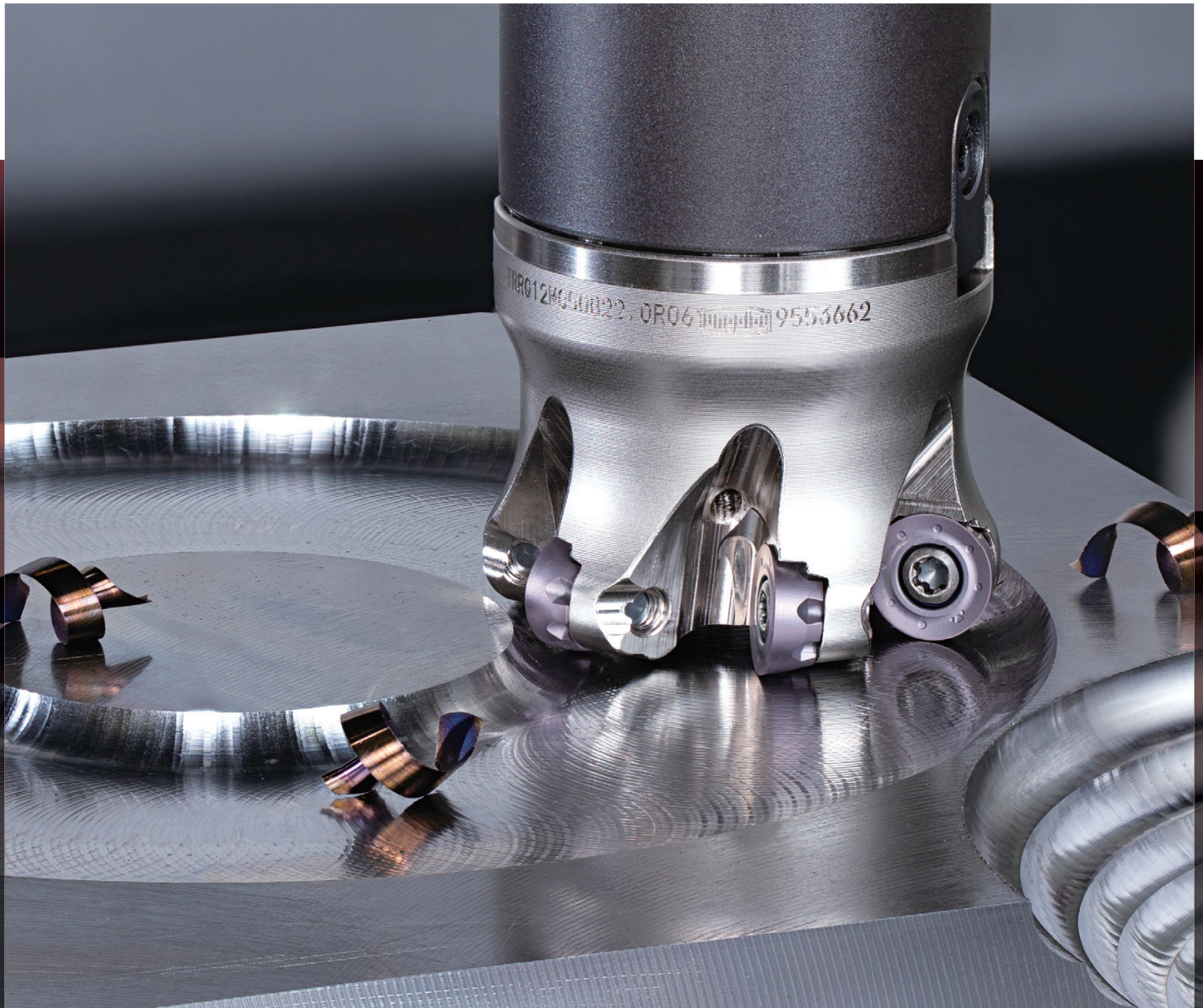


Profile milling cutter

FIXRMILL

Tungaloy Report No. 418S1-G

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

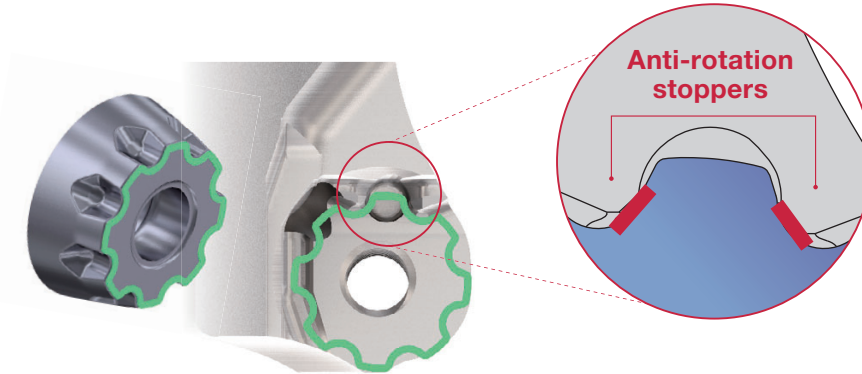
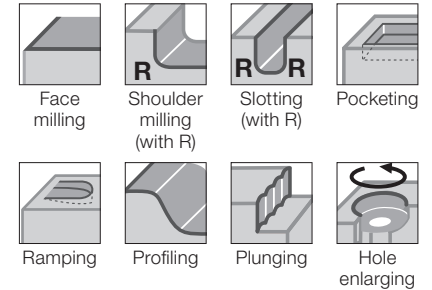




Accurate and secure clamping

- 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

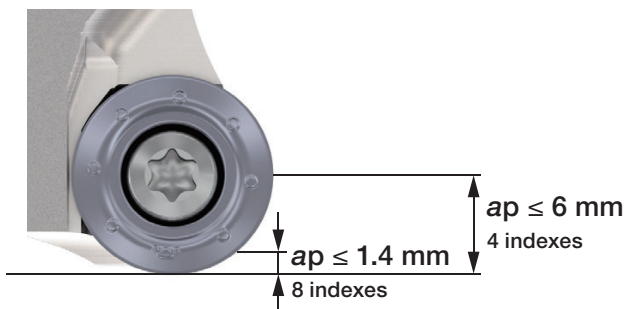


Inserts per diameter density comparisons: FixRMill vs conventional round insert cutter

Tool diameter DCX (mm)	FIXRMILL close pitched	Conventional round insert cutter
ø50	6	5
ø63	7	6

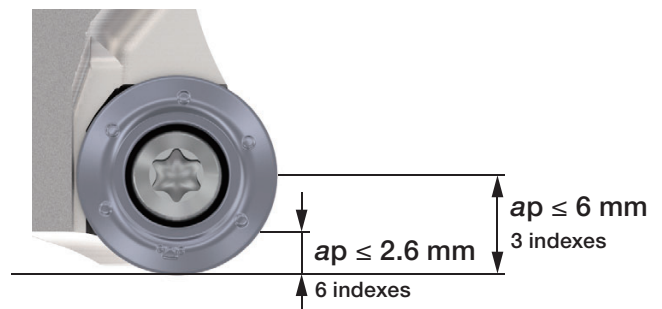
Two types of inserts

- 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



RQMT1204ENC8-MM

Allows up to 8 indexes for 1.4 mm or smaller D.O.C. and up to 4 indexes for up to 6 mm D.O.C.

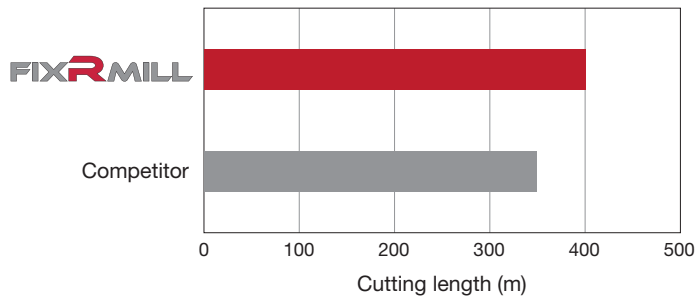


RQMT1204ENC6-MM

Allows up to 6 indexes for 2.6 mm or smaller D.O.C. and up to 3 indexes for up to 6 mm D.O.C.

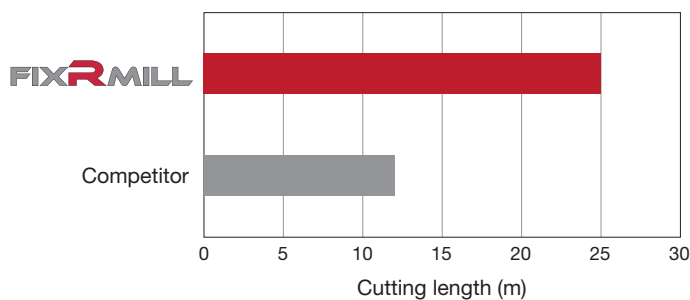
TOOL LIFE

P Carbon steel S55C / C55 (200HB)



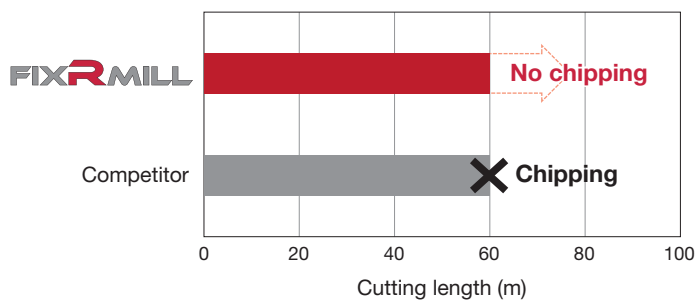
Cutter : TRRQ12M050B22.0R05 (DCX = 50 mm, CICT = 5)
 Insert : RQMT1204ENC6-MM AH3135
 Cutting speed : $V_c = 150$ m/min
 Feed per tooth : $f_z = 0.6$ mm/t
 Depth of cut : $a_p = 1.5$ mm
 Width of cut : $a_e = 30$ mm
 Coolant : Dry
 Overhang length: 100 mm
 Machine : Horizontal M/C, BT40
 Performed with 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)



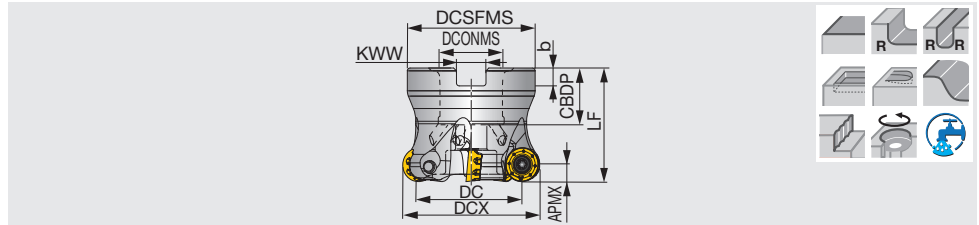
Cutter : TRRQ12M050B22.0R06 (DCX = 50 mm, CICT = 6)
 Insert : RQMT1204ENC8-MM AH3135
 Cutting speed : $V_c = 75$ m/min
 Feed per tooth : $f_z = 0.3$ mm/t
 Depth of cut : $a_p = 1$ mm
 Width of cut : $a_e = 3$ mm
 Coolant : Dry
 Overhang length: 150 mm
 Machine : Vertical M/C, HSK100
 Performed with all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

BORE TYPE

TRRQ12

Radius mill with anti-rotation system

GAMP = +5°, GAMF = -3°



Designation	APMX	DCX	CICT	DC	DCSFMS	DCONMS	LF	CBDP	KWW	b	WT(kg)	Air hole	Insert
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...

(1) Always use the dedicated shell locking bolt # SRPS118-0416 when assembling the cutter on the arbor. See page 7 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
TRRQ12M040B16.0R04	CSPB-4S	BLDIP15/S7	H-TB2W	-	SRPS118-0416
TRRQ12M050 - 063...	CSPB-4S	BLDIP15/S7	H-TB2W	CM10X30H	-
TRRQ12M080B27.0R06	CSPB-4S	BLDIP15/S7	H-TB2W	CM12X30H	-

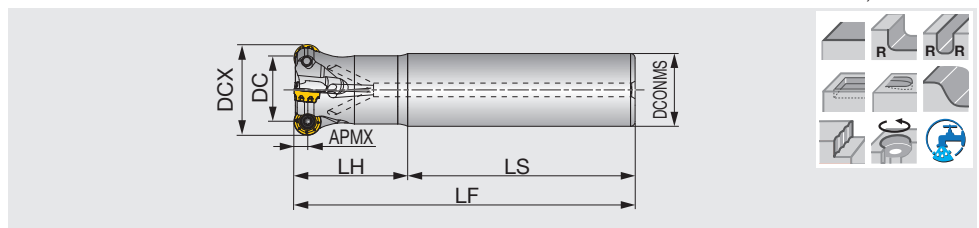
*Recommended clamping torque (N·m): CSPB-4S = 3.5

SHANK TYPE

ERRQ12

Radius endmill with anti-rotation system, shank type

GAMP = +5°, GAMF = -3°



Designation	APMX	DCX	CICT	DC	DCONMS	LF	LH	LS	WT(kg)	Air hole	Insert
ERRQ12M040C32.0R04	6	40	4	28	32	150	50	100	0.84	With	RQMT12...

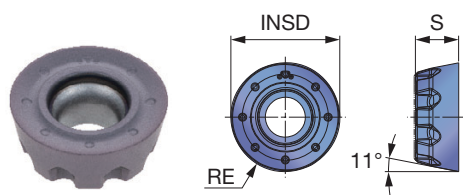
SPARE PARTS

Designation	Clamping screw	Torx bit	Grip
ERRQ12M040C32.0R04	CSPB-4S	BLDIP15/S7	H-TB2W

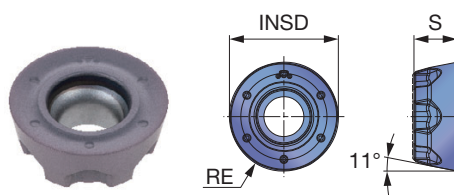
*Recommended clamping torque (N·m): CSPB-4S = 3.5

■ INSERTS

RQMT1204ENC8-MM



RQMT1204ENC6-MM

[illegible]

● : 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

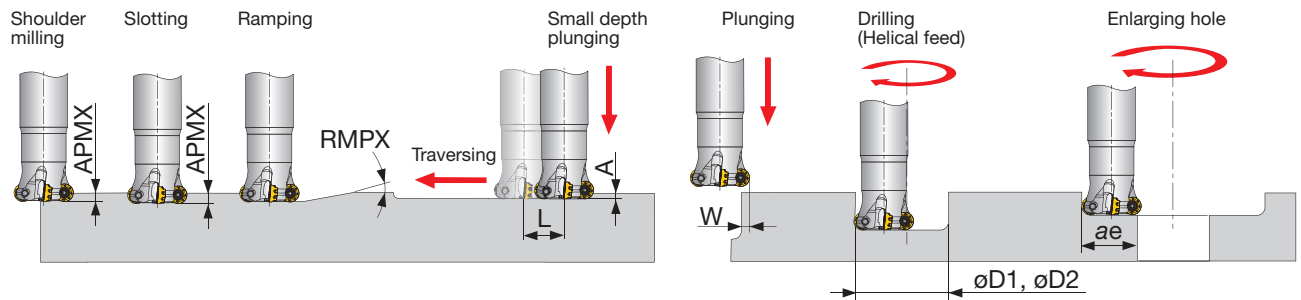
AH8015 **K** **S** **H**

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

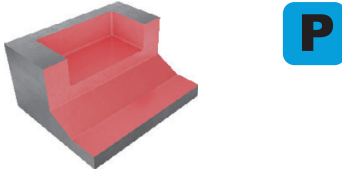
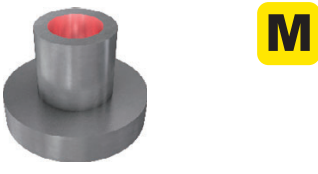
APPLICATION RANGE



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 øD1	Max. machining diameter øD2*	Max. cutting width engagement ae
T/ERRQ12M040...	40	6	5.1°	2.4	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

* For flat bottom hole

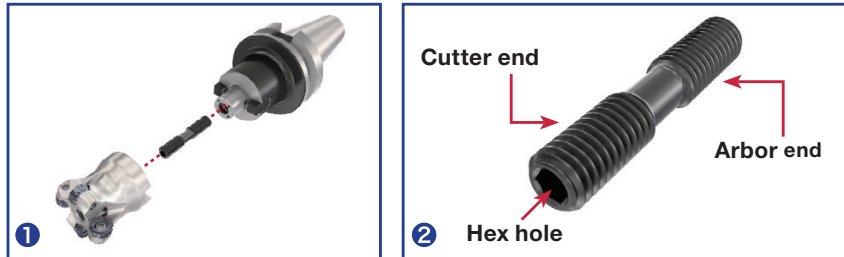
PRACTICAL EXAMPLES

Workpiece type		Mold	Generator part
Cutter		TRRQ12M050B22.0R05 (DCX = 50 mm, CICT = 5)	TRRQ12M050B22.0R06 (DCX = 50 mm, CICT = 6)
Insert		RQMT1204ENC8-MM	RQMT1204ENC8-MM
Grade		AH3135	AH3135
Workpiece material		S45C / C45	SUS304 / X5CrNi18-9
			
Cutting conditions	Cutting speed: V_c (m/min)	125	75
	Feed per tooth: f_z (mm/t)	1.25	0.3
	Depth of cut : a_p (mm)	0.5	1
	Width of cut : a_e (mm)	50	3
	Machining	Profiling	Profiling
	Coolant	Air	Air
Machine		Vertical M/C, BT50	Vertical M/C, HSK100
Results		 No chipping	 Chipping
		The competitor's cutter resulted in edge chipping and could not complete the machining of one workpiece. FixRMill demonstrated no edge chipping and completed one workpiece thanks to its tough AH3135 grade inserts.	Due to a long overhang setup of 4xD and insecure anti-rotation feature, the competitor's cutter allowed the inserts to rotate during machining, yielding damage to the insert pockets and short cutter tool life. FixRMill prevented insert rotation thanks to its anti-rotation system, providing the cutter with security and long tool life.

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

Before assembly

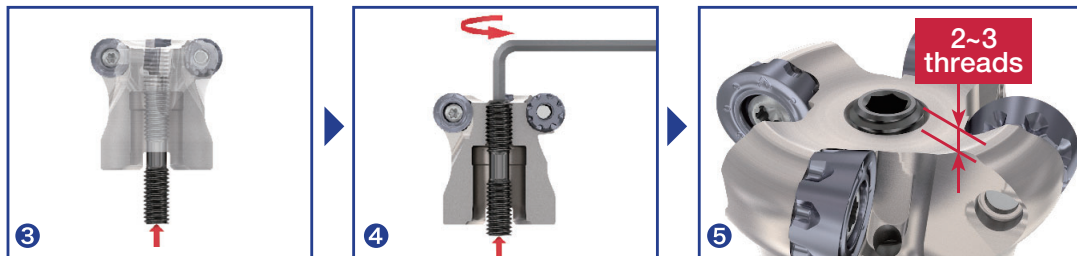
- Ensure before assembly that the milling cutter, dedicated shell locking bolt, and arbor are present and of the right sizes. (Fig.①)
- The screw end with the hex hole should be inserted in the cutter body; the screw end with no hole goes in the arbor. (Fig.②)



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



Tungaloy Corporation (Head office)

11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima 970-1144 Japan
Phone: +81-246-36-8501
Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy America, Inc.

3726 N Ventura Drive
Arlington Heights, IL 60004, U.S.A.
Phone: +1-888-554-8394
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada

432 Elgin St. Unit 3
Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779
Fax: +1-519-758-5791
www.tungaloy.com/ca

Tungaloy de Mexico S.A.

C. Los Arellano 113,
Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410
Fax: +52-449-929-5411
www.tungaloy.com/mx

Tungaloy do Brasil Ltda.

Avd. Independência N4158 Residencial Flora
13280-000 Vinhedo, São Paulo, Brasil
Phone: +55-19-38262757
Fax: +55-19-38262757
www.tungaloy.com/br

Tungaloy Germany GmbH

An der Alten Ziegelei 1
D-40789 Monheim, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.com/de

Tungaloy France S.A.S.

ZA Courtaboeuf - Le Rio
1 rue de la Terre de feu
F-91952 Courtaboeuf Cedex, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.com/fr

Tungaloy Italia S.r.l.

Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1
Fax: +39-02-252012-65
www.tungaloy.com/it

Tungaloy Czech s.r.o.

Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391
Fax: +420-532 123 392
www.tungaloy.com/cz

Tungaloy Ibérica S.L.

C/Miquel Servet, 43B, Nau 7
Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360
Fax: +34 93 876 2798
www.tungaloy.com/es

Tungaloy Scandinavia AB

Bultgatan 38
442 40 Kungälv, Sweden
Phone: +46-462119200
Fax: +46-462119207
www.tungaloy.com/se

Tungaloy Rus, LLC

Andropova avenue, h.18/7,
11 floor, office 3, 115432,
Moscow, Russia
Phone: +7-499-683-01-80
Fax: +7-499-683-01-81
www.tungaloy.com/ru

Tungaloy Polska Sp. z o.o.

Ul. Irysowa 1, 55-040 Bielany
Wrocławskie, Poland
Phone: +48 607 907 237
www.tungaloy.com/pl

Tungaloy U.K. Ltd

Gallan Park, Watling Street,
Cannock, WS110XG, UK
Phone: +44 121 4000 231
Fax: +44 121 270 9694
www.tungaloy.com/uk

Tungaloy Hungary Kft

Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846
Fax: +36 1 781-6866
www.tungaloy.com/hu

Tungaloy Turkey

Serifali Mah.bayraktar Bulvari Kule Sk. No:26
34775 Umraniye / Istanbul / Turkey
Phone: +90 216 540 04 67
Fax: +90 216 540 04 87
www.tungaloy.com/tr

Tungaloy Benelux b.v.

Tjalk 70
NL-2411 NZ Bodegraven, Netherlands
Phone: +31 172 630 420
Fax: +31 172 630 429
www.tungaloy.com/nl

Tungaloy Croatia

Ulica bana Josipa Jelačića 87,
10430, Samobor, Croatia
Phone: +385 1 3326 604
Fax: +385 1 3327 683
www.tungaloy.com/hr

Tungaloy Cutting Tool (Shanghai) Co.,Ltd.

Rm No 401 No.88 Zhabei
Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880
Fax: +86-21-3621-1918
www.tungaloy.com/cn

Tungaloy Cutting Tools (Taiwan) Co.,Ltd.

9F. No.293, Zhongyang Rd,
Xinzhuan Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy Cutting Tools (Thailand) Co.,Ltd.

Interlink tower 4th Fl.
1858/5-7 Bangna-Trad Road
km.5 Bangna, Bangna, Bangkok 10260
Thailand
Phone: +66-2-751-5711
Fax: +66-2-751-5715
www.tungaloy.com/th

Tungaloy Singapore (Pte.), Ltd.

62 Ubi Road 1, #06-11 Oxley BizHub 2
Singapore 408734
Phone: +65-6391-1833
Fax: +65-6299-4557
www.tungaloy.com/sg

Tungaloy Vietnam

LE04.38, Lexington Residence
67 Mai Chi Tho St., Dist. 2,
Ho Chi Minh City, Vietnam
Phone: +84-2837406660
www.tungaloy.com/sg

Tungaloy India Pvt. Ltd.

One International Center,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai -400013, India
Phone: +91-22-6124-8804
Fax: +91-22-6124-8899
www.tungaloy.com/in

Tungaloy Korea Co., Ltd

#1312, Byucksan Digital Valley 5-ch
Beotkkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161
Fax: +82-2-6393-8952
www.tungaloy.com/kr

Tungaloy Malaysia Sdn Bhd

50 K-2, Kelana Mall, Jalan SS6/14
Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan
Malaysia
Phone: +603-7805-3222
Fax: +603-7804-8563
www.tungaloy.com/my

Tungaloy Australia Pty Ltd

Unit 68 1470 Ferntree Gully Road
Knoxfield 3180 Victoria, Australia
Phone: +61-3-9755-8147
Fax: +61-3-9755-6070
www.tungaloy.com/au

PT. Tungaloy Indonesia

Kompleks Grand Wisata Block AA-10 No.3-5
Cibitung
Bekasi 17510, Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
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