

NEW PRODUCT NEWS

mgt
MEGA TECH
METALWORK

Tungaloy Report No. 373-G

Round insert milling cutter

ROUND **SPLIT**

**Round insert milling cutter with serrated inserts
for superior chatter stability!**





ROUNDSPLIT



Expansion of AH3135 grade insert line for increased tool longevity and better efficiency at accelerated feeds and speeds

ROUNDSPLIT

High efficiency round insert milling cutter

Exceptionally improved chatter resistance

- The serrated cutting edges produce smaller chips.
- Reduced chatter even when machining with a long overhang



Serrated edge type

Comparison of chip shape



ROUNDSPLIT



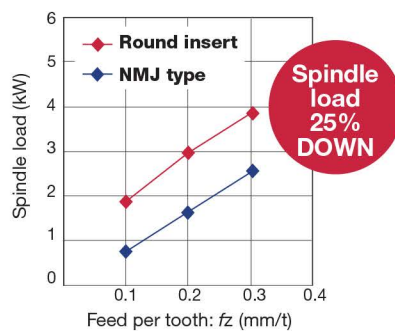
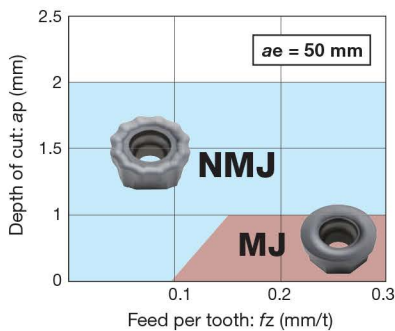
Conventional Round insert

P S55C / C55

Cutter : TRC12R080M31.7-07 (ø80 mm, CICT = 7)
Insert : RCMT1204EN-NMJ AH725
Cutting speed : $V_c = 150$ m/min
Feed per tooth : $f_z = 0.5$ mm/t
Depth of cut : $a_p = 2$ mm
Width of cut : $a_e = 50$ mm
Coolant : Dry
Machine : Vertical M/C, BT50

Comparison of application areas

Comparison of spindle load



P S55C / C55

Cutter : TRC12R050M22.2-05 (ø50 mm, CICT = 5)
Insert : RCMT1204EN-NMJ AH725
Cutting speed : $V_c = 150$ m/min
Feed per tooth : $f_z \sim 0.3$ mm/t
Depth of cut : $a_p \sim 2$ mm
Width of cut : $a_e = 50$ mm (Grooving)
Coolant : Dry
Machine : Vertical M/C, BT50
Overhang length : 238 mm (L/D = 4.76)

Available in the new grades

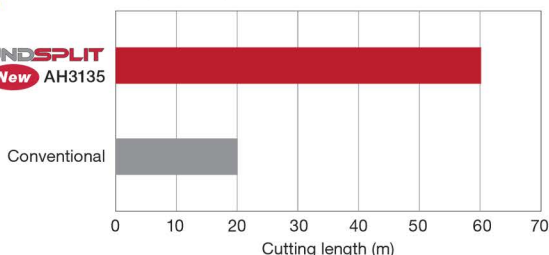
New AH3135 P M

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

CUTTING PERFORMANCE

P S55C / C55 (200HB)

ROUNDSPPLIT
New AH3135



ROUNDSPPLIT



Conventional

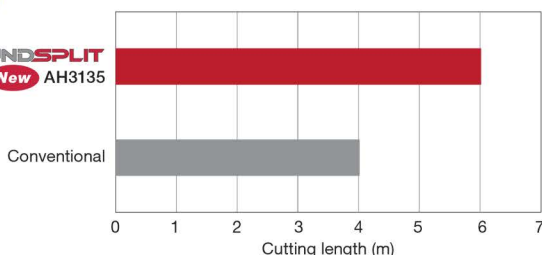
Excessive fracture

Cutter : TRC12R050M22.0-05 (ø50 mm, CICT = 5)
Insert : RCMT1204EN-NMJ AH3135
Cutting speed : $V_c = 200$ m/min
Feed per tooth : $f_z = 0.3$ mm/t
Depth of cut : $a_p = 1.5$ mm
Width of cut : $a_e = 30$ mm
Coolant : Dry
Machine : Vertical M/C, BT50

3 times tool life increase during steel machining!

M SUS304 / X5CrNi18-9 (170HB)

ROUNDSPPLIT
New AH3135



ROUNDSPPLIT



Conventional

Excessive fracture

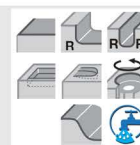
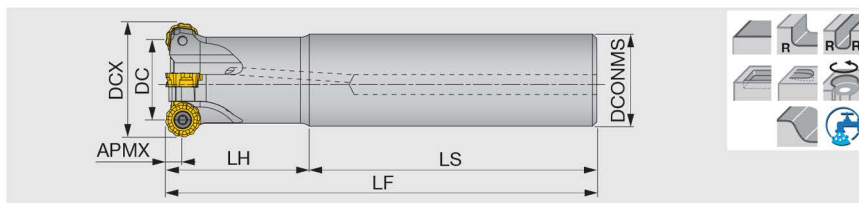
Cutter : TRC12R050M22.0-05 (ø50 mm, CICT = 5)
Insert : RCMT1204EN-NMJ AH3135
Cutting speed : $V_c = 150$ m/min
Feed per tooth : $f_z = 0.2$ mm/t
Depth of cut : $a_p = 1.5$ mm
Width of cut : $a_e = 30$ mm
Coolant : Dry
Machine : Vertical M/C, BT50

Reduced edge fracture during stainless steel machining, while increasing tool life by 1.5 times!

ERC12/16

Endmill, shank type

GAMP = +0°, GAMF = -1° ~ -5°



Designation	APMX	DCX	DC	CICT	DCONMS	LF	LH	LS	WT(kg)	Air hole	Insert
ERC12R032M32.0-03	6	32	20	3	32	150	70	80	0.8	With	RCMT1204...
ERC12R032M32.0-03L	6	32	20	3	32	250	150	100	1.3	With	RCMT1204...
ERC12R032M32.0-03LL	6	32	20	3	32	300	180	120	1.6	With	RCMT1204...
ERC12R033M32.0-03	6	33	21	3	32	150	70	80	0.8	With	RCMT1204...
ERC12R033M32.0-03L	6	33	21	3	32	250	150	100	1.4	With	RCMT1204...
ERC12R033M32.0-03LL	6	33	21	3	32	300	70	230	1.7	With	RCMT1204...
ERC12R040M32.0-04	6	40	28	4	32	150	50	100	0.8	With	RCMT1204...
ERC12R040M32.0-04L	6	40	28	4	32	250	50	200	1.5	With	RCMT1204...
ERC12R040M32.0-04LL	6	40	28	4	32	300	50	250	1.8	With	RCMT1204...
ERC12R050M42.0-05	6	50	38	5	42	150	50	100	1.5	With	RCMT1204...
ERC12R050M42.0-05L	6	50	38	5	42	250	50	200	2.6	With	RCMT1204...
ERC12R050M42.0-05LL	6	50	38	5	42	300	50	250	3	With	RCMT1204...
ERC16R040M32.0-02	8	40	24	2	32	150	50	100	0.8	With	RCMT1606...
ERC16R040M32.0-02L	8	40	24	2	32	250	50	200	1.4	With	RCMT1606...
ERC16R040M32.0-02LL	8	40	24	2	32	300	50	250	1.7	With	RCMT1606...
ERC16R050M42.0-03	8	50	34	3	42	150	50	100	1.4	With	RCMT1606...
ERC16R050M42.0-03L	8	50	34	3	42	250	50	200	2.4	With	RCMT1606...
ERC16R050M42.0-03LL	8	50	34	3	42	300	50	250	3	With	RCMT1606...

SPARE PARTS

Designation	Clamping screw	Wrench
ERC12R...	CSTB-4L090	T-15DB
ERC16R040...	CSTB-5L105	T-20DB
ERC16R050...	CSTB-5L120	T-20DB

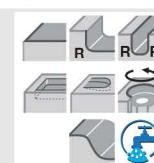
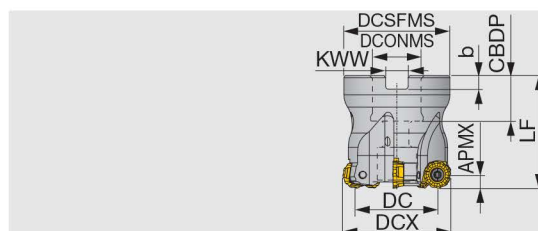
Recommended clamping torque: CSTB-4L090 = 3.5 N·m, CSTB-5L105 = 5 N·m, CSTB-5L120 = 5 N·m

ROUNDSPLIT

TRC12/16

Face mill bore type cutter

GAMP = +0°, GAMF = -1° ~ -5°



Designation	APMX	DCX	DC	CICT	DCSFMS	LF	DCONMS	CBDP	KWW	b	WT(kg)	Air hole	Insert
TRC12R040M16.0-04	6	40	28	4	35	40	16	18	8.2	5.6	0.2	With	RCMT1204...
TRC12R040M16.0E04	6	40	28	4	35	40	16	19	8.4	5.6	0.2	With	RCMT1204...
TRC12R050M22.0-05	6	50	38	5	47	50	22	20	10	6	0.4	With	RCMT1204...
TRC12R050M22.0E05	6	50	38	5	47	50	22	20	10.4	6.3	0.4	With	RCMT1204...
TRC12R050M22.2-05	6	50	38	5	47	50	22.225	20	8	5	0.4	With	RCMT1204...
TRC12R052M22.0E05	6	52	40	5	49	50	22	20	10.4	6.3	0.4	With	RCMT1204...
TRC12R063M22.0-06	6	63	51	6	59	50	22	20	10	6	0.7	With	RCMT1204...
TRC12R063M22.0E06	6	63	51	6	59	50	22	20	10.4	6.3	0.7	With	RCMT1204...
TRC12R063M22.2-06	6	63	51	6	59	50	22.225	20	8	5	0.7	With	RCMT1204...
TRC12R066M22.0E06	6	66	54	6	62	50	22	20	10.4	6.3	0.7	With	RCMT1204...
TRC12R080M27.0E07	6	80	68	7	76	50	27	22	12.4	7	1.1	With	RCMT1204...
TRC12R080M31.7-07	6	80	68	7	76	63	31.750	32	12.7	8	1.5	With	RCMT1204...
TRC16R050M22.0-04	8	50	34	4	47	50	22	20	10	6	0.4	With	RCMT1606...
TRC16R050M22.0E04	8	50	34	4	47	50	22	20	10.4	6.3	0.3	With	RCMT1606...
TRC16R050M22.2-04	8	50	34	4	47	50	22.225	20	8	5	0.4	With	RCMT1606...
TRC16R052M22.0E04	8	52	36	4	49	50	22	20	10.4	6.3	0.4	With	RCMT1606...
TRC16R063M22.0-05	8	63	47	5	59	50	22	20	10	6	0.6	With	RCMT1606...
TRC16R063M22.0E05	8	63	47	5	59	50	22	20	10.4	6.3	0.6	With	RCMT1606...
TRC16R063M22.2-05	8	63	47	5	59	50	22.225	20	8	5	0.7	With	RCMT1606...
TRC16R066M22.0E05	8	66	50	5	62	50	22	20	10.4	6.3	0.7	With	RCMT1606...
TRC16R080M27.0E06	8	80	64	6	76	50	27	22	12.4	7	1	With	RCMT1606...
TRC16R080M31.7-06	8	80	64	6	76	63	31.75	32	12.7	8	1.3	With	RCMT1606...
TRC16R100M31.7-07	8	100	84	7	96	63	31.75	32	12.7	8	1.6	With	RCMT1606...
TRC16R100M32.0E07	8	100	84	7	96	63	32	25	14.4	8	2.4	With	RCMT1606...
TRC16R125M38.1-08	8	125	109	8	98	63	38.1	43	15.9	10	3.6	With	RCMT1606...
TRC16R125M40.0E08	8	125	109	8	98	63	40	32	16.4	9	3	With	RCMT1606...

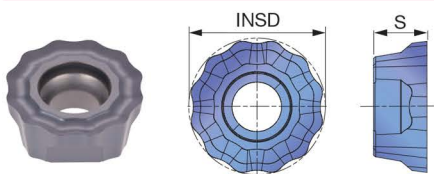
SPARE PARTS

Designation	Clamping screw	Grip	Shell locking bolt 1	Shell locking bolt 2	Torx bit
TRC12R040...	CSTB-4L090	H-TBS	-	FSHM8-30H	BT15S
TRC12R050 - 066...	CSTB-4L090	H-TBS	-	CM10X30H	BT15S
TRC12R080M27.0E07	CSTB-4L090	H-TBS	-	CM12X30H	BT15S
TRC12R080M31.7-07	CSTB-4L090	H-TBS	-	CM16X40H	BT15S
TRC16R050 - 052...	CSTB-5L120	H-TB	-	FSHM10-40H	BT20S
TRC16R063 - 066...	CSTB-5L120	H-TB	-	CM10X30H	BT20S
TRC16R080M27.0E06	CSTB-5L120	H-TB	-	CM12X30H	BT20S
TRC16R080M31.7-06	CSTB-5L120	H-TB	-	CM16X40H	BT20S
TRC16R100...	CSTB-5L120	H-TB	-	CM16X40H	BT20S
TRC16R125...	CSTB-5L120	H-TB	TMBA-M20H	-	BT20M

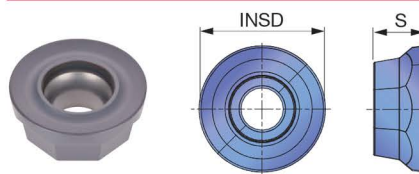
Recommended clamping torque: CSTB-4L090 = 3.5 N·m, CSTB-5L120 = 5 N·m

INSERT

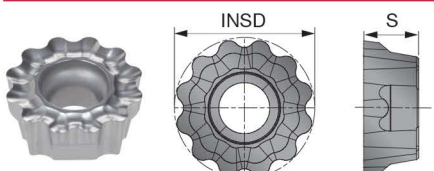
RCMT-NMJ



RCMT-MJ



RCMT-NAJ



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

★ : First choice
☆ : Second choice

Designation	APMX	Coated					Uncoated					INS D	S
		AH120	AH140	AH3135	AH725	KS15F							
RCMT1204EN-NMJ	6	●	●	●	●							12	4.8
RCMT1204EN-MJ	6	●	●	●	●							12	4.8
RCMT1204FN-NAJ	6					●						12	4.8
RCMT1606EN-NMJ	8	●	●	●	●							16	6.5
RCMT1606EN-MJ	8	●	●	●	●							16	6.5
RCMT1606FN-NAJ	8					●						16	6.5

● : New product
● : Line up

STANDARD CUTTING CONDITIONS

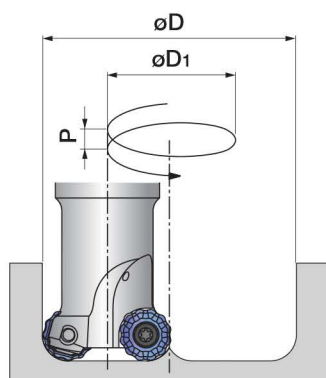
ISO	Workpiece material	Hardness HB	Priority	Grade	Cutting speed Vc (m/min)	Feed per tooth: fz (mm/t) each chipbreaker		
						NMJ	MJ	NAJ
P	Low carbon steels S15C, SS400, etc. C15E4, E275A, etc.	~ 200	First choice For wear resistance	AH3135 AH120	100 - 220	0.17 - 0.3	0.2 - 0.7	-
	High carbon steels S45C, S55C, etc. C45, C55, etc.	200 ~ 300	First choice For wear resistance	AH3135 AH120	100 - 200	0.17 - 0.25	0.2 - 0.7	-
	Alloyed steels SCM440, SCr415, etc. 42CrMo4, 20Cr4, etc.	150 ~ 300	First choice For wear resistance	AH3135 AH120	100 - 200	0.17 - 0.25	0.2 - 0.7	-
	Tool steels SK, SKH, etc. X40CrMoV5-1, etc.	~ 300	First choice For wear resistance	AH3135 AH120	100 - 180	0.17 - 0.25	0.2 - 0.7	-
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc.	-	First choice For impact resistance	AH3135 AH140	90 - 180	0.15 - 0.25	0.2 - 0.6	-
K	Grey cast irons FC250, FC300, etc. 250, 300, etc.	150 ~ 250	First choice For wear resistance	AH3135 AH120	140 - 250	0.17 - 0.3	0.2 - 0.7	-
	Ductile cast irons FCD400, etc. 400-15S, etc.	150 ~ 250	First choice For wear resistance	AH3135 AH120	140 - 250	0.17 - 0.3	0.2 - 0.7	-
N	Aluminium alloys Si < 13%	-		KS15F	500 - 1200	-	-	0.1 - 0.3
	Aluminium alloys Si ≥ 13%	-		KS15F	100 - 300	-	-	0.1 - 0.3
S	Heat-resistant alloy Inconel 718, Ti-6Al-4V, etc.	-	First choice For wear resistance	AH3135 AH725	20 - 50	0.15 - 0.25	0.2 - 0.6	-

• To remove excessive chip accumulation use an air blast.
• When chips stick to the cutting edges (aluminium machining), use a water soluble cutting fluid.

• Cutting conditions are limited by machine power and material rigidity. When the cutting width or depth is large, set Vc and fz below the recommended values and check the machine vibration and spindle load.

ROUNDSPLIT

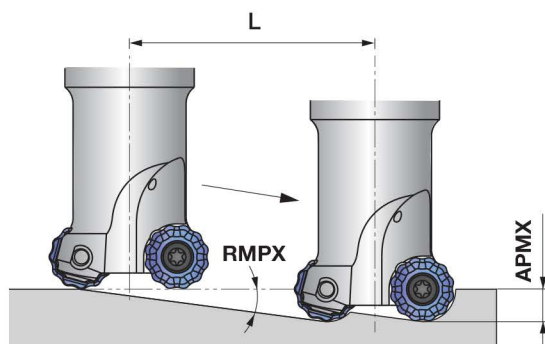
Holemaking with helical feed



Designation	Tool diameter DCX (mm)	Min. machining diameter (mm)		Max. machining diameter (mm)		Pitch P (mm)
		ϕD	$\phi D1$	ϕD	$\phi D1$	
ERC12R032...	$\phi 32$	52	20	62	30	< 6
ERC12R033...	$\phi 33$	54	21	64	31	< 6
T/ERC12R040...	$\phi 40$	68	28	78	38	< 6
T/ERC12R050...	$\phi 50$	88	38	98	48	< 6
TRC12R063...	$\phi 63$	114	51	124	61	< 6
TRC12R080...	$\phi 80$	148	68	158	78	< 6
ERC16R040...	$\phi 40$	64	24	78	38	< 8
T/ERC16R050...	$\phi 50$	84	34	98	48	< 8
TRC16R063...	$\phi 63$	110	47	124	61	< 8
TRC16R080...	$\phi 80$	144	64	158	78	< 8
TRC16R100...	$\phi 100$	184	84	198	98	< 8
TRC16R125...	$\phi 125$	234	109	248	123	< 8

When holemaking with a helical feed, the pitch (P) needs to be set at lower values than that shown above.

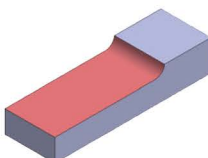
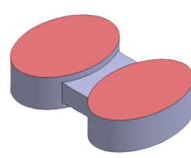
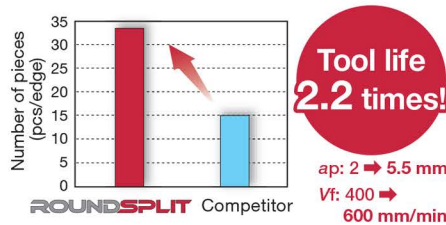
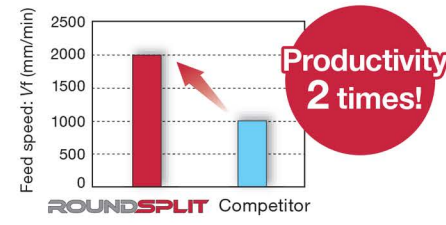
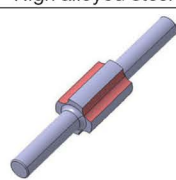
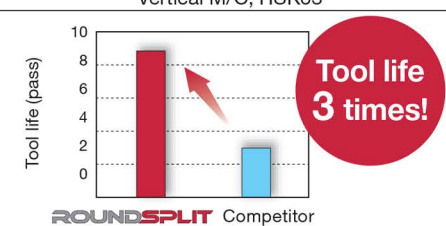
Ramping



Designation	Tool diameter DCX (mm)	Max. ramping angle RMPX	L: tool pass length when ramping angle is 2 degrees				
			ap (mm)				
			2	3	4	6	8
ERC12R032...	$\phi 32$	10°	57	85	114	171	–
ERC12R033...	$\phi 33$	9°	57	85	114	171	–
T/ERC12R040...	$\phi 40$	6°	57	85	114	171	–
T/ERC12R050...	$\phi 50$	4°	57	85	114	171	–
TRC12R063...	$\phi 63$	3°	57	85	114	171	–
TRC12R080...	$\phi 80$	2.3°	57	85	114	171	–
ERC16R040...	$\phi 40$	12°	57	85	114	171	229
T/ERC16R050...	$\phi 50$	7.4°	57	85	114	171	229
TRC16R063...	$\phi 63$	6°	57	85	114	171	229
TRC16R080...	$\phi 80$	4.3°	57	85	114	171	229
TRC16R100...	$\phi 100$	3°	57	85	114	171	229
TRC16R125...	$\phi 125$	2.4°	57	85	114	171	229

Tool pass length: $L = ap / \tan RMPX$, Ramping angle needs to be set at smaller than 2 degrees in order to prevent chips from getting tangled.

PRACTICAL EXAMPLES

Workpiece type		Die & mold parts	Die & mold parts
Cutter		TRC12R050M22.0-05 (ø50 mm, CICT = 5)	ERC12R033M32.0-03 (ø33 mm, CICT = 3)
Insert		RCMT1204EN-NMJ	RCMT1204EN-NMJ
Grade		AH725	AH725
Workpiece material		S50C / C50	SS400 / St44-2
		 P	 P
Cutting conditions	Cutting speed : Vc (m/min)	220	220
	Feed per tooth : fz (mm/t)	0.09	0.3
	Depth of cut : ap (mm)	5.5	1
	Width of cut : ae (mm)	32	20
	Machining	Shoulder milling	Face milling
	Coolant	Dry	Dry
	Machine	Vertical M/C, BT40	Vertical M/C, BT40
Results		 Tool life 2.2 times! ap: 2 → 5.5 mm Vf: 400 → 600 mm/min ROUND SPLIT Competitor NMJ chipbreaker with low cutting force provides high productivity.	 Productivity 2 times! ROUND SPLIT Competitor NMJ chipbreaker with serrated edges allows feed speed to be doubled without chattering, even when machining low rigidity work pieces.
Workpiece type		Stabilizer	
Cutter		TRC12R080M27.0E07 (ø80 mm, CICT = 7)	
Insert		RCMT1204EN-MJ	
Grade		AH725	
Workpiece material		High alloyed steel	
		 P	
Cutting conditions	Cutting speed : Vc (m/min)	100	
	Feed per tooth : fz (mm/t)	0.1	
	Feed speed : Vf (mm/min)	279	
	Depth of cut : ap (mm)	5	
	Width of cut : ae (mm)	40	
	Machining	Face milling	
	Coolant	Wet (Internal)	
	Machine	Vertical M/C, HSK63	
Results		 Tool life 3 times! ROUND SPLIT Competitor RoundSplit MJ geometry delivered low cutting forces, and together with wear-resistant AH725 grade inserts, ensured process security and achieved 3 times tool life at 40% higher cutting speed.	

CONTACT US

mgt

MEGA TECH
METALWORK



MEGA TECH METALWORK CO.,LTD (Headquarter)



Tel : 02-943-1591



Fax : 02-943-1592



Line ID : @mgt_metalwork



Email : sales.m@mgtg.co.th



Web : <https://www.mgtg.co.th/>



17/4 Soi Ramintra 89
Ramintra Khannayao
Bangkok 10230



For more
Information

SCAN NOW

