Solid Carbide
Solid Quality
Solid Performance

Because of the **solid tungsten carbide** support blade, Sumitomo cut-off tools are able to perform in the most demanding applications. Tungsten carbide is more rigid than steel so bending, vibration and movement at the cutting edge are all drastically reduced.

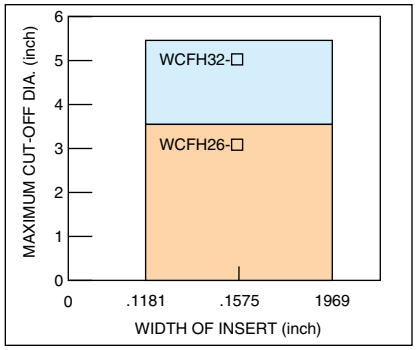
The Sumitomo solid carbide support blades fit in many existing cut-off tool blocks.

The unique positive rake inserts are available in neutral, right hand, and left hand styles. The insert design collapses the width of the chip, breaks it and facilitates chip flow away from the cut, thus welding and wear on the insert corners are greatly reduced, and coolant is easier to direct.

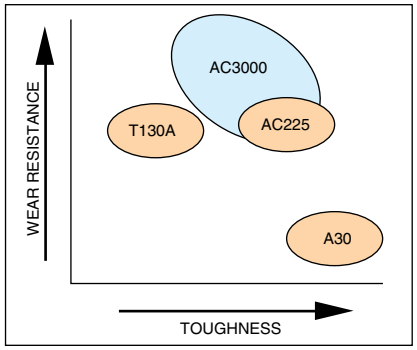
Operating at high speeds and feeds is possible because of longer tool life, and down-time for chip removal is drastically reduced.

NOTE: Sumitomo Inserts fit only Sumitomo Blades.

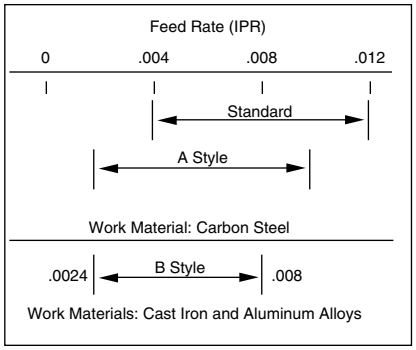
■ MAXIMUM CUT-OFF DIAMETER



■ GRADE APPLICATION RANGE



■ CHIPBREAKER RANGE



■ GRADE APPLICATION

GRADE	C.B. STYLE	APPLICATION	FEATURE
AC3000	STANDARD	Heavy feed in steel (.0032–.012 ipr)	Coated insert with excellent wear resistance. Standard chipbreaker for low cutting force applications.
AC225	A	Light feed in steel (.0016–.010 ipr) Carbon steel, stainless steel	Coated insert with excellent toughness. A style chipbreaker with good chip control.
T130A	A	Light feed in steel (.0012–.0061 ipr)	Cermet inserts produce excellent surface finish.
A30N	A	Slow speed and feed in steel	Equivalent to C5, C6 carbide.
G10E	A	For exotic materials	C2 carbide for exotic materials.
G10E	B	For cast iron and aluminum alloy	C2 carbide with a sharp cutting edge.

CAUTION
1. Do not use AC3000 for light feed rate applications (Feed rate should be at least .004 ipr)
2. Use AC225 for stainless steel.
3. Use A style chipbreaker for low carbon steel.
4. Use coolant.

■ RECOMMENDED RUNNING CONDITIONS

GRADE	V (SFM) f (ipr)	STEEL	CARBON STEEL	STAINLESS STEEL	DIE STEEL	CAST IRON	EXOTICS
AC25 AC3000	V	320–720	400–820	260–650	200–500	—	—
	f	.004–.012	.004–.006	.004–.006	.004–.006		
AC225	V	260–650	320–750	200–600	200–500	—	—
	f	.0016–.010	.0016–.008	.0016–.008	.0016–.008		
T130A	V	260–650	320–750	200–600	200–500	—	—
	f	.0012–.006	.0012–.004	.0012–.004	.0012–.0032		
A30N	V	160–400	230–500	230–500	160–400	—	—
	f	.002–.008	.0016–.006	.0016–.006	.0016–.006		
G10E	V	—	—	—	—	160–320	100–160
	f					.0024–.008	.002–.003