

Groove and cut-off tool

Seco's cut-off tool has a unique fastening of the insert. The blade that holds the insert is manufactured of high speed steel. This is more heat-resistant than tool steel, which means that the clamping force on the insert is maintained even when the blade becomes warm.

The following simple rules should be observed:

- As a quick guide with normal parting off a cutting speed of 100 m/min and a feed of 0.1 mm/r should be chosen.
- The tolerance for the centre height should never be greater than ± 0.1 mm.
- Make sure the coolant supply is generous.
- A neutral insert usually gives a longer wear time. However, a left or right insert reduces the size of the peg or ring on the parted part. (Cutting data recommendations refer to natural inserts.)
- The life span can be increased if the feed is reduced during the final stages of parting.
- The life span can also be increased if a stop is introduced during the final stages of parting.
- A part catcher for parts also contributes to increasing the life span.