

## High-performance tooling from ACT



Microcut RHSS-1010 tooling used for parting-off 5mm diameter stainless steel bar



ACT2.2 tooling for parting-off 20mm stainless steel bar and 8mm stainless steel tube



Microcut tooling for parting-off radio-metal components

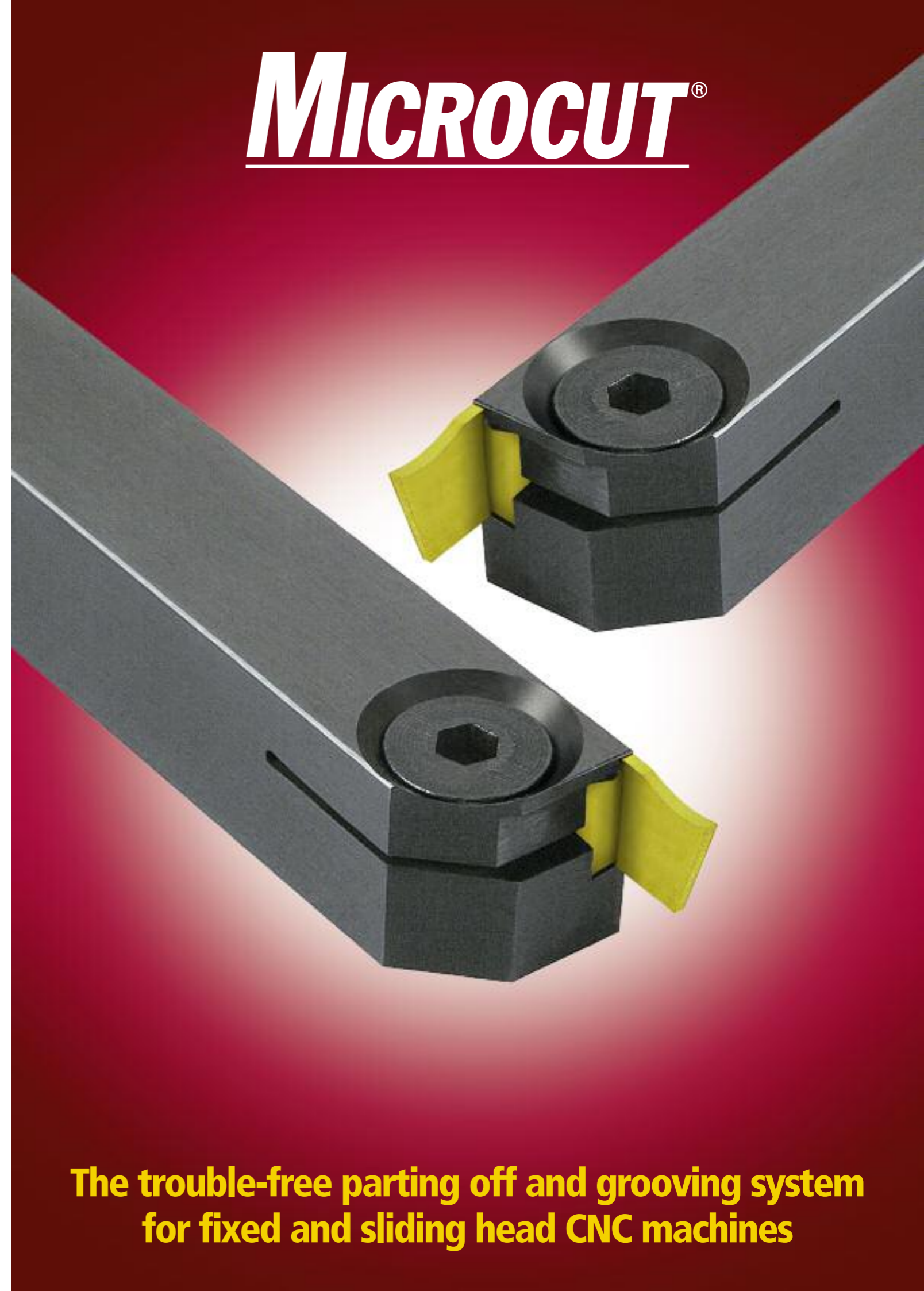


ACT2.2 tooling for face-grooving radio-metal components for aerospace applications



ACT2.2 tooling for face-grooving stainless steel components for medical equipment

# MICROCUT®



**ACT**  
GROUP

**ADVANCED CARBIDE TOOLING LIMITED**

Sketchley Meadows Business Park, Hinckley, Leicestershire LE10 3EZ

Tel: 0044 (0) 1455 234000 Fax: 0044 (0) 1455 234022

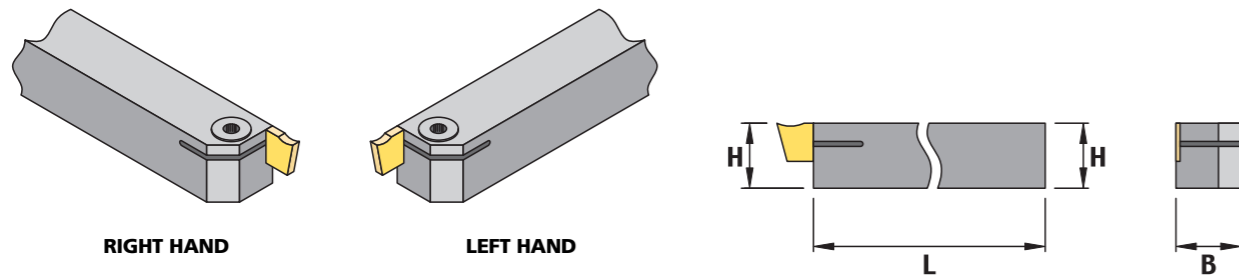
E-mail: [sales@advancedcarbide tooling.co.uk](mailto:sales@advancedcarbide tooling.co.uk)

Web: [www.advancedcarbide tooling.co.uk](http://www.advancedcarbide tooling.co.uk)



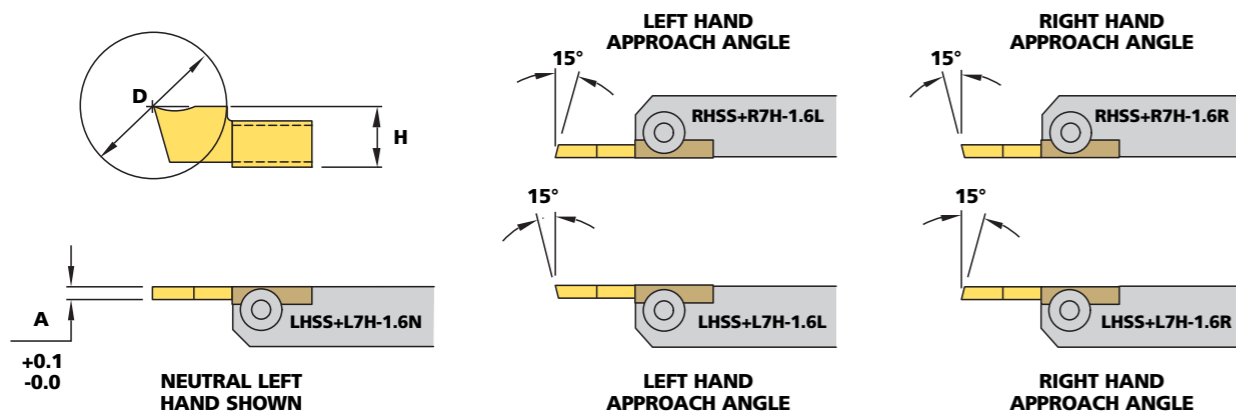
**The trouble-free parting off and grooving system  
for fixed and sliding head CNC machines**

## MICROCUT® TOOL HOLDERS



RIGHT/LEFT HAND TOOLHOLDER	H	H	B	L	INSERT HEIGHT	CLAMPING SCREW	KEY
R/L HSS – 0808	8	8	8	140	5	ACT-38	ACT-10
R/L HSS – 1010	10	10	10	140	7	ACT-38	ACT-10
R/L HSS – 1212	12	12	12	140	7	ACT-38	ACT-10
R/L HSS – 1616	16	16	16	140	7	ACT-38	ACT-10
R/L HSS – 2020	20	20	20	140	7	ACT-38	ACT-10

## INSERTS – ASP® 2060 HSS TIN COATED



INSERT PART NUMBER	H	A	ØD	DESCRIPTION	USE WITH					STOCK
					0808	1010	1212	1616	2020	
R/L5H – 0.5N	5	0.5	10	RH/LH 5 HIGH x 0.5 WIDE NEUTRAL	■					
R/L5H – 0.8N	5	0.8	10	RH/LH 5 HIGH x 0.8 WIDE NEUTRAL	■					
R/L5H – 1.1N	5	1.1	12	RH/LH 5 HIGH x 1.1 WIDE NEUTRAL	■					■
R/L5H – 1.1 R/L	5	1.1	12	RH/LH 5 HIGH x 1.1 WIDE RH/LH	■					
R/L7H – 0.5N	7	0.5	10	RH/LH 7 HIGH x 0.5 WIDE NEUTRAL		■	■	■	■	■
R/L7H – 0.8N	7	0.8	10	RH/LH 7 HIGH x 0.8 WIDE NEUTRAL		■	■	■	■	■
R/L7H – 1.1NS	7	1.1	10	RH/LH 7 HIGH x 1.1 WIDE NEUTRAL SHORT		■	■	■	■	■
R/L7H – 1.1 R/LS	7	1.1	10	RH/LH 7 HIGH x 1.1 WIDE RH/LH SHORT		■	■	■	■	■
R/L7H – 1.1 N	7	1.1	16	RH/LH 7 HIGH x 1.1 WIDE NEUTRAL		■	■	■	■	■
R/L7H – 1.6N	7	1.6	16	RH/LH 7 HIGH x 1.6 WIDE NEUTRAL		■	■	■	■	■
R/L7H – 1.6 R/L	7	1.6	16	RH/LH 7 HIGH x 1.6 WIDE RH/LH		■	■	■	■	■

ORDERING EXAMPLE: 1 – OFF RHSS – 1010

ASP® IS A BRAND NAME BELONGING TO ERASTEEL

10 – OFF R7H – 1.6R

# MICROCUT®

- Choice of toolholders from 8mm to 20mm square
- All toolholders are available ex-stock
- Insert widths from 0.5mm to 1.6mm, match standard ISO circlip grooves
- Insert reaches from 5mm to 8mm
- TiN-coated ASP® 2060 HSS inserts perform well on all materials
- Insert design reduces cutting pressures
- Clamping system allows quick insert changes
- All 7mm high inserts fit all toolholders from 10mm to 20mm shanks
- Designed and manufactured in the UK

## ASP® 2060 HSS TIN COATED INSERTS

Cutting data for Parting Off & External Grooving

Material:-	Free Cutting Steels & Carbon Steel	Alloy Steel	Stainless Steel	Copper	Phosphor Bronze	Brass	Aluminium Alloys	Titanium Ti6Al-4V
	0.2% Free Cut. 0.2%C 0.45%C 0.83%C		Martensitic Austenitic					
Brinell Hardness	<100 <150 <190 <250	<230 <350 <420	175-375 135-175	50-85	85-110	60-110	80-120 30-80	300-395
Cutting Speed Vc (m/min)	<160 <80 <60 <50	<60	<40	<115 <150	<110	<120	<240 <400	<40
Feed f(mm/rev)	0.02- 0.08-	0.02- 0.08-	0.02- 0.08-	0.02- 0.08-	0.02- 0.08-	0.02- 0.08-	0.02- 0.08-	0.02- 0.08-

When using right or left handed approach angle Microcut inserts reduce the feed by 30-50%