

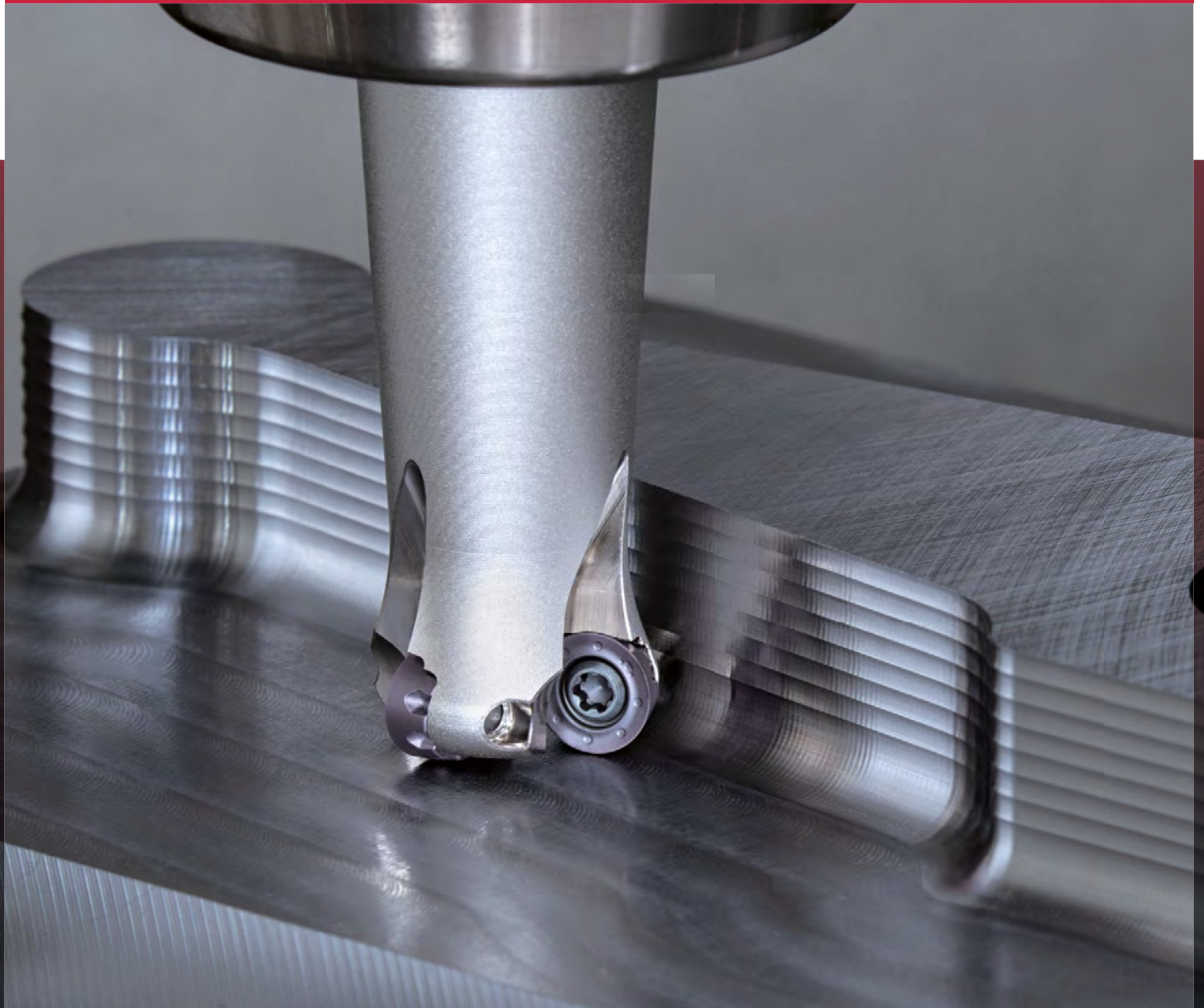


Profile milling cutter

FIXRMILL

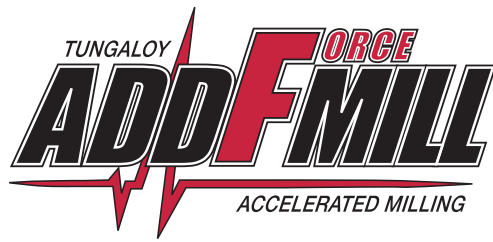
Tungaloy Report No. 418-G

Now offering $\varnothing 20$ and $\varnothing 25$ mm cutter bodies for size R5 inserts





MO63B22. ORG



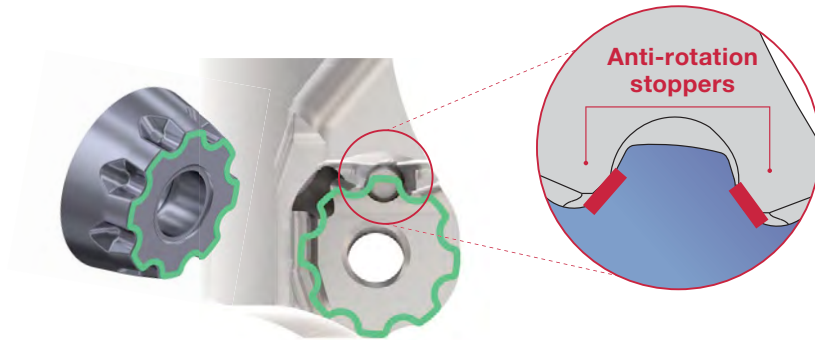
FIXRMILL



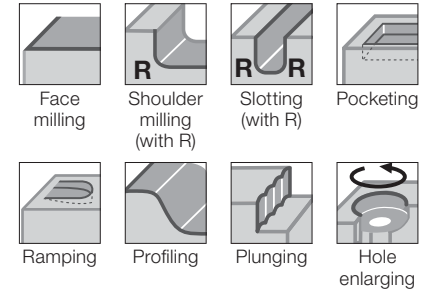
Upgraded FixRMill round insert copy mill with
unique anti-rotation system

■ Accurate and secure clamping

- The anti-rotation system securely keeps the inserts locked in place and prevents them from moving in the pockets during machining, ensuring tool reliability and accurate indexing over various applications.



Applications capabilities



- High productive cutter with close pitch design

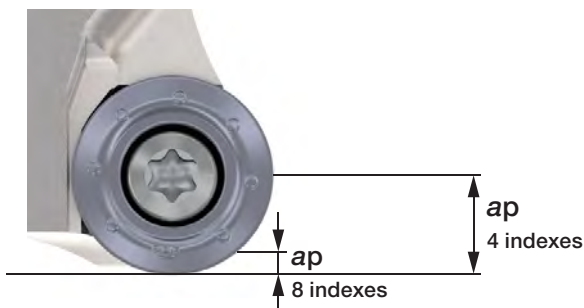


■ Inserts per diameter density comparisons: FixRMill vs conventional round insert cutter

Tool diameter DCX (mm)		FIXRMILL close pitched	Conventional round insert cutter
R5	ø40	6	5
R6	ø50	6	5
R8	ø66	6	5

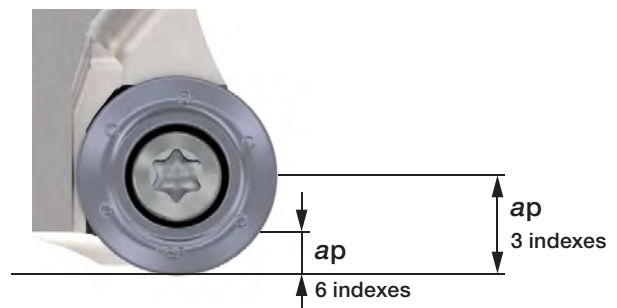
■ Two types of inserts

- Both inserts can be clamped in the same pocket
- Inserts can be selected based on the required depth of cut for best cost per edge



RQMT****ENC8-MM

	For 8 indexes	For 4 indexes
R5	DOC ≤ 1.2 mm	DOC ≤ 5 mm
R6	DOC ≤ 1.4 mm	DOC ≤ 6 mm
R8	DOC ≤ 2 mm	DOC ≤ 8 mm

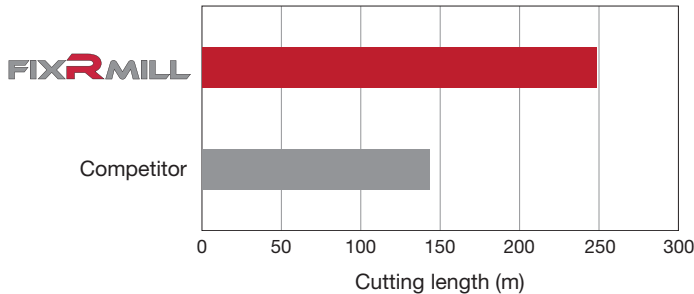


RQMT****ENC6-MM

	For 6 indexes	For 3 indexes
R5	DOC ≤ 2.2 mm	DOC ≤ 5 mm
R6	DOC ≤ 2.6 mm	DOC ≤ 6 mm
R8	DOC ≤ 3.5 mm	DOC ≤ 8 mm

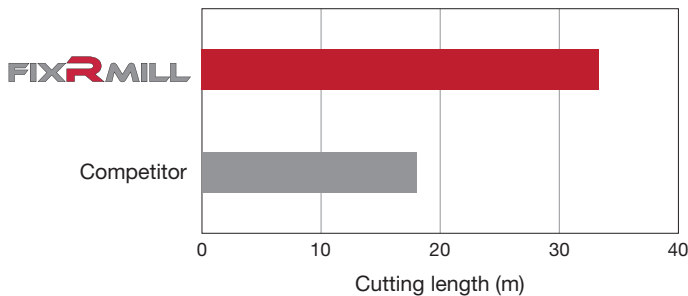
TOOL LIFE

P Carbon steel S55C / C55 (200HB)



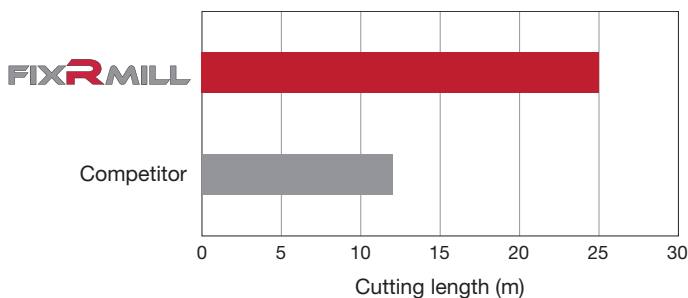
Cutter : ERRQ10M032C32.0R05 (DCX = 32 mm, CICT = 5)
 Insert : RQMT10T3ENC8-MM AH3135
 Cutting speed : $V_c = 150$ m/min
 Feed per tooth : $f_z = 0.6$ mm/t
 Depth of cut : $a_p = 1.2$ mm
 Width of cut : $a_e = 19$ mm
 Coolant : Dry
 Overhang length: 70 mm
 Machine : Vertical M/C, BT40
 Performed with all inserts on the cutter

P Alloy steels SCM440 / 42CrMo4 (270HB)



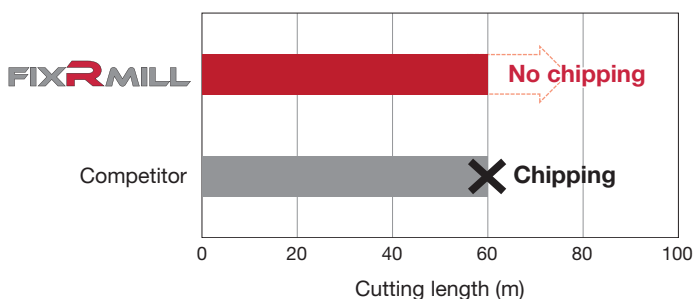
Cutter : TRRQ16M063B22.0R06 (DCX = 63 mm, CICT = 6)
 Insert : RQMT1605ENC8-MM AH3135
 Cutting speed : $V_c = 150$ m/min
 Feed per tooth : $f_z = 0.6$ mm/t
 Depth of cut : $a_p = 2$ mm
 Width of cut : $a_e = 38$ mm
 Coolant : Dry
 Overhang length: 100 mm
 Machine : Vertical M/C, BT50
 Performed with only one insert on the cutter

P Plastic mold steel NAK80 (40HRC)



Cutter : TRRQ12M050B22.0R05 (DCX = 50 mm, CICT = 5)
 Insert : RQMT1204ENC6-MM AH3135
 Cutting speed : $V_c = 140$ m/min
 Feed per tooth : $f_z = 0.3$ mm/t
 Depth of cut : $a_p = 1.5$ mm
 Width of cut : $a_e = 20$ mm
 Coolant : Dry
 Overhang length: 150 mm
 Machine : Horizontal M/C, BT40
 Performed with only one insert on the cutter

M Austenitic stainless steel SUS304 / X5CrNi18-9 (160HB)



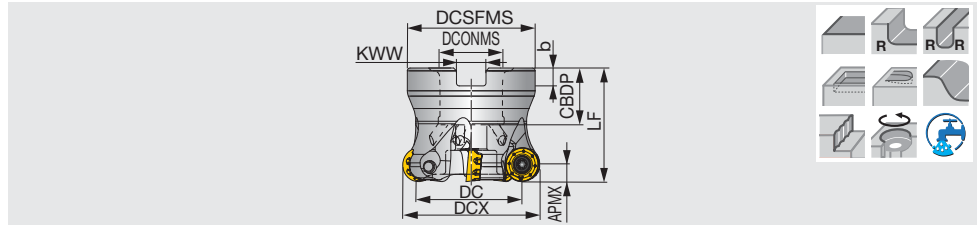
Cutter : TRRQ12M050B22.0R06 (DCX = 50 mm, CICT = 6)
 Insert : RQMT1204ENC8-MM AH3135
 Cutting speed : $V_c = 75$ m/min
 Feed per tooth : $f_z = 0.3$ mm/t
 Depth of cut : $a_p = 1$ mm
 Width of cut : $a_e = 3$ mm
 Coolant : Dry
 Overhang length: 150 mm
 Machine : Vertical M/C, HSK100
 Performed with all inserts on the cutter

BORE TYPE

TRRQ

Radius mill with anti-rotation system

GAMP = +4° ~ +5°, GAMF = -4° ~ -3°



Designation	APMX	DCX	CICT	DC	DCSFMS	DCONMS	LF	CBDP	KWW	b	WT(kg)	Air hole	Insert
TRRQ10M040B16.0R06	5	40	6	30	34	16	40	18	8.4	5.6	0.18	With	RQMT10...
TRRQ10M050B22.0R06	5	50	6	40	45	22	40	20	10.4	6.3	0.31	With	RQMT10...
TRRQ10M050B22.0R07	5	50	7	40	45	22	40	20	10.4	6.3	0.32	With	RQMT10...
TRRQ10M052B22.0R06	5	52	6	42	45	22	40	20	10.4	6.3	0.33	With	RQMT10...
TRRQ12M040B16.0R04 ⁽¹⁾	6	40	4	28	34	16	40	24	8.4	5.6	0.16	With	RQMT12...
TRRQ12M050B22.0R05	6	50	5	38	45	22	40	20	10.4	6.3	0.27	With	RQMT12...
TRRQ12M050B22.0R06	6	50	6	38	45	22	40	20	10.4	6.3	0.26	With	RQMT12...
TRRQ12M052B22.0R05	6	52	5	40	45	22	40	20	10.4	6.3	0.29	With	RQMT12...
TRRQ12M063B22.0R06	6	63	6	51	50	22	40	20	10.4	6.3	0.44	With	RQMT12...
TRRQ12M063B22.0R07	6	63	7	51	50	22	40	20	10.4	6.3	0.42	With	RQMT12...
TRRQ12M080B27.0R06	6	80	6	68	56	27	50	22	12.4	7	0.88	With	RQMT12...
TRRQ16M052B22.0R05	8	52	5	36	45	22	40	20	10.4	6.3	0.3	With	RQMT16...
TRRQ16M063B22.0R05	8	63	5	47	50	22	40	20	10.4	6.3	0.44	With	RQMT16...
TRRQ16M063B22.0R06	8	63	6	47	50	22	40	20	10.4	6.3	0.45	With	RQMT16...
TRRQ16M066B27.0R06	8	66	6	50	56	27	50	22	12.4	7	0.61	With	RQMT16...
TRRQ16M080B27.0R07	8	80	7	64	56	27	50	22	12.4	7	0.8	With	RQMT16...

(1) Always use the dedicated shell locking bolt # SRPS118-0416 when assembling the cutter on the arbor. See page 12 for the instruction for the cutter-arbor assembly.
Coolant needs to be supplied from the end of the arbor inlay. Coolant cannot be supplied from the shell locking bolt.

SPARE PARTS

Designation	Clamping screw	Torx bit	Grip	Shell locking bolt 1	Shell locking bolt 2
TRRQ10M040B16.0R06	CSPB-3.5S	BLD IP15/S7	H-TB2W	FSHM8-30H	-
TRRQ10M050 - 052...	CSPB-3.5S	BLD IP15/S7	H-TB2W	CM10X30H	-
TRRQ12M040B16.0R04	CSPB-4S	BLD IP15/S7	H-TB2W	-	SRPS118-0416
TRRQ12M050 - 063...	CSPB-4S	BLD IP15/S7	H-TB2W	CM10X30H	-
TRRQ12M080B27.0R06	CSPB-4S	BLD IP15/S7	H-TB2W	CM12X30H	-
TRRQ16M052 - 063...	CSPB-5	BLD IP20/S7	H-TB2W	FSHM10-40H	-
TRRQ16M066 - 080...	CSPB-5	BLD IP20/S7	H-TB2W	CM12X30H	-

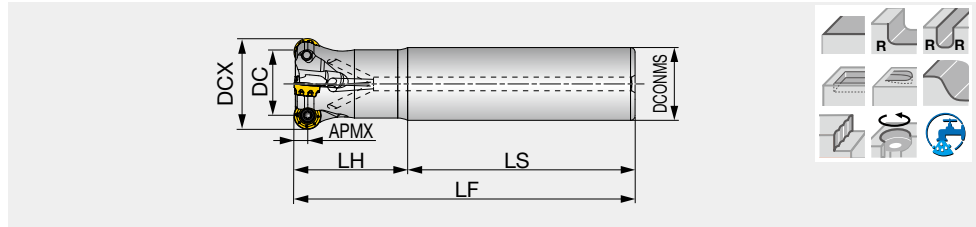
*Recommended clamping torque (N·m): CSPB-3.5S, CSPB-4S = 3.5, CSPB-5 = 5

SHANK TYPE

ERRQ

Radius endmill with anti-rotation system, shank type

GAMP = +1.6° ~ +5°, GAMF = -6.2° ~ -3°



	Designation	APMX	DCX	CICT	DC	DCONMS	LF	LH	LS	WT(kg)	Air hole	Insert
New	ERRQ10M020C20.0R02	5	20	2	10	20	150	50	100	0.32	With	RQMT10...
New	ERRQ10M025C25.0R03	5	25	3	15	25	150	60	90	0.48	With	RQMT10...
	ERRQ10M032C32.0R05	5	32	5	22	32	150	70	80	0.78	With	RQMT10...
	ERRQ12M032C32.0R03	6	32	3	20	32	150	50	100	0.81	With	RQMT12...
	ERRQ12M040C32.0R04	6	40	4	28	32	150	50	100	0.84	With	RQMT12...

SPARE PARTS



Designation	Clamping screw	Torx bit	Grip
ERRQ10M020 - 032...	CSPB-3.5S	BLD IP15/S7	H-TB2W
ERRQ12M032 - 040...	CSPB-4S	BLD IP15/S7	H-TB2W

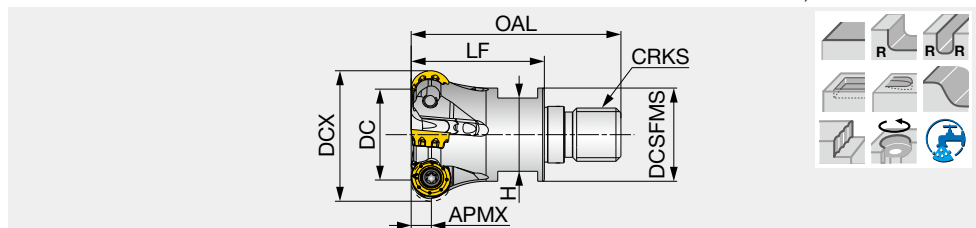
*Recommended clamping torque (N·m): CSPB-3.5S, CSPB-4S = 3.5

MODULAR TYPE

HRRQ

Radius endmill with anti-rotation system, modular type (TungFlex)

GAMP = +1.6° ~ +5°, GAMF = -6.2° ~ -3°



	Designation	APMX	DCX	CICT	DC	OAL	LF	H	DCSFMS	CRKS	WT(kg)	Air hole	Insert
	HRRQ10M032M16R05	5	32	5	22	63	40	22	28.8	M16	0.19	With	RQMT10...
	HRRQ12M032M16R03	6	32	3	20	63	40	22	28	M16	0.17	With	RQMT12...
	HRRQ12M040M16R05	6	40	5	28	63	40	22	28	M16	0.21	With	RQMT12...

SPARE PARTS

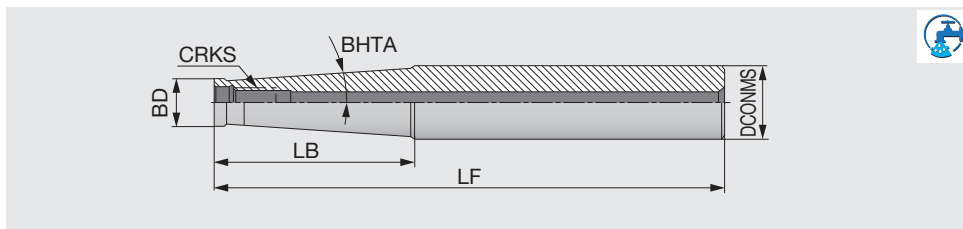


Designation	Clamping screw	Torx bit	Grip
HRRQ10M...	CSPB-3.5S	BLD IP15/S7	H-TB2W
HRRQ12M...	CSPB-4S	BLD IP15/S7	H-TB2W

*Recommended clamping torque (N·m): CSPB-3.5S, CSPB-4S = 3.5

SM

Steel modular shank



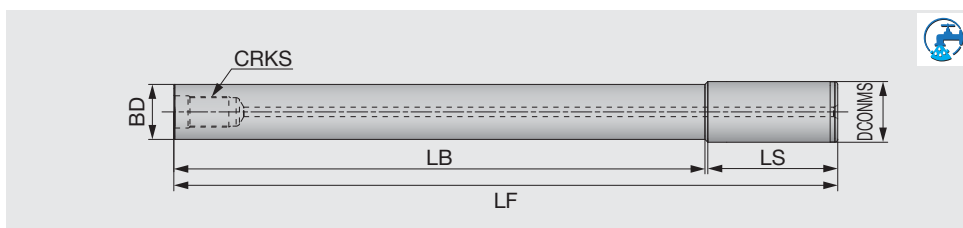
Designation	CRKS	DCONMS	LF	LB	BD	BHTA
SM16-L95-C32	M16	32	95	35	29	1.7°
SM16-L230-C32	M16	32	230	50	29	1.8°

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SM-C-H

Carbide modular shank



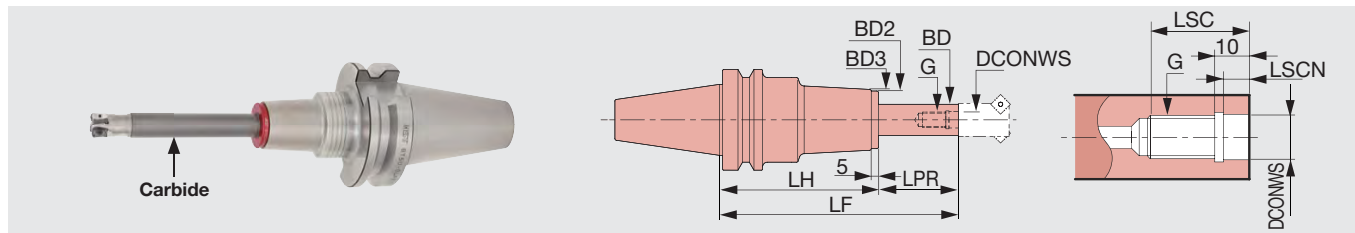
Designation	CRKS	DCONMS	LF	LB	LS	BD
SM16-L100-40-C32-C-H	M16	32	100	40	58.5	29
SM16-L150-80-C32-C-H	M16	32	150	80	68.5	29
SM16-L200-100-C32-C-H	M16	32	200	100	98.5	29
SM16-L200-140-C32-C-H	M16	32	200	140	58.5	29
SM16-L250-130-C32-C-H	M16	32	250	130	118.5	29
SM16-L250-180-C32-C-H	M16	32	250	180	68.5	29
SM16-L300-180-C32-C-H	M16	32	300	180	118.5	29
SM16-L300-230-C32-C-H	M16	32	300	230	68.5	29
SM16-L350-230-C32-C-H	M16	32	350	230	118.5	29
SM16-L350-280-C32-C-H	M16	32	350	280	68.5	29

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BT-RSG (Screw clamping head holder)

TungFlex modular tooling system with BT shank



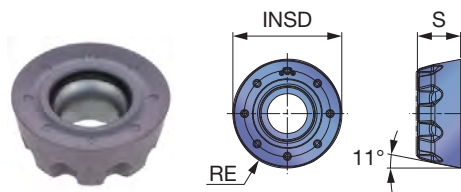
Designation	DCONWS	LSC	LSCN	BD	LF	LPR	LH	BD2	BD3	WT (kg)	G
BT50-RSG 16-140-M 25	17	25	6	29	140	25	115	52	54	5.4	M16
BT50-RSG 16-165-M 50	17	25	6	29	165	50	115	52	54	5.6	M16
BT50-RSG 16-190-M 75	17	25	6	29	190	75	115	52	54	5.8	M16
BT50-RSG 16-215-M100	17	25	6	29	215	100	115	52	54	6	M16
BT50-RSG 16-240-M125	17	25	6	29	240	125	115	52	54	6.2	M16

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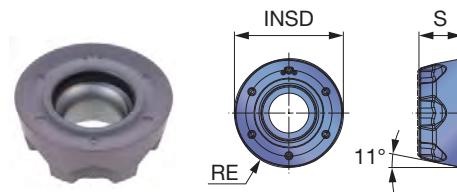


INSERTS

RQMT...C8-MM



RQMT...C6-MM



P Steel	★										
M Stainless	★										
K Cast iron		★									
N Non-ferrous											
S Superalloy	★	★									
H Hard materials	☆	☆									

★ : First choice
☆ : Second choice

Designation	RE	APMX	Coated								INSD	S
			AH3135	AH8015								
RQMT10T3ENC8-MM	5	5	●	●							10	3.97
RQMT10T3ENC6-MM	5	5	●	●							10	3.97
RQMT1204ENC8-MM	6	6	●	●							12	4.76
RQMT1204ENC6-MM	6	6	●	●							12	4.76
RQMT1605ENC8-MM	8	8	●	●							16	5.61
RQMT1605ENC6-MM	8	8	●	●							16	5.61

● : Line up

GRADES

AH3135 **P M S H**

- PVD grade for high fracture resistance
- Most suitable for steel, stainless steel, and titanium alloy in general cutting parameters

AH8015 **K S H**

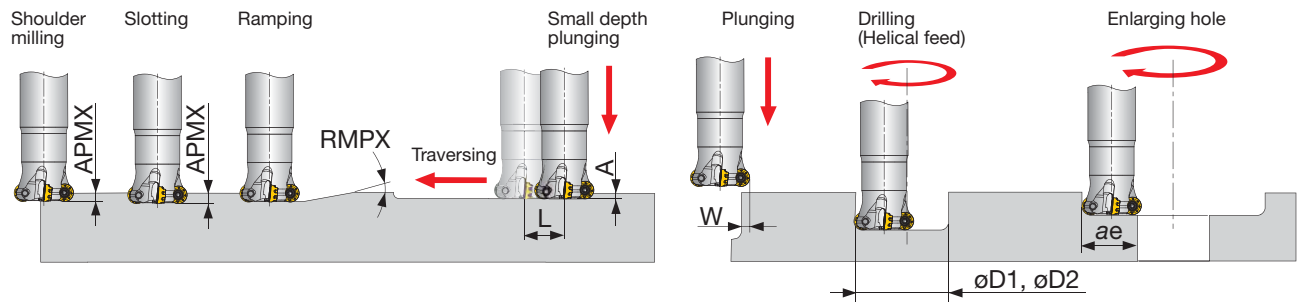
- Incorporates a hard coating layer and carbide substrate
- Strong resistance to wear, heat, and built-up edge. Ideal for machining cast iron, heat-resistant alloy, and hardened steel

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Grades	Cutting speed Vc (m/min)	Feed per tooth: fz (mm/t)		
					RQMT10...	RQMT12...	RQMT16...
P	Low carbon steel S15C, etc. C15E4, etc.	- 200HB	AH3135	100 - 300			
	Carbon steel and alloy steel S55C, SCM440, etc. C55, 42CrMo4, etc.	- 300HB	AH3135	100 - 250	ap = 5 mm : 0.1 - 0.3 ap = 2 mm : 0.15 - 0.6 ap = 1 mm : 0.2 - 0.8	ap = 6 mm : 0.1 - 0.3 ap = 2 mm : 0.15 - 0.6 ap = 1 mm : 0.2 - 0.8	ap = 8 mm : 0.1 - 0.3 ap = 2 mm : 0.15 - 0.7 ap = 1 mm : 0.2 - 1
	Prehardened steel NAK80, PX5, etc.	30 - 40HRC	AH3135	100 - 200			
M	Austenitic stainless steel SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc.	- 200HB	AH3135	100 - 200	ap = 5 mm : 0.1 - 0.25 ap = 2 mm : 0.15 - 0.5 ap = 1 mm : 0.2 - 0.65	ap = 6 mm : 0.1 - 0.25 ap = 2 mm : 0.15 - 0.5 ap = 1 mm : 0.2 - 0.65	ap = 8 mm : 0.1 - 0.25 ap = 2 mm : 0.15 - 0.55 ap = 1 mm : 0.2 - 0.8
	Martensitic stainless steel SUS420J1, etc. X20Cr13, etc.	- 200HB	AH3135	100 - 300			
K	Grey cast iron FC250, etc. 250, etc.	150 - 250HB	AH8015	100 - 300	ap = 5 mm : 0.1 - 0.3 ap = 2 mm : 0.15 - 0.6 ap = 1 mm : 0.2 - 0.8	ap = 6 mm : 0.1 - 0.3 ap = 2 mm : 0.15 - 0.6 ap = 1 mm : 0.2 - 0.8	ap = 8 mm : 0.1 - 0.3 ap = 2 mm : 0.15 - 0.7 ap = 1 mm : 0.2 - 1
	Ductile cast iron FCD400, FCD600, etc. 400-15S, 600-3, etc.	150 - 250HB	AH8015	80 - 250			
S	Titanium alloys Ti-6Al-4V, etc.	-	AH3135	30 - 60	ap = 5 mm : 0.08 - 0.2 ap = 2 mm : 0.12 - 0.4 ap = 1 mm : 0.15 - 0.6	ap = 6 mm : 0.08 - 0.2 ap = 2 mm : 0.12 - 0.4 ap = 1 mm : 0.15 - 0.6	ap = 8 mm : 0.08 - 0.2 ap = 2 mm : 0.1 - 0.2 ap = 1 mm : 0.15 - 0.8
	Heat-resistant alloys Inconel718, etc.	-	AH8015	20 - 50	ap = 5 mm : 0.05 - 0.12 ap = 2 mm : 0.08 - 0.25 ap = 1 mm : 0.1 - 0.3	ap = 6 mm : 0.05 - 0.12 ap = 2 mm : 0.08 - 0.25 ap = 1 mm : 0.1 - 0.3	ap = 8 mm : 0.05 - 0.12 ap = 2 mm : 0.06 - 0.3 ap = 1 mm : 0.08 - 0.4
H	Hardened steel	SKD61, etc. X40CrMoV5-1, etc.	AH3135	50 - 150	ap = 5 mm : 0.05 - 0.12 ap = 2 mm : 0.08 - 0.25 ap = 1 mm : 0.1 - 0.3	ap = 5 mm : 0.05 - 0.12 ap = 2 mm : 0.08 - 0.25 ap = 1 mm : 0.1 - 0.3	ap = 5 mm : 0.05 - 0.12 ap = 2 mm : 0.08 - 0.25 ap = 1 mm : 0.1 - 0.3
		SKD11, etc. X153CrMoV12, etc.	AH8015	50 - 70	ap = 5 mm : 0.03 - 0.1 ap = 2 mm : 0.05 - 0.12 ap = 1 mm : 0.05 - 0.15	ap = 5 mm : 0.03 - 0.1 ap = 2 mm : 0.05 - 0.12 ap = 1 mm : 0.05 - 0.15	ap = 5 mm : 0.03 - 0.1 ap = 2 mm : 0.05 - 0.12 ap = 1 mm : 0.05 - 0.15

When using ERRQ10M020C20.0R02, please lower the cutting conditions (Vc, fz, ap) to 70% of the standard cutting conditions.

APPLICATION RANGE



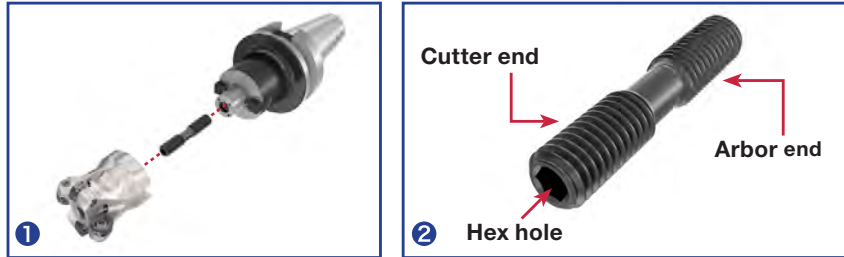
Designation		DCX	Max. depth of cut APMX	Max. ramping angle RMPX	Max. plunging depth A	Max. cutting width in plunging W	Machining length for removing uncut portion L	Min. machining diameter $\phi D1$	Max. machining diameter $\phi D2^*$	Max. cutting width engagement ae
New	ERRQ10M020C20.0R02	20	5	3.1°	0.4	5	11	27	39	13
New	ERRQ10M025C25.0R03	25	5	11.8°	2.2	5	16	32	49	18
	E/HRRQ10M032...	32	5	3.6°	1	5	23	48	63	25
	TRRQ10M040B16.0R06	40	5	5.4°	2.4	5	31	62	79	33
	TRRQ10M050B22....	50	5	3.8°	2.4	5	41	82	99	43
	TRRQ10M052B22.0R06	52	5	3.8°	2.4	5	43	86	103	45
	E/HRRQ12M032...	32	6	3°	0.8	6	21	47	63	24
	T/ERRQ12M040...	40	6	5.1°	2.4	6	29	59	79	32
	HRRQ12M040M016R05	40	6	7°	2.6	6	29	59	79	32
	TRRQ12M050B22.0...	50	6	3.6°	2.4	6	39	79	99	42
	TRRQ12M052B22.0R05	52	6	3.4°	2.4	6	41	83	103	44
	TRRQ12M063B22.0...	63	6	3°	2.4	6	52	105	125	55
	TRRQ12M080B27.0R06	80	6	2.1°	2.4	6	69	139	159	72
	TRRQ16M052B22.0R05	52	8	4°	2	8	37	78	103	42
	TRRQ16M063B22.0...	63	8	6.6°	4.5	8	48	96	125	53
	TRRQ16M066B27.0R06	66	8	6.2°	4.5	8	51	102	131	56
	TRRQ16M080B27.0R07	80	8	4.6°	4.5	8	65	130	159	70

* For bottom hole

How to Assemble on the Arbor (For Cutter # TRRQ12M040B16.0R04)

Before assembly

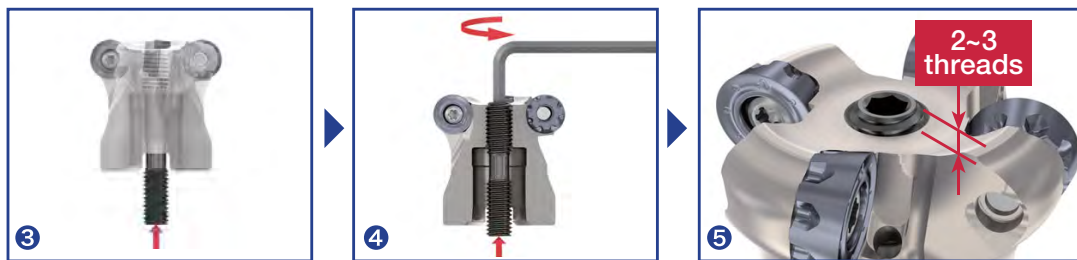
- Ensure before assembly that the milling cutter, dedicated shell locking bolt, and arbor are present and of the right sizes. (Fig. ①)
- The screw end with the hex hole should be inserted in the cutter body; the screw end with no hole goes in the arbor. (Fig. ②)



Assembling the screw in the cutter body

- Insert the screw end with the hex hole into the cutter body. (Fig. ③)
- Turn the screw counterclockwise (left) until it stops. (Fig. ④)
- Ensure that 2 to 3 threads are visible from the top of the cutter body. (Fig. ⑤)

NOTE: Always insert the shell locking bolt from the bottom of the cutter. NEVER insert the screw into the top of the cutter body; this will damage the screw threads.



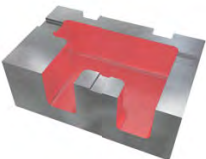
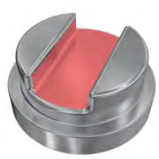
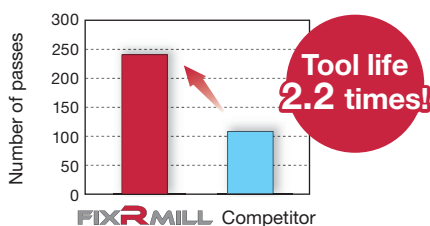
Assembling the cutter and arbor

- Place the cutter body on the arbor so that the drive keys on the arbor engage the grooves on the cutter body. (Fig. ⑥)
- Tighten the screw clockwise (right) to lock the cutter body onto the arbor. While doing so, ensure that the drive keys stay in contact with the grooves at all times. (Fig. ⑦)
- Tighten the screw until the cutter body flange face is flush with the arbor face. (Fig. ⑧)
- Ensure the cutter body does not rotate on the arbor to finish the assembly.

NOTE: Recommended torque for the screw: 8N·m



PRACTICAL EXAMPLES

Workpiece type		Mold	Mold
Cutter		ERRQ10M020C20.0R02 (DCX = 20 mm, CICT = 2)	ERRQ10M025C25.0R03 (DCX = 25 mm, CICT = 3)
Insert		RQMT10T3ENC8-MM	RQMT10T3ENC8-MM
Grade		AH3135	AH8015
Workpiece material		SKD61 / X40CrMoV5-1 (HRC30)	DAC3 (HRC50)
		 P	 H
Cutting conditions	Cutting speed: V_c (m/min)	150	67
	Feed per tooth: f_z (mm/t)	0.42	0.3
	Depth of cut : a_p (mm)	0.8	0.5
	Width of cut : a_e (mm)	~ 20	~ 25
	Machining	Profiling	Slotting
	Coolant	Air	Air
	Machine	Vertical M/C, BT50	Vertical M/C, BT50
Results		 No chipping  Chipping The competitor's cutter resulted in edge chipping after 90 minutes of machining. FixRMill showed no edge chipping and completed 90 minutes of machining, thanks to its tough AH3135 grade inserts.	 No chipping  Chipping The competitor's cutter resulted in chipping, requiring a corner change after 20 minutes of machining. FixRMill with grade AH8015, designed for machining hard steel, showed minimal damage after 20 minutes of machining, allowing continued operation.
Workpiece type		Generator part	Generator part
Cutter		TRRQ12M050B22.0R06 (DCX = 50 mm, CICT = 6)	TRRQ16M080B27.0R07 (DCX = 80 mm, CICT = 7)
Insert		RQMT1204ENC8-MM	RQMT1605ENC8-MM
Grade		AH3135	AH3135
Workpiece material		SUS304 / X5CrNi18-9	SUS430 / X6Cr17
		 M	 M
Cutting conditions	Cutting speed: V_c (m/min)	75	180
	Feed per tooth: f_z (mm/t)	0.3	0.15
	Depth of cut : a_p (mm)	1	0.2
	Width of cut : a_e (mm)	3	45
	Machining	Profiling	Face milling
	Coolant	Air	Air
	Machine	Vertical M/C, HSK100	Vertical M/C, HSK63
Results		Due to a long overhang setup of 4xD and an insecure anti-rotation feature, the competitor's cutter allowed the inserts to rotate during machining, causing damage to the insert pockets and shortening tool life. FixRMill prevented insert rotation thanks to its anti-rotation system, providing the cutter with security and long tool life.	 Tool life 2.2 times! FixRMill, combined with fracture-resistant AH3135 grade inserts, provided a 2.2x increase in tool life.

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