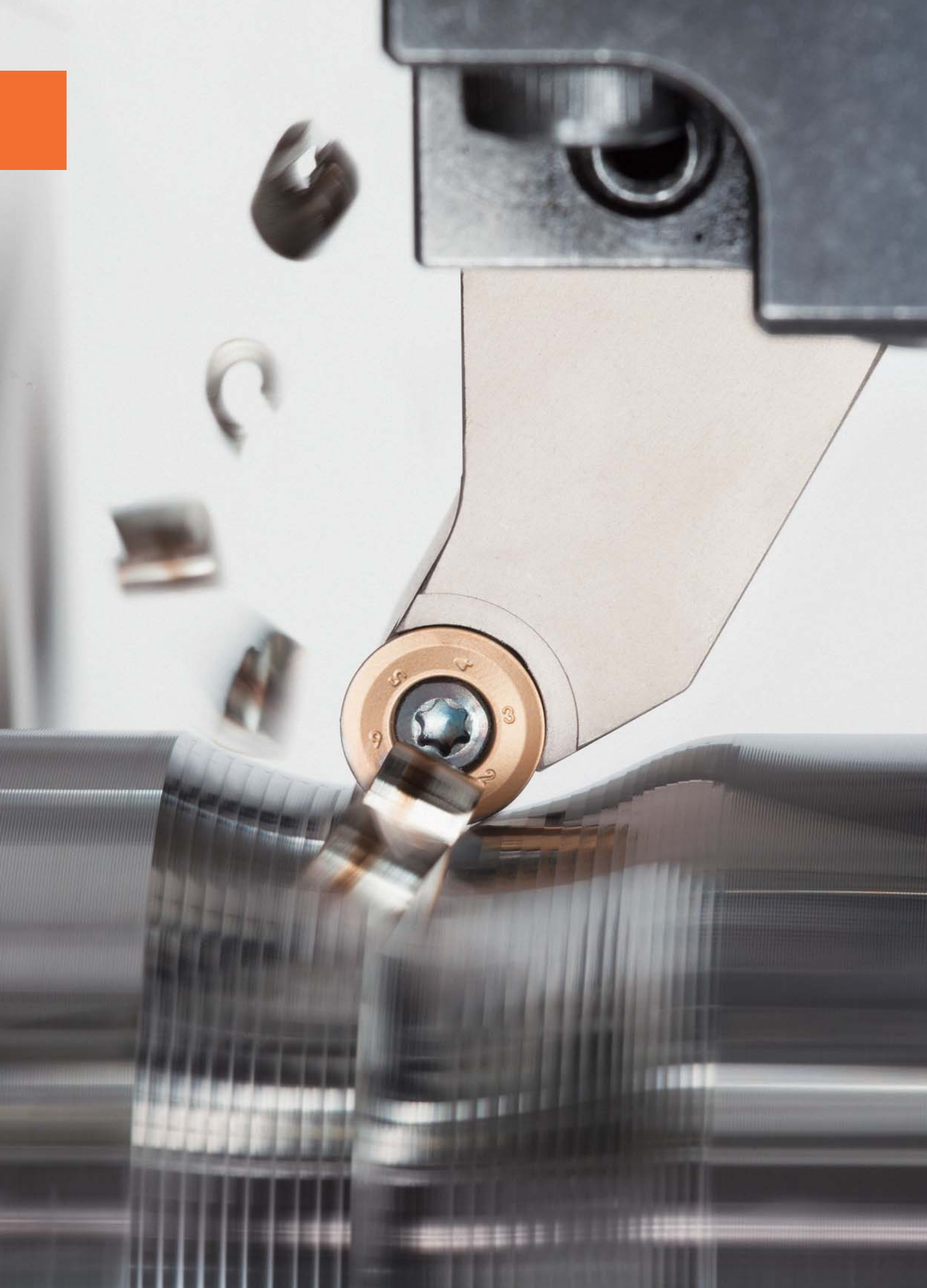


w w w . t u n g a l o y . c o m

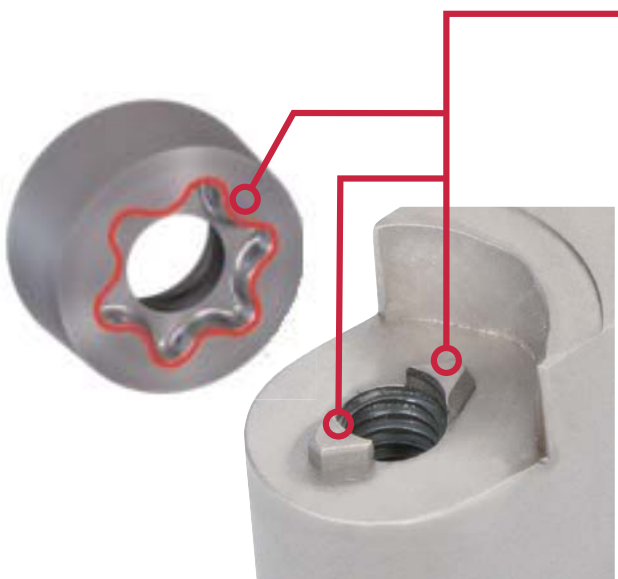
Новая серия круглых пластин и державок с точной фиксацией.



FIXRTURN TUNGALOY

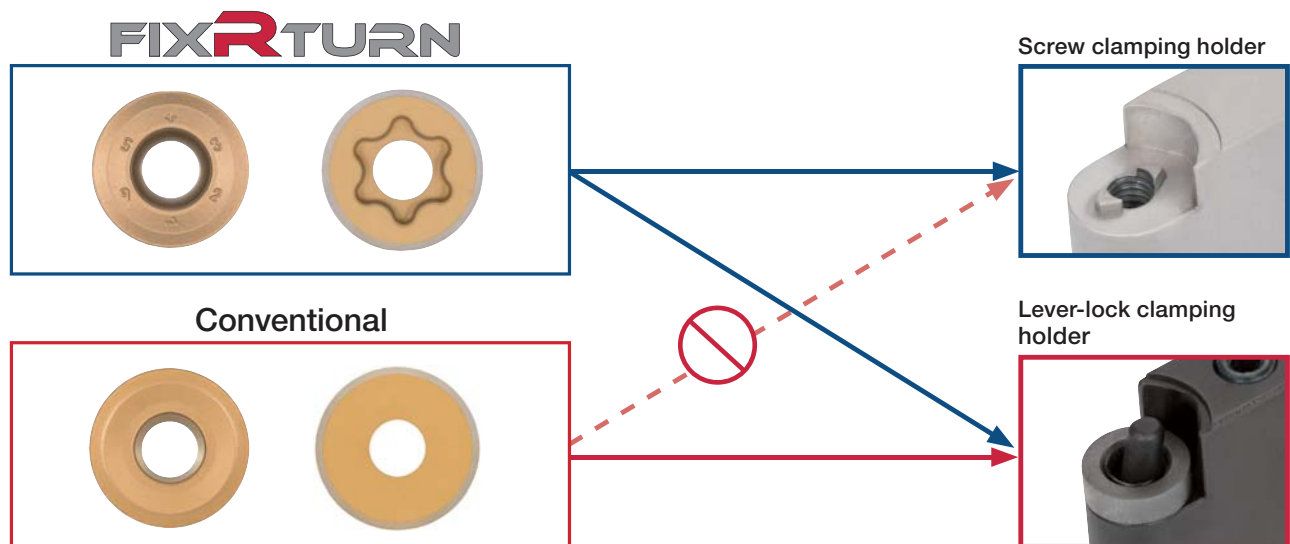
* доступны круглые пластины с точной фиксацией в 6 положениях.

* $a_p \leq 2$ мм.



- Выемка на нижней поверхности пластины и приливы на державке.
- Повернуть пластину можно без снятия винта!
- Круглая пластина применима для черновой обработки на высокой подаче!
Макс. подача : $f = 1.0$ мм/об.
 $a_p \leq 2$ мм.)
- 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.

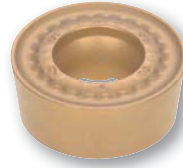
● Chipbreaker

6RM type



General purpose chipbreaker with toughness and sharpness

6RS type



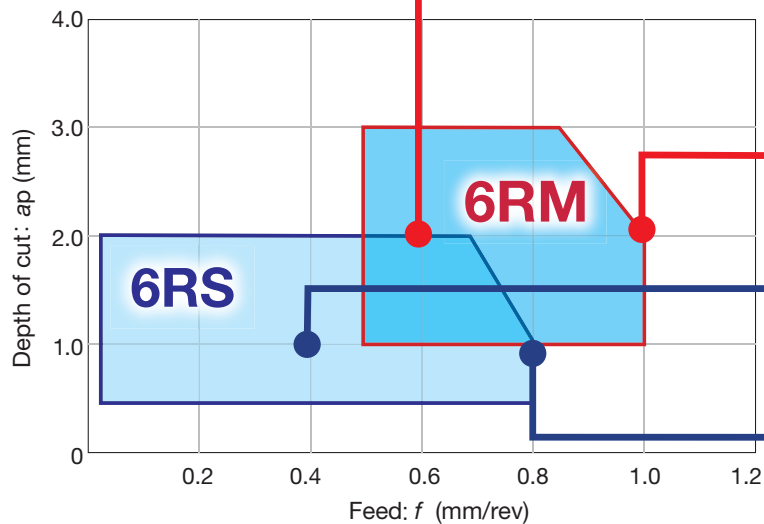
For lower cutting force with sharp cutting edge

● Application range



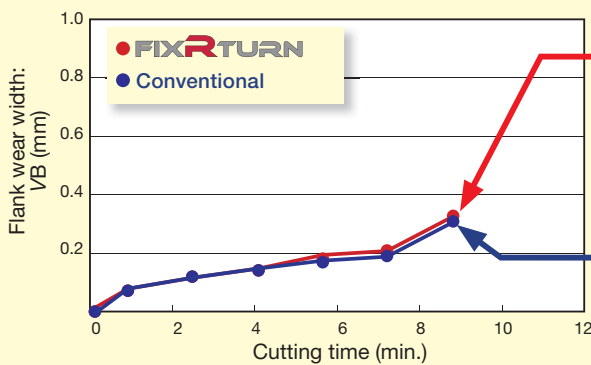
Workpiece-material : SCM440
 Cutting speed : $V_c = 250$ m/min
 Machining : External turning (continuous)
 Coolant : Wet

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



● Cutting performance

■ Continuous machining



FIXRTURN



Conventional

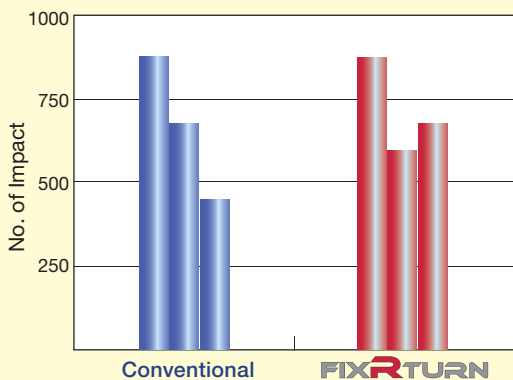


P Alloy steel
 SCM440 (290 ~ 310HB)

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

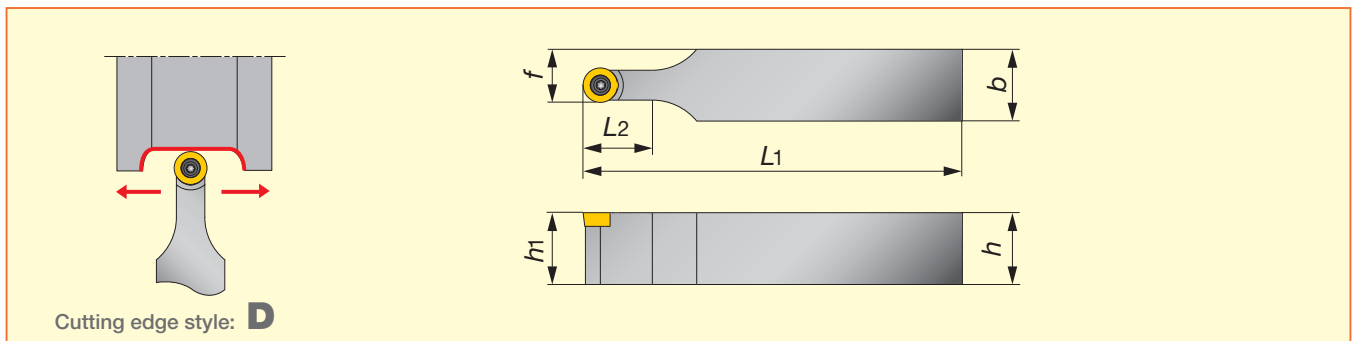
| Chipbreaker | | | Grades | | | | Dimensions (mm) | | | | |
|-------------------------|-------------------------------|----------|-----------------------|--------|-------|--------|-----------------|----------------------------|-----------------------|----------------------------------|---------------------------------|
| Application | Appearance (Cross section) | $f - ap$ | Cat. No | Coated | | Cermet | | I.C.dia $\varnothing d$ | Thick- ness s | Hole dia $\varnothing d_1$ | 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)

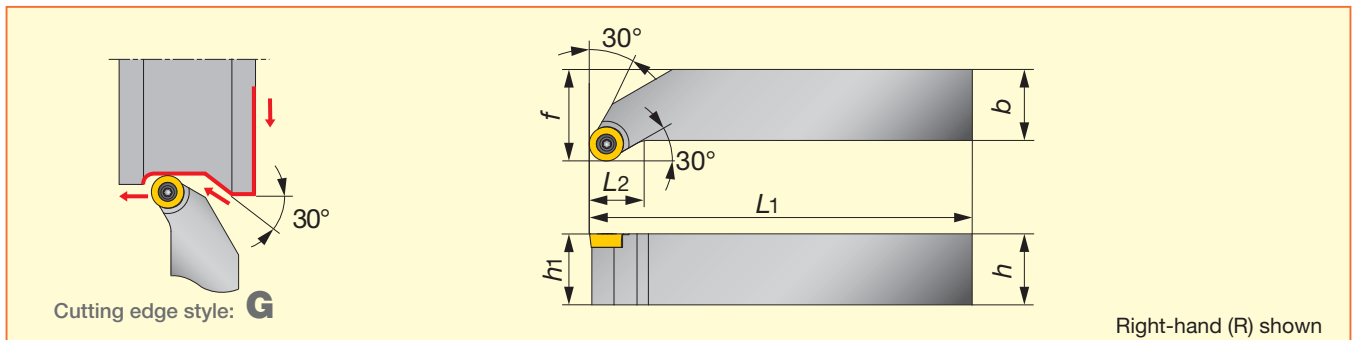


| Cat. No | Stock | Dimensions (mm) | | | | | | | Insert | Parts | | | Torque (N·m) |
|------------------------|-------|-----------------|-----|-------|-------|-------|------|-------|--------------|--------|--------------------|-------|-----------------|
| | | h | b | L_1 | L_2 | h_1 | f | f_2 | | Screw | 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

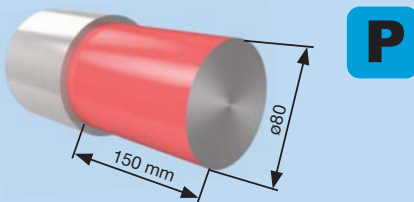

S-type (Positive rake, screw-on system)



| 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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