

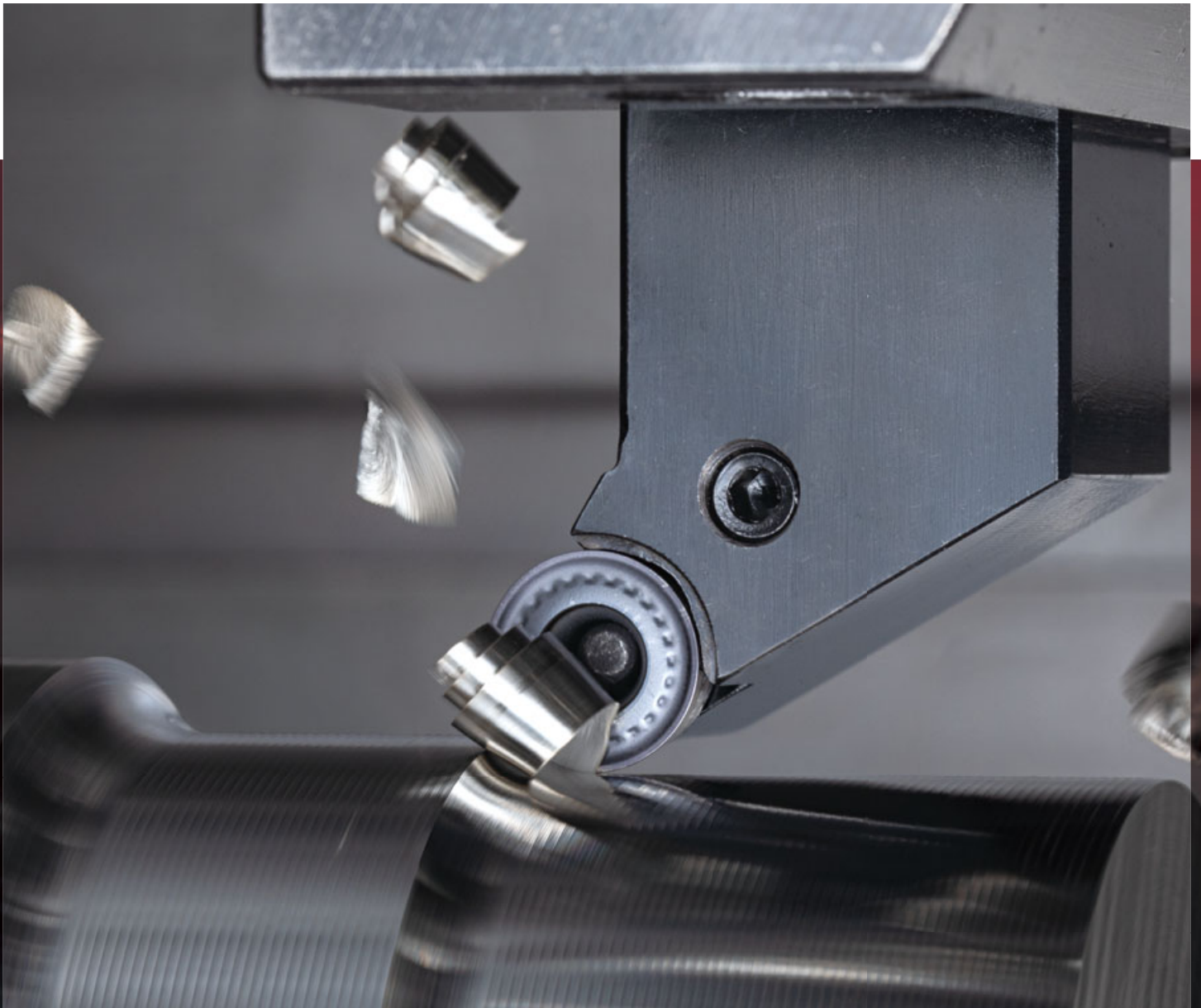


Grades for heat-resistant alloy

AH8000 SERIES

Tungaloy Report No. 437S2-US

**Expansion of RS chipbreaker with
AH8000 grade series for all RCMT turning
inserts sizes** for heat-resistant superalloys



AH8000 SERIES

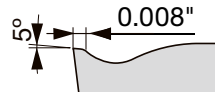
Now offering RCMT inserts with -RS chipbreaker for exotic materials

RS chipbreaker

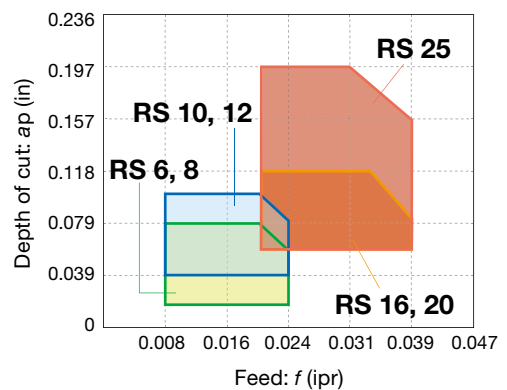
New



Sharp cutting edge generates light cutting action. Most suited for heat-resistant superalloys and stainless steel.



APPLICATION AREA AND CHIP CONTROL



Insert POSITIVE TYPE

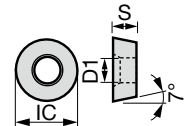
- : Continuous cutting
- ◐ : Light interrupted cutting
- ◑ : Heavy interrupted cutting

RC



Round, with hole Positive 7°

Material	Coated	Application Area	Chip Control
P Steel			
M Stainless	● c		
K Cast iron			
N Non-ferrous			
S Superalloys	● c		
H Hard materials			





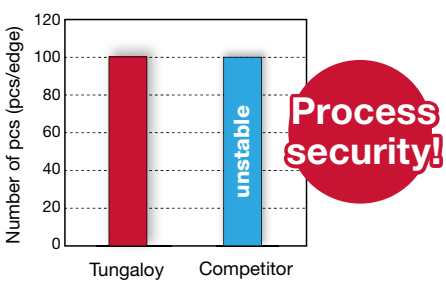
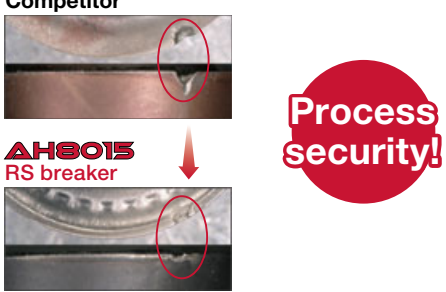
Application	Chipbreaker	Designation		Coated		Dimension (in)			
		Inch	Metric	AH8005	AH8015	RE	IC	S	D1
Finishing		-	RCMT0602M0-RS	●	●	-	0.236	0.094	0.110
		-	RCMT0803M0-RS	●	●	-	0.315	0.125	0.134
		-	RCMT10T3M0-RS	●	●	-	0.394	0.156	0.173
		-	RCMT1204M0-RS	●	●	-	0.472	0.187	0.173
		-	RCMT1606M0-RS	●	●	-	0.630	0.250	0.217
		-	RCMT2006M0-RS	●	●	-	0.787	0.250	0.256
		-	RCMT2507M0-RS	●	●	-	0.984	0.313	0.299

- : New
- : Line up

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Chipbreaker	Size	Depth of cut ap (in)	Feed f (ipr)	Cutting speed: Vc (sfm)	
						AH8005	AH8015
M	Stainless steel 303SS, 304SS, etc.	RS	RCMT06...	0.020 - 0.079	0.008 - 0.024	328 - 722	295 - 656
			RCMT08...	0.020 - 0.079	0.008 - 0.024		
			RCMT10...	0.039 - 0.098	0.008 - 0.024		
			RCMT12...	0.039 - 0.098	0.008 - 0.024		
			RCMT16...	0.059 - 0.118	0.020 - 0.039		
			RCMT20...	0.059 - 0.118	0.020 - 0.039		
			RCMT25...	0.059 - 0.197	0.020 - 0.039		
S	Superalloys Inconel718, etc.	RS	RCMT06...	0.020 - 0.079	0.008 - 0.024	131 - 328	66 - 262
			RCMT08...	0.020 - 0.079	0.008 - 0.024		
			RCMT10...	0.039 - 0.098	0.008 - 0.024		
			RCMT12...	0.039 - 0.098	0.008 - 0.024		
			RCMT16...	0.059 - 0.118	0.020 - 0.039		
			RCMT20...	0.059 - 0.118	0.020 - 0.039		
			RCMT25...	0.059 - 0.197	0.020 - 0.039		

PRACTICAL EXAMPLES

Workpiece type		Flange	Disk	
Insert		RCMT10T3M0-RS	RCMT1606M0-RS	
Grade		AH8005	AH8015	
Workpiece material		Inconel 718	Ti-6Al-4V	
		 S	 S	
Cutting conditions	Cutting speed : Vc (sfm)	279	98	
	Feed : f (ipr)	0.010	0.020	
	Depth of cut : ap (in)	0.049	0.118	
	Coolant	Wet	Wet	
Results	 <p>A combination of AH8005 and -RS chipbreaker eliminated premature failure.</p>		 <p>A combination of AH8015 and -RS chipbreaker significantly reduced notch wear.</p>	

Tungaloy-NTK America Inc.

United States

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.

Inside Sales: +1-888-554-8394

Technical Support: +1-888-554-8391

Fax: +1-888-554-8392

www.tungaloy.com/us

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

Mexico

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



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