



# Y-axis Toolholders

for Small Parts Machining

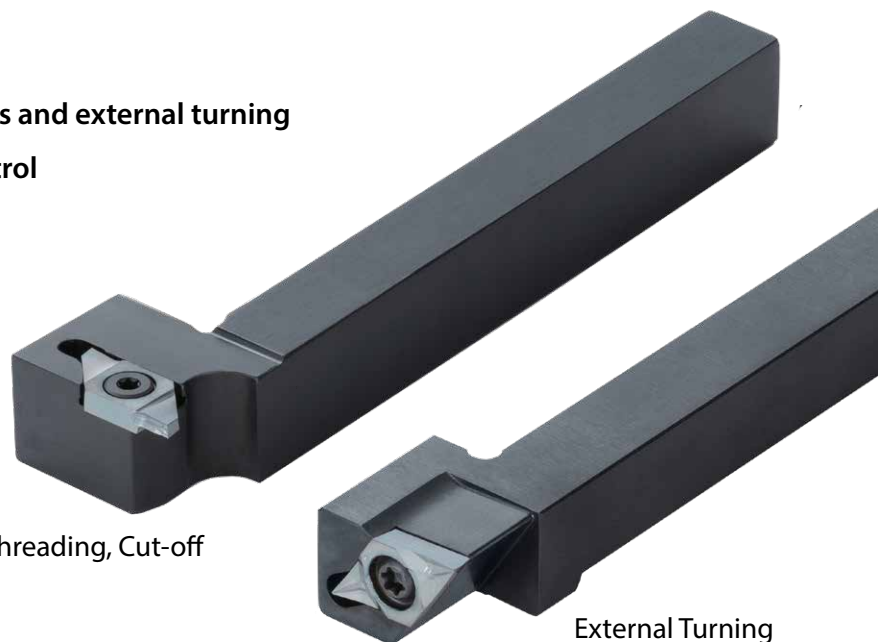


Excellent Chip Evacuation with Y-axis Turning Prevents Chip Entanglement

New Y-axis toolholder design

Available for KTKF grooving and cut-off systems and external turning

Advanced productivity with excellent chip control



Back Turning, Threading, Cut-off

External Turning

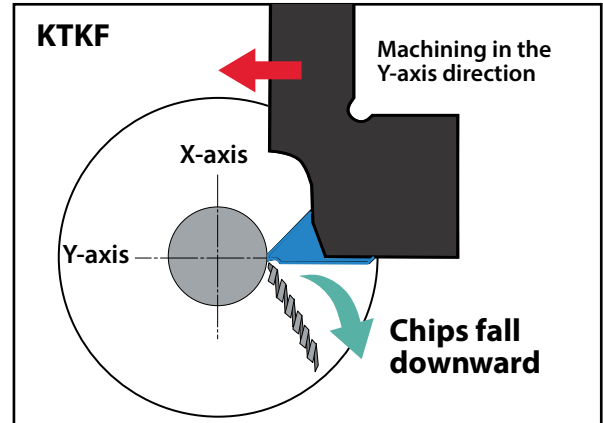
# Y-axis Toolholders

Improved Chip Control

New Toolholder Designs for Better Chip Evacuation in Small Parts Machining



## 1 Controlled Chip Evacuation for Stable Machining



The Y-axis machining direction allows the chips to fall down and away from the workpiece, improving chip evacuation.

## 2 KTKF Grooving and Cut-Off System and External Turning Holders

### KTKF

Back Turning, Threading and Cut-off



KTKFR1216JX-12-Y : Shank 1216 Type  
KTKFR1616JX-12-Y : Shank 1616 Type  
Applicable Inserts : TKF12R...

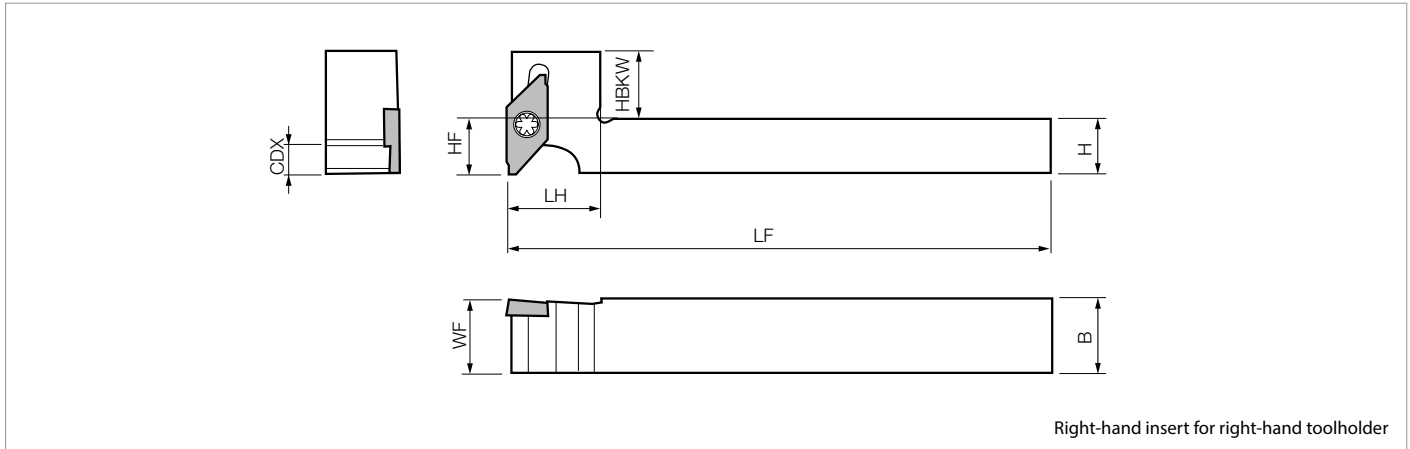
### External Turning

Front turning



SDJCR1212JX-11FF-Y : Shank 1212 Type  
SDJCR1616JX-11FF-Y : Shank 1616 Type  
Applicable Inserts : DC □□ 325...

## KTKF-Y (Back Turning, Threading, Cut-off)



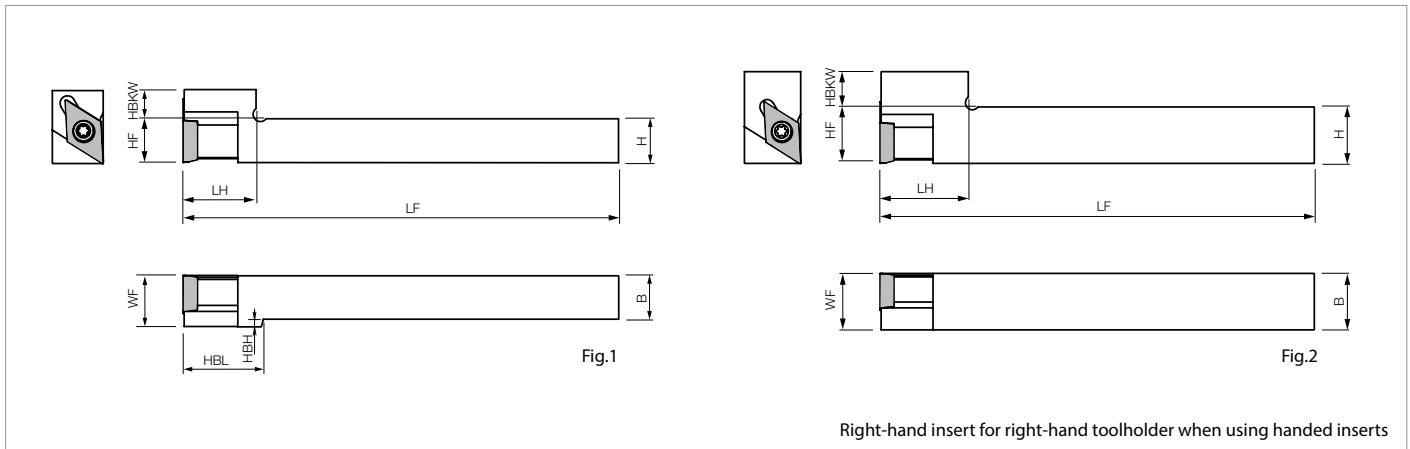
### Toolholder Dimensions

Part Number	Stock		Dimensions (mm)								Spare Parts		Applicable Inserts
	R	L	H	HF	B	LF	LH	WF	CDX	HBKW	Clamp Screw	Wrench	
KTKFR 1216JX-12-Y	●		12	12	16	120	20	16	6	15	SB-4590TRWN	FT-10	TKF12R...
1616JX-12-Y	●		16	16	16		25	16		11			

CDX shows the distance from the toolholder to the cutting edge

● : Standard Stock

## SDJC-Y (External Turning)



### Toolholder Dimensions

Part Number	Stock		Dimensions (mm)									Drawing	Spare Parts		Applicable Inserts
	R	L	H	HF	B	LF	LH	WF	HBKW	HBL	HBH		Clamp Screw	Wrench	
SDJCR 1212JX-11FF-Y	●		12	12	12	120	20	14	8	22	2	Fig.1	SB-4085TR	FT-15	DC□□ 325...
1616JX-11FF-Y	●		16	16	16		25	16	10	-	-				

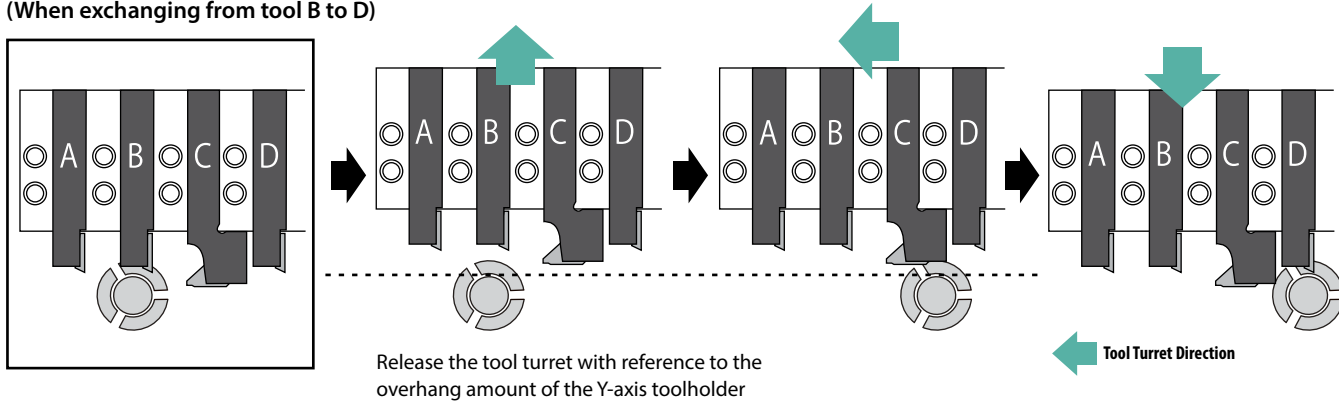
● : Standard Stock

# Precautions

Do not use Y-axis toolholders side-by-side to prevent interference (Only two Y-axis holders can be used at the same time)



When changing the tool, set the retracted position with reference to the cutting edge of the Y-axis holder (When exchanging from tool B to D)



Release the tool turret with reference to the overhang amount of the Y-axis toolholder

Note that using other toolholder styles together will result in different outside diameters

(Unit: mm)

Y-axis Toolholder Overhang	Examples	Overhang Amount : L			
		Available Outside Cutting Dia. (Ø)	20	22	25
20		A	Without Restriction	Without Restriction	Without Restriction
		B	13.0	13.0	13.0
		C	Without Restriction	Without Restriction	Without Restriction
25		A	38.0	58.0	Without Restriction
		B	14.9	13.6	13.0
		C	45.0	60.0	Without Restriction



## KYOCERA Precision Tools

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