

NEW PRODUCT NEWS

T-TURN



RA Chip Breaker for Positive Insert with Round Shape

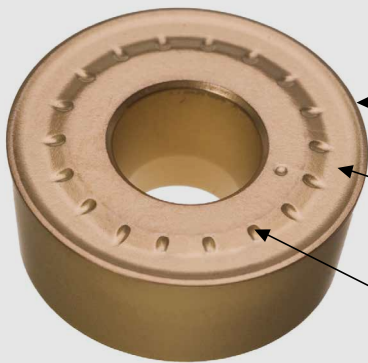


T-TURN

RA chip breaker for positive insert with round shape

FEATURES

- Improved stability and machining through real negative and positive cutting edges on the rake angle
- Increased tool life by minimizing cutting resistance with optimized chip groove geometry
- Excellent tool life due to superior cutting edges minimizing heat generation during machining
- Superior chip control is applicable to extensive application range



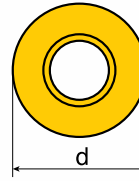
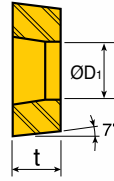
- **Excellent chip control**
 - Wide chip control range in low feed conditions and D.O.C
- **Strong cutting edge with wide land**
 - Suitable for heavy and interrupted machining
- **Optimized chip groove geometry**
 - Broad chip control range
 - No damage due to long chip evacuation
- **Heat radiation**
 - Chip breaking while preventing adhesion
 - Special dimple helps heat radiation

TaeguTec is introducing a new RA chip breaker for heavy rough machining of large sized parts.


RA chip breaker inserts maximize tool life due to decreased cutting forces enabling excellent chip breaking while stable edge structures make for easier rough and semi-machining processing. RA chip breaker is now available in RCMX type guaranteeing excellent tool life and chip breaking under high and low cutting conditions.

Insert

| Designation | d | t | ØD ₁ |
|-------------|------|------|-----------------|
| RCMX 100300 | 10.0 | 3.18 | 3.61 |
| RCMX 120400 | 12.0 | 4.76 | 4.19 |
| RCMX 160600 | 16.0 | 6.35 | 5.21 |
| RCMX 200600 | 20.0 | 6.35 | 6.20 |
| RCMX 250700 | 25.0 | 7.94 | 7.18 |
| RCMX 320900 | 32.0 | 9.52 | 9.50 |



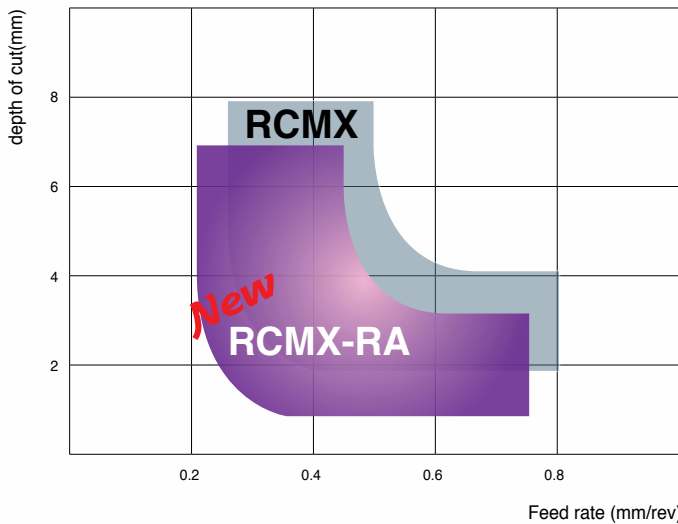
- P** Carbon steel C: 0.45%
- M** Austenitic stainless steel
- K** High tensile cast iron
- N** Aluminum
- S** Inconel
- H** Hardened steel

| Insert | Designation | Recommended machining conditions | | Grade & Vc (m/min) | | | | | | | | | | | | | | | | | | | |
|---|-----------------------|----------------------------------|------------|--------------------|--------|------------|--------|--------|--------|--------|--------|--------|--------|------------|--------|----------|--------|--------|--------|-----|-----|-----|--|
| | | feed (mm/rev) | ap (mm) | Cermet | | CVD coated | | | | | | | | PVD coated | | Uncoated | | | | | | | |
| | | | | PV3010 | CT3000 | TT1300 | TT7310 | TT8115 | TT8125 | TT8135 | TT9215 | TT9225 | TT9235 | TT5100 | TT7100 | TT5080 | TT8020 | TT9020 | TT9080 | P20 | K10 | K20 | |
|  | RCMX 100300 RA | 0.20 - 0.50 | 1.0 - 4.0 | | | | | • | • | • | | | | | | | | | | | | | |
| | 120400 RA | 0.25 - 0.60 | 2.0 - 5.0 | | | | | • | • | • | | | | | | | | | | | | | |
| | 160600 RA | 0.35 - 0.75 | 2.5 - 7.0 | | | | | • | • | • | | | | | | | | | | | | | |
| | 200600 RA | 0.40 - 0.90 | 3.0 - 9.0 | | | | | • | • | • | | | | | | | | | | | | | |
| | 250700 RA | 0.50 - 1.20 | 3.5 - 12.0 | | | | | • | • | • | | | | | | | | | | | | | |
| | 320900 RA | 0.60 - 1.50 | 4.0 - 15.0 | | | | | • | • | • | | | | | | | | | | | | | |

• Non-standard grades are special order items.

• Marked: Standard Items

Chip control range



- Insert: RCMX 160600 RA
- Cutting speed: 100 m/min
- Material: 0.45% Carbon steel