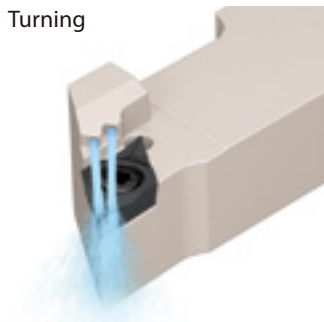


JCTM Series



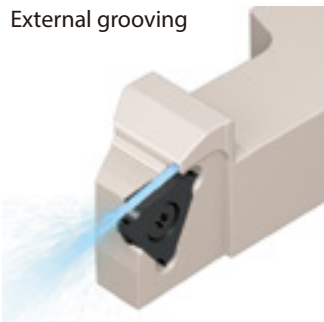
Supports fewer piping attachments with direct coolant supply

Turning



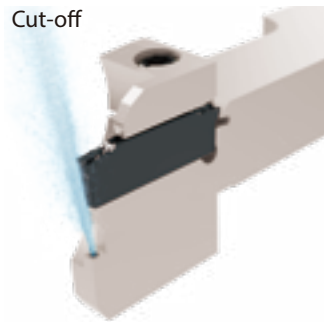
Screw Clamp-JCTM

External grooving



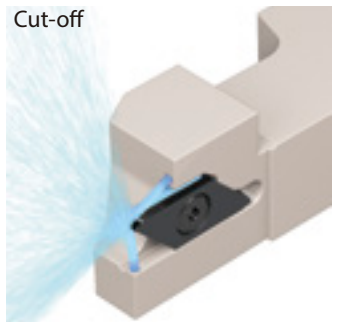
KGBF-JCTM

Cut-off



KGZ-JCTM

Cut-off



KTKF-JCTM

Applicable to different supply styles

Supports internal coolant with/without piping system

Large line-up for various tooling operations

Long tool life with Kyocera's high-performance insert grade.

**KEEPS YOU
AHEAD**

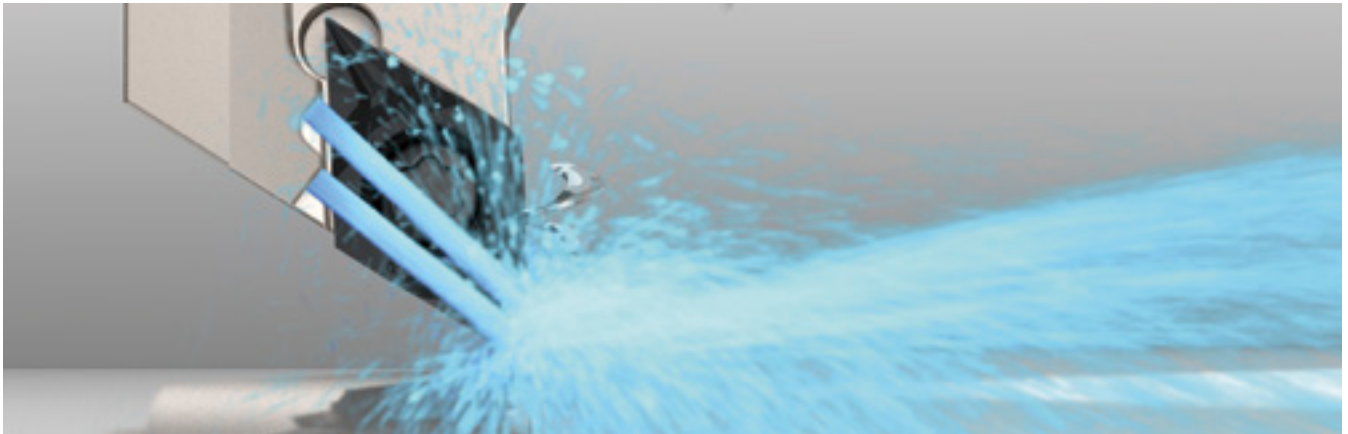


Direct coolant holder for small parts machining

JCTM Series

Applicable to different supply styles. Supports internal coolant with/without piping system.
Line-up of turning, grooving (KGBF), and cut-off (KGZ/KTKF) holders.

1 Using internal coolant to enhance tool performance



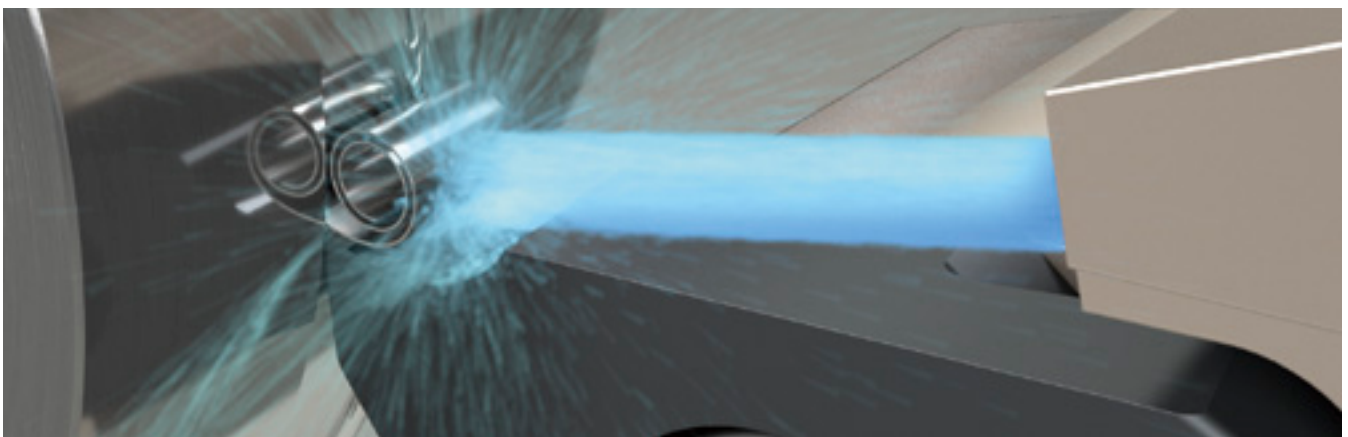
CG Image

Challenges

- Difficulty in automatic operation due to sudden chip entanglement
- Insert change is not enough to extend tool life

Solution

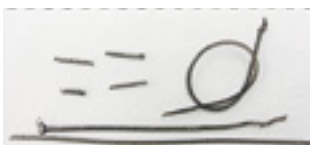
- The JCTM series is compatible with internal coolant in a wide range of machines and also works under normal pressure
- Reduces down time by improving chip control and reduces cost by extending tool life



CG Image

Switching to internal coolant toolholder reduces chip entanglement

Internal coolant (2.5 MPa)



External coolant



Pin alloy tool steel (SKS 93, JIS)

$V_c = 180$ m/min, $a_p = 1.4$ mm

$f = 0.13$ mm/rev, Wet

SDJC / DCMT11T304 type

(User evaluation)

2

Applicable to different supply styles.
Supports internal coolant with/without piping system.

Internal coolant without piping

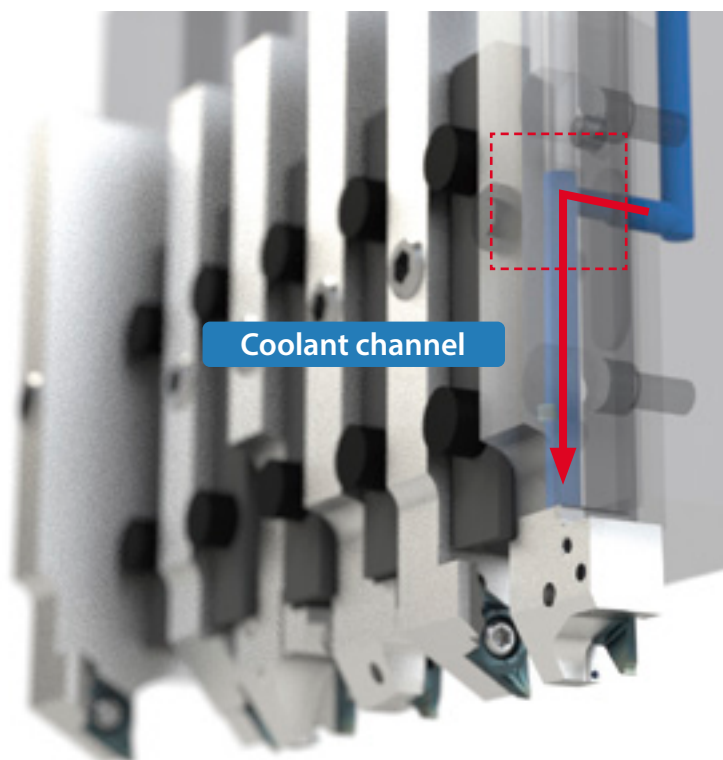
***When the tool turret supports direct coolant**

Coolant is supplied directly from tool turret into the holder. No need for piping just by installing tools

Applicable to wide range of machines **The tool turret is optional. Please contact our company sales representative for details.**

CITIZEN MACHINERY CO., LTD. (L12(2M), L20(2M/3M), L32(2M), D25, M32(5M))
STAR MICRONICS CO., LTD. (SB Series, SD Series, SP Series)
TSUGAMI CORPORATION (B026/032-III Series, BW269/329ZJ, SS267/327-III Series, S205/206-II, S205A/206A-II)
Compatible with various machine including the above.
Toolholders can be customized as well.

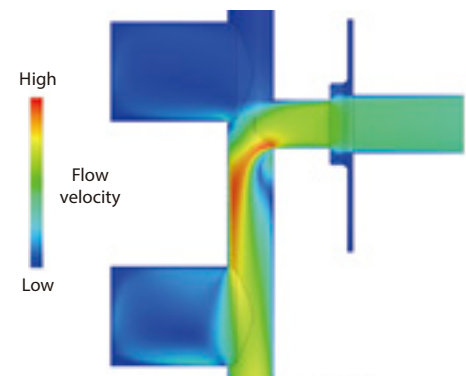
(Random order)
Based on Kyocera Survey in October 2025



Point

Appropriate hole design to reduce energy loss based on deep analysis

Analysis image (Internal evaluation)

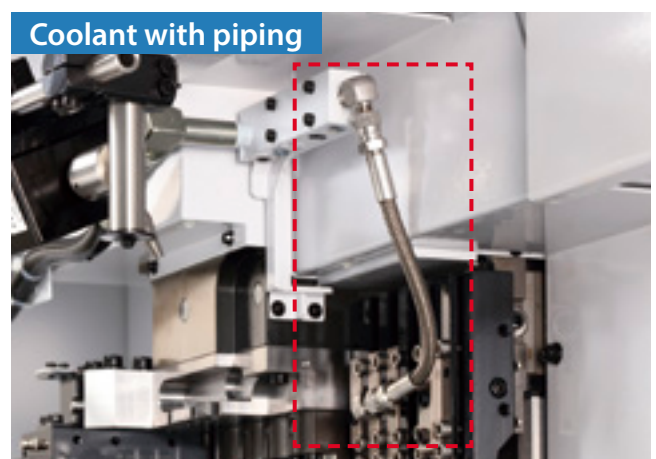


Internal coolant with piping

***Piping parts:** See pages 17 and 18

Compatible with internal coolant on any machine with standard piping parts.

Commercial piping parts are available when using at normal pressure.

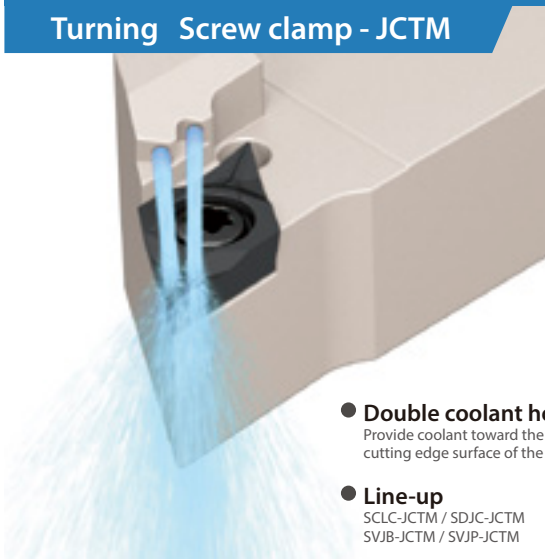


3

Large line-up for various tooling operations

Turning Screw clamp - JCTM

➔ P5
(Image)



- **Double coolant holes**

Provide coolant toward the cutting edge surface of the insert

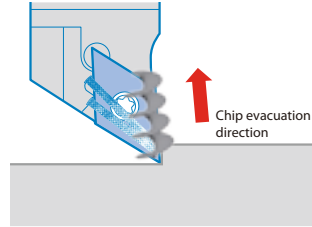
- **Line-up**

SCLC-JCTM / SDJC-JCTM
SVJB-JCTM / SVJP-JCTM

Coolant supply structure comparison (Internal evaluation)

Screw clamp - JCTM

Discharges coolant toward the rake surface of insert



Chip control performance

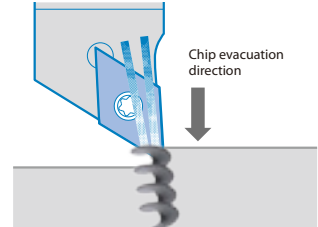
✓ Provides stable chip curls

Cooling effect

✓ The cutting edge stays cool

Competitor A

Discharges coolant down onto the chip forcing the chip into the part



Chip control performance

Chip becomes unstable

Cooling effect

Chip can cause interference with the workpiece

External grooving KGBF - JCTM

➔ P9



- **Provides coolant toward the rake surface of insert**

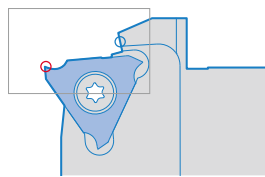
- **Specification**

Edge width: 0.25 - 3 mm
Ground chipbreaker / 3D GL Chipbreaker
Maximum groove depth: 3 mm

Coolant discharging comparison (Internal evaluation)

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

- Cutting edge
- Coolant hole



4

Kyocera's High-performance insert grade

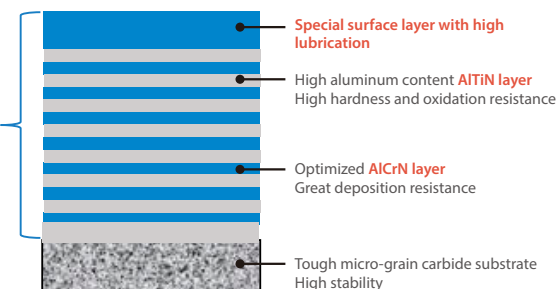
PR1725 1st recommendation for steel machining. Excellent surface finish and long tool life

MEGACOAT NANO® PLUS

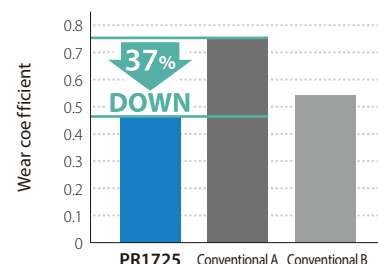
AlTiN/AlCrN Nano laminated film with superior wear resistance and adhesion resistance

Reduces cracking

Reduces abnormal damages such as chipping because of increased lamination layer with a thinner gap than conventional coatings.

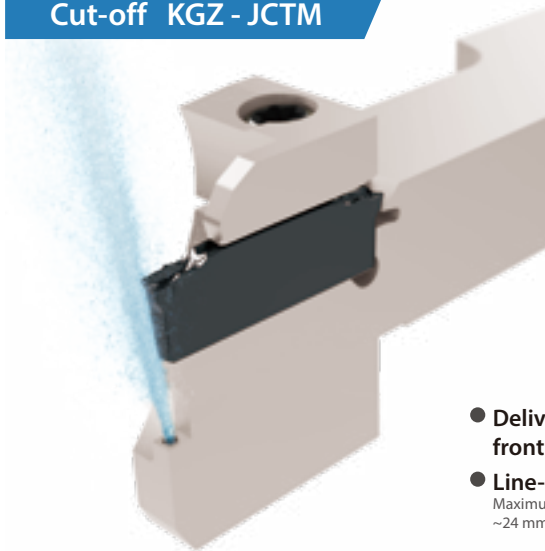


Wear coefficient comparison (Internal evaluation)



Cut-off KGZ - JCTM

➔ P11



- Delivers coolant directly to front flank face
- Line-up
Maximum cutting diameters:
~24 mm, ~26 mm, ~32 mm

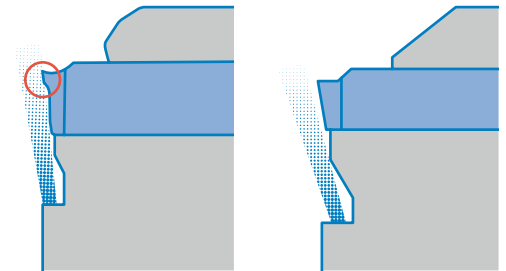
Coolant discharge comparison (Image)

KGZ-JCTM

Cooling the cutting edge leads to longer tool life.

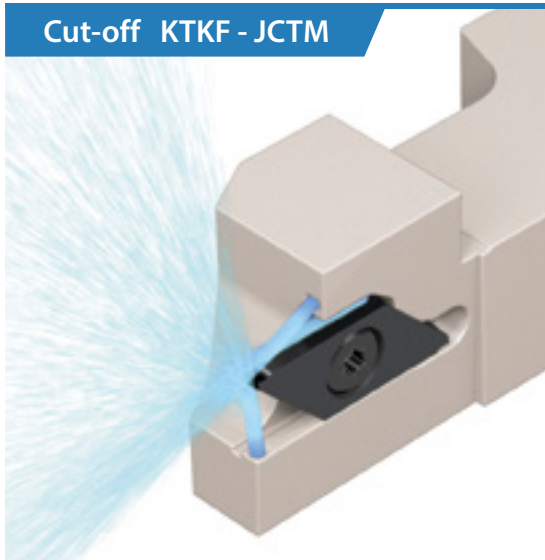
Competitor C

Coolant does not flow directly toward the cutting edge



Cut-off KTKF - JCTM

➔ P13



- Discharges coolant in three directions toward rake surface of insert*

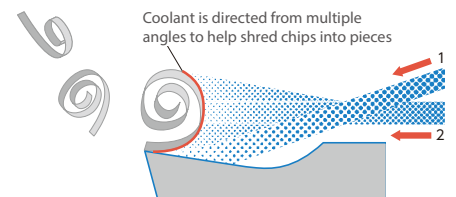
(Two holes toward the rake face and one hole toward the flank face of the insert)

- Line-up

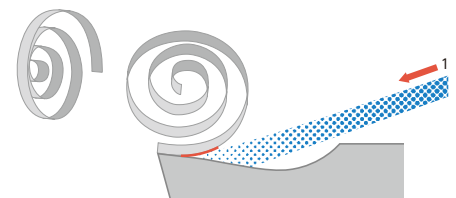
TKF 12 Type
(Maximum cutting diameter Ø5 – 12 mm)
TKF 16 Type
(Maximum cutting diameter Ø16 mm)

*1012 toolholder: Two directions

Coolant discharge structure comparison (Image)



KTKF-JCTM



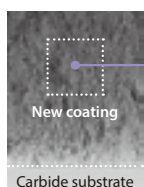
Competitor D

PR20 Series NEW Achieve long tool life with the combination of high content aluminium nano coating layer

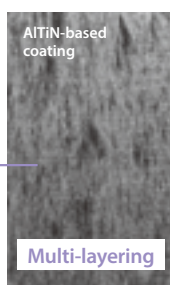


Multi-layering of high content aluminium nano layers.
Excellent wear resistance, high-temperature hardness and plastic deformation resistance.

Insert cross-section



AlTiN-based coating



Multi-layering

Long tool life

High melting point material having different concentration.
Excellent oxidation resistance.

Stable machining

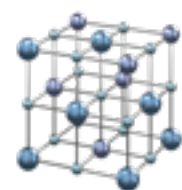
Crystal grain refinement.
High coating toughness
Suppresses crack growth.

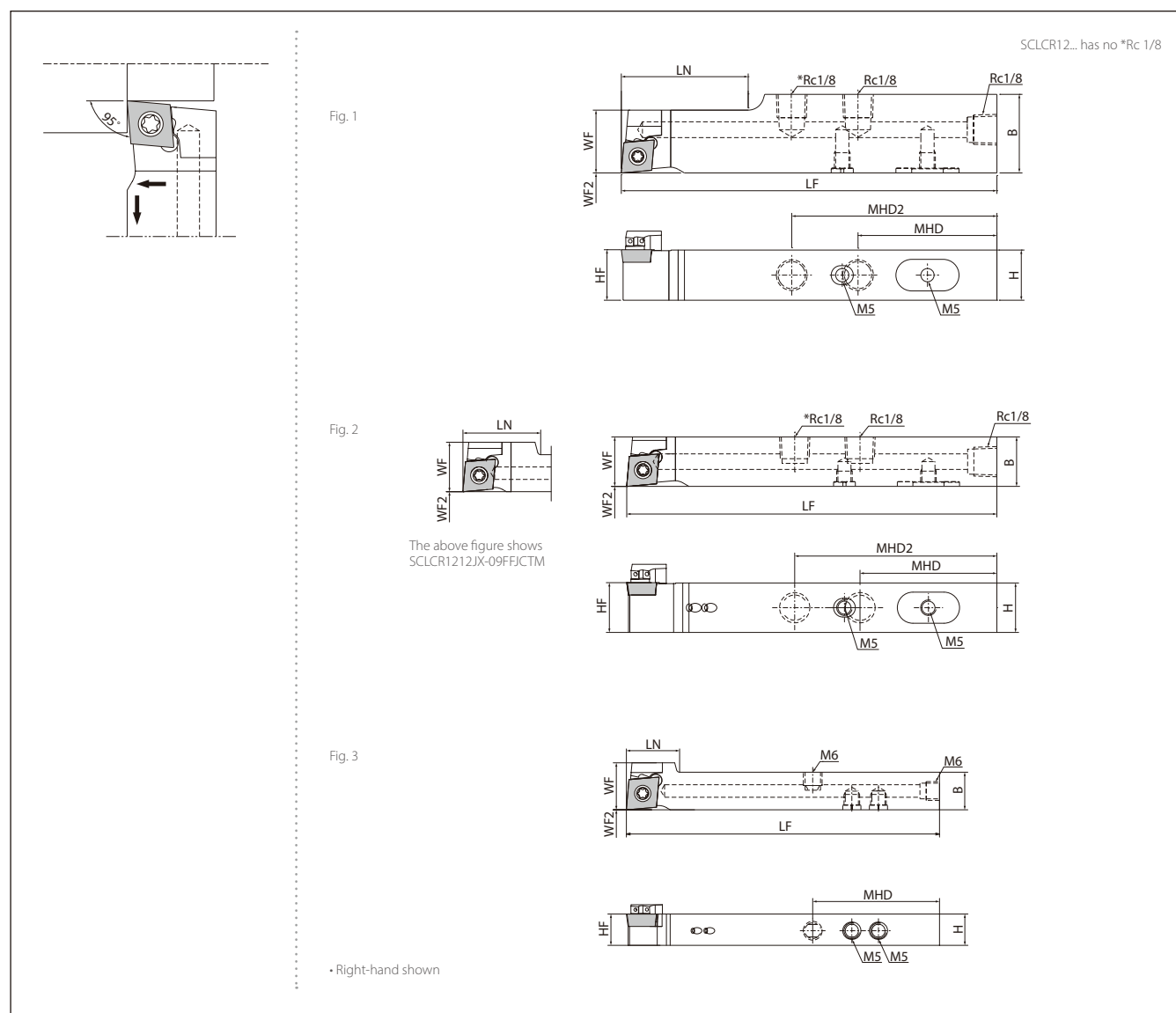
Unique technology (Patent applied)

Proprietary coating process improves high content aluminium nano layers performance

Maintains a cubic crystal structure to maximize the properties of aluminium (Al)

CG Image



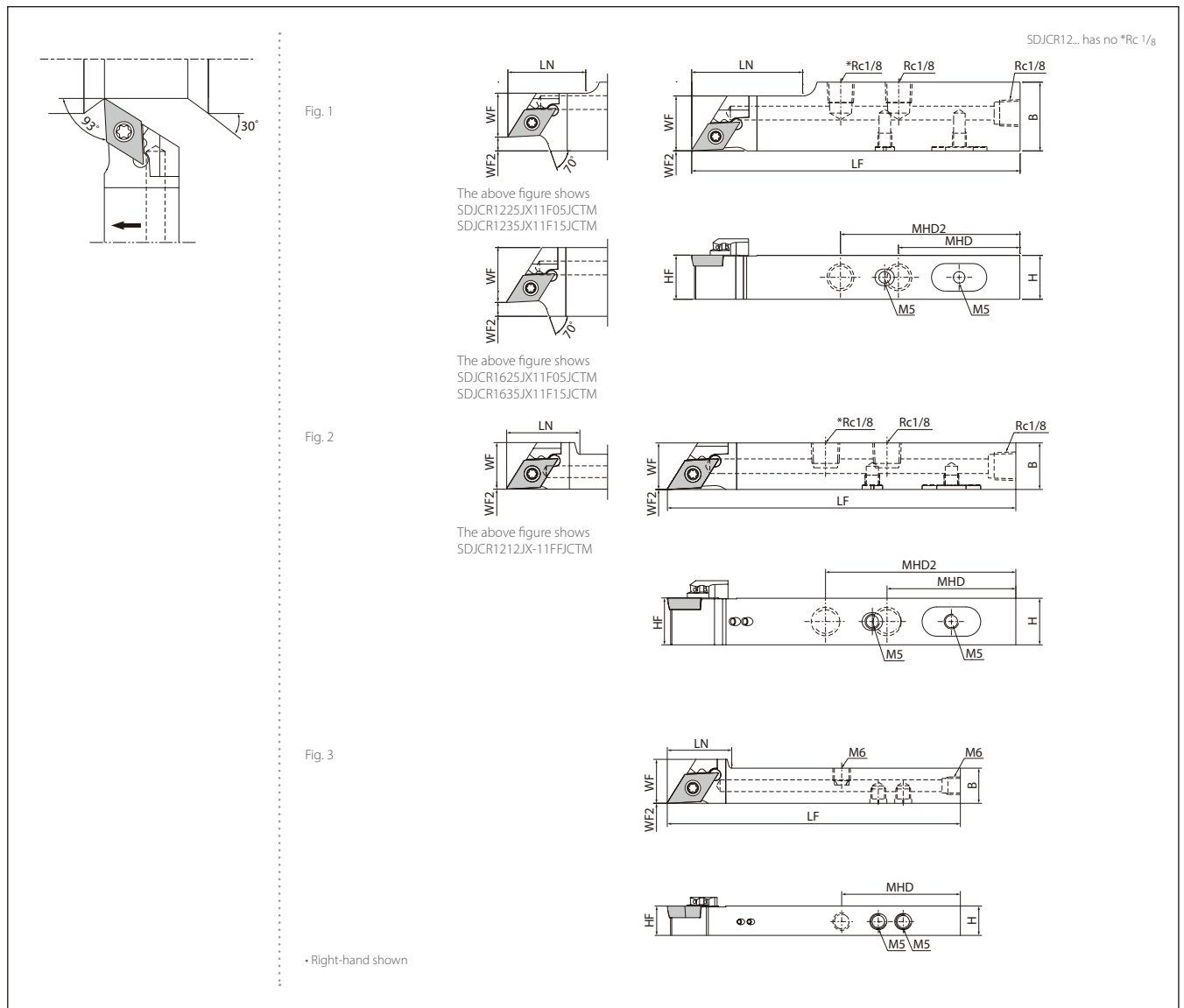


Toolholder dimensions

Description		Availability	Dimensions (mm)									Reference Corner-R (RE)	Shape	Parts			
														Clamp screw	Wrench	Plug 1	Plug 2
			R	H	HF	B	LF	LN	WF	WF2	MHD			MHD2			
SCLCR	1012H-09FFJCTM	●	10	10	12	100	17	15	0	40	-	0.2	Fig. 3	SB-408STR	FT-15	HS6X6LP	HSSX4LP
	1218JX-09FFJCTM	●	12	12	18	120	28	16	0	54	-	0.2	Fig. 1	SB-408STR		GP-1	
	1625JX-09FFJCTM	●	16	16	25		40	20		44	65						
	2025JX-09FFJCTM	●	20	20			-										
SCLCR	1212JX-09FFJCTM	●	12	12	12	120	25	16	0	59	-	0.2	Fig. 2	SB-408STR	FT-15	GP-1	HSSX4LP
	1616JX-09FFJCTM	●	16	16	16		-			44	65						
	2020JX-09FFJCTM	●	20	20	20		20	-									

*For coolant holder piping parts, see pages 17 and 18.

●: Available

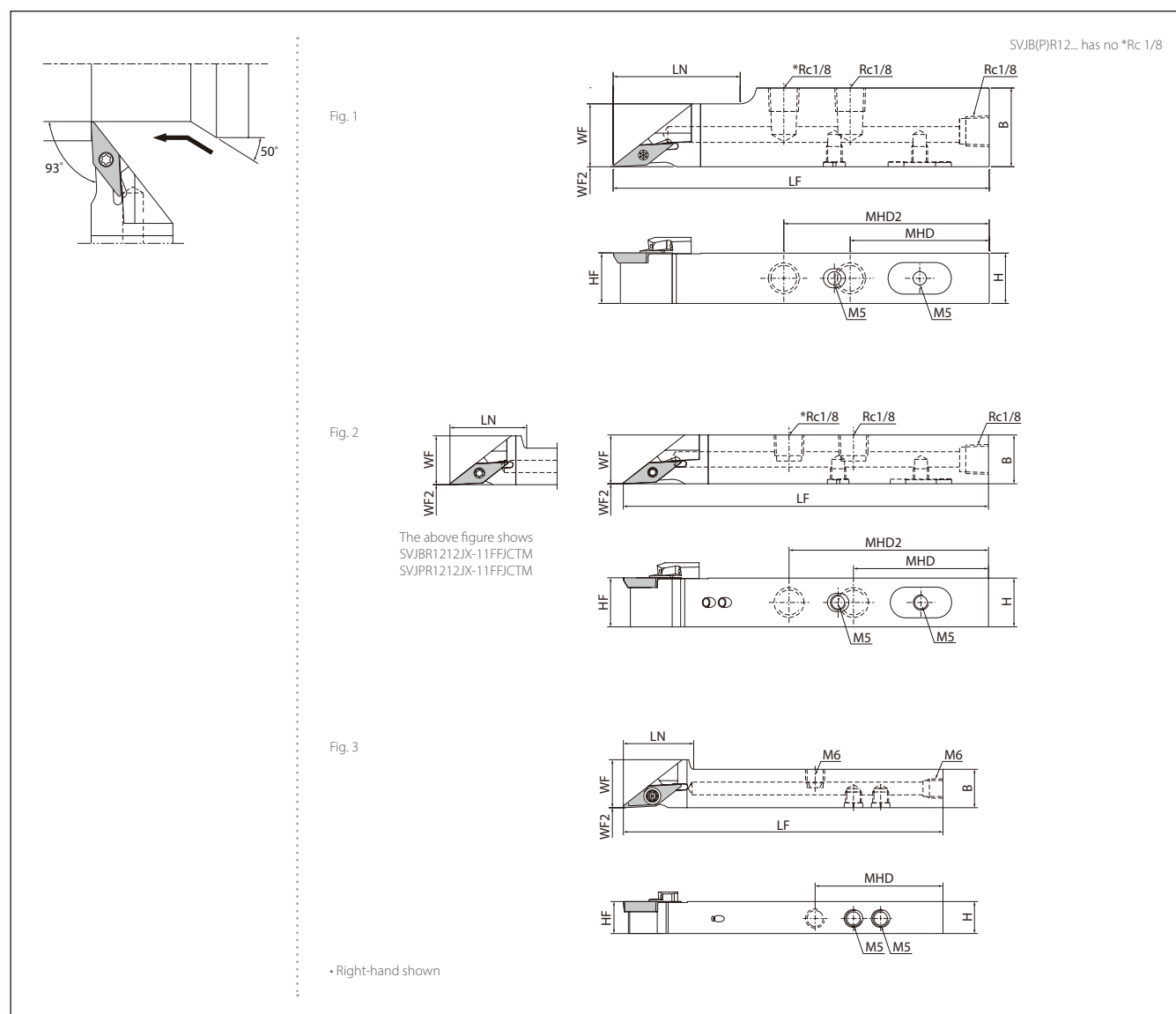


Toolholder dimensions

Description	Availability	Dimensions (mm)										Reference Corner-R (RE)	Shape	Parts			
		R	H	HF	B	LF	LN	WF	WF2	MHD	MHD2			Clamp screw	Wrench	Plug 1	Plug 2
																	
SDJCR 1012H-11FFJCTM	●	10	10	12	100	22	15	0	40	-	2.2	Fig. 3	SB-4085TR	FT-15	HS6X6LP	HSSX4LP	
1218JX-11FFJCTM	●	12	12	18	120	28	16	0	54	-	0.2						
1625JX-11FFJCTM	●	16	16	25		40	20		44	65							
2025JX-11FFJCTM	●	20	20														
SDJCR 1225JX11F05JCTM	●	12	12	25	120	28	16	5	54	-	0.2	Fig. 1	SB-4085TR	FT-15	GP-1	HSSX4LP	
1235JX11F15JCTM	●			35				15									
SDJCR 1625JX11F05JCTM	●	16	16	25	120	-	20	5	44	65	0.2						
1635JX11F15JCTM	●			35				15									
SDJCR 1212JX-11FFJCTM	●	12	12	12	120	25	16	0	59	-	0.2	Fig. 2	SB-4085TR	FT-15	GP-1	HSSX4LP	
1616JX-11FFJCTM	●	16	16	16													-
2020JX-11FFJCTM	●	20	20	20													

*For coolant holder piping parts, see pages 17 and 18.

●: Available



Toolholder dimensions

Description		Availability	Dimensions (mm)									Reference Corner-R (RE)	Shape	Parts				
			R	H	HF	B	LF	LN	WF	WF2	MHD			MHD2				
SVJBR	1012H-11FFJCTM	●	10	10	12	100	22	15	0	40	-	0.4	Fig. 3	SB-2570TR	FT-8	HS6X6LP	HSSX4LP	
	1218JX-11FFJCTM	●	12	12	18	120	28	16	0	54	-	0.4				Fig. 1		GP-1
	1625JX-11FFJCTM	●	16	16	25		40	20		44	65							
	2025JX-11FFJCTM	●	20	20														
SVJPR	1012H-11FFJCTM	●	10	10	12	100	22	15	0	40	-	0.2	Fig. 3	SB-2570TR	FT-8	HS6X6LP	HSSX4LP	
	1218JX-11FFJCTM	●	12	12	18	120	28	16	0	54	-	0.2				Fig. 1		GP-1
	1625JX-11FFJCTM	●	16	16	25		40	20		44	65							
	2025JX-11FFJCTM	●	20	20														
SVJBR	1212JX-11FFJCTM	●	12	12	12	120	25	16	0	59	-	0.4	Fig. 2	SB-2570TR	FT-8	GP-1	HSSX4LP	
	1616JX-11FFJCTM	●	16	16	16		-			44	65							
	2020JX-11FFJCTM	●	20	20	20		20											
SVJPR	1212JX-11FFJCTM	●	12	12	12	120	25	16	0	59	-	0.2		Fig. 2	SB-2570TR	FT-8	GP-1	HSSX4LP
	1616JX-11FFJCTM	●	16	16	16		-			44	65							
	2020JX-11FFJCTM	●	20	20	20		20											

*For coolant holder piping parts, see pages 17 and 18.

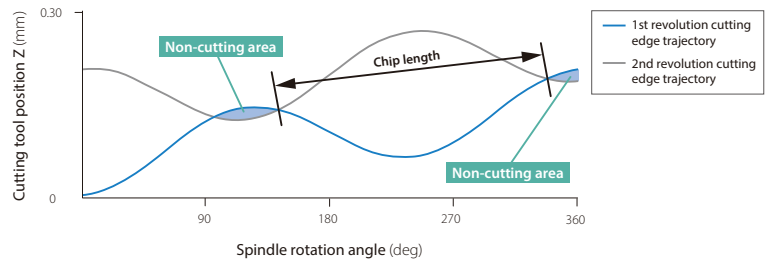
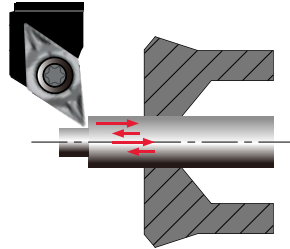
●: Available

Featured Inserts for vibration machining

What is vibration machining?

The unique vibration machining method generates intentional micro vibrations of a tool or workpiece in a cutting direction to finely cut chips. This creates a stable and intermittent discharge of chips to prevent entanglement issues with the workpiece and is compatible with a variety of workpiece materials.

Example of vibration machining



Solution

Inserts for high precision, high quality, and high productivity

Combination of a high toughness substrate and special coating to withstand high machining load

PVD Coating MEGACOAT NANO
PR1535

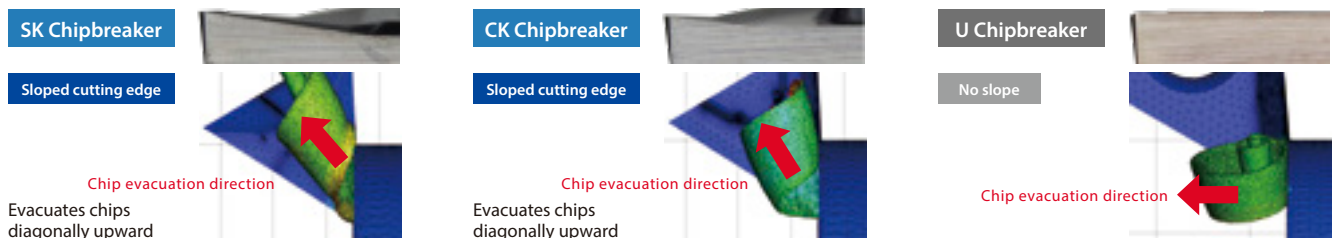
+

Low cutting resistance enables longer tool life and stable machining.

Controls chips with a slanted cutting edge

Molded Sharp Edge Chipbreaker
SKChipbreaker / CKChipbreaker

Chip evacuation examples (Internal evaluation)



Machining condition comparison in vibration machining (Internal evaluation)

SK chipbreaker shows good chip condition, reduced burrs, and excellent surface finish.

In vibration machining, the combination of PR1535 and SK or CK chipbreakers provides excellent performance.

	SK Chipbreaker	Competitor Q (Sloped cutting edge)	Competitor R (No slope)
Chips	✓	✗	✗
Surface finish	✓	✓	✗
Burr	✓	✗	✓

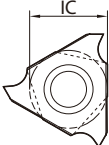
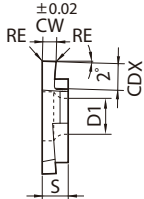
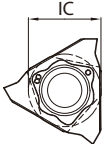
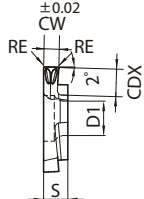
Cutting conditions : Vc = 60 m/min, f = 0.05 mm/rev, ap = 2.0 mm, SUS304.

●: Available

-

KGBF-JCTM applicable inserts

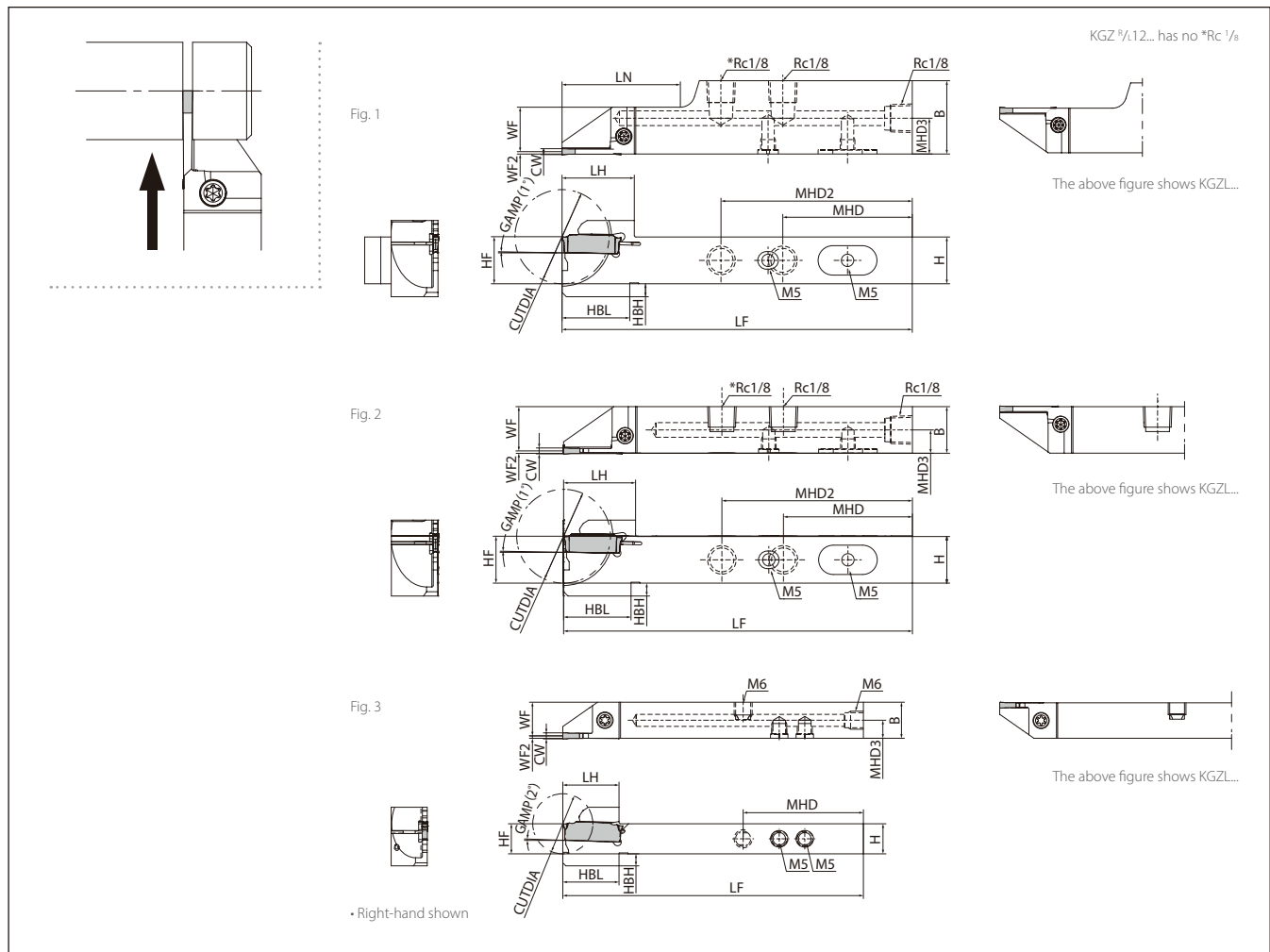
Applicable inserts

Shape	Description	Dimensions (mm)			MEGACOAT	MEGACOAT NANO	Carbide	
		CW	CDX	RE	PR1215	PR1535	GW15	
 	GBF32R	025-000F	0.25	0.00	●	●	●	
		025-005		0.05	●	●	●	
		030-000F	0.30	0.00	●	●	●	
		030-005		0.05	●	●	●	
		033-000F *1	0.33	0.00	●	●	●	
		033-005 *1		0.05	●	●	●	
		043-000F *2	0.43	0.00	●	●	●	
		043-005 *2		0.05	●	●	●	
		050-000F	0.50	0.00	●	●	●	
		050-005		0.05	●	●	●	
		053-000F *3	0.53	0.00	●	●	●	
		053-005 *3		0.05	●	●	●	
		065-000F	0.65	0.00	●	●	●	
		065-005		0.05	●	●	●	
		075-000F	0.75	0.00	●	●	●	
		075-005		0.05	●	●	●	
		075-010		0.1	●	●	●	
		080-000F	0.80	0.00	●	●	●	
		080-005		0.05	●	●	●	
		080-010		0.1	●	●	●	
		095-000F	0.95	0.00	●	●	●	
		095-005		0.05	●	●	●	
		095-010		0.1	●	●	●	
		100-000F	1.00	0.00	●	●	●	
		100-005		0.05	●	●	●	
		100-010		0.1	●	●	●	
		110-000F	1.10	0.00	●	●	●	
		110-005		0.05	●	●	●	
		110-010		0.1	●	●	●	
		120-000F	1.20	0.00	●	●	●	
		120-005		0.05	●	●	●	
		120-010		0.1	●	●	●	
		125-000F	1.25	0.00	●	●	●	
		125-005		0.05	●	●	●	
		125-010		0.1	●	●	●	
		130-000F	1.30	0.00	●	●	●	
		130-005		0.05	●	●	●	
		130-010		0.1	●	●	●	
		140-000F	1.40	0.00	●	●	●	
		140-005		0.05	●	●	●	
		140-010		0.1	●	●	●	
		145-000F	1.45	0.00	●	●	●	
		145-005		0.05	●	●	●	
		145-010		0.1	●	●	●	
		150-000F	1.50	0.00	●	●	●	
		150-005		0.05	●	●	●	
		150-010		0.1	●	●	●	
		165-000F	1.65	0.00	●	●	●	
		165-005		0.05	●	●	●	
		165-010		0.1	●	●	●	
		170-000F	1.70	0.00	●	●	●	
		170-005		0.05	●	●	●	
		170-010		0.1	●	●	●	
		175-000F	1.75	0.00	●	●	●	
		175-005		0.05	●	●	●	
		175-010		0.1	●	●	●	
		200-000F	2.00	0.00	●	●	●	
		200-005		0.05	●	●	●	
		200-010		0.1	●	●	●	
		225-005	2.25	0.05	●	●	●	
		225-010		0.1	●	●	●	
		250-005	2.50	0.05	●	●	●	
		250-010		0.1	●	●	●	
		300-005	3.00	0.05	●	●	●	
		300-010		0.1	●	●	●	
 	GBF32R	075-005GL	0.75	2.0	0.05	●	●	
		095-005GL	0.95	2.0	0.05	●	●	
		100-005GL	1.00	2.0	0.05	●	●	
		150-010GL	1.50	2.7	0.10	●	●	
		200-010GL	2.00	3.0	0.10	●	●	
		300-010GL	3.00	3.0	0.10	●	●	

Maximum cutting diameter in a groove depth of 3 mm is Ø51 mm (Please check the precautions on page 9).

*1. GBF32R 033-000F / 005 Edge width tolerance : 0.33 ^{+0.015}/_{-0.025} *2. GBF32R 043-000F / 005 Edge width tolerance : 0.43 ^{+0.015}/_{-0.025} *3. GBF32R 053-000F / 005 Edge width tolerance : 0.53 ^{+0.015}/_{-0.025}

•: Available



Description	Availability		Dimensions (mm)														Edge Width CW (mm)		Shape	Parts				Applicable inserts
	R	L	CUTDIA	H	B	LH	MHD	MHD2	MHD3	HF	HBH	HBL	LF	LN	WF	WF2*	MIN.	MAX.		Plug 1	Plug 2	Clamp screw	Wrench	
KGZR 1012H-2JCTM	●		20	10	12	18.8	40	-	6	10	4	18.7	100	-	11.2	0.8	2	3	Fig. 3	HS6X6LP	HS5X4LP	SB-40120 TR	LTW-155	GZ...2020... GZ...2220... GZ...2420... GZ...2520... GZ...3020...
KGZL 1012H-2JCTM		●														-								
KGZR 1218JX-2JCTM	●		24	12	18	19.8	54	-	8.4	12	8.5	19.8	120	43.7	11.2	0.8	2	3	Fig. 1	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	
KGZL 1218JX-2JCTM		●							7.7															
KGZR 1625JX-2JCTM	●		32	16	25	24.8	44	65	12.2	16	4.5	23.2	120	40.0	15.2	0.8	2.4	3	Fig. 1	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	GZ...2420... GZ...2520... GZ...3020...
KGZL 1625JX-2JCTM		●							7.7															
KGZR 1218JX-2.4JCTM	●		24	12	18	19.8	54	-	8.4	12	8.5	19.8	120	43.7	11.0	1.0	2.4	3	Fig. 1	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	
KGZL 1218JX-2.4JCTM		●							7.7															
KGZR 1625JX-2.4JCTM	●		32	16	25	24.8	44	65	12.2	16	4.5	23.2	120	40.0	15.0	1.0	3	3	Fig. 1	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	GZ...3020...
KGZL 1625JX-2.4JCTM		●							7.7															
KGZR 1218JX-3JCTM	●		24	12	18	19.8	54	-	8.6	12	8.5	19.8	120	43.7	10.8	1.2	3	3	Fig. 1	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	
KGZL 1218JX-3JCTM		●							7.7															
KGZR 1625JX-3JCTM	●		32	16	25	24.8	44	65	12.2	16	4.5	23.2	120	40.0	14.8	1.2	3	3	Fig. 1	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	
KGZL 1625JX-3JCTM		●							7.7															

*L-hand toolholder has no WF2

Recommended tightening torque: 2.0N · m(SB-40120TR)

GM* and GD* inserts cannot be installed in the KGZ holder (GMM, GMG, GMN, GMR/L, GDM, GDG, GDGS, GDMS).

• Available

Description	Availability		Dimensions (mm)													Edge Width CW (mm)			Shape	Parts				Applicable inserts
	R	L	CUTDIA	H	B	LH	MHD	MHD2	MHD3	HF	HBH	HBL	LF	LN	WF	WF2*	MIN.	MAX.		Plug 1	Plug 2	Clamp screw	Wrench	
KGZ ^R /L 1212JX-2JCTM	●	●	24	12	12	19.8	59	-	6	12	5	19.8	120		11.2	0.8	2	3	Fig.2	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	GZ...2020... GZ...2220... GZ...2420... GZ...2520... GZ...3020...
KGZ ^R /L 1616JX2D26JCTM	●	●	26	16	16	24.8	44	65	8	16	1	23.2												
KGZ ^R /L 1616JX-2JCTM	●	●	32								4.5													
KGZ ^R /L 1212JX-2.4JCTM	●	●	24	12	12	19.8	59	-	6	12	5	19.8	120	-	11.0	1.0	2.4	3	Fig.2	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	GZ...2420... GZ...2520... GZ...3020...
KGZ ^R /L 1616JX2.4D26JCTM	●	●	26	16	16	24.8	44	65	8	16	1	23.2												
KGZ ^R /L 1616JX-2.4JCTM	●	●	32								4.5													
KGZ ^R /L 1212JX-3JCTM	●	●	24	12	12	19.8	59	-	6	12	5	19.8	120		10.8	1.2	3	3	Fig.2	GP-1	HS5X 4LP	SB-40120 TR	LTW-155	GZ...3020...
KGZ ^R /L 1616JX3D26JCTM	●	●	26	16	16	24.8	44	65	8	16	1	23.2												
KGZ ^R /L 1616JX-3JCTM	●	●	32								4.5													

*L-hand toolholder has no WF2

Recommended tightening torque: 2.0N · m (SB-40120TR)

GM* and GD* inserts cannot be installed in the KGZ holder (GMM, GMG, GMN, GMR/L, GDM, GDG, GDGS, GDMs).

●: Available

KGZ-JCTM applicable inserts

Shape Handed insert shows Right-hand		Description	Dimensions (mm)		MEGACOAT NANO EX			DLC coat.	Carbide		
			CW Tolerance	RE	PR2015	PR2025	PR2035	PDL025	GW15		
Low feed		GZM 1316N-003PF	1.3	+0.04 -0.04	0.03	●	●	●			
		1316N-015PF			0.15	●	●	●			
		1516N-003PF	1.5		0.03	●	●	●			
		1516N-015PF			0.15	●	●	●			
		GZM 1316R-003PF-15D	1.3		0.03	●	●	●			
		1316L-003PF-15D				●	●	●			
		1516R-003PF-15D	1.5			●	●	●			
		1516L-003PF-15D				●	●	●			
	15° Lead angle	1516R-015PF-15D		0.15		●	●	●			
			GZM 2020N-003PF	2		0.03	●	●	●		
			2020N-015PF			0.15	●	●	●		
			2520N-003PF	2.5		0.03	●	●	●		
2520N-015PF	0.15		●		●	●					
3020N-003PF	3		0.03	●	●	●					
			0.15	●	●	●					
	GZM 2020R-003PF-15D	2	0.03	●	●	●					
	2020L-003PF-15D			●	●	●					
	2020R-015PF-15D	2.5	0.03	●	●	●					
	2520R-003PF-15D			●	●	●					
	2520R-015PF-15D	3	0.03	●	●	●					
	3020R-003PF-15D			●	●	●					
	3020L-003PF-15D	0.15	●	●	●						
	3020R-015PF-15D		●	●	●						

Shape Handed insert shows Right-hand		Description	Dimensions (mm)		MEGACOAT NANO EX			DLC coat.	Carbide	
			CW Tolerance	RE	PR2015	PR2025	PR2035	PDL025	GW15	
Medium feed 6° Lead angle		GZM 2020N-020PM	2	+0.03 -0.03	0.2	●	●	●		
		2520N-020PM	2.5			●	●	●		
		3020N-025PM	3		●	●	●			
		GZM 2020R-020PM-6D	2		0.2	●	●	●		
		2520R-020PM-6D	2.5			●	●	●		
		3020R-025PM-6D	3		●	●	●			
High feed (cut-off / Grooving) 1-edge		GZM 2020N-020PH	2	+0.03 -0.03	0.2	●	●	●		
		2520N-020PH	2.5			●	●	●		
		3020N-030PH	3		●	●	●			
		GZMS 2020N-020PH	2		0.2	●	●	●		
		3020N-030PH	3			●	●	●		
						0.3	●	●	●	
Low cutting force 15° Lead angle		GZG 2020N-005PG	2	+0.02 -0.02	0.05		●	●	●	●
		2520N-005PG	2.5				●	●	●	●
		3020N-005PG	3				●	●	●	●
		GZG 2020R-005PG-15D	2				●	●	●	●
		2520R-005PG-15D	2.5				●	●	●	●
		3020R-005PG-15D	3				●	●	●	●

Please see KGZ brochure for grooving inserts.

Using PF or PM chipbreaker for grooving will not create a flat bottom.
GZM and GZG inserts cannot be installed in KGM and KGD holders.

●: Available

Right hand (R)

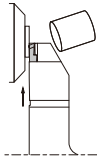
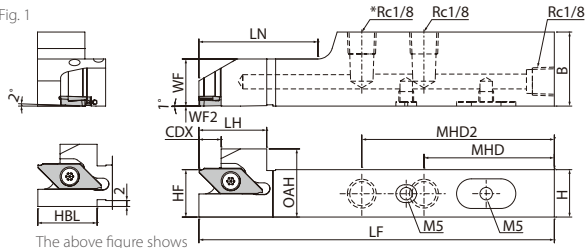
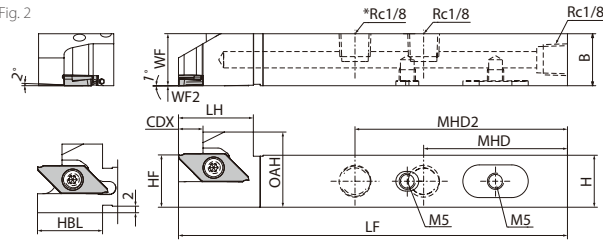


Fig. 1



The above figure shows KTKFR1218JX...

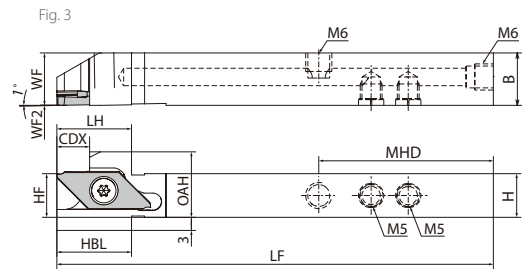
Fig. 2



The above figure shows KTKFR1212JX...

• Right-hand shown

Fig. 3



KTKFR12... has no *Rc 1/8

Right hand (R) insert applicable on right hand (R) holder

Left hand (L)

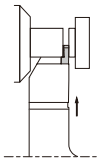


Fig. 1

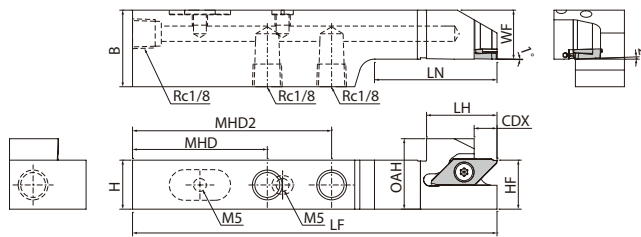
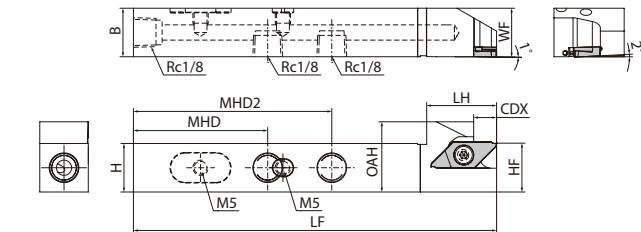


Fig. 2



• Left-hand (L) shown

L-hand insert (L) for L-hand (L) toolholder

Toolholder dimensions

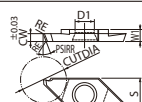
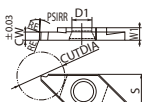
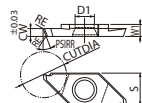
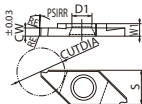
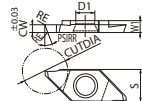
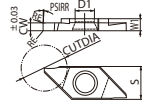
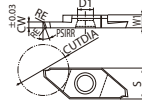
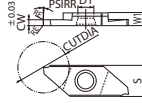
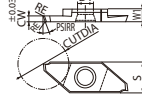
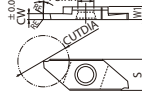
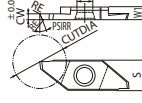
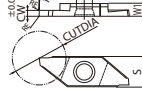
Description		Availability		Dimensions (mm)														Shape	Parts				Applicable inserts																			
		R	L	H	HF	OAH	B	LF	HBL	LH	LN	WF	WF2*	CDX	MHD	MHD2	Clamp screw		Wrench	Plug 1	Plug 2																					
																																										
KTKFR	1012H-12-JCTM	●		10	10	15	12	100	17.1	17.1	-	12	0	7.5	40	-	Fig.3			HS6X6LP	HSSX4LP	TKF12R...																				
KTKFR	1218JX-12JCTM	●		12	12	19	18	120	20	20	28	12	0	7.5	54	-	Fig.1			GP-1	HSSX4LP	TKF12R...																				
KTKF ⁹ / _L	1625JX-12JCTM	●	●	16	16	23	25														-	23	40	16	0	7.5	44	65	Fig.1	GP-1	-	TKF12 ⁹ / _L ...										
KTKF ⁹ / _L	2025JX-12JCTM	●	●	20	20	27																									25	40	16	0	9.6	44	65	Fig.2	GP-1	HSSX4LP	TKF16 ⁹ / _L ...	
KTKF ⁹ / _L	1625JX-16JCTM	●	●	16	16	23												25	41																					20	0	9.6
KTKF ⁹ / _L	2025JX-16JCTM	●	●	20	20	27	120	20	20	-	12	0	7.5	44	65	Fig.2	GP-1			HSSX4LP											TKF12R...											
KTKFR	1212JX-12JCTM	●		12	12	19														12	120	-	23	-	16	0	7.5	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	1616JX-12JCTM	●	●	16	16	23												16		120												-	23	-	16	0	7.5	44	65			
KTKF ⁹ / _L	2020JX-12JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	1616JX-16JCTM	●	●	16	16	23	16	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-	16	0	9.6	44	65			
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20											120	-																					23	-	16
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20	120	-	23	-	16	0	9.6	44	65	Fig.2																									
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20														120	-	23	-	16	0	9.6	44	65	Fig.2	GP-1											
KTKF ⁹ / _L	2020JX-16JCTM	●	●	20	20	27	20													120												-	23	-								

*L-hand toolholder has no WF2
*For coolant holder piping parts, see pages 17 and 18.

● Available

KTKF-JCTM applicable inserts

Applicable inserts (TKF12/TKF16)

Applicable inserts (TKF12/TKF16)		Usage Classification		P	Carbon steel / Alloy steel	☐	☐	☐											
		☐ : Continuous-Light Interruption / 1 st choice ☐ : Continuous-Light Interruption / 2 nd choice ● : Continuous / 1 st choice ○ : Continuous / 2 nd choice		M	Stainless steel	☐	●	☐											
				K	Cast iron					●									
				N	Non-ferrous metal					●	☐								
Shape Handed insert shows right-hand		Description	Dimensions (mm)					Angle	MEGACOAT NANO PLUS	MEGACOAT NANO	MEGACOAT	DLC coating	Carbide						
			CW	CUTDIA	RE	W1	S	D1	PSIRR/L	PR1725	PR1535	PR1225	PDL025	KW10					
 With right lead angle		TKF12 [®] /L 050-S-16DR	0.5	5	0.03	3	8.7	5	16°	●	●	●	●			●	●		
		070-S-16DR	0.7	8								●	●			●	●		
		100-S-16DR	1.0								●	●	●	●	●	●	●		
		125-S-16DR	1.25								●	●	●	●	●	●	●		
		150-S-16DR	1.5								●	●	●	●	●	●	●		
200-S-16DR	2.0			●	●	●	●	●	●	●	●	●							
 Tough edge		TKF12 [®] /L 050-S	0.5	5	0.03	3	8.7	5	0°	●	●	●	●	●	●	●	●		
		070-S	0.7	8								●	●	●	●	●	●		
		100-S	1.0								●	●	●	●	●	●	●		
		125-S	1.25								●	●	●	●	●	●	●		
		150-S	1.5								●	●	●	●	●	●	●		
200-S	2.0			●	●	●	●	●	●	●	●								
 With right lead angle/ Tough edge		TKF12 [®] /L 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 [®] /L 100-T	1.0	12	0.08	3	8.7	5	0°	●	●	●	●	●					
		150-T	1.5									●	●	●	●	●			
		200-T	2.0									●	●	●	●	●			
 With right lead angle/ Without chipbreaker		TKF12 [®] /L 050-NB-20DR	0.5	5	0	3	8.7	5	20°	●	●	●	●			●	●		
		070-NB-20DR	0.7	8								●	●			●	●		
		100-NB-20DR	1.0								●	●	●	●			●	●	
		150-NB-20DR	1.5								●	●	●	●			●	●	
		200-NB-20DR	2.0								●	●	●	●			●	●	
 Without chipbreaker		TKF12 [®] /L 050-NB	0.5	5	0	3	8.7	5	0°	●	●	●	●			●	●		
		070-NB	0.7	8								●	●			●	●		
		100-NB	1.0								●	●	●	●			●	●	
		150-NB	1.5								●	●	●	●			●	●	
		200-NB	2.0								●	●	●	●			●	●	
 With right lead angle		TKF16 [®] /L 150-S-16DR	1.5	16	0.05	4	9.5	5	16°	●	●	●	●	●	●	●	●		
		200-S-16DR	2.0									●	●	●	●	●	●	●	
 Without chipbreaker		TKF16 [®] /L 150-S	1.5	16	0.05	4	9.5	5	0°	●	●	●	●	●	●	●	●		
		200-S	2.0									●	●	●	●	●	●	●	
 With right lead angle/ Tough edge		TKF16 [®] /L 150-T-16DR	1.5	16	0.08	4	9.5	5	16°	●	●	●	●	●					
		200-T-16DR	2.0									●	●	●	●				
 Tough edge		TKF16 [®] /L 150-T	1.5	16	0.08	4	9.5	5	0°	●	●	●	●	●					
		200-T	2.0									●	●	●	●	●			
 With right lead angle/ Without chipbreaker		TKF16 [®] /L 150-NB-20DR	1.5	16	0	4	9.5	5	20°	●	●	●	●			●	●		
		200-NB-20DR	2.0									●	●	●	●			●	●
 Without chinbreaker		TKF16 [®] /L 150-NB	1.5	16	0	4	9.5	5	0°	●	●	●	●			●	●		
		200-NB	2.0									●	●	●	●			●	●

Recommended cutting conditions ★ 1st recommendation ☆ 2nd recommendation

GBF

Workpiece	Cutting speed Vc (m/min)			1. Feed during Grooving Machining (mm/rev) 2. Feed during Traversing (mm/rev) 3. D.O.C. during Traversing (mm)			
	MEGACOAT	MEGACOAT NANO	Carbide				
	PR1215	PR1535	GW15	GBF32R 025 - 053 (- 000F)	GBF32R 065 - 095 (- 000F)	GBF32R 100 - 145 (- 000F)	GBF32R 150 - 300 (- 200-000F)
Carbon steel	★ 80 - 180	☆ 70 - 160	-	1. 0.01 - 0.05 (0.005 - 0.03) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.02 - 0.07 (0.01 - 0.04) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.08 (0.01 - 0.05) 2. 0.03 - 0.06 (0.01 - 0.04) 3. MAX. 0.2	1. 0.03 - 0.08 (0.01 - 0.05) 2. 0.03 - 0.06 (0.01 - 0.04) 3. MAX. 0.2
Alloy steel	★ 80 - 180	☆ 70 - 160	-	1. 0.01 - 0.04 (0.005 - 0.025) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.02 - 0.06 (0.01 - 0.03) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.07 (0.01 - 0.04) 2. 0.02 - 0.05 (0.01 - 0.03) 3. MAX. 0.2	1. 0.03 - 0.07 (0.01 - 0.04) 2. 0.02 - 0.05 (0.01 - 0.03) 3. MAX. 0.2
Stainless steel	☆ 60 - 130	★ 50 - 120	-	1. 0.01 - 0.04 (0.005 - 0.02) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.02 - 0.06 (0.01 - 0.025) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.07 (0.01 - 0.03) 2. 0.02 - 0.05 (0.01 - 0.025) 3. MAX. 0.2	1. 0.03 - 0.07 (0.01 - 0.03) 2. 0.02 - 0.05 (0.01 - 0.025) 3. MAX. 0.2
Cast iron	-	-	★ 60 - 100	1. 0.01 - 0.05 (0.005 - 0.03) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.02 - 0.07 (0.01 - 0.04) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.08 (0.01 - 0.05) 2. 0.03 - 0.06 (0.01 - 0.04) 3. MAX. 0.2	1. 0.03 - 0.08 (0.01 - 0.05) 2. 0.03 - 0.06 (0.01 - 0.04) 3. MAX. 0.2
Aluminium alloy	-	-	★ 150 - 400	1. 0.01 - 0.05 (0.005 - 0.03) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.02 - 0.07 (0.01 - 0.04) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.08 (0.01 - 0.05) 2. 0.03 - 0.06 (0.01 - 0.04) 3. MAX. 0.2	1. 0.03 - 0.08 (0.01 - 0.05) 2. 0.03 - 0.06 (0.01 - 0.04) 3. MAX. 0.2
Brass	-	-	★ 150 - 300	1. 0.01 - 0.04 (0.01 - 0.03) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.02 - 0.06 (0.01 - 0.04) 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.07 (0.01 - 0.05) 2. 0.02 - 0.05 (0.01 - 0.04) 3. MAX. 0.2	1. 0.03 - 0.07 (0.01 - 0.05) 2. 0.02 - 0.05 (0.01 - 0.04) 3. MAX. 0.2

GBF-GL

Workpiece	Cutting speed Vc (m/min)		1. Feed during grooving machining (mm/rev) 2. Feed during traversing (mm/rev) 3. D.O.C. during traversing (mm)			
	MEGACOAT	MEGACOAT NANO				
	PR1215	PR1535	GBF32R 075 - 005GL	GBF32R 095 - 100-005GL	GBF32R 150 - 200-010GL	GBF32R 300 - 010GL
Carbon steel	★ 80 - 180	☆ 70 - 160	1. 0.02 - 0.07 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.08 2. 0.03 - 0.06 3. MAX. 0.2	1. 0.03 - 0.08 2. 0.03 - 0.06 3. MAX. 0.3	1. 0.04 - 0.1 2. 0.04 - 0.08 3. MAX. 0.5
Alloy steel	★ 80 - 180	☆ 70 - 160	1. 0.02 - 0.06 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.07 2. 0.03 - 0.06 3. MAX. 0.2	1. 0.03 - 0.07 2. 0.03 - 0.06 3. MAX. 0.3	1. 0.04 - 0.09 2. 0.04 - 0.08 3. MAX. 0.5
Stainless steel	☆ 60 - 130	★ 50 - 120	1. 0.02 - 0.06 2. Traversing is NOT recommended 3. Traversing is NOT recommended	1. 0.03 - 0.07 2. 0.03 - 0.06 3. MAX. 0.2	1. 0.03 - 0.07 2. 0.03 - 0.06 3. MAX. 0.3	1. 0.04 - 0.09 2. 0.04 - 0.08 3. MAX. 0.5

KGZ (Cut-off)

Workpiece	Cutting speed Vc (m/min)					f (mm/rev)										Remarks
	MEGACOAT NANO EX			DLC	Carbide	PF (RE = 0.03)			PF (RE = 0.15)			PM	PH	PG		
						Edge width CW (mm)										
	PR2015	PR2025	PR2035	PDL025	GW15	1.3/1.5	2.0	2.5/3.0	1.3/1.5	2.0	2.5/3.0	2.0 - 3.0	2.0 - 3.0	2.0	2.5/3.0	
Carbon steel	☆ 70 - 180	★ 70 - 150	☆ 70 - 150	-	-	0.01 - 0.04	0.02 - 0.06	0.02 - 0.08	0.01 - 0.05	0.03 - 0.08	0.04 - 0.10	0.05 - 0.15	0.10 - 0.20	0.01 - 0.04	0.01 - 0.05	Wet
Alloy steel	☆ 70 - 180	★ 70 - 150	☆ 70 - 150	-	-											
Stainless steel	☆ 60 - 150	☆ 60 - 120	★ 60 - 120	-	-	0.01 - 0.03	0.01 - 0.04	0.01 - 0.05	0.01 - 0.04	0.03 - 0.07	0.04 - 0.08	0.04 - 0.12	0.08 - 0.16	0.01 - 0.03	0.01 - 0.04	
Cast iron	★ 80 - 200	-	-	-	☆ 50 - 100	0.01 - 0.05	0.02 - 0.07	0.03 - 0.08	0.01 - 0.06	0.03 - 0.09	0.04 - 0.10	0.05 - 0.15	0.10 - 0.20	0.01 - 0.04	0.01 - 0.05	
Aluminium alloy	-	-	-	★ 200 - 500	☆ 200 - 450	-	-	-	-	-	-	-	-	0.01 - 0.05	0.01 - 0.06	
Brass	-	-	-	-	★ 100 - 200	-	-	-	-	-	-	-	-	0.01 - 0.07	0.01 - 0.08	

KGZ (Grooving)

Workpiece	Cutting speed Vc (m/min)						f (mm/rev)									Remarks
	MEGACOAT NANO EX			Cermet	Carbide	PCD	GM		GL		PH	CM	GS	NB		
							Edge width CW (mm)									
	PR2015	PR2025	PR2035	TN620	GW15	KPD001	2.2/2.4	3.0	2.4	3.0	2.0-3.0	3.0	2.5/3.0	2.0	3.0	
Carbon steel	☆ 70-180	★ 70-150	☆ 70-150	★ 80-150	-	-	0.05-0.13	0.07-0.17	0.03-0.11	0.04-0.15	0.10-0.20	0.05-0.15	0.04-0.09	-	-	
Alloy steel	☆ 70-180	★ 70-150	☆ 70-150	★ 80-150	-	-										
Stainless steel	☆ 60-150	☆ 60-120	★ 60-120	-	-	-	0.03-0.12	0.05-0.15	0.02-0.10	0.03-0.12	0.08-0.16	0.04-0.12	0.03-0.08	-	-	
Cast iron	★ 80-200	-	-	-	☆ 50-100	-	0.05-0.13	0.07-0.17	0.03-0.11	0.04-0.15	0.10-0.20	0.05-0.15	0.04-0.09	-	-	
Aluminium alloy	-	-	-	-	☆ 200-450	★ 150-2,000	-	-	-	-	-	-	0.03-0.07	0.05-0.15	0.05-0.15	
Brass	-	-	-	-	☆ 100-200	★ 200-800	-	-	-	-	-	-	-			

KTKF

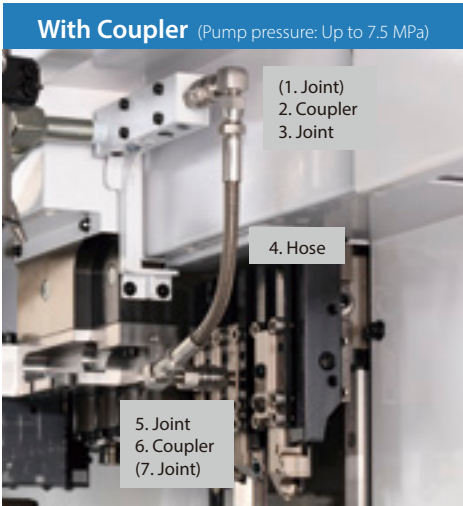
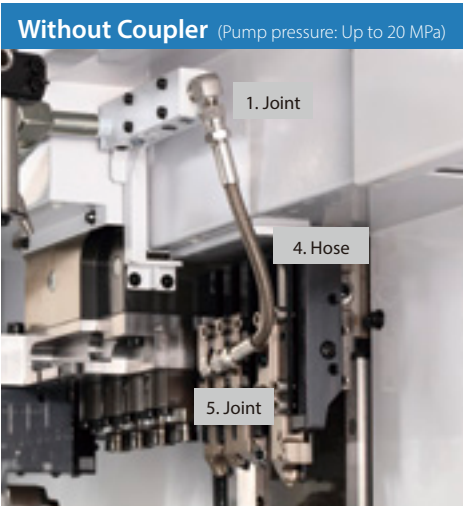
Workpiece	Cutting speed Vc (m/min)					TKF12						TKF16		Remarks
						Edge width CW (mm)						Edge width CW (mm)		
	MEGACOAT NANO PLUS	MEGACOAT NANO	MEGACOAT	DLC	Carbide	0.5	0.7	1.0	1.25	1.5	2.0	1.5	2.0	
	PR1725	PR1535	PR1225	PDL025	KW10	f (mm/rev)						f (mm/rev)		
Carbon steel	★ 70 - 170 (50 - 140)	☆ 70 - 150 (50 - 120)	☆ 70 - 150 (50 - 120)	-	-	0.01 - 0.02	0.01 - 0.03	0.01 - 0.04 (0.01 - 0.05)	0.01 - 0.04	0.01 - 0.04 (0.02 - 0.1)	0.01 - 0.04 (0.02 - 0.1)	0.02 - 0.07 (0.02 - 0.1)	0.02 - 0.07 (0.02 - 0.1)	Wet
Alloy steel	★ 70 - 170 (50 - 140)	☆ 70 - 150 (50 - 120)	☆ 70 - 150 (50 - 120)	-	-	0.01 - 0.02	0.01 - 0.03	0.01 - 0.04 (0.01 - 0.05)	0.01 - 0.04	0.01 - 0.04 (0.02 - 0.1)	0.01 - 0.04 (0.02 - 0.1)	0.02 - 0.07 (0.02 - 0.1)	0.02 - 0.07 (0.02 - 0.1)	
Stainless steel	☆ 60 - 140 (40 - 120)	★ 60 - 120 (40 - 100)	☆ 60 - 120 (40 - 100)	-	-	0.005 - 0.015	0.01 - 0.02	0.01 - 0.02 (0.01 - 0.03)	0.01 - 0.02	0.01 - 0.02 (0.01 - 0.05)	0.01 - 0.02 (0.01 - 0.05)	0.01 - 0.04 (0.01 - 0.05)	0.01 - 0.04 (0.01 - 0.05)	
Cast iron	-	-	-	-	★ 50 - 100	0.01 - 0.03	0.01 - 0.04	0.01 - 0.05	0.01 - 0.05	0.01 - 0.05	0.01 - 0.05	0.02 - 0.08	0.02 - 0.08	
Aluminium alloy	-	-	-	★ 200 - 500	☆ 200 - 450	0.01 - 0.03	0.01 - 0.04	0.01 - 0.05	0.01 - 0.05	0.01 - 0.05	0.01 - 0.05	0.02 - 0.08	0.02 - 0.08	
Brass	-	-	-	-	★ 100 - 200	0.01 - 0.03	0.01 - 0.04	0.01 - 0.06	0.01 - 0.06	0.01 - 0.06	0.01 - 0.06	0.02 - 0.1	0.02 - 0.1	

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

Piping parts

Pipe parts will be required separately if internal coolant is used.

Pump pressure: Up to 20 MPa.
Pump pressure: Up to 7.5 MPa if couplers are used.



Combined part description (Example)

Parts	Description
1. Joint	J-AN-R1/8-G1/8
4. Hose	HS-G1/8-G1/8-200
5. Joint	J-AN-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.

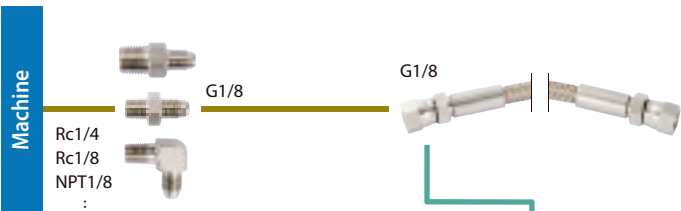
Combined part description (Example)

Parts	Description
(1. Joint)	-
2. Coupler	CP-ST-R1/8, P-ST-RC1/8
3. Joint	J-AN-R1/8-G1/8
4. Hose	HS-G1/8-G1/8-200
5. Joint	J-AN-R1/8-G1/8
6. Coupler	P-ST-RC1/8, CP-ST-R1/8
(7. Joint)	-

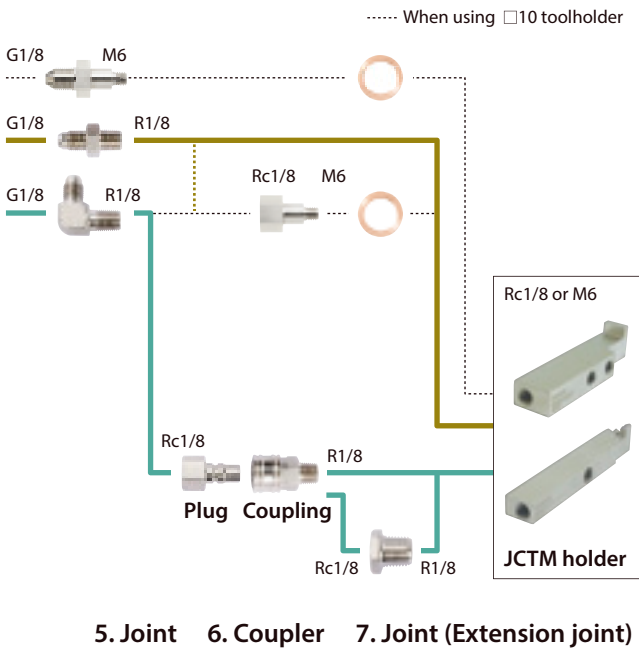
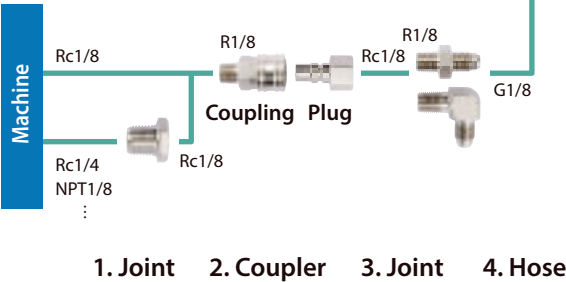
Convert the thread standards on the machine's side (Rc1/4, Rc1/8, NPT1/8, etc.) to thread standards of the coupler (Rc1/8, etc.) or hose (G1/8) for use.
Use sealing agents such as seal tapes when installing piping parts.

Combination image

Without coupler (Pump pressure : Up to 20 MPa)



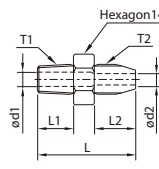
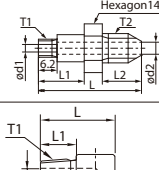
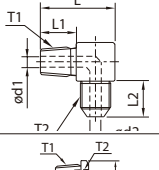
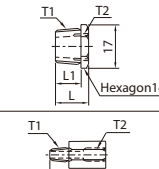
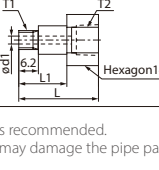
With coupler (Pump pressure : Up to 7.5 MPa)



Piping installation parts descriptions

Joint (1, 3, 5, 7) Pressure: Up to 20.0 MPa

(Unit : mm)

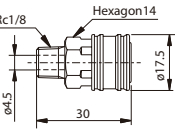
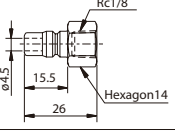
Shape		Description	Availability	Ød1	Ød2	L	L1	L2	T1	T2
		J-ST-R1/4-G1/8	●	5.5	4.0	34	13	13	R1/4	G1/8
		J-ST-NPT1/8-G1/8	●	3.5	3.5	29	10	13	NPT1/8	G1/8
		J-ST-R1/8-G1/8	●	4.0	4.0	29	10	13	R1/8	G1/8
		J-ST-R1/8-G1/8-L	●	4.0	4.0	40	20	14	R1/8	G1/8
		J-ST-M6-G1/8	●	2.5	4.0	34.2	15.2	13	M6	G1/8
		J-AN-R1/8-G1/8	●	4.0	4.0	27	14	13	R1/8	G1/8
		J-AN-R1/8-G1/8-L	●	4.0	4.0	34	20	14	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
		J-ST-M6-RC1/8	●	2.5	4.0	25.2	15.2	—	M6	Rc1/8

Elbow piping (J-AN-R1/8-G1/8) is recommended.
Caution in use: Over-tightening may damage the pipe parts.

●: Available

Coupler (2, 6) Pressure: Up to 7.5 MPa

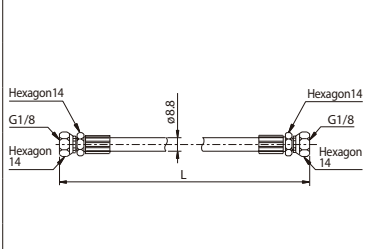
(Unit : mm)

Shape		Description	Availability
		CP-ST-R1/8	●
		P-ST-RC1/8	●

●: Available

Hose (4) Pressure: Up to 20.0 MPa

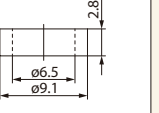
(Unit : mm)

Shape		Description	Availability	L
		HS-G1/8-G1/8-200	●	200
		HS-G1/8-G1/8-300	●	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

●: Available

Washer

(Unit : mm)

Shape		Description	Availability
		WS-6	●

●: Available

Precautions

Maximum D.O.C. of the next tool (indicated as tool A) and holder interference

When using JCTM holder 1218/1212, note maximum D.O.C. of the next tool to avoid interference.



Estimated maximum D.O.C. of tool A (mm)

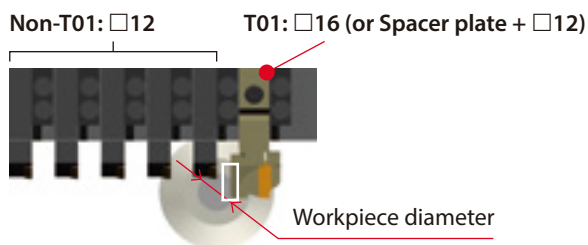
Workpiece diameter	Ø12	Ø16	Ø20
JCTM Description			
KGZ R/L 1218JX-*JCTM	2.4	2.0	1.7
KGZ R/L 1212JX-*JCTM	-	-	3.8
KGZ R/L 1212JX-*JCTM	-	-	3.8

When using the JCTM holder 1218/1625/1616 for T01 on the following models, please check the workpiece diameter in advance to avoid interference.

Models

T01: Machines where both □16 (or Spacer plate + □12) holders can be mounted.

Non-T01: Machines where only □12 holders can be mounted.



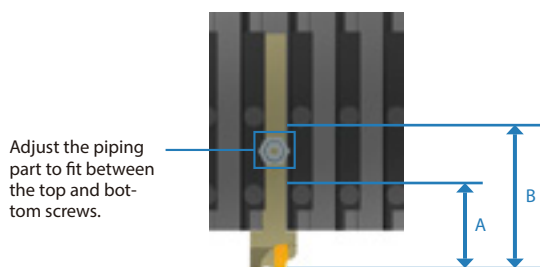
KGZ Compatibility

Workpiece diameter	Ø14 or smaller	Ø14 or larger
JCTM Description		
KGZ R/L 1218JX-*JCTM	Compatible	Please use KGZ R/L 1212JX-*JCTM or KGZ R/L 1616JX-*D26JCTM
KGZ R/L 1625JX-*JCTM		
KGZ R/L 1616JX-*JCTM		

Piping part interference avoidance

Rectangular shank are recommended for use with piping parts connected to JCTM holders.

When connecting the J-**-R1/8-G1/8-L piping parts to the rectangular shank, please check for any potential interference with the machine in advance.



When connecting piping parts to the JCTM square shank, check the lengths of A and B below to avoid interference with the screws of the tool turret.

Shank Size	Availability of square shank use
□12	"A" shorter than 51.5 mm and "B" longer than 68.5 mm → Available Other than the above conditions → Use J-**-R1/8-G1/8-L or a rectangular shank
□16	Available

Compatibility with conventional tools

KGZ is not compatible with the conventional tools (KGD/KGM)

KGZ



Conventional

