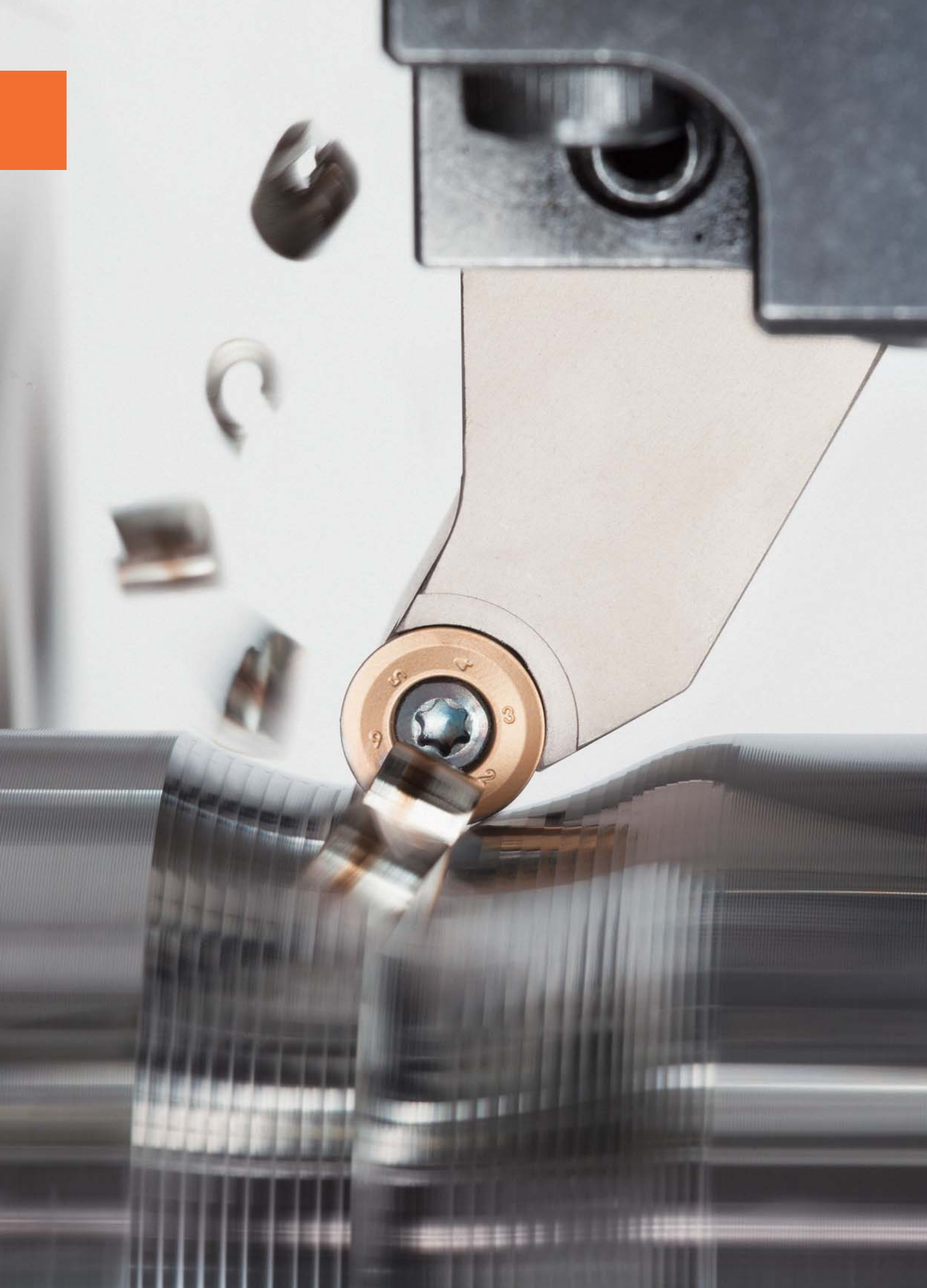


w w w . t u n g a l o y . c o m

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





FIX**R**TURN

TUNGALOY

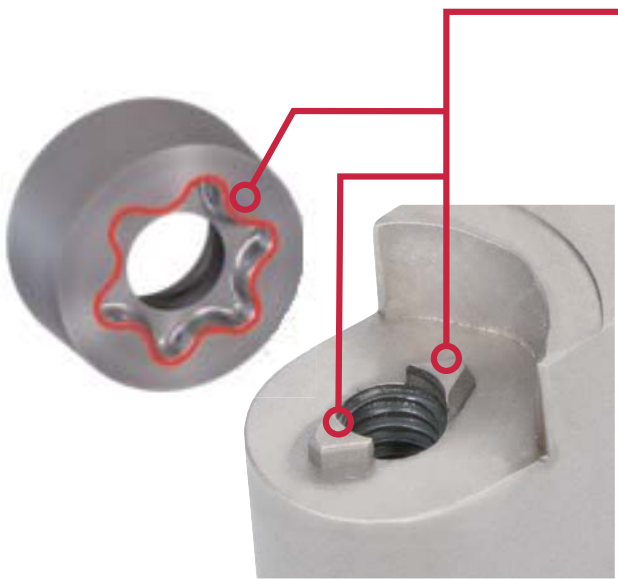
**Highly productive round insert
with 6 indexes**

Suitable for roughing operations of
medium to large workpieces

FIXRTURN TUNGALOY

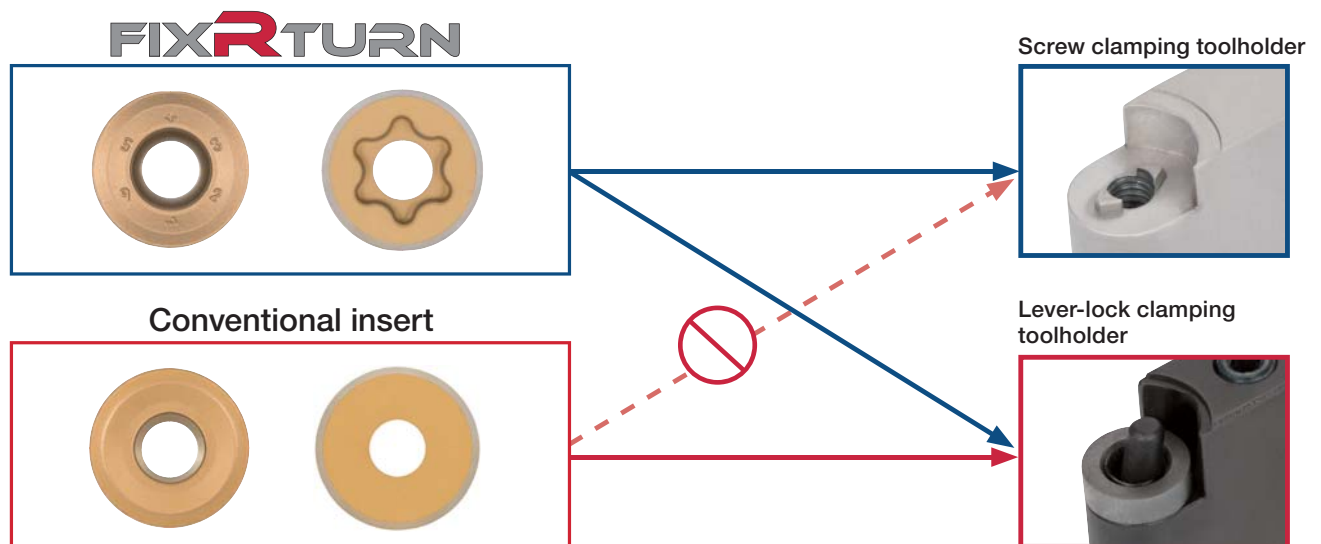
Round insert that guarantees the use of all 6 indexes*

*in case of $ap \leq 2$ mm



- The cavity on the insert's bottom and the protrusion on the toolholder enable exact indexing!
- Index is possible without taking off the screw!
- Round insert is applicable for roughing at high feed!
Max. feed rate : $f = 1.0$ mm/rev
($ap \leq 2$ mm)
- Cutting performance is equal to that of the conventional tool with flat interface between the toolholder and the insert.
- Index numbers are shown on the rake face.

● Compatibility with conventional tools



Note: The conventional inserts with flat bottom are NOT applicable for FixRTurn toolholders.

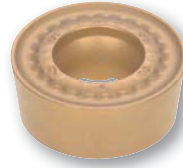
● Chipbreakers

6RM type



Tough and sharp cutting edge for general use

6RS type



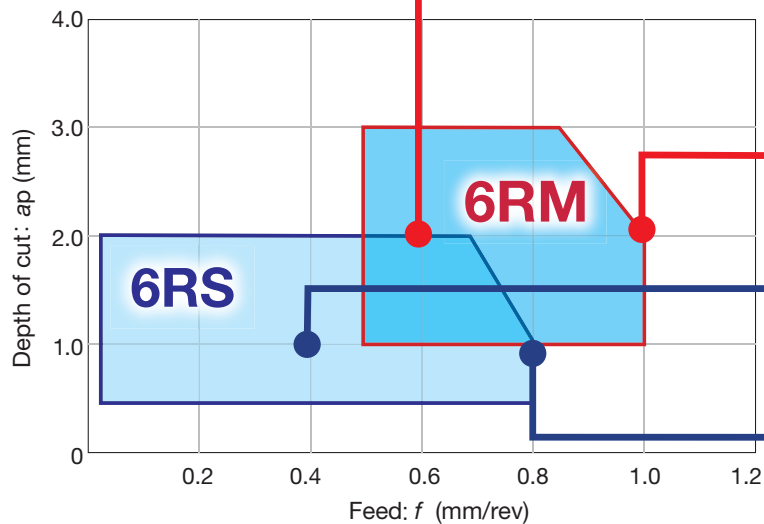
Sharp cutting edge for low cutting force

● Application range

P

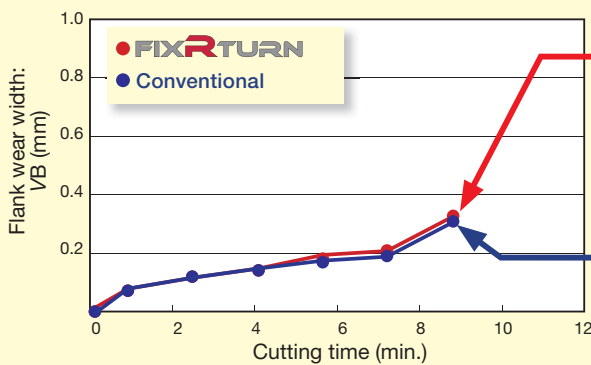
Workpiece material : SCM440
Cutting speed : $V_c = 250$ m/min
Machining : External turning (continuous)
Coolant : Wet

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



● Cutting performance

■ Continuous machining



FIXRTURN



Conventional

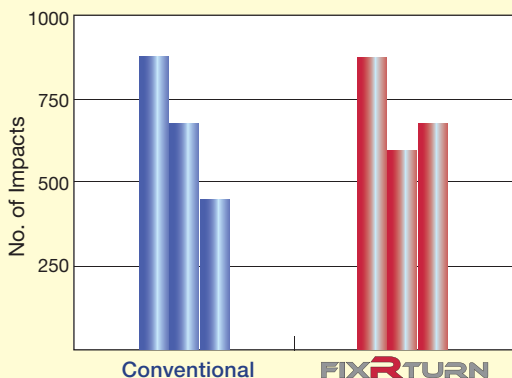


P Alloy steel
SCM440 (290 ~ 310HB)

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

Wear resistance is as high as that of the conventional tool.

■ 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

Highly rigid clamping even in interrupted machining

● Inserts

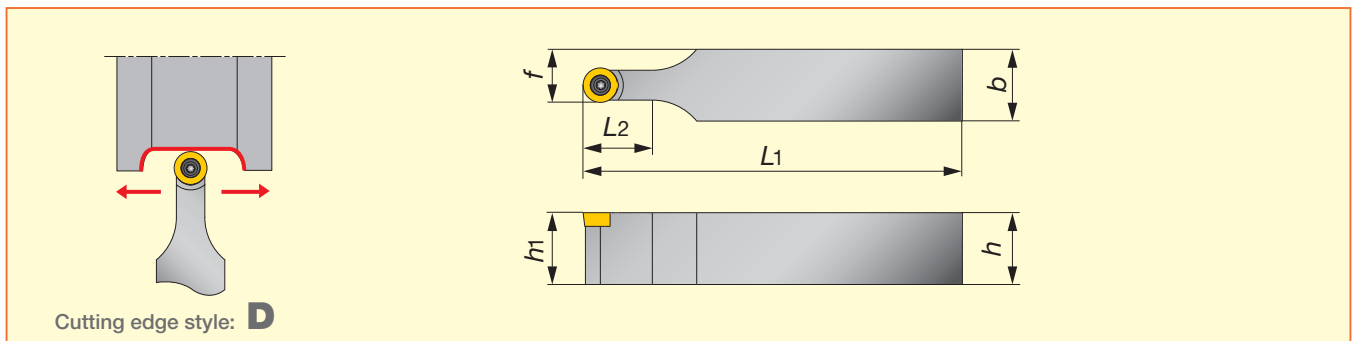
Chipbreaker				Grades				Dimensions (mm)			
Application	Appearance (Cross section)	$f - a_p$	Cat. No	Coated		Cermet		I.C.dia ϕd	Thick- ness s	Hole dia ϕd_1	Corner radius $r\epsilon$
				T9115	T9125	NS9530					
Low cutting force	6RS		RCMT1204M0-6RS	●	●	●		12	4.76	5.16	-
General use	6RM		RCMT1204M0-6RM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

● External toolholders

SRDCN

External turning and profiling

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

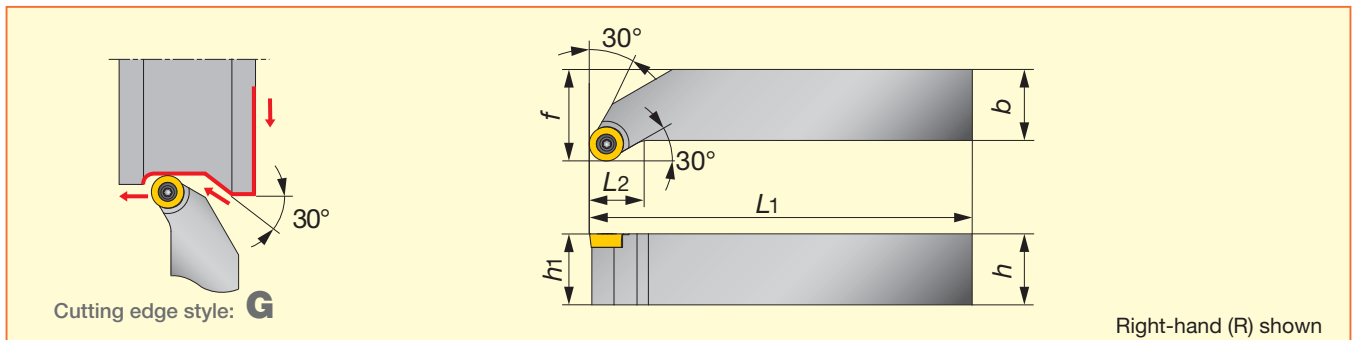


Cat. No	Stock	Dimensions (mm)						Insert	Parts			Torque (N·m)	
		h	b	L_1	L_2	h_1	f		f_2	Screw	Screw lubricant		Key
SRDCN2525M12-6F	●	25	25	150	24.1	25	18.5	-	RC*1204M0-6*	CSTB-4	M-1000	T-15F	3.0

SRGCR/L

External turning and profiling

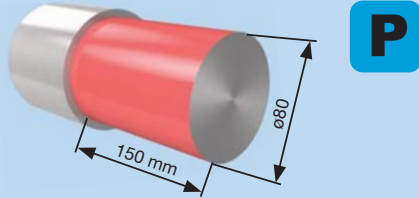

S-type (Positive rake, screw-on system)



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 all 6 indexes to be used by its easy indexing system and also delivers excellent chip control!</p>	



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