T-TURN™

RA CHIPBREAKER

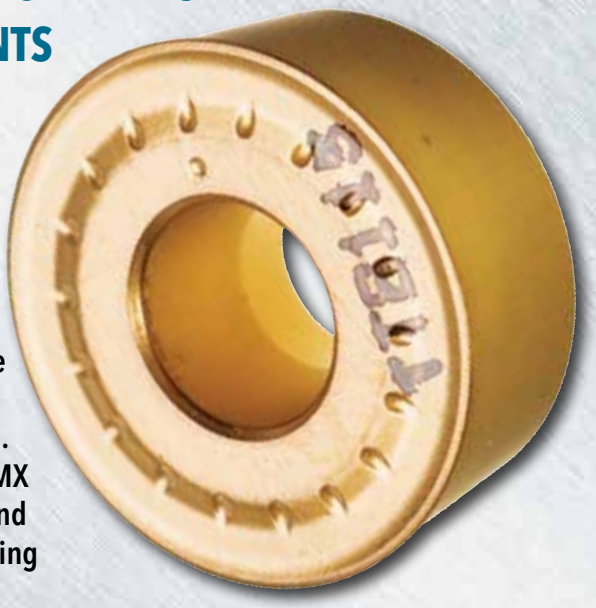
FOR ROUGH MACHINING OF MEDIUM AND LARGE SIZED COMPONENTS

Insert Style:
RCMX

Grades:
TT8115
TT8125
TT8135

Feed Rates:
.008~.059 ipr

Cutting Depths:
.039~.591 inches

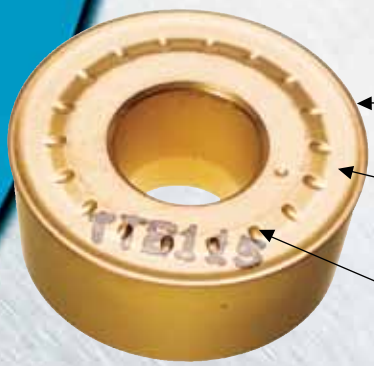


Ingersoll is introducing a new RA chipbreaker for heavy rough machining of large sized parts.

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

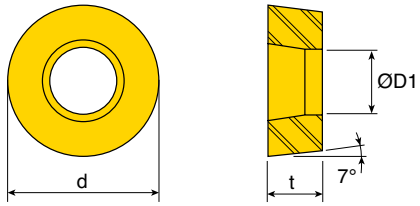
OPTIMIZED CHIP GROOVE GEOMETRY
√ Broad chip control range
√ No damage due to long chip evacuation

HEAT RADIATION
√ Chip breaking while preventing adhesion
√ Special dimple helps heat radiation

Member IMC Group
Ingersoll Cutting Tools

TOTURN™

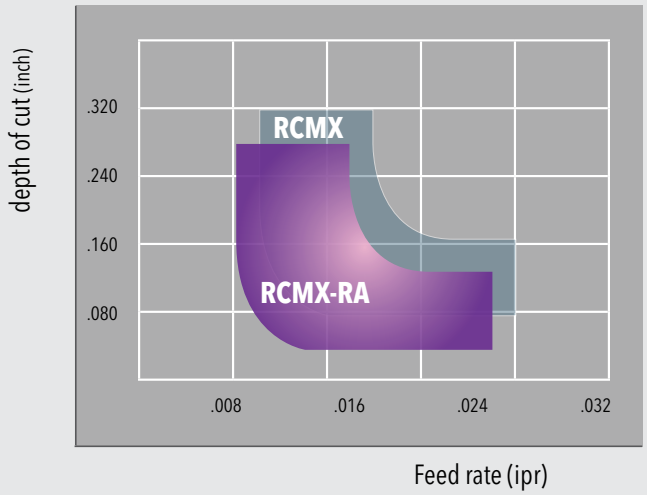
RCMX RA



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Dimensions (inch)			Grade	TT8115	TT8125	TT8135
				d	t	D1				
RCMX100300RA	RCMX100300RA	0.008 - 0.020	0.039 - 0.157	0.394	0.125	0.142		●	●	●
RCMX120400RA	RCMX120400RA	0.010 - 0.024	0.079 - 0.197	0.472	0.187	0.165		●	●	●
RCMX160600RA	RCMX160600RA	0.014 - 0.030	0.098 - 0.276	0.630	0.250	0.205		●	●	●
RCMX200600RA	RCMX200600RA	0.016 - 0.035	0.118 - 0.354	0.787	0.250	0.256		●	●	●
RCMX250700RA	RCMX250700RA	0.020 - 0.047	0.138 - 0.472	0.984	0.312	0.283		●	●	●
RCMX320900RA	RCMX320900RA	0.024 - 0.059	0.157 - 0.591	1.260	0.375	0.374		●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

CHIP CONTROL RANGE



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

TOTURN™

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

Tool life UP 14%

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

Tool life UP 66%

Test 3		
Part name	Shaft	
Material	Alloy Steel	
Cutting speed (Vc)	525 sfm	
Feed (f)	.024 o[r	
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

Tool life UP 233%

Availability
In stock

Price
Available in the GAL system