Ingersoll is introducing a new RA chipbreaker for heavy rough machining of large sized parts. RA chipbreaker 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 chipbreaker is now available in RCMX type guaranteeing excellent tool life and chip breaking under high and low cutting conditions.

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
RCMX RA

CHIP CONTROL RANGE

- Insert: RCMX 160600 RA
- Cutting speed: 325 sfm
- Material: 0.45% Carbon steel
## TEST REPORT

### Test 1
- **Part name**: Main Shaft
- **Material**: Alloy steel
- **Cutting speed (Vc)**: 590 sfm
- **Feed (f)**: .008 ipr
- **Depth of cut (ap)**: .120"
- **Operation**: External Turning
- **Tool life**: Improved chip control
- **Competitor**: Competitor A, 3.5pcs/edge
- **Ingersoll**: RCMX 250700 RA, TT8115, 4pcs/edge

### Test 2
- **Part name**: Crank Throw
- **Material**: Alloy steel
- **Cutting speed (Vc)**: 230-395 sfm
- **Feed (f)**: .020 ipr
- **Depth of cut (ap)**: .200"
- **Operation**: External Turning
- **Tool life**: Improved chip control
- **Competitor**: Competitor B, .6pcs/edge
- **Ingersoll**: RCMX 250700 RA, TT8135, 1.0pcs/edge

### Test 3
- **Part name**: Shaft
- **Material**: Alloy Steel
- **Cutting speed (Vc)**: 525 sfm
- **Feed (f)**: .024 ofr
- **Depth of cut (ap)**: .040"
- **Operation**: External Turning
- **Tool life**: Improved chip control
- **Competitor**: Competitor C, 3pcs/edge
- **Ingersoll**: RCMX 160600 RA, TT8115, 10pcs/edge

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**Availability**
In stock

**Price**
Available in the GAL system

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