T-TURN™

RX CHIPBREAKER

FOR ROUGH MACHINING OF LARGE PARTS

Insert Styles:
CNMM
TNMM
SNMM

Grades:
TT8115
TT8125
TT8135

Feed Rates:
.008~.047 ipr

Cutting Depths:
.028~.472 inches

Applications:
Rough machining of medium to large parts.

Now available from Ingersoll, the "RX" chipbreaker designed for rough machining of medium to large sized components. For rough machining, the RX chipbreaker inserts offer reduced cutting force and maximized tool life due to its excellent chip control and inclined cutting edge geometry. The RX chipbreaker is available in CNMM, TNMM and SNMM shapes that guarantee outstanding tool life and chip breaking when operating at both high and low feed rates.

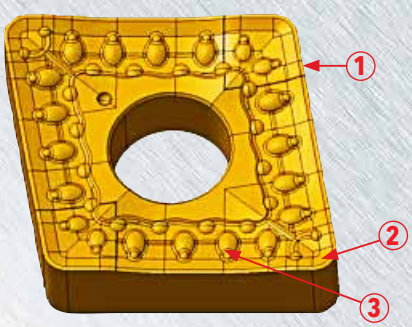
FEATURES

① Ideal cutting edge: increases tool life by minimizing cutting resistance

② Rounded protuberance: ensures outstanding chip control under various cutting conditions

③ Double protuberance: prevents initial wear and dissipates heat from the insert

④ Extensive applications: applicable to a broad range of workpieces



Member IMC Group
Ingersoll Cutting Tools

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FIELD TEST RESULTS

TEST 1	
Component	Slewing Bearing
Material	0.48% Carbon Steel
Cutting Speed(Vc)	395 sfm
Feed rate(f)	.024 ipr
Depth of cut(ap)	.275"~.355"
Operation	Face and external
TOOL LIFE	
Competitors	6.5 pcs/edge
Ingersoll	CNMM 644 RX, TT8125 7 pcs/edge

Tool life UP ↑ 7%

TEST 2	
Component	Shaft
Material	Alloy steel
Cutting Speed(Vc)	650 sfm
Feed rate(f)	.031 ipr
Depth of cut(ap)	.275"
Operation	External
TOOL LIFE	
Competitors	4 pcs/edge
Ingersoll	CNMM 644 RX, TT8115 6 pcs/edge

Tool life UP ↑ 50%

TEST 3	
Component	Shaft
Material	Alloy steel
Cutting Speed(Vc)	460 sfm
Feed rate(f)	.031 ipr
Depth of cut(ap)	.315"~.395"
Operation	External
TOOL LIFE	
Competitors	4 pcs/edge
Ingersoll	CNMM 646 RX, TT8115 8 pcs/edge

Tool life UP ↑ 100%

TEST 4	
Component	Shaft
Material	Alloy steel
Cutting Speed(Vc)	650 sfm
Feed rate(f)	.031 ipr
Depth of cut(ap)	.236"
Operation	External
TOOL LIFE	
Competitors	10 pcs/edge
Ingersoll	CNMM 546 RX, TT8115 22 pcs/edge

Tool life UP ↑ 120%

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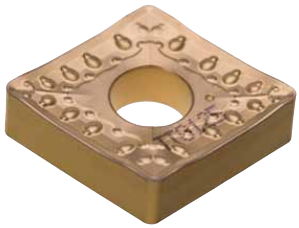
CNMM RX



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT8115	TT8125	TT8135
CNMM432RX	CNMM120408RX	.016 (0.008 - 0.022)	.197 (0.028 - 0.276)		●	●	●
CNMM433RX	CNMM120412RX	.020 (0.010 - 0.028)	.197 (0.039 - 0.276)		●	●	●
CNMM543RX	CNMM160612RX	.020 (0.010 - 0.028)	.236 (0.039 - 0.354)		●	●	●
CNMM544RX	CNMM160616RX	.022 (0.012 - 0.035)	.236 (0.059 - 0.354)		●	●	●
CNMM546RX	CNMM160624RX	.022 (0.014 - 0.047)	.236 (0.079 - 0.354)		●	●	●
CNMM642RX	CNMM190608RX	.016 (0.008 - 0.022)	.276 (0.028 - 0.394)		●	●	●
CNMM643RX	CNMM190612RX	.020 (0.010 - 0.028)	.276 (0.039 - 0.394)		●	●	●
CNMM644RX	CNMM190616RX	.022 (0.012 - 0.035)	.276 (0.059 - 0.394)		●	●	●
CNMM646RX	CNMM190624RX	.022 (0.014 - 0.043)	.276 (0.079 - 0.394)		●	●	●
CNMM856RX	CNMM250724RX	.022 (0.014 - 0.047)	.335 (0.079 - 0.472)		●	●	●
CNMM866RX	CNMM250924RX	.022 (0.014 - 0.047)	.335 (0.079 - 0.472)		●	●	●

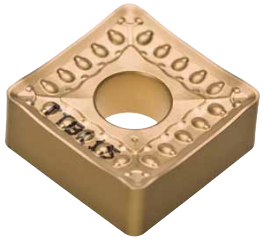
● = P ● = M ● = K ● = N ● = S ○ = H

TNMM RX

ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT8115	TT8125	TT8135
TNMM332RX	TNMM160408RX	.016 (0.008 - 0.022)	.157 (0.028 - 0.236)		●	●	●
TNMM333RX	TNMM160412RX	.020 (0.010 - 0.028)	.157 (0.039 - 0.276)		●	●	●
TNMM432RX	TNMM220408RX	.016 (0.008 - 0.022)	.197 (0.028 - 0.295)		●	●	●
TNMM433RX	TNMM220412RX	.020 (0.010 - 0.028)	.197 (0.039 - 0.295)		●	●	●
TNMM434RX	TNMM220416RX	.022 (0.012 - 0.035)	.197 (0.059 - 0.295)		●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

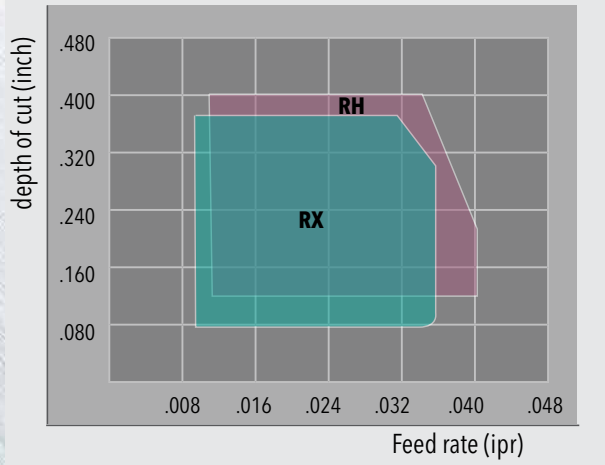
SNMM RX



ANSI Number	ISO Number	feed (ipr)	DOC (inch)	Grade	TT8115	TT8125	TT8135
SNMM432RX	SNMM120408RX	.016 (0.008 - 0.022)	.197 (0.028 - 0.276)		●	●	●
SNMM433RX	SNMM120412RX	.020 (0.010 - 0.028)	.197 (0.039 - 0.276)		●	●	●
SNMM543RX	SNMM150612RX	.020 (0.010 - 0.028)	.236 (0.039 - 0.354)		●	●	●
SNMM643RX	SNMM190612RX	.020 (0.010 - 0.028)	.276 (0.039 - 0.394)		●	●	●
SNMM644RX	SNMM190616RX	.022 (0.012 - 0.035)	.276 (0.059 - 0.394)		●	●	●
SNMM646RX	SNMM190624RX	.022 (0.014 - 0.043)	.276 (0.079 - 0.394)		●	●	●
SNMM856RX	SNMM250724RX	.022 (0.014 - 0.047)	.335 (0.079 - 0.472)		●	●	●
SNMM866RX	SNMM250924RX	.022 (0.014 - 0.047)	.335 (0.079 - 0.472)		●	●	●

● = P ● = M ● = K ● = N ● = S ○ = H

CHIP CONTROL RANGE



- Insert : CNMM 644 RX
- Cutting speed(Vc): 325 sfm
- Material: 0.45% Carbon steel

Availability
In stock

Price
Available in the GAL system