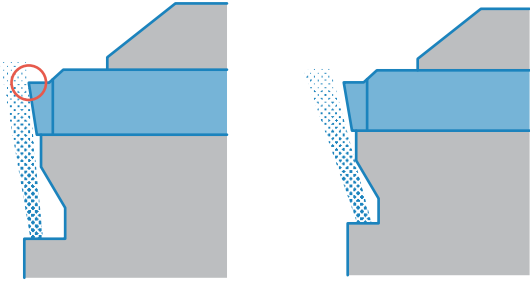


Cutting Conditions : Vc = 260 sfm, f=0.06ipr (~0.079" : f = 0.0007 ipr), KGDR1625H-2JCT, GDM2020N-015PF PR1535 (Insert Width : 0.079") Workpiece : 304 (Ø0.984")
Internal Coolant(218 psi) Cut-off

Coolant Discharge

KGD-JCT
Sufficient cooling towards the cutting edge

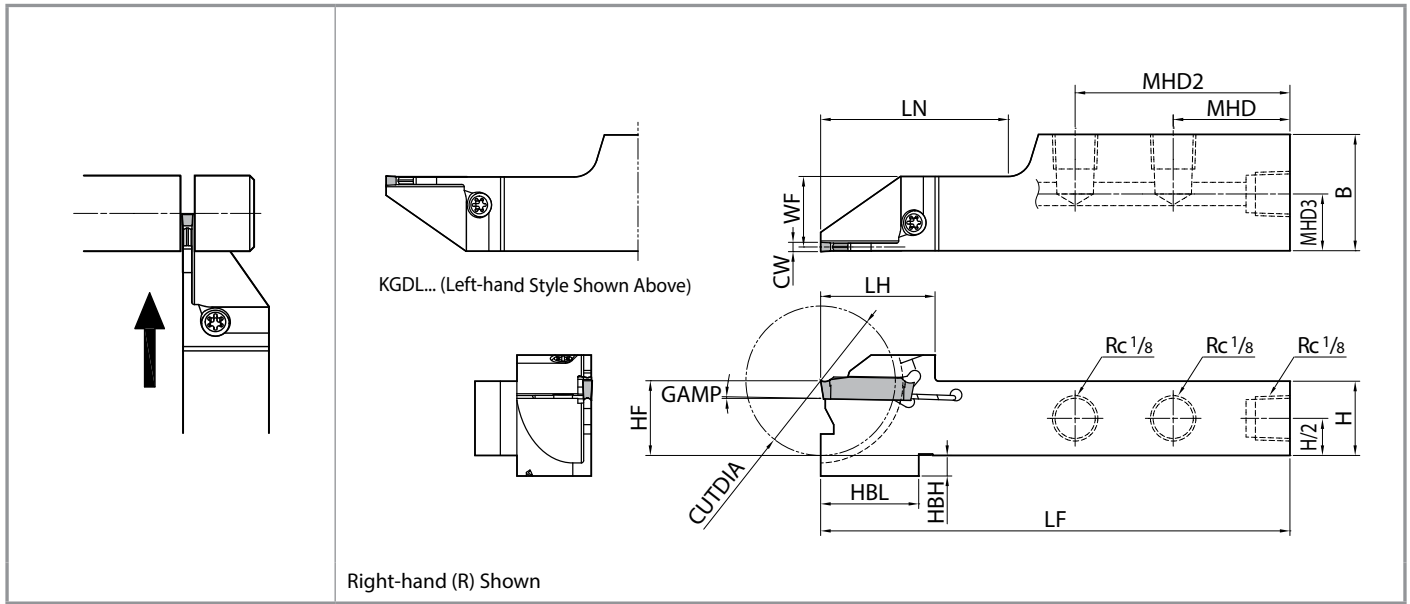
Competitor A
Coolant does not flow directly towards the cutting edge



Cutting Edge (After Machining 20 min)






High density and high speeds coolant provides effective cooling of the cutting edge
Superior cooling action improves tool life



Toolholder Dimensions (Metric Size)

Part Number	Stock	Cut-Off Dia.	Dimensions (mm)											Angle	Edge Width CW (mm)		Applicable Inserts
			CUTDIA	H=HF	HBH	B	LF	LH	HBL	LN	WF	MHD	MHD2		MHD3	GAMP	
KGDR 1220H-2JCT	●	24	12	8.5	20	100	19.5	21	44	11.2	35	-	8.4	1°	2.0	3.0	GDM Type GDG Type (GDMS Type) (GDGS Type)
KGDL 1220H-2JCT	●						21.5	7.7									
KGDR 1625H-2JCT	●	32	16	4.5	25		24.5	21	40	15.2	25	46	12.2				
KGDL 1625H-2JCT	●						7.7										
KGDR 1220H-2.4JCT	●	24	12	8.5	20	100	19.5	21	44	11	35	-	8.4	1°	2.4	3.0	
KGDL 1220H-2.4JCT	●						21.5	7.7									
KGDR 1625H-2.4JCT	●	32	16	4.5	25		24.5	21	40	15	25	46	12.2				
KGDL 1625H-2.4JCT	●						7.7										
KGDR 1220H-3JCT	●	24	12	8.5	20	100	19.5	21	44	10.8	35	-	8.6	1°	3.0	3.0	
KGDL 1220H-3JCT	●						21.5	7.7									
KGDR 1625H-3JCT	●	32	16	4.5	25		24.5	21	40	14.8	25	46	12.2				
KGDL 1625H-3JCT	●						7.7										

● : Standard Item

Spare Parts	Clamp Screw		Wrench		Plug	
		SB-40120TR		LTW-15S		GP-1

KGD-JCT Applicable Inserts

External Grooving / Traversing

Usage Classification		P	Carbon Steel / Alloy Steel		●	○	●	○	●	○		
		M	Stainless Steel				●	○	●	○		
● : Light Interruption / 1st Choice ○ : Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice		K	Cast Iron						●	○		
		N	Non-ferrous Material								●	
		S	Titanium Alloy				●				○	
		H	Hardened Material (~40HRC)					○				
				Hardened Material (40HRC~)								
Shape	Part Number	Dimensions (in)			RE	CERMET	MEGA COAT NANO	MEGACOAT	Carbide			
		Edge Width CW										
		inch	mm	Tolerance		TN620	TN90	PR1535	PR1225	PR1215	GW15	
External Grooving & Traversing	General Purpose	GDM 3020N-020GM 3020N-040GM	0.118	3	±0.0012	0.008	●	●	●	●	●	
						0.016	●	●	●	●	●	
		4020N-020GM 4020N-040GM	0.157	4	±0.0012	0.008	●	●	●	●	●	●
						0.016	●	●	●	●	●	
		4020N-080GM 5020N-040GM	0.197	5	±0.0016	0.016	●	●	●	●	●	●
						0.031	●	●	●	●	●	
	5020N-080GM	0.197	5	±0.0016	0.031	●	●	●	●	●	●	
					0.031	●	●	●	●	●		
	General Purpose 1-Edge	GDM 3020N-020GL 3020N-040GL	0.118	3	±0.0012	0.008	●	●	●	●	●	
						0.016	●	●	●	●	●	
		4020N-020GL 4020N-040GL	0.157	4	±0.0012	0.008	●	●	●	●	●	
						0.016	●	●	●	●	●	
5020N-040GL		0.197	5	±0.0016	0.016	●	●	●	●	●		
					0.016	●	●	●	●	●		
Grooving	Wiper Edge	GDG 3020N-020GS 3520N-020GS	0.118	3.5	±0.0008	0.008	●	●	●	●	●	
						0.016	●	●	●	●	●	
		4020N-040GS 5020N-040GS	0.157	4	±0.0008	0.016	●	●	●	●	●	
						0.016	●	●	●	●	●	
Full-R / Copying		GDM 3020N-150R-CM 4020N-200R-CM	0.118	4	±0.0012	0.059	●	●	●	●		
						0.079	●	●	●	●		
		5020N-250R-CM	0.197	5	±0.0016	0.098	●	●	●	●		
Grooving & Cut-Off (High Feed)	1-Edge	GDM 3020N-030PH 4020N-030PH	0.118	3	±0.0012	0.012		●	●	●		
						0.012		●	●	●		
	GDMS 3020N-030PH 4020N-030PH	0.118	3	±0.0012	0.012		●	●	●	●		
					0.012		●	●	●	●		

Inserts sold in 10 piece boxes

Cut-Off

Usage Classification		P	Carbon Steel / Alloy Steel		○	●	○			
		M	Stainless Steel		●	○	○			
● : Light Interruption / 1st Choice ○ : Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice		N	Non-ferrous Material					●	○	
		Shape	Part Number	Dimensions (in)			RE	MEGA COAT NANO	MEGACOAT	DLC Coated Carbide
Edge Width CW										
		inch	mm	Tolerance		PR1535	PR1225	PR1215	PDL025	GW15
Cut-Off	6° Lead Angle	GDM 3020N-025PM 4020N-030PM	0.118	3	±0.0012	0.010	●	●	●	
						0.012	●	●	●	
	1-Edge	GDM 3020R-025PM-6D 4020N-030PM	0.118	3	±0.0012	0.010	●	●	●	
						0.012	●	●	●	
	6° Lead Angle 1-Edge	GDMS 3020R-025PM-6D 4020R-030PM-6D	0.118	3	±0.0012	0.010	●	●	●	
						0.012	●	●	●	
	Cut-Off (Low Feed)	15° Lead Angle	GDM 3020N-003PF 3020N-015PF	0.118	3	±0.0016	0.001	●	●	
							0.006	●	●	●
		15° Lead Angle	GDM 3020 ^{R/L} -003PF-15D 3020R-015PF-15D	0.118	3	±0.0016	0.001	●	●	
							0.006	●	●	●
	Cut-Off (Medium Feed)	15° Lead Angle	GDM 3020N-010PQ GDM 3020R-010PQ-15D	0.118	3	±0.0012	0.004	●	●	
							0.004	●	●	
Cut-Off (Low Cutting Force)	15° Lead Angle	GDG 3020N-005PG GDG 3020R-005PG-15D	0.118	3	±0.0008	0.002	●	●	●	
						0.002	●	●	●	●

Inserts sold in 10 piece boxes

CBN / PCD

Usage Classification		N	Non-ferrous Material				●	
		S	Titanium Alloy				●	
● : Light Interruption / 1st Choice ○ : Light Interruption / 2nd Choice ● : Continuous / 1st Choice ○ : Continuous / 2nd Choice		H	Hardened Material (~40HRC)					
			Hardened Material (40HRC~)		●			
		-	Powdered Steel			●		
		Shape	Part Number	Dimensions (in)			RE	MEGA COAT CBN
Edge Width CW								
		inch	mm	Tolerance		KBN05M	KBN1570	KPD001
Grooving	1-Edge	GDGS 3020N-020NB 3020N-040NB	0.118	3	±0.0012	0.008		●
						0.016	●	●
		4020N-020NB 4020N-040NB	0.157	4	±0.0012	0.008		●
						0.016	●	●
		5020N-020NB 5020N-040NB	0.197	5	±0.0012	0.008		●
						0.016	●	●

CBN and PCD inserts sold in 1 piece boxes

● : Standard Item

Recommended Cutting Conditions (Cut-Off) ★ 1st Recommendation ☆ 2nd Recommendation

PF Chipbreaker

Workpiece	Cutting Conditions (Vc : sfm)				Feed Rate (f : ipr)						Notes
	Recommended Insert Grade				PF Corner-R (RE) = 0.001			PF Corner-R (RE) = 0.006			
	MEGACOAT NANO	MEGACOAT		Carbide	Insert Width (W)			Insert Width (W)			
	PR1535	PR1225	PR1215	GW15	0.051" - 0.059" 1.3mm - 1.5mm	0.079" 2.0mm	0.098" - 0.118" 2.5mm - 3.0mm	0.051" - 0.059" 1.3mm - 1.5mm	0.079" 2.0mm	0.098" - 0.118" 2.5mm - 3.0mm	
Carbon Steel	☆ 230 - 490	★ 230 - 490	☆ 230 - 590	-	0.0004 - 0.0016	0.0008 - 0.0024	0.0008 - 0.0031	0.0004 - 0.0020	0.0012 - 0.0031	0.0016 - 0.0039	Coolant
Alloy Steel	☆ 230 - 490	★ 230 - 490	☆ 230 - 590	-							
Stainless Steel	★ 200 - 390	☆ 200 - 390	☆ 200 - 490	-							
Cast Iron	-	-	★ 260 - 660	☆ 160 - 330							

PQ / PG Chipbreaker

Workpiece	Cutting Conditions (Vc : sfm)					Feed Rate (f : ipr)				Notes
	Recommended Insert Grade					PQ		PG		
	MEGACOAT NANO	MEGACOAT		DLC Coated Carbide	Carbide	Insert Width (CW)		Insert Width (CW)		
	PR1535	PR1225	PR1215	PDL025	GW15	0.079" 2.0mm	0.098" - 0.118" 2.5mm - 3.0mm	0.079" 2.0mm	0.098" - 0.118" 2.5mm - 3.0mm	
Carbon Steel	☆ 230 - 490	★ 230 - 490	☆ 230 - 590	-	-	0.0012 - 0.0039	0.0016 - 0.0047	0.0004 - 0.0016	0.0004 - 0.0020	Coolant
Alloy Steel	☆ 230 - 490	★ 230 - 490	☆ 230 - 590	-	-					
Stainless Steel	★ 200 - 390	☆ 200 - 390	☆ 200 - 490	-	-	0.0008 - 0.0028	0.0008 - 0.0031	0.0004 - 0.0012	0.0004 - 0.0016	
Cast Iron	-	-	★ 260 - 660	-	☆ 160 - 330	0.0016 - 0.0039	0.0016 - 0.0047	0.0004 - 0.0016	0.0004 - 0.0020	
Aluminum Alloy	-	-	-	★ 660 - 1,640	☆ 660 - 1,480	-	-	0.0004 - 0.0020	0.0004 - 0.0024	
Brass	-	-	-	-	★ 330 - 660	-	-	0.0004 - 0.0028	0.0004 - 0.0031	

PM / PH Chipbreaker

Workpiece	Cutting Conditions (Vc : sfm)			Feed Rate (f : ipr)			Notes
	Recommended Insert Grade			PM	PH		
	MEGACOAT NANO	MEGACOAT		Insert Width (CW)	Insert Width (CW)		
	PR1535	PR1225	PR1215	0.079" - 0.158" 2.0mm - 4.0mm	0.079" 2.0mm	0.095" - 0.158" 3.0mm - 4.0mm	
Carbon Steel	☆ 260 - 660	★ 260 - 660	☆ 330 - 660	0.0031 - 0.0071	0.0039 - 0.0098	0.0059 - 0.0110	Coolant
Alloy Steel	☆ 230 - 590	★ 230 - 590	☆ 260 - 590				
Stainless Steel	★ 200 - 490	☆ 200 - 490	☆ 200 - 490	0.0024 - 0.0047	0.0020 - 0.0047	0.0031 - 0.0059	
Cast Iron	-	-	★ 330 - 660	0.0031 - 0.0071	0.0039 - 0.0098	0.0059 - 0.0110	

Recommended Cutting Conditions (External Grooving) ★ 1st Recommendation ☆ 2nd Recommendation

Workpiece	Chipbreaker	Recommended Insert Grade (Vc : sfm)								Notes	
		Cermet		MEGACOAT NANO	MEGACOAT		Carbide	MEGACOAT CBN	CBN		PCD
		TN620	TN90	PR1535	PR1225	PR1215	GW15	KBN05M	KBN570		KPD001
Carbon Steel	GM	☆ 260 - 720	☆ 330 - 720	☆ 260 - 660	★ 260 - 660	☆ 330 - 660	-	-	-	-	Coolant
Alloy Steel	GL	☆ 230 - 660	☆ 260 - 660	☆ 230 - 590	★ 230 - 590	☆ 260 - 590	-	-	-	-	
Stainless Steel	CM	-	-	★ 200 - 490	☆ 200 - 490	☆ 200 - 490	-	-	-	-	
Cast Iron	PH	-	-	-	-	★ 330 - 660	-	-	-	-	
Aluminum Alloy	GS	-	-	-	-	-	☆ 660 - 1,640	-	-	★ 490 - 6,560	
Brass	NB	-	-	-	-	-	☆ 330 - 660	-	-	★ 660 - 2,620	
Hard Materials	-	-	-	-	-	-	-	★ 260 - 490	-	-	
Powdered Steel	NB	-	-	-	-	-	-	-	★ 330 - 820	-	

KTKF-JCT

Cut-Off

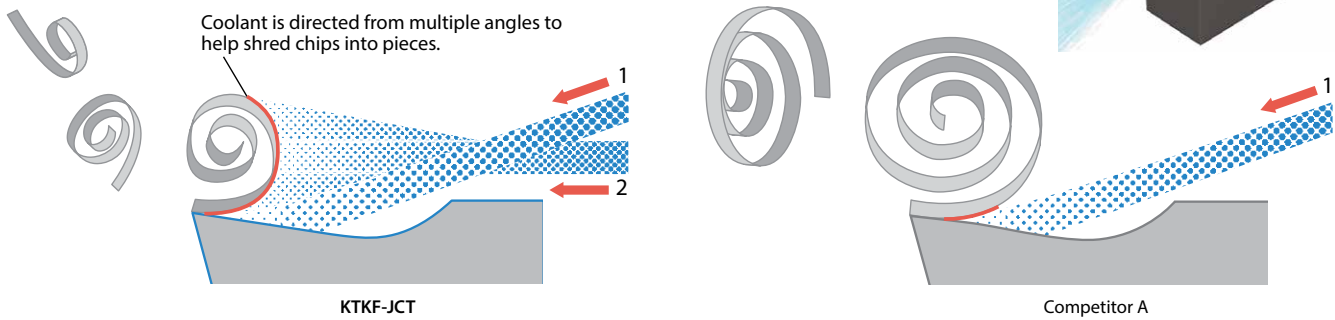
Coolant-Through Cut-Off Holders for Small Parts Machining

KTKF-JCT holders break chips evenly into small pieces with excellent chip control performance when machining difficult-to-cut material and stainless steel.

1 Excellent Chip Control Performance

The KTKF-JCT discharges coolant in two directions toward rake surface of insert and breaks chips into small pieces.

Coolant Discharge Structure Comparison

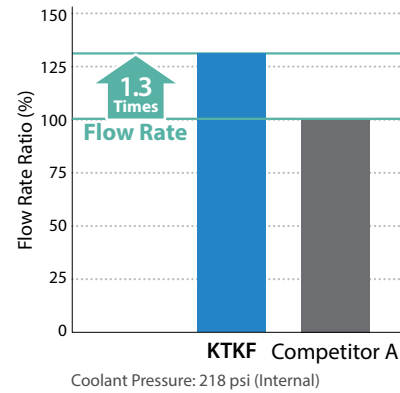


Chip Control Comparison (Internal Evaluation)

304				Ti-6Al-4V			
f (ipr)	0.0004	0.0008	0.0012	f (ipr)	0.0004	0.0008	0.0012
KTKF-JCT				KTKF-JCT			
Competitor A				Competitor A			

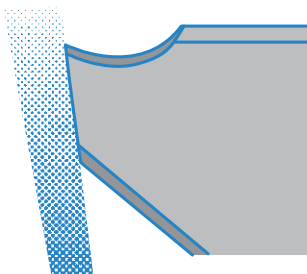
Cutting Conditions: $V_c = 260$ sfm, Wet (Oil-based) Coolant Pressure: 218 psi (Internal)
Workpiece: $\varnothing 0.472''$

Coolant Flow Rate Comparison (Internal Evaluation)

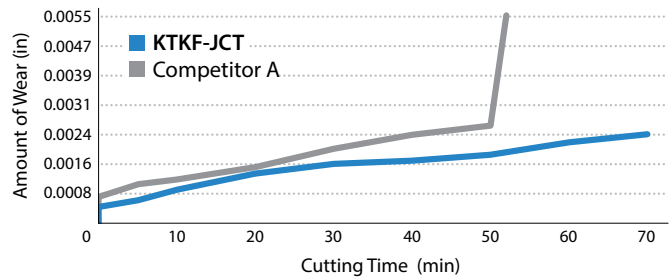


2 Superior Cooling Action Improves Tool Life

Coolant is also directed from the flank face of the insert to supply an ample amount of coolant to the tool edge area to help further suppress insert wear.

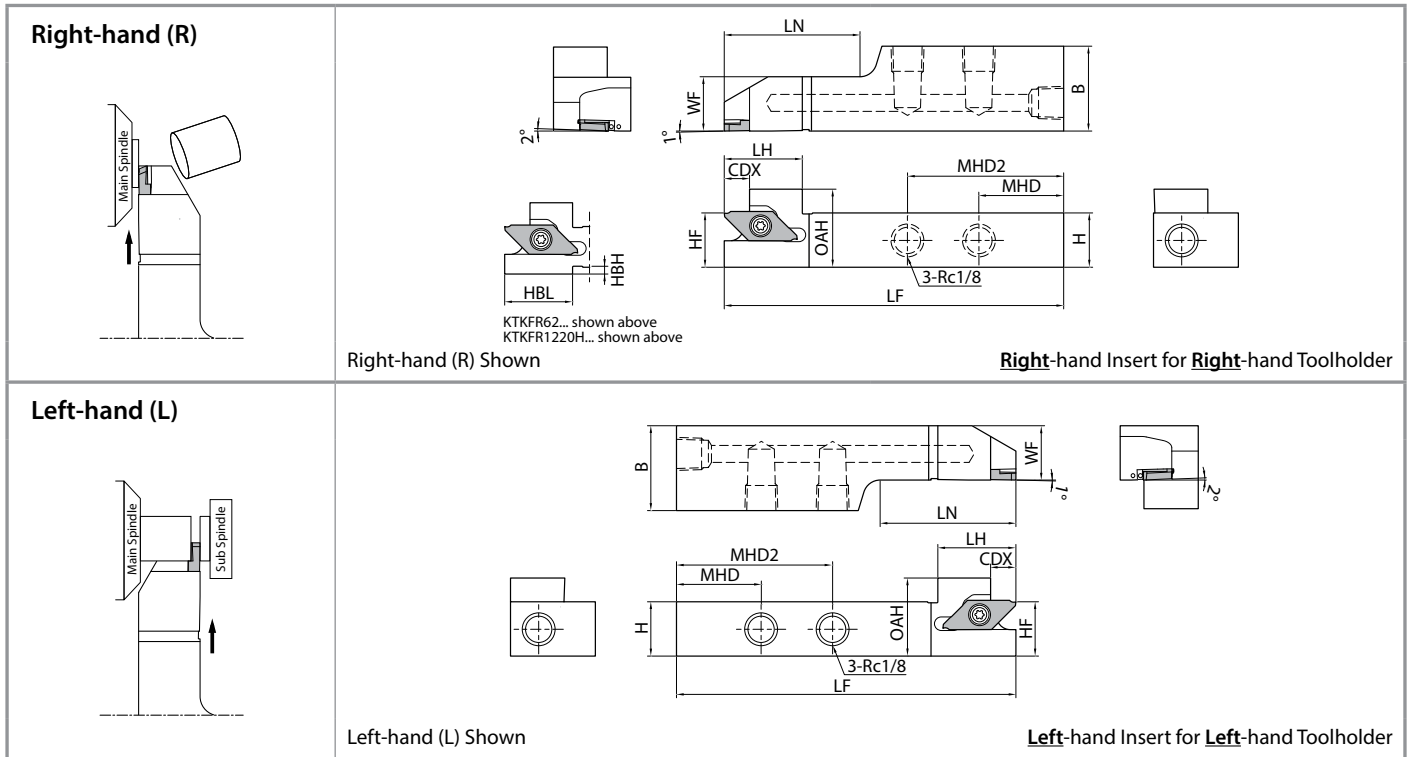


Wear Resistance Comparison (Internal Evaluation)



Cutting Conditions: $V_c = 330$ sfm, $f = 0.0008$ ipr, Wet (Oil-based)
Lubricating Pressure: 218 psi (Internal) Workpiece: Ti-6Al-4v $\varnothing 0.472''$

KTKF-JCT (Small Parts Cut-Off)


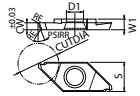

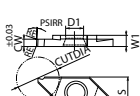

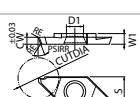

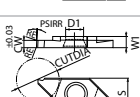

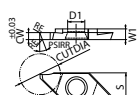

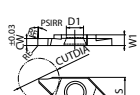

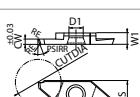

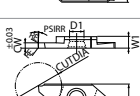

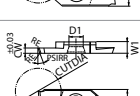

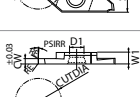

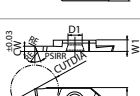

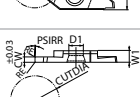


Toolholder Dimensions

Part Number	Stock		Unit	Dimensions											Spare Parts			
	R	L		H=HF	OAH	B	LF	HBH	HBL	LH	LN	WF	CDX	MHD	MHD2	Insert Screw	Wrench	Plug
NEW KTKFR 62-12JCT	●		in	0.500	0.775	0.750	4.750	-	0.783	0.783	1.110	0.500	0.295	1.417	-	SB-4590TRWN	FT-10	GP-1
NEW 82.5-12JCT	●			0.625	0.900	1.000	4.750	-	-	0.901	1.582	0.625	0.295	0.984	1.811	SB-4590TRWN	FT-10	GP-1
NEW KTKFR 82.5-16JCT	●			0.625	0.900	1.000	4.750	-	-	0.901	1.582	0.625	0.378	0.984	1.811	SB-4590TRWN	FT-10	GP-1
KTKFR 1220H-12JCT	●		mm	12	19	20	100	2	20	20	28	12	7.5	35	-	SB-4590TRWN	FT-10	GP-1
KTKF ^{R/L} 1625H-12JCT	●	●		16	23	25	100	-	-	23	40	16	7.5	25	46			
2025H-12JCT	●	●		20	27													
KTKF ^{R/L} 1625H-16JCT	●	●		16	23	25	100	-	-	23	40	16	9.6	25	46	SB-4590TRWN	FT-10	GP-1
2025H-16JCT	●	●	20	27	41													

● : Standard Item

KTKF-JCT Applicable Inserts

Shape		Part Number	Dimensions (mm)						Angle	MEGACOAT NANO		MEGACOAT NANO		MEGACOAT		PVD Coated Carbide		DLC Coated Carbide		Uncoated Carbide						
			CW	CUTDIA	RE	W1	S	D1		PSIRR	PR1425		PR1535		PR1225		PR1025		PDL025		KW10					
											R	L	R	L	R	L	R	L	R	L	R	L				
 Right Lead Angle		TKF12 % 050-S-16DR	0.5	5	0.03	3	8.7	5	16°	●	●	●	●	●	●	●	●	●	●	●	●					
		070-S-16DR	0.7	8						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
		100-S-16DR	1.0	12						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		125-S-16DR	1.25							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		150-S-16DR	1.5							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		200-S-16DR	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 0°		TKF12 % 050-S	0.5	5	0.03	3	8.7	5	0°	●	●	●	●	●	●	●	●	●	●	●	●					
		070-S	0.7	8						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
		100-S	1.0	12						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		125-S	1.25							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		150-S	1.5							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		200-S	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Right Lead Angle / Tough Edge		TKF12 % 100-T-16DR	1.0	12	0.08	3	8.7	5	16°	●	●	●	●	●	●	●	●	●	●	●	●					
		150-T-16DR	1.5							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		200-T-16DR	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Tough Edge		TKF12 % 100-T	1.0	12	0.08	3	8.7	5	0°	●	●	●	●	●	●	●	●	●	●	●	●					
		150-T	1.5							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		200-T	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Right Lead Angle / Without Chipbreaker		TKF12 % 050-NB-20DR	0.5	5	0	3	8.7	5	20°	●	●	●	●	●	●	●	●	●	●	●	●					
		070-NB-20DR	0.7	8						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
		100-NB-20DR	1.0	12						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		150-NB-20DR	1.5							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		200-NB-20DR	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Without Chipbreaker		TKF12 % 050-NB	0.5	5	0	3	8.7	5	0°	●	●	●	●	●	●	●	●	●	●	●	●					
		070-NB	0.7	8						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
		100-NB	1.0	12						●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		150-NB	1.5							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
		200-NB	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Right Lead Angle		TKF16 % 150-S-16DR	1.5	16	0.05	4	9.5	5	16°	●	●	●	●	●	●	●	●	●	●	●	●					
		200-S-16DR	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 0°		TKF16 % 150-S	1.5	16	0.05	4	9.5	5	0°	●	●	●	●	●	●	●	●	●	●	●	●					
		200-S	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Right Lead Angle / Tough Edge		TKF16 % 150-T-16DR	1.5	16	0.08	4	9.5	5	16°	●	●	●	●	●	●	●	●	●	●	●	●					
		200-T-16DR	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Tough Edge		TKF16 % 150-T	1.5	16	0.08	4	9.5	5	0°	●	●	●	●	●	●	●	●	●	●	●	●					
		200-T	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Right Lead Angle / Without Chipbreaker		TKF16 % 150-NB-20DR	1.5	16	0	4	9.5	5	20°	●	●	●	●	●	●	●	●	●	●	●	●					
		200-NB-20DR	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
 Without Chipbreaker		TKF16 % 150-NB	1.5	16	0	4	9.5	5	0°	●	●	●	●	●	●	●	●	●	●	●	●					
		200-NB	2.0							●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Lead angle (front cutting edge angle: PSIRR) shows the angle when installed in the toolholder.
Machining diameter of insert (CUTDIA) indicates the machining diameter when the tool tip has proceeded to the center of workpiece

● : Standard Item

Recommended Cutting Conditions ★ 1st Recommendation ☆ 2nd Recommendation

Workpiece	Recommended Insert Grade (Vc: sfm)						TKF12						TKF16		Notes
							Edge Width W (mm)						Edge Width W (mm)		
	MEGACOAT NANO		MEGACOAT	PVD Coated Carbide	DLC Coated Carbide	Uncoated Carbide	0.5	0.7	1.0	1.25	1.5	2.0	1.5	2.0	
	PR1425	PR1535	PR1225	PR1025	PDL025	KW10	f (ipr)						f (ipr)		
Carbon Steel	★ 230 - 560 (160 - 460)	☆ 230 - 490 (160 - 390)	☆ 230 - 490 (160 - 390)	☆ 200 - 430	-	-	0.0004-0.0008	0.0004-0.0012	0.0004-0.0016 (0.0004-0.0020)	0.0004-0.0016	0.0004-0.0016 (0.0008-0.0039)	0.0004-0.0016 (0.0008-0.0039)	0.0008-0.0028 (0.0008-0.0039)	0.0008-0.0028 (0.0008-0.0039)	
Alloy Steel	★ 230 - 560 (160 - 460)	☆ 230 - 490 (160 - 390)	☆ 230 - 490 (160 - 390)	☆ 200 - 430	-	-	0.0004-0.0008	0.0004-0.0012	0.0004-0.0016 (0.0004-0.0020)	0.0004-0.0016	0.0004-0.0016 (0.0008-0.0039)	0.0004-0.0016 (0.0008-0.0039)	0.0008-0.0028 (0.0008-0.0039)	0.0008-0.0028 (0.0008-0.0039)	
Stainless Steel	☆ 200 - 460 (130 - 390)	★ 200 - 390 (130 - 330)	☆ 200 - 390 (130 - 330)	☆ 160 - 330	-	-	0.0002-0.0006	0.0004-0.0008	0.0004-0.0008 (0.0004-0.0012)	0.0004-0.0008	0.0004-0.0008 (0.0004-0.0020)	0.0004-0.0008 (0.0004-0.0020)	0.0004-0.0016 (0.0004-0.0020)	0.0004-0.0016 (0.0004-0.0020)	
Cast Iron	-	-	-	-	-	★ 160 - 330	0.0004-0.0012	0.0004-0.0016	0.0004-0.0020	0.0004-0.0020	0.0004-0.0020	0.0004-0.0020	0.0008-0.0031	0.0008-0.0031	
Aluminum	-	-	-	-	★ 660 - 1,640	☆ 660 - 1,470	0.0004-0.0012	0.0004-0.0016	0.0004-0.0020	0.0004-0.0020	0.0004-0.0020	0.0004-0.0020	0.0008-0.0031	0.0008-0.0031	
Brass	-	-	-	-	-	★ 330 - 660	0.0004-0.0012	0.0004-0.0016	0.0004-0.0024	0.0004-0.0024	0.0004-0.0024	0.0004-0.0024	0.0008-0.0039	0.0008-0.0039	

Recommendations in Parentheses () : Tough Edge Type (TKF..T.)



KYOCERA Precision Tools

102 Industrial Park Road
Hendersonville, NC 28792
Customer Service | 800.823.7284 - Option 1
Technical Support | 800.823.7284 - Option 2



Official Website | www.kyoceraprecisiontools.com
Distributor Website | mykpti.kyocera.com
Email | cuttingtools@kyocera.com