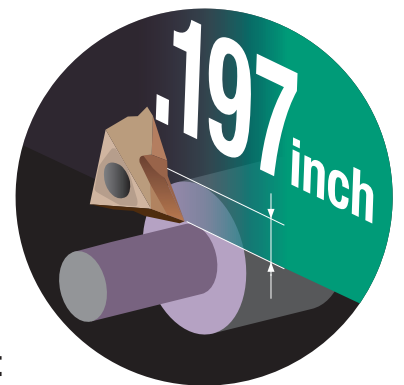
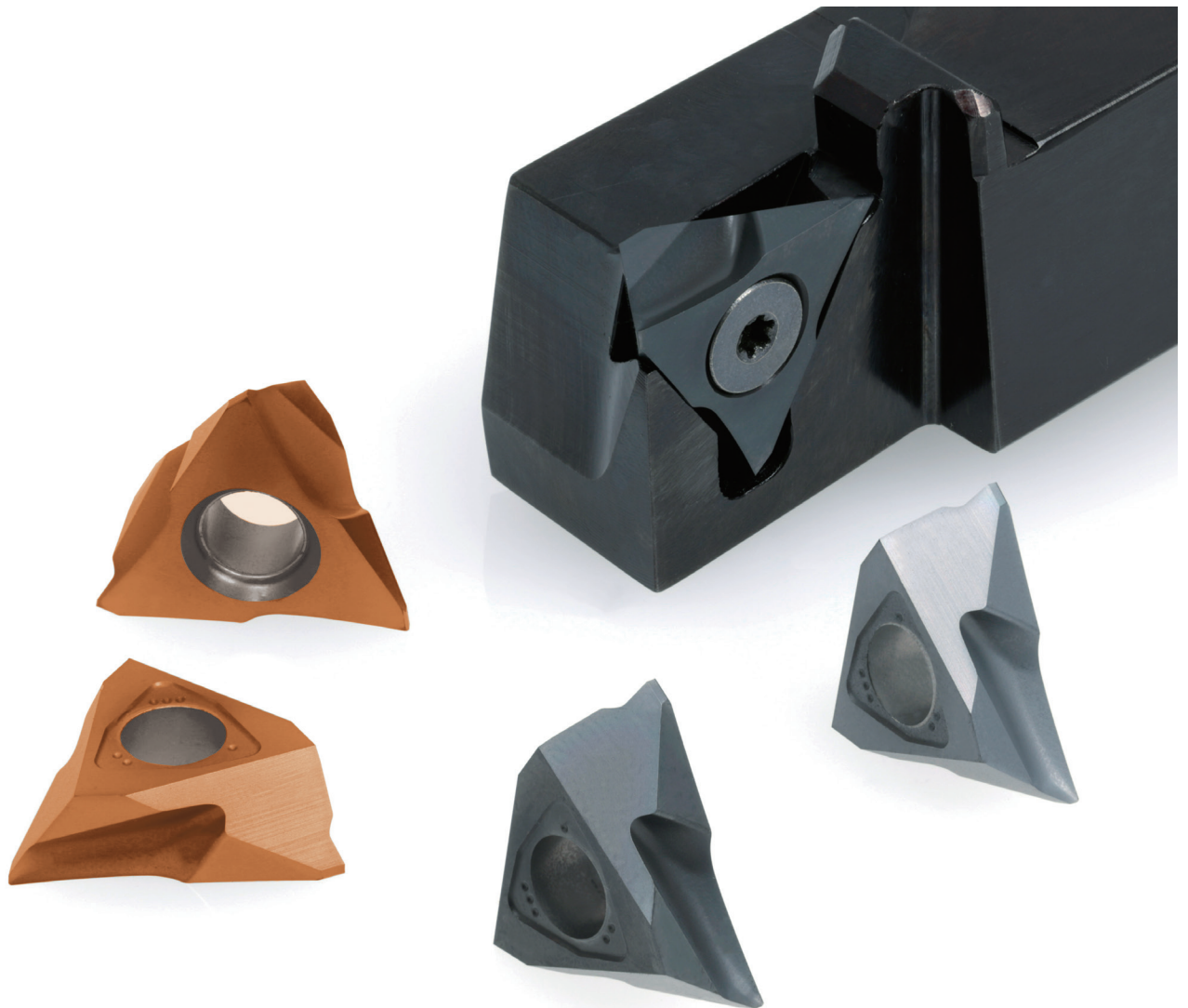


The Front Max

For External turning | CNC automatic lathes



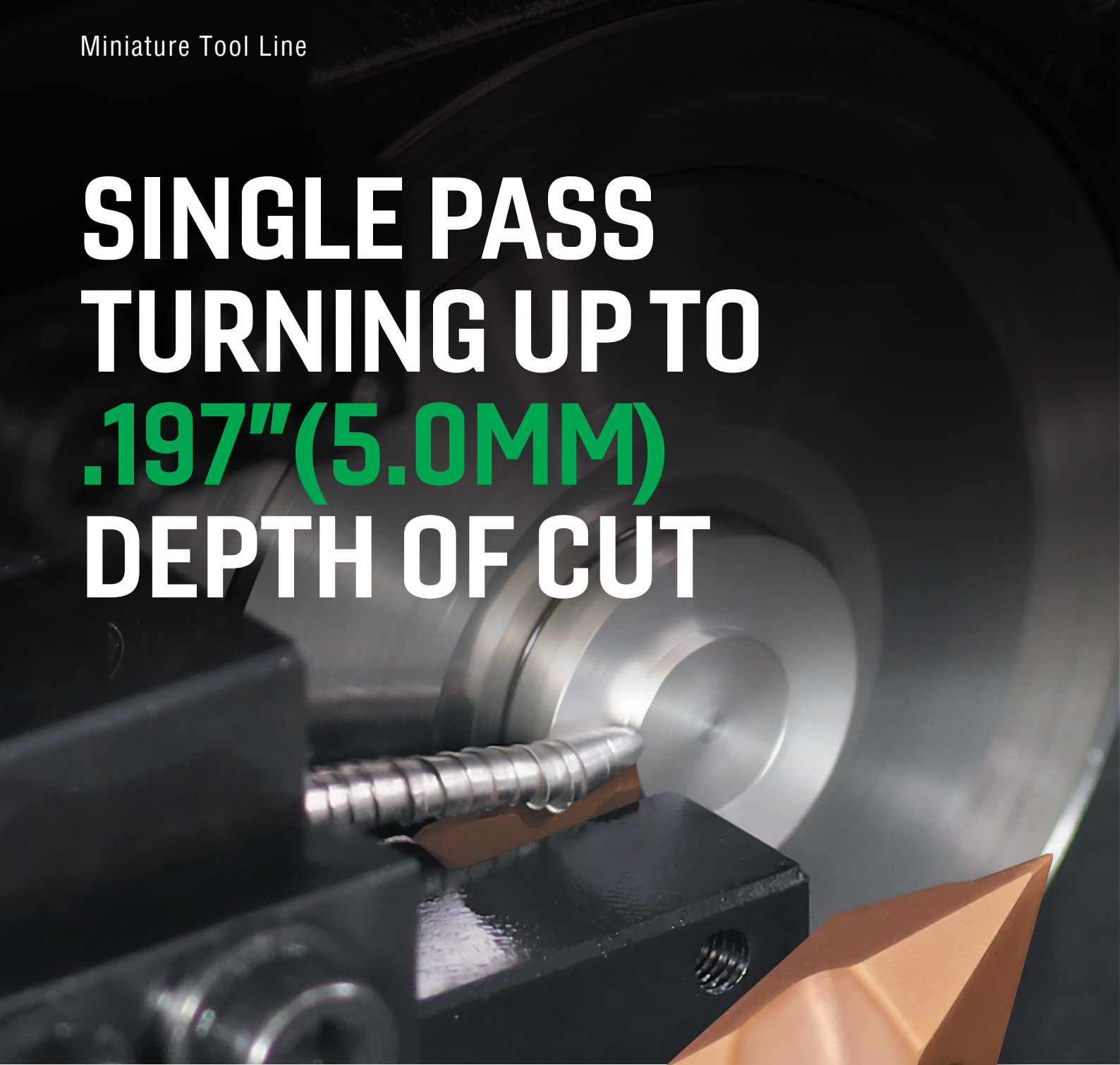
Single pass machining of up to .197" (5.0mm) depth of cut

Significant reduction in cycle time due to large depth of cut capability

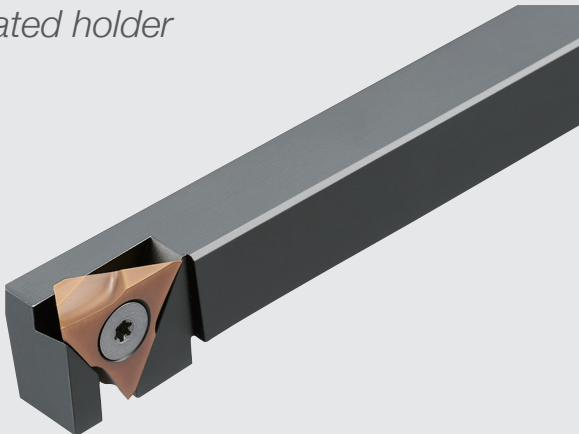
CERTainly | but not only | *CERamics*
Outstanding solutions for demanding applications

Miniature Tool Line

SINGLE PASS TURNING UP TO .197" (5.0MM) DEPTH OF CUT



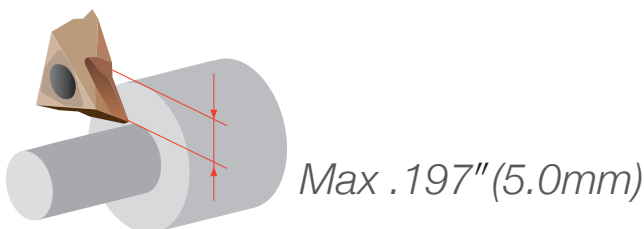
Dedicated holder



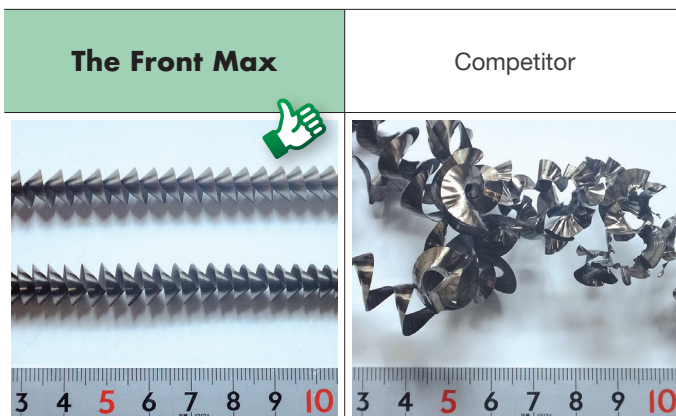
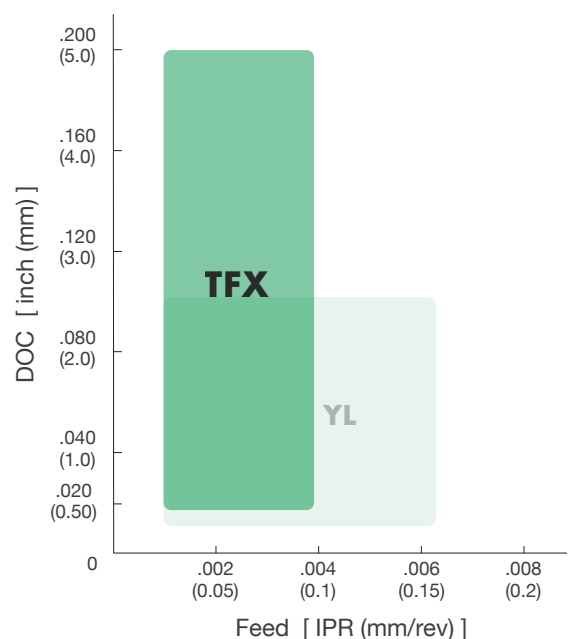
The Front Max

Maximum depth of cut .197"(5.0mm)
 Single pass machining reduces cycle time.
 Fewer machining passes reduce insert wear.
 Tool life can be extended.

Uniquely Designed Chipbreaker Achieves Excellent Chip Control And Machined Surfaces.



FUNCTIONING RANGE



material: AISI304
 ap.**0.197inch (5.0mm)** vc=260SFM (80m/min)
 f=.001IPR (0.03mm/rev) WET

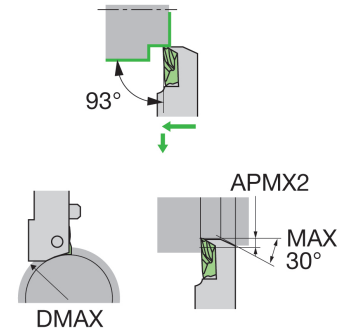
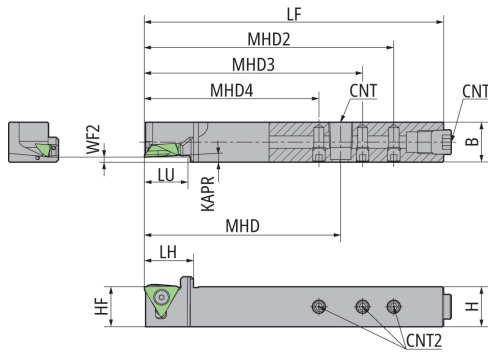


Front Turning Operations

TF.. series/Toolholder

Inch

TFT-OH3 [93°] Direct connect coolant port 3-hole type The Front Max.



● Diagram shows right-hand tool

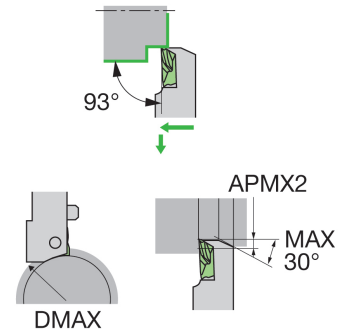
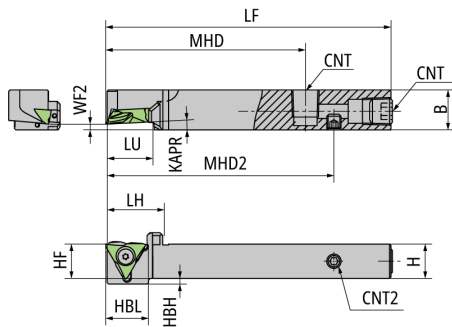
[Workpiece shape restrictions during machining]
 DMAX: Max. bar stock diameter during APMX2 max DOC
 APMX2: Max depth of cut

Item Number	Hand	DMAX	APMX2	B	CNT	CNT2	H	HF	KAPR	LF	LH	LU	MHD	MHD2	MHD3	MHD4	WF2	Insert Gage	
		inch	inch	inch			inch	inch	°	inch	inch	inch	inch	inch	inch	inch	inch	inch	TFX33..
TFTR10X-IN-OH3	R	1.575	.098	5/8	NPT1/8	M5	5/8	5/8	3	4.724	.778	.709	3.100	3.937	3.445	2.756	.079	TFX33..	TF33..

Spare Parts

Item Number	Clamp screw	Screw (for CNT)	Screw (for CNT2)	Wrench (for Clamp screw)	Wrench (for CNT2)
TFTR10X-IN-OH3	LR-S-4*10PW	SPNPT1/8	SS0505SC	CLR-15S	LW-2.5

TFT-OH2 [93°] Direct connect coolant port 1-hole type The Front Max.



● Diagram shows right-hand tool

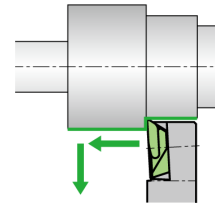
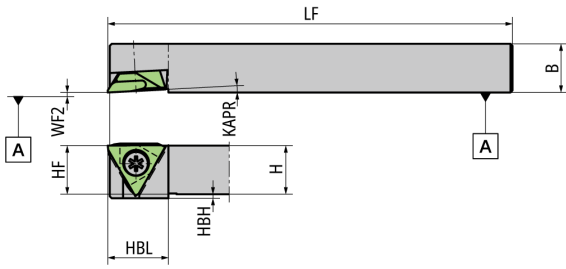
[Workpiece shape restrictions during machining]
 DMAX: Max. bar stock diameter during APMX2 max DOC
 APMX2: Max depth of cut

Item Number	Hand	DMAX	APMX2	B	CNT	CNT2	H	HBH	HBL	HF	KAPR	LF	LH	LU	MHD	MHD2	WF2	Insert Gage	
		inch	inch	inch			inch	inch	inch	inch	inch	inch	°	inch	inch	inch	inch	inch	TFX33..
TFTR06H-IN-OH2	R	.787	.098	.551	M6*1	M5	3/8	.157	.591	3/8	3	3.937	.787	.591	2.756	3.150	.079	TFX33..	TF33..
TFTR08H-IN-OH2	R	1.181	.098	.551	NPT1/8	M5	1/2	.079	.591	1/2	3	3.937	.787	.591	2.756	3.150	.079	TFX33..	TF33..
TFTR10X-IN-OH2	R	1.575	.098	5/8	NPT1/8	M5	5/8	-	-	5/8	3	4.724	.787	.689	2.756	3.937	.079	TFX33..	TF33..

Spare Parts

Item Number	Clamp screw	Screw (for CNT)	Screw (for CNT2)	Wrench (for Clamp screw)	Wrench (for CNT2)
TFTR06H-IN-OH2	LR-S-4*10PW	SS0605SC	SS0505SC	CLR-15S	LW-2.5
TFTR08H-IN-OH2	LR-S-4*10PW	SPNPT1/8	SS0505SC	CLR-15S	LW-2.5
TFTR10X-IN-OH2	LR-S-4*10PW	SPNPT1/8L	SS0505SC	CLR-15S	LW-2.5

TFT [93°]



● Diagram shows right-hand tool

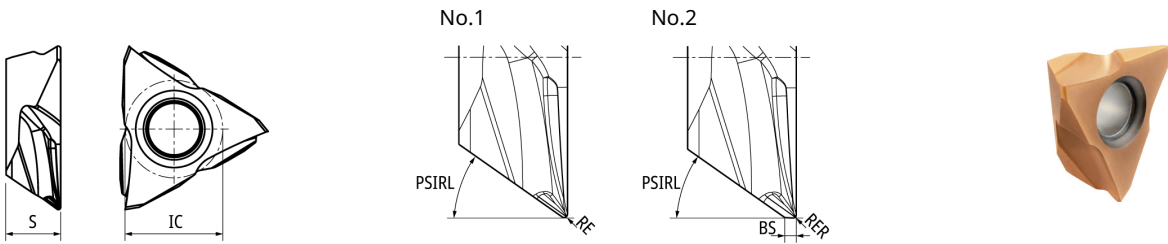
Item Number	Hand	B	H	HBH	HBL	HF	KAPR	LF	WF2	Insert Gage	
		inch	inch	inch	inch	inch	°	inch	inch	TFX33..	TF33..
TFTR06-IN	R	3/8	3/8	.118	.591	3/8	3	4.724	.000	TFX33..	TF33..
TFTR08-IN	R	1/2	1/2	.039	.591	1/2	3	4.724	.000	TFX33..	TF33..

Spare Parts

Item Number	Clamp screw	Wrench (for Clamp screw)
TFTR06-IN	LR-S-4*10PW	CLR-15S
TFTR08-IN	LR-S-4*10PW	CLR-15S

TF.. series/Inserts

TFX The Front Max



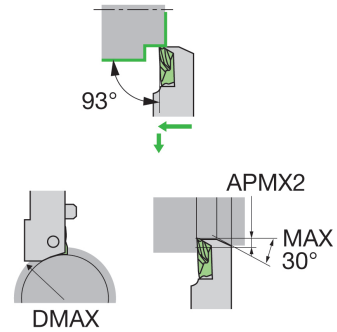
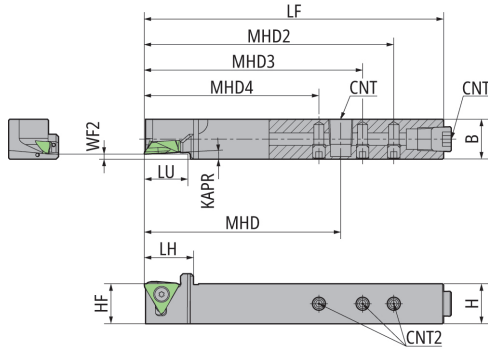
● Diagram shows right-hand tool
All angles shown are obtained when insert is set in the holder.

Figure	Item Number	Hand	Wiper	APMX	IC	S	BS	PSIRL	RE	RER	Carbide	
				inch	inch	inch	inch	°	inch	inch	PVD	
											DM4	ST4
1	TFX3301MR	R	-	.197	3/8	3/16	-	32	.003	-	●	●
1	TFX3302MR	R	-	.197	3/8	3/16	-	32	.007	-	●	●
1	TFX3304MR	R	-	.197	3/8	3/16	-	32	.015	-	●	●
2	TFX3301MRW	R	Straight	.197	3/8	3/16	.020	32	-	.003	●	●
2	TFX3302MRW	R	Straight	.197	3/8	3/16	.020	32	-	.007	●	●
2	TFX3304MRW	R	Straight	.197	3/8	3/16	.020	32	-	.015	●	●

Note: Initial dimensional adjustments may be required depending on the machining condition.

Front Turning Operations TF.. series/Toolholder

TFT-OH3 [93°] Direct connect coolant port 3-hole type The Front Max.



● Diagram shows right-hand tool

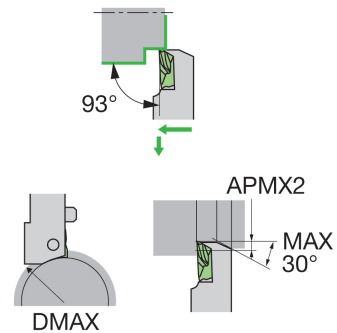
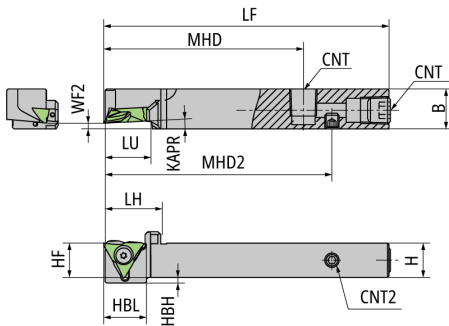
[Workpiece shape restrictions during machining]
DMAX: Max. bar stock diameter during APMX2 max DOC
APMX2: Max depth of cut

Item Number	Stock	Hand	DMAX	APMX2	B	CNT	CNT2	H	HF	KAPR	LF	LH	LU	MHD	MHD2	MHD3	MHD4	WF2	Insert Gage		
			mm	mm	mm			mm	mm	mm	mm	mm	°	mm	mm	mm	mm	mm	mm	mm	mm
TFTR1616X-OH3	Blue	Red	R	40	2.5	16	Rc1/8	M5	16	16	3	120	19.75	18	78.75	100	87.5	70	2	TFX33..	TF33..

Spare Parts

Item Number	Clamp screw	Screw (for CNT)	Screw (for CNT2)	Wrench (for Clamp screw)	Wrench (for CNT2)
TFTR1616X-OH3	LR-S-4*10PW	SPR1/8L	SS0505SC	CLR-15S	LW-2.5

TFT-OH2 [93°] Direct connect coolant port 1-hole type The Front Max.



● Diagram shows right-hand tool

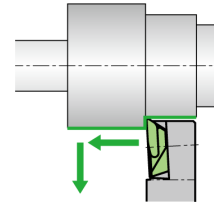
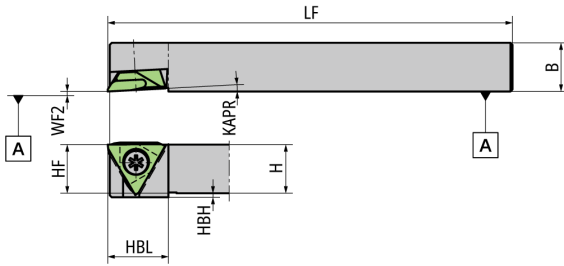
[Workpiece shape restrictions during machining]
DMAX: Max. bar stock diameter during APMX2 max DOC
APMX2: Max depth of cut

Item Number	Hand	DMAX	APMX2	B	CNT	CNT2	H	HBH	HBL	HF	KAPR	LF	LH	LU	MHD	MHD2	WF2	Insert Gage	
		mm	mm	mm			mm	mm	mm	mm	mm	mm	°	mm	mm	mm	mm	mm	mm
TFTR1014H-OH2	R	20	2.5	14	M6*1	M5	10	4	15	10	3	100	20	15	70	80	2	TFX33..	TF33..
TFTR1214H-OH2	R	30	2.5	14	Rc1/8	M5	12	2	15	12	3	100	20	15	70	80	2	TFX33..	TF33..
TFTR1616X-OH2	R	40	2.5	16	Rc1/8	M5	16	-	-	16	3	120	20	17.5	70	80	2	TFX33..	TF33..

Spare Parts

Item Number	Clamp screw	Screw (for CNT)	Screw (for CNT2)	Wrench (for Clamp screw)	Wrench (for CNT2)
TFTR1014H-OH2	LR-S-4*10PW	SS0605SC	SS0505SC	CLR-15S	LW-2.5
TFTR1214H-OH2	LR-S-4*10PW	SPR1/8	SS0505SC	CLR-15S	LW-2.5
TFTR1616X-OH2	LR-S-4*10PW	SPR1/8L	SS0505SC	CLR-15S	LW-2.5

TFT [93°]



● Diagram shows right-hand tool

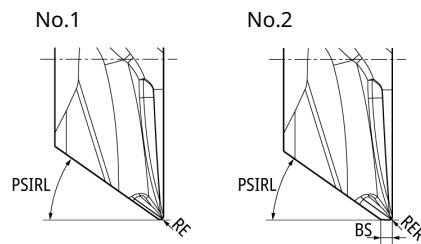
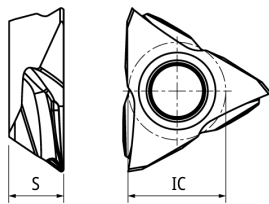
Item Number	Hand	B	H	HBH	HBL	HF	KAPR	LF	WF2	Insert Gage	
		mm	mm	mm	mm	mm	°	mm	mm	TFX33..	TF33..
TFTR10	R	10	10	3	15	10	3	120	0	TFX33..	TF33..
TFTR12	R	12	12	1	15	12	3	120	0	TFX33..	TF33..
TFTR16	R	16	16	-	-	16	3	120	0	TFX33..	TF33..
TFTR20	R	20	20	-	-	20	3	120	0	TFX33..	TF33..

Spare Parts

Item Number	Clamp screw	Wrench (for Clamp screw)
TFTR10	LR-S-4*10PW	CLR-15S
TFTR12	LR-S-4*10PW	CLR-15S
TFTR16	LR-S-4*10PW	CLR-15S
TFTR20	LR-S-4*10PW	CLR-15S

TF.. series/Inserts

TFX The Front Max



● Diagram shows right-hand tool
All angles shown are obtained when insert is set in the holder.

Figure	Item Number	Hand	Wiper	APMX	IC	S	BS	PSIRL	RE	RER	Carbide PVD	
				mm	mm	mm	mm	°	mm	mm	DM4	ST4
1	TFX3301MR	R	-	5	9.525	4.76	-	32	0.08	-	●	●
1	TFX3302MR	R	-	5	9.525	4.76	-	32	0.18	-	●	●
1	TFX3304MR	R	-	5	9.525	4.76	-	32	0.38	-	●	●
2	TFX3301MRW	R	Straight	5	9.525	4.76	0.5	32	-	0.08	●	●
2	TFX3302MRW	R	Straight	5	9.525	4.76	0.5	32	-	0.18	●	●
2	TFX3304MRW	R	Straight	5	9.525	4.76	0.5	32	-	0.38	●	●

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