

Technical Tip #141 – Cut-Off Inserts and Guidelines

1. Cut-Off Inserts:

Cut-off inserts are designed in neutral and right-hand or left-hand cut.

- Neutral inserts -- (cutting edge parallel with work piece) are used primarily in solid material and produce a center “stub” on both the workpiece and the part when using solid material stock. Neutral inserts also reduce side deflection.
- Right-hand cut or lead inserts leave a center “stub” or bur on the chuck side of the workpiece and produce a clean part.
- Left-hand cut or lead inserts leave a center “stub” or bur on the part and produce a clean workpiece nearest the chuck side.

2. Guidelines:

Right- or left-handed inserts are most often used in cut-off operations for tubing. The use of handed inserts may decrease tool life and increase side deflection.

Note that when using handed inserts in inverted holders, the above mentioned will be reversed.