

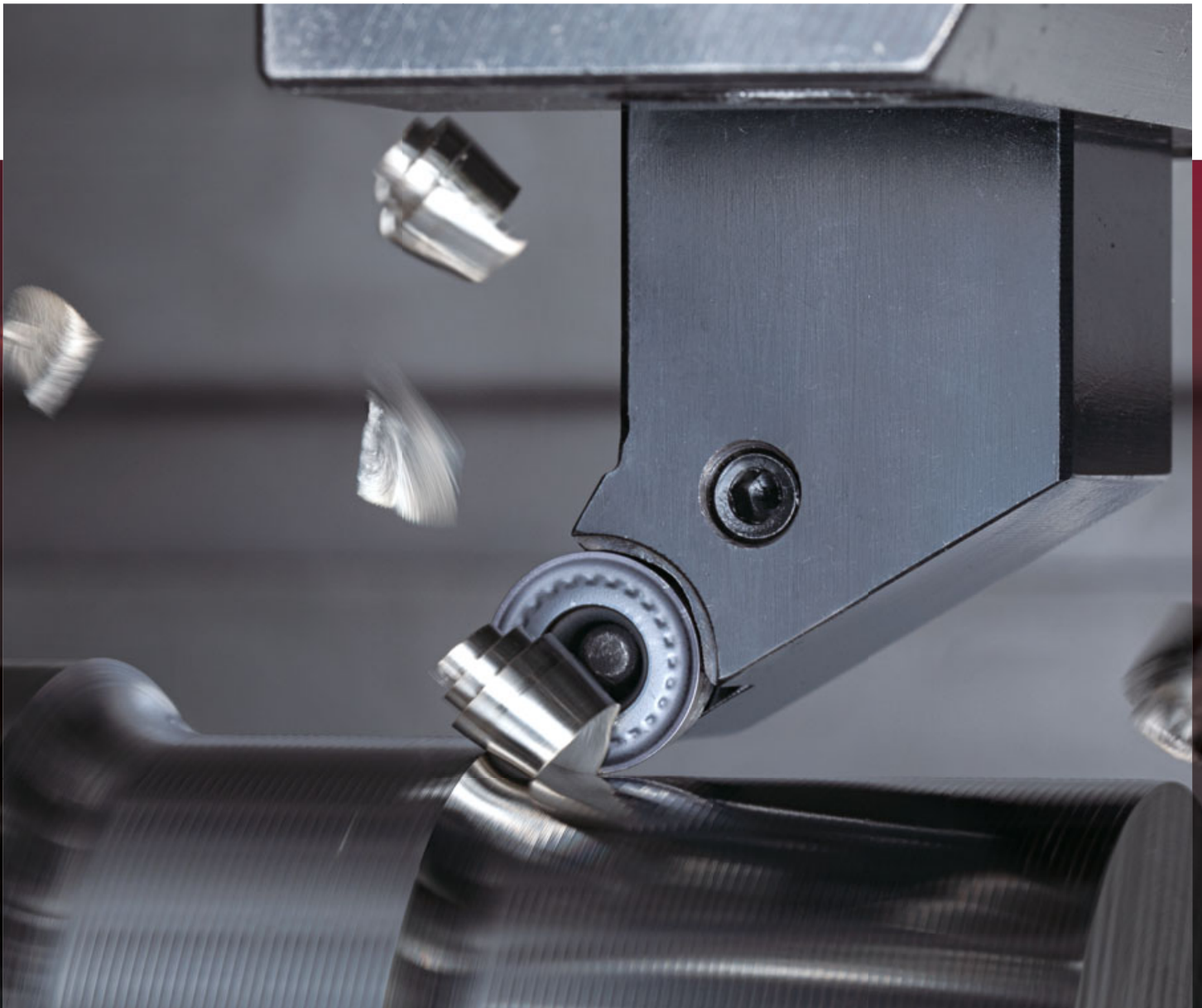


Grades for heat-resistant alloy

# AH8000 SERIES

Tungaloy Report No. 437S2-G

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

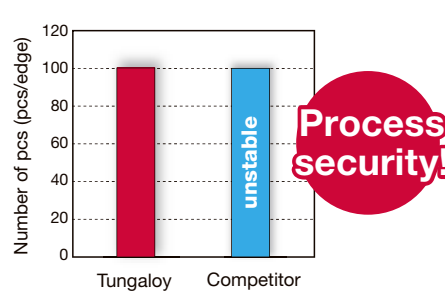
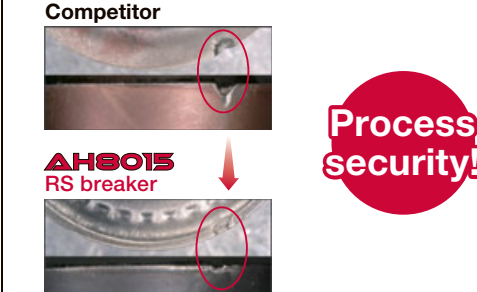




## STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Chipbreaker	Size	Depth of cut ap (mm)	Feed f (mm/rev)	Cutting speed: Vc (m/min)	
						AH8005	AH8015
<b>M</b>	Stainless steel SUS303, SUS304, etc. X10CrNiS18-9, X5CrNi18-9, etc.	<b>RS</b>	RCMT06...	0.5 - 2	0.2 - 0.6	100 - 220	90 - 200
			RCMT08...	0.5 - 2	0.2 - 0.6		
			RCMT10...	1 - 2.5	0.2 - 0.6		
			RCMT12...	1 - 2.5	0.2 - 0.6		
			RCMT16...	1.5 - 3	0.5 - 1		
			RCMT20...	1.5 - 3	0.5 - 1		
			RCMT25...	1.5 - 5	0.5 - 1		
<b>S</b>	Superalloys Inconel718, etc.	<b>RS</b>	RCMT06...	0.5 - 2	0.2 - 0.6	40 - 100	20 - 80
			RCMT08...	0.5 - 2	0.2 - 0.6		
			RCMT10...	1 - 2.5	0.2 - 0.6		
			RCMT12...	1 - 2.5	0.2 - 0.6		
			RCMT16...	1.5 - 3	0.5 - 1		
			RCMT20...	1.5 - 3	0.5 - 1		
			RCMT25...	1.5 - 5	0.5 - 1		

## PRACTICAL EXAMPLES

Workpiece type		Flange	Disk
Insert		RCMT10T3M0-RS	RCMT1606M0-RS
Grade		AH8005	AH8015
Workpiece material		Inconel 718	Ti-6Al-4V
Cutting conditions			
Cutting speed : Vc (m/min)		85	30
Feed : f (mm/rev)		0.25	0.5
Depth of cut : ap (mm)		1.25	3
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>

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