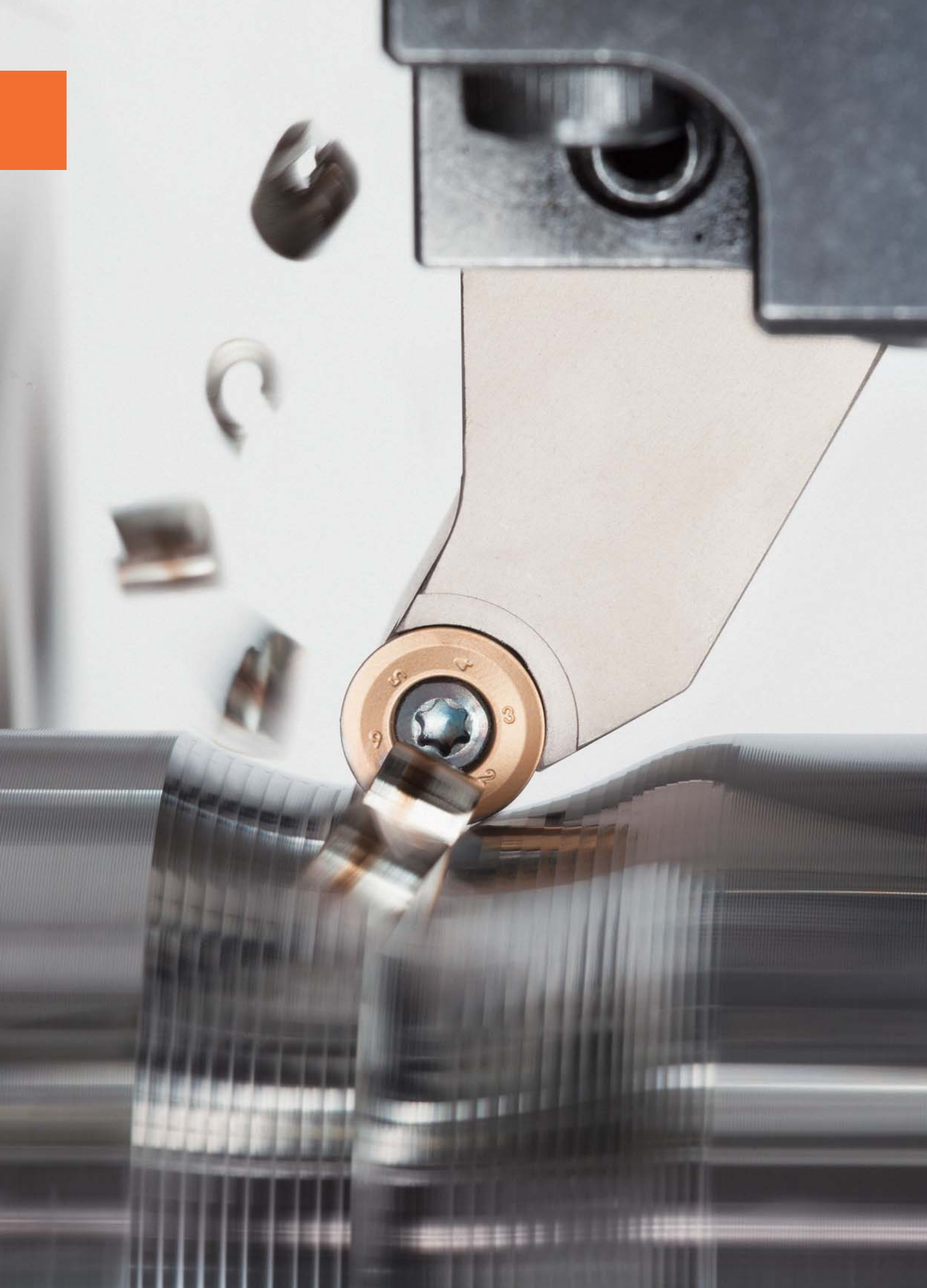


w w w . t u n g a l o y . c o m

**Round insert and
toolholder with the exact
indexing system**





FIX**R**TURN

TUNGALOY

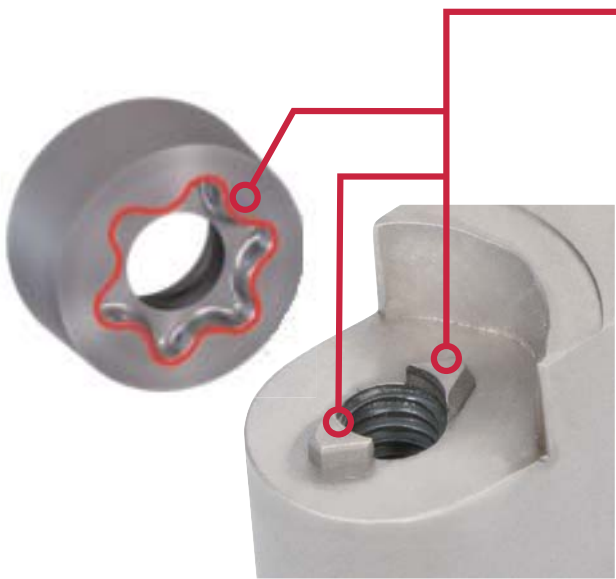
**High performance round insert
with 6-indexes**

Suitable for roughing operation for
medium to large size workpieces

FIXRTURN TUNGALOY

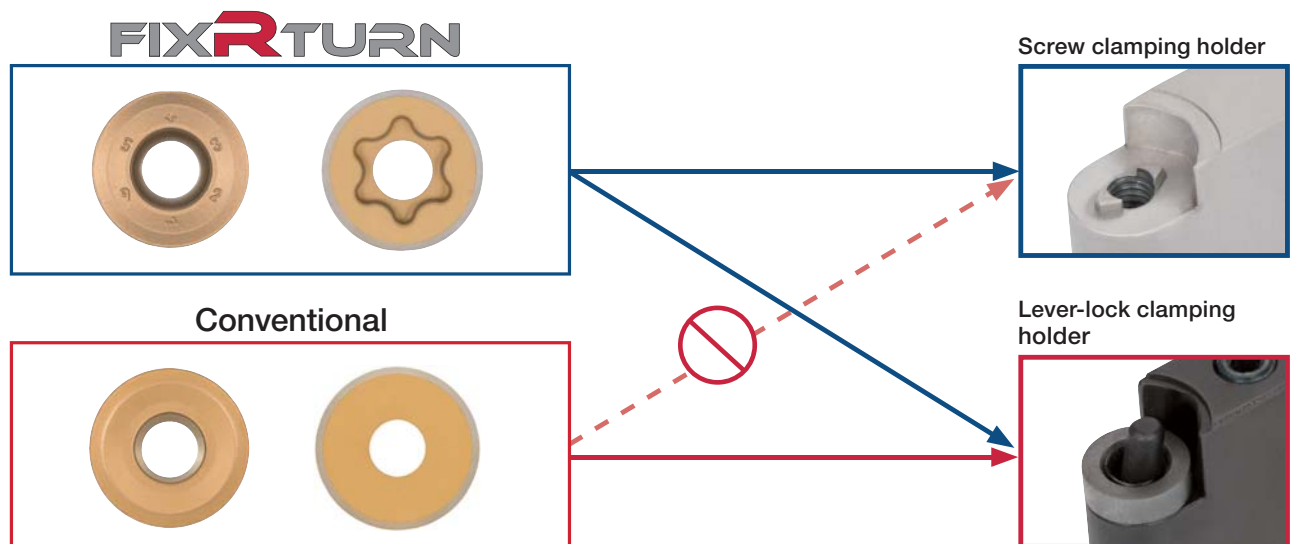
Round insert with exact 6-indexes* are available

*ap ≤ 2 mm



- The cavity on the insert's bottom and the protrusion on the toolholder guide indexing!
- Index without taking off the screw!
- Round insert is applicable for roughing at high feed!
Max. feed rate : $f = 1.0 \text{ mm/rev}$
($ap \leq 2 \text{ mm}$)
- FixRTurn provides the same cutting performance of the conventional toolholder and flat bottom inserts.
- Index numbers are shown on the insert's rake face

● Compatibility with conventional tools



Note: conventional insert with flat bottom is NOT applicable for FixRTurn toolholders.

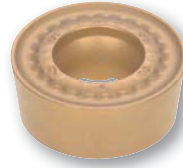
● Chipbreaker

6RM type



General purpose chipbreaker with toughness and sharpness

6RS type



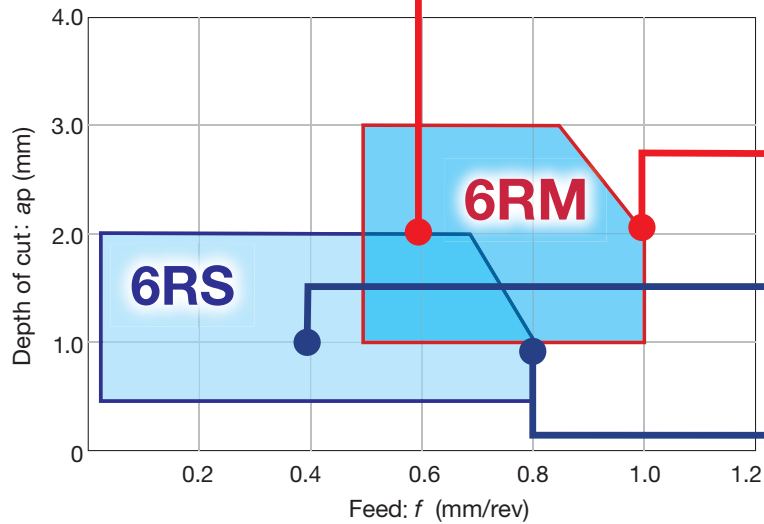
For lower cutting force with sharp cutting edge

● Application range



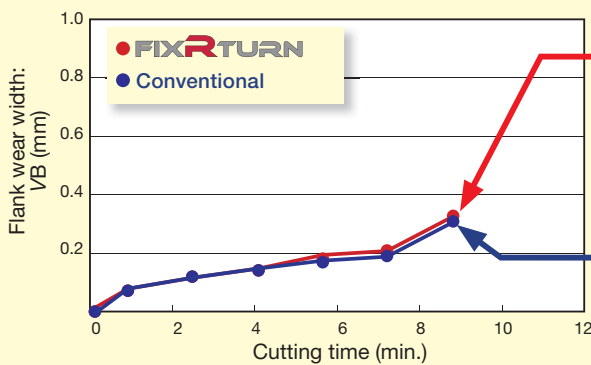
Workpiece-material : SCM440
 Cutting speed : $V_c = 250$ m/min
 Machining : External turning (continuous)
 Coolant : Wet

*For 6-index use, depth of cut should be under 2.0 mm.



● Cutting performance

■ Continuous machining



FIXRTURN



Conventional

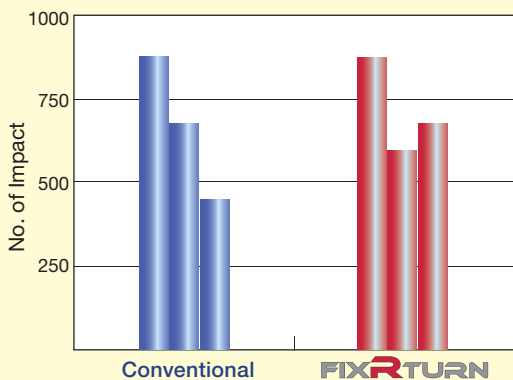


P Alloy steel
 SCM440 (290 ~ 310HB)

Insert : RCMT1204M0-6RM
 T9125
 Cutting speed : $V_c = 200$ m/min
 Feed : $f = 0.8$ mm/rev
 Depth of cut : $a_p = 2.0$ mm
 Coolant : Wet

The same level of wear resistance as that of the conventional product due to exact indexing.

■ Interrupted machining



FIXRTURN



Conventional



P Alloy steel
 SCM440 (290 ~ 310HB)

Insert : RCMT1204M0-6RM
 T9125
 Cutting speed : $V_c = 150$ m/min
 Feed : $f = 0.3$ mm/rev
 Depth of cut : $a_p = 2.0$ mm
 Coolant : Wet

Stable clamping rigidity even in interrupted cutting.

● Inserts

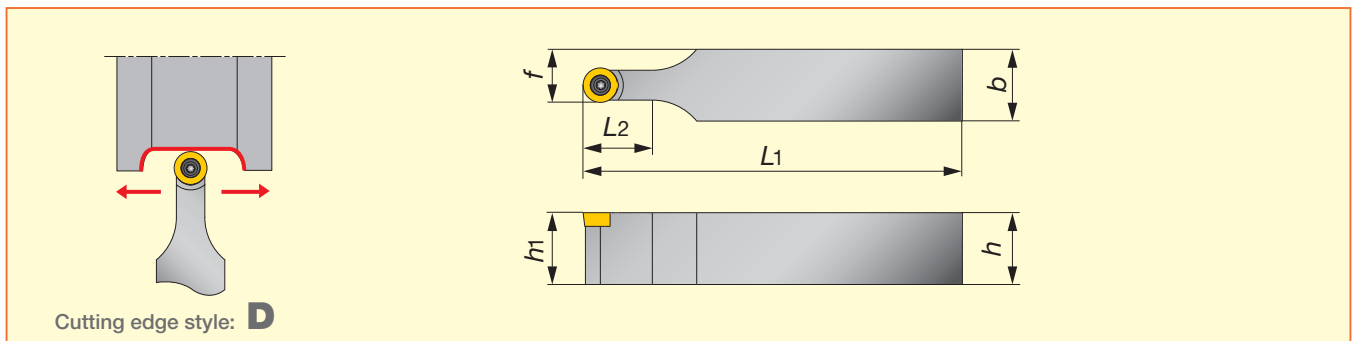
Chipbreaker				Grades				Dimensions (mm)			
Application	Appearance (Cross section)	$f - ap$	Cat. No	Coated		Cermet		I.C.dia ϕd	Thick- ness s	Hole dia ϕd_1	Corner radius $r\epsilon$
				T9115	T9125	NS9530					
Low cutting force	6RS		RCMT1204M0-6RS	●	●	●		12	4.76	5.16	-
General use	6RM		RCMT1204M0-6RM	●	●	●		12	4.76	5.16	-

● External toolholders

SRDCN

External turning and profiling

S-type (Positive rake, screw-on system)

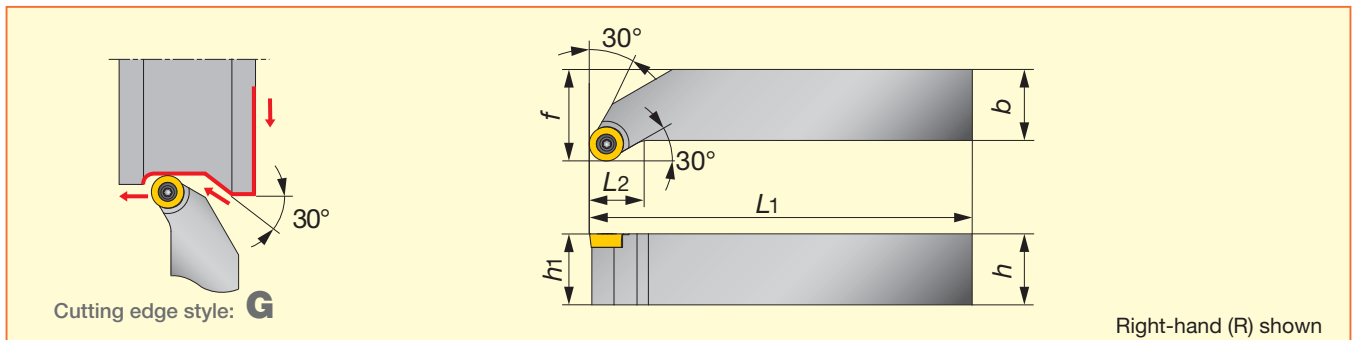


Cat. No	Stock	Dimensions (mm)							Insert	Parts			Torque (N·m)
		h	b	L_1	L_2	h_1	f	f_2		Screw	Screw lubricant	Key	
SRDCN2525M12-6F	●	25	25	150	24.1	25	18.5	-	RC*1204M0-6*	CSTB-4	M-1000	T-15F	3.0

SRGCR/L

External turning and profiling

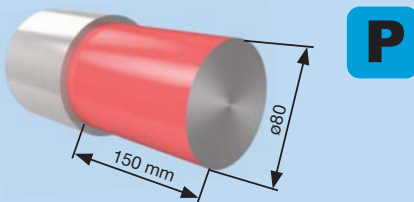

S-type (Positive rake, screw-on system)



Cat. No	Stock		Dimensions (mm)							Insert	Parts			Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	f_2		Screw	Screw lubricant	Key	
SRGCR/L2525M12-6F	●	●	25	25	150	18.6	25	32	-	RC*1204M0-6*	CSTB-4	M-1000	T-15F	3.0

● : Stocked items

● Practical examples

Workpiece type		Cylinder
Toolholder		SRGCL2525M12-6F
Insert		RCMT1204M0-6RM
Grade		T9115
Workpiece material		SCM435 / 34CrMo4
		
Cutting conditions	Cutting speed: V_c (m/min)	200
	Feed: f (mm/rev)	1.0
	Depth of cut: a_p (mm)	1.0
	Machining	External turning (continuous)
	Coolant	Wet
Results		 <p>FixRTurn allows easy indexing and also delivers excellent chip control !!</p>



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Dec. 2015 (TJ)