



NARROW WIDTH SLITTERS

Diameter Range:
Ø3.00" - 8.00"

Width Range:
.063" - .200"

Insert series:
TIMC

Applications:
Slitting & Sawing

Materials:
Iron, Steel, Stainless Steel,
Hi-Temps, Titanium



AHB Tooling & Machinery, Inc.
ISO Certified
(800) 991-4225
www.ahbinc.com
customerservice@ahbinc.com
Complete Metalworking Solutions
Roseville Saginaw & Jackson, MI

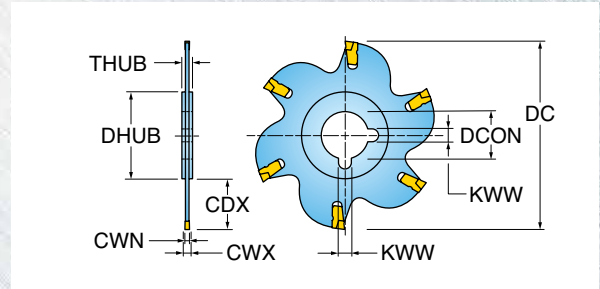
**PRODUCT
BULLETIN
2017**

General Features:

- Narrow widths starting at .063"
- Simple easy-to-mount inserts...no wedges, clamps or screws
- Secure insert retention
- Self-positioning insert stopper for repeatability and minimal runout
- Positive rake geometry reduces cutting forces

TOCLAMP^{ULTRA}™ SERIES TSC_A

THIN SLITTER (.063 - .094 WIDTH)

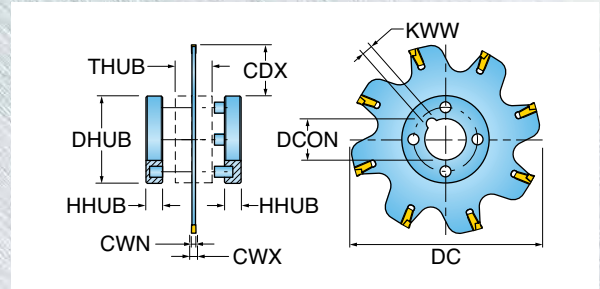


| Part Number | DC Cutting Diameter | CWN Cutting Width Min. | CWX Cutting Width Max. | CDX Cutting Depth Max. | ZFPP Effective Teeth | ZNP Peripheral Insert Count | DHUB Hub Diameter | THUB Hub Thickness | DCON Bore Diameter | KWW Keyway | SSC Insert Seat Size | RPMX RPM Max. |
|----------------|---------------------|------------------------|------------------------|------------------------|----------------------|-----------------------------|-------------------|--------------------|--------------------|------------|----------------------|---------------|
| TSC3.0631.000A | 3.000 | 0.063 | 0.063 | 0.71 | 8 | 8 | 1.54 | 0.094 | 1.000 | 0.25 | 1 | 1050 |
| TSC3.0871.000A | 3.000 | 0.087 | 0.094 | 0.71 | 8 | 8 | 1.54 | 0.094 | 1.000 | 0.25 | 2 | 1050 |
| TSC4.0631.000A | 4.000 | 0.063 | 0.063 | 1.21 | 10 | 10 | 1.54 | 0.094 | 1.000 | 0.25 | 1 | 780 |

NOTE: Insert extractor supplied with each cutter. Note maximum RPM ratings. Cutter width is dictated by insert width.

TOCLAMP^{ULTRA}™ SERIES TSC_K

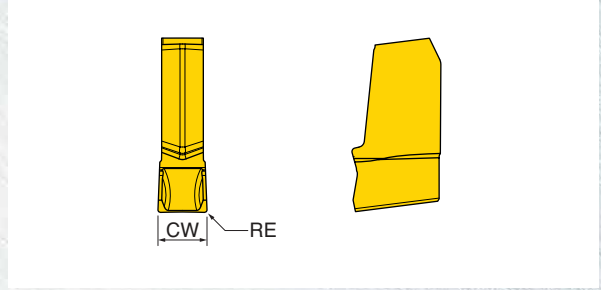
THIN SLITTER (.122 - .200 WIDTH)



| Part Number | DC Cutting Diameter | CWN Cutting Width Min. | CWX Cutting Width Max. | CDX Cutting Depth Max. | ZFPP Effective Teeth | ZNP Peripheral Insert Count | DHUB Hub Diameter | HHUB Hub Height | THUB Hub Thickness | DCON Bore Diameter | KWW Keyway | SSC Insert Seat Size | RPMX RPM Max. |
|----------------|---------------------|------------------------|------------------------|------------------------|----------------------|-----------------------------|-------------------|-----------------|--------------------|--------------------|------------|----------------------|---------------|
| TSC4.1221.000K | 4.000 | 0.122 | 0.161 | 1.08 | 6 | 6 | 1.81 | 0.390 | 0.874 | 1.000 | 0.25 | 4 | 780 |
| TSC4.1881.000K | 4.000 | 0.188 | 0.200 | 1.08 | 6 | 6 | 1.81 | 0.390 | 0.937 | 1.000 | 0.25 | 4 | 780 |
| TSC5.1221.250K | 5.000 | 0.122 | 0.161 | 1.40 | 8 | 8 | 2.17 | 0.390 | 0.874 | 1.250 | 0.31 | 4 | 630 |
| TSC6.1221.500K | 6.000 | 0.122 | 0.161 | 1.41 | 10 | 10 | 3.15 | 0.470 | 1.034 | 1.500 | 0.38 | 4 | 520 |
| TSC8.1221.500K | 8.000 | 0.122 | 0.161 | 2.41 | 14 | 14 | 3.15 | 0.470 | 1.034 | 1.500 | 0.38 | 4 | 390 |


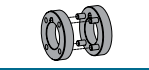
NOTE: Insert extractor supplied with each cutter. Hub-set ordered separately. Note maximum RPM ratings. Cutter width is dictated by insert width.

TOCLAMP^{ULTRA}™ INSERTS

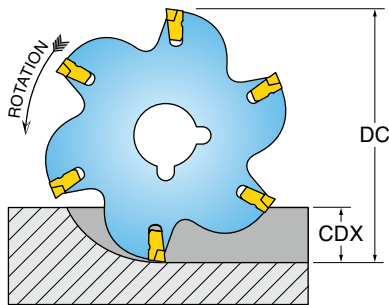


| Part Number | CW Cutting Width | RE Corner Radius | SSC Insert Seat Size | IH Insert Hand | Grade | TT6030 | TT8020 | TT9030 |
|-------------|---------------------|---------------------|-------------------------|-------------------|-------|--------|--------|--------|
| | | | | | | | | |
| TIMC1.6 | 0.063 | 0.006 | 1 | Neutral | • | • | • | |
| TIMC2 | 0.087 | 0.008 | 2 | Neutral | • | • | • | |
| TIMC2.4 | 0.094 | 0.008 | 2 | Neutral | • | • | • | |
| TIMC3 | 0.122 | 0.008 | 4 | Neutral | • | • | • | |
| TIMC4 | 0.161 | 0.010 | 4 | Neutral | • | • | • | |
| TIMC4.8 | 0.189 | 0.011 | 4 | Neutral | • | • | | |
| TIMC5 | 0.200 | 0.012 | 4 | Neutral | | | • | |

TOCLAMP^{ULTRA}™ HARDWARE

| Part Number |  |  |
|----------------|---|---|
| | Insert Extractor | Hub Set |
| TSC3.0631.000A | HZS.0012 | - |
| TSC3.0871.000A | HZS.0012 | - |
| TSC4.0631.000A | HZS.0012 | - |
| TSC4.1221.000K | HZS.0012 | FL-0002 |
| TSC4.1881.000K | DR-0031 | FL-0002 |
| TSC5.1221.250K | HZS.0012 | FL-0003 |
| TSC6.1221.500K | HZS.0012 | FL-0004 |
| TSC8.1221.500K | HZS.0012 | FL-0004 |

| Series TSC | | | | Feed per Insert by Width Range | | | | Grades | | | Coolant |
|-----------------|-------------------------------|-----------|-----------|--------------------------------|-----------|-----------|-----------|--------|--------|------------------------------------|---------|
| Material | Brinnell Hardness | SFM | 0.063 | .087-.094 | .122-.161 | .188-.200 | IN6030 | IN8020 | IN9030 | | |
| Aluminum | 6061-T6, 7075-T6, 2024 | - | 700 - 800 | .001-.004 | .002-.007 | .002-.008 | .003-.009 | 1 | | | Yes |
| Cast Iron | Gray | 150 - 250 | 300 - 600 | .001-.004 | .002-.006 | .002-.007 | .003-.008 | 1 | | 2 | No |
| | Nodular | | 250 - 500 | | | | | | | | |
| Steel | Low Carbon 1018, 8620 | 100 - 250 | 400 - 700 | .001-.004 | .002-.006 | .002-.007 | .003-.008 | | 1 | 2 | No |
| | High Carbon F-6180 | 250 - 400 | 300 - 600 | | | | | | | | |
| | Alloyed Steel 4140, 4340 | 150 - 300 | 300 - 500 | | | | | | | | |
| | Tool Steel A-6, D-1, D-2 | Up to 300 | | | | | | | | | |
| Stainless Steel | 300 Series, 304, 316 | - | 300 - 500 | .001-.004 | .002-.006 | .002-.006 | .003-.006 | 1 | 2 | May not be required at high speeds | |
| | 400 Series 15-5 PH | Up to 320 | 350 - 550 | | | | | | | | |
| | 13-8 PH | - | 200 - 400 | | | | | | | Yes | |
| Nickel Alloys | Inconel, Hastelloy, Waspalloy | - | 70-100 | .001-.003 | .002-.005 | .002-.005 | .002-.005 | | 2 | 1 | Yes |
| Titanium | 6AL-4V | - | 100 - 130 | .001-.003 | .002-.005 | .002-.005 | .002-.005 | | 1 | 2 | Yes |



For radial depths of cut (CDX) less than 1/4 of cutter diameter (DC), increase feed rates by the following %

| Depth of Cut (CDX) x Cutter Dia. (DC) | 1/4 | 1/6 | 1/8 | 1/10 | 1/20 |
|---------------------------------------|-----|-----|-----|------|------|
| Increase Feed Rate by | 0% | 15% | 30% | 45% | 100% |

Insert Loading Procedure

1. Be sure insert pockets are free of dirt prior to assembly.
2. Manually place insert into seat and tap into position using a plastic hammer.



Insert Removal Procedure

1. To remove inserts from the cutter body, first, place insert extractor into space behind the insert.
2. Turn the extractor 90° until the insert is dislodged from the pocket.
3. One extractor is provided with each cutter.



Cutter Mounting

When using drive flange-style cutter bodies, the use of a drive flange set is highly recommended to provide more bearing surface for the drive key. Without the drive flange set, the drive flange key or arbor may be damaged when the cutter is run at high speeds.

