

sumiCutoff™ Solid Carbide Toolholders

Solid Carbide • Solid Quality • Solid Performance

Because of the solid tungsten carbide support blade, Sumitomo cut-off tools are able to perform at depths 40% greater than any tools now available. Tungsten carbide is more rigid than steel so even in long overhang applications, bending, vibration and movement at the cutting edge are drastically reduced.

The 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

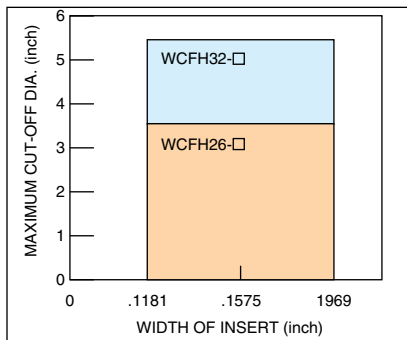
chip, breaks it and facilitates chip flow away from the cut, thus welding and wear on the insert corners are greatly reduced, and coolant is easier to direct.

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

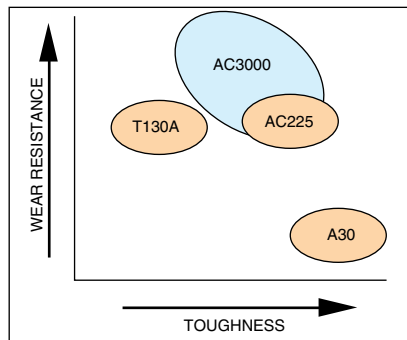
Safety is enhanced because long, stringy chips are avoided.

Note: Sumitomo Inserts fit only Sumitomo Blades.

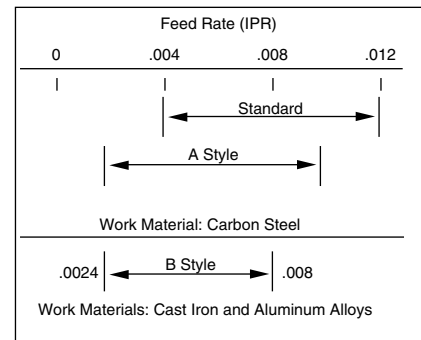
Maximum Cut-Off Diameter



Grade Application Range



Chipbreaker Range



Inserts 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 AC25 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 Cutting Conditions

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

General Info

Negative Inserts

Positive Inserts

Ace-Fix Inserts

Threading, Grooving, & Cut-Off Inserts

Ceramic Inserts

PCBN & PCD Inserts

Toolholders

Swiss Toolholders

Boring Bars

Technical Info

ALMT