

Your Professional Cutting Partner



Tools For Rail Transit



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Hi-Tech Cutting Tool Co., Ltd.

Tel: +86 769 8150 2920 Fax: +86 769 81502952 Email: shirleypeng@htcuttingtool.com Web: www.htcuttingtool.com
Add: No. 8, West 1st District, Shihe Road, Shilongkeng Village, Liaobu Town, Dongguan City, China



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Tools for rail wheels

New wheel turning and re-turning

Rough-R



Finish-R



Finish-R



Turning-C/S

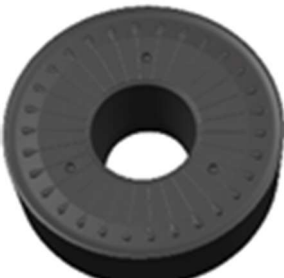
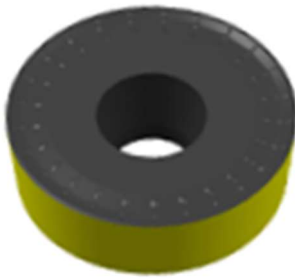


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Geometries and Grades

		
-HM 1st option, general	-HI Interrupted turning	-ME Interrupted turning
The geometry structure takes into the requirements of chip control and strength, suitable for continuous and weakly interrupted heavy turning.	The cutting edge is strengthened with high safety, suitable for heavy-duty turning under intermittent and other unstable conditions.	Suitable for heavy-duty turning inserts for steel and stainless steel, combined with HC4115 material, it has good wear resistance and toughness.

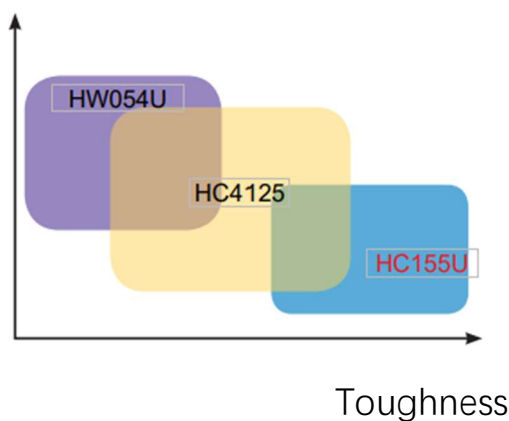
			
-MXR Rough turning	-HWR Rough turning	-HWM Semi-Finishing	-HWF Finishing

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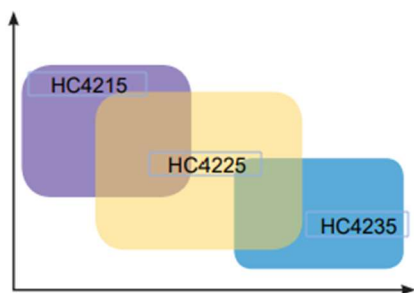
Geometries and Grades

Hardness



CVD Coating	HW054U	Semi-finishing and finishing turning for rail wheels, wet turning.
	HC4125	Semi-finishing and rough turning
	HC155U	Semi-finishing and rough turning

Hardness



CVD Coating	HC4215	High hardness substrate, thick TiCN and Al ₂ O ₃ coating, Excellent wear resistance, suitable for heavy turning under continuous working conditions
	HC4225	Substrate with both hardness and strength, thick TiCN and Al ₂ O ₃ coating, excellent wear resistance, applied in continuous and light intermittent turning.
	HC4235	High strength substrate, thick TiCN and Al ₂ O ₃ coating, excellent impact resistance, suitable for heavy intermittent heavy turning.

Toughness

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Round Inserts (Single-face)

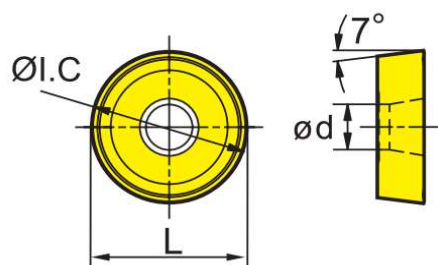
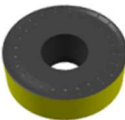
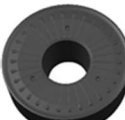


Photo	Code	Dimensions			CVD			Ap (mm)	Fn (mm/r)
		IC	S	d	HW054U	HC4125	HC155U		
	RCMX2006MO-HWF	20	6.35	6.5	★			2.0~8.0	0.20~1.20
	RCMX2507MO-HWF	25	7.94	7.5	★			2.5~10.0	0.25~1.50
	RCMX2006MO-HWM	20	6.35	6.5			●	2.5~8.0	0.20~1.70
	RCMX2507MO-HWM	25	7.94	7.5			●	2.5~10.0	0.25~2.00
	RCMX3209MO-HWM	32	9.525	9.6			●	3.0~12.0	0.30~2.50
	RCMX2507MO-HWR	25	7.94	7.5			★	2.5~10.0	0.25~2.50
	RCMX3209MO-HWR	32	9.525	9.6			★	3.0~12.0	0.30~3.00
	RCMX1606MO-TY	16	6.35	5.2		○		2.0~6.0	0.20~1.0
	RCMX2006MO-MXR	20	6.35	6.5		★		2.5~8.0	0.20~1.70
	RCMX2507MO-MXR	25	7.94	7.2		★		2.5~10.0	0.25~2.50
	RCMX3209MO-MXR	32	9.525	9.76		★		3.0~12.0	0.30~3.00

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Heavy Turning Inserts (CN&SN)



Photo	Code	Dimensions					CVD			Ap (mm)	Fn (mm/r)
		L	IC	S	d	R	HC4215	HC4225	HC4235		
	CNMM190616-HM	19.3	19.05	6.35	7.94	1.6		★		2.0-8.0	0.3-0.8
	CNMM190624-HM	19.3	19.05	6.35	7.94	2.4		★		2.0-8.0	0.4-1.0
	CNMM250924-HM	25.8	25.4	9.525	9.12	2.4		★		3.0-13.	0.5-1.4
	CNMM190616-HI	19.3	19.05	6.35	7.94	1.6		★		2.0-10.	0.3-0.8
	CNMM190624-HI	19.3	19.05	6.35	7.94	2.4		★		2.0-10.	0.4-1.0
	CNMM250924-HI	25.8	25.4	9.525	9.12	2.4		★		3.0-15.	0.5-1.4
	SNMM190616-HM	19.05	19.05	6.35	7.94	1.6		★		2.0-8.0	0.3-0.8
	SNMM190624-HM	19.05	19.05	6.35	7.94	2.4		★		2.0-8.0	0.4-1.0
	SNMM250724-HM	25.4	25.4	7.94	9.12	2.4		★		3.0-15	0.5-1.4
	SNMM250924-HM	25.4	25.4	9.525	9.12	2.4		★		3.0-17	0.5-1.4
	SNMM190616-HI	19.05	19.05	6.35	7.94	1.6		★		2.0-10	0.3-0.8
	SNMM190624-HI	19.05	19.05	6.35	7.94	2.4		★		2.0-10	0.4-1.0
	SNMM250924-HI	25.4	25.4	9.525	9.12	2.4		★		3.0-18	0.5-1.6
	SNMM250932-HI	25.4	25.4	9.525	9.12	3.2		★		3.0-20	0.5-1.6

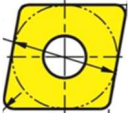
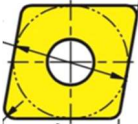
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Heavy Turning Inserts (CN&SN)



Photo	Code	Dimensions					CVD			Ap (mm)	Fn (mm/r)
		L	IC	S	d	R	HC4215	HC4225	HC4235		
 -PM, semi-finishing turning	CNMG190616-PM	19.30	19.05	6.35	7.94	1.6 0		★		2.0-8.0	0.3-0.7
 -KPR, rough turning	CNMG190616-KPR	19.30	19.05	6.35	7.94	1.6 0		★		2.0-8.0	0.3-0.7
 -KPR, rough turning	SNMG190616-KPR	19.05	19.05	6.35	7.94	1.6 0		★		2.0-8.0	0.3-0.7
 -HT, heavy turning	SNMM250724-HT	25.40	25.40	7.94	9.12	2.4 0		★		3.0-15	0.5-1.4
	SNMM250924-HT	25.40	25.40	9.53	9.12	2.4 0		★		3.0-15	0.5-1.4

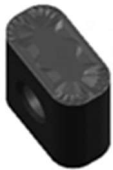
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Wheel Re-turning Inserts



Photo	Code	Dimensions					CVD			Ap (mm)	Fn (mm/r)
		L	C	S	d	R	HC4215	HC4225	HC4235		
	LNMX191940-RWF	19.05	19.05	10.0	6.35	4.0		★		0.3~5.0	0.3~1.0
	LNMX191940-RWM	19.05	19.05	10.0	6.35	4.0		★		1.5~9.0	0.45~1.3
	LNMX301940-RWM	30.00	19.05	12.0	6.35	4.0		★		1.5~15.	0.5~1.3
	LNMX301940-RWR	30.00	19.05	12.0	6.35	4.0		★		2.0~15.	0.7~1.5

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Rail wheel axles turning inserts



Photo	Code	Cutting Parameter					CVD		
		L	IC	S	d	R	HC4215	HC4225	HC4235
	LNMX322212-RWR	32.0	22.0	12.7	6.6	1.2		★	
	CNMG190612-PM	19.30	19.05	6.35	7.94	1.20		★	
	CNMM190624-WE	19.30	19.05	6.35	7.94	2.40		★	
	CNMM250924-WE	25.80	25.40	9.53	9.12	2.40		★	
	SNMG190616-PM	19.05	19.05	6.35	7.94	1.60		★	
	SNMM190624-WE	19.05	19.05	6.35	7.94	2.4		★	
	SNMM250924-WE	25.4	25.4	9.52	9.12	2.4		★	
	DNMG150608-PM	15.5	12.7	6.35	5.16	0.8		★	
	DNMG150612-PM	15.5	12.7	6.35	5.16	1.2		★	
	TNMG220412-PR	22	12.7	4.76	5.16	1.2		★	
	VBMT160408-TM	16.5	9.525	4.76	4.4	0.8		★	

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Milling inserts for turnout profile



Photo	Code	Cutting Parameter					CVD	PVD	Picture
		L	IW	S	d	R	MC4130	MP1120	
	N18-1	15.88	12.7	7.94	5.5		★		
	SNC55-1	15.88	12.7	7.94	5.5		★		
	N134	15.88	12.7	7.94	5.5	16	★		
	N137	15.88	12.7	7.94	5.5	2	★		
	N136	15.88	12.7	7.94	5.5		★		
	N135-R10	15.88	12.7	7.94	5.5	10	★		
	N135-NR 13	15.88	12.7	7.94	5.5	13	★		
	NR80	15.88	12.7	7.94	5.5	80	★		
	NR80-A	15.88	12.7	7.94	5.5	75	★		
	NR80-B	15.88	12.7	7.94	5.5	70	★		
	NR300	15.88	12.7	7.94	5.5	300	★		

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Milling inserts for cut off

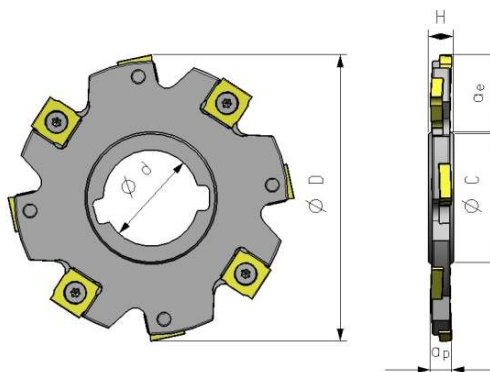
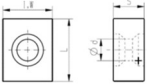


Photo	Code	Cutting Parameter					CVD	PVD	Picture
		L	IW	S	d	R	MC4130	MP1120	
	N19	19.05	14.3	6.35	5.8	0.0	★		
	N19-2A	19.05	14.3	6.35	5.8	1.0	★		

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Drilling inserts

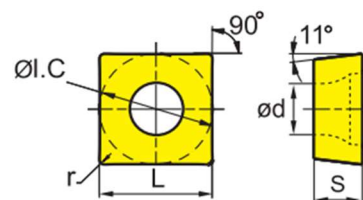
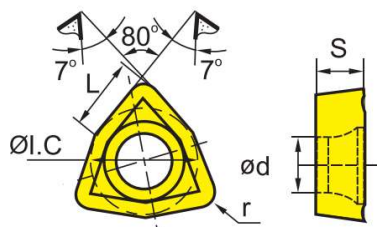


Photo	Code	Cutting Parameter					CVD	PVD
		L	IW	S	d	R	MC4130	MP1120
	WCMX030208-UK	6.6	5.56	2.38	2.8	0.8	★	
	WCMX040208-UK	4.3	6.35	2.38	3.1	0.8	★	
	WCMX050308-UK	9.63	7.94	3.33	3.2	0.8	★	
	WCMX06T308-UK	11.64	9.53	4.11	3.7	0.8	★	
	WCMX080412-UK	15.45	12.70	4.88	4.3	1.2	★	
	SPMT050204-UK	5	5	2.47	2.2	0.4	★	
	SPMT060204-UK	6	6	2.47	2.6	0.4	★	
	SPMT07T308-UK	7.94	7.94	4.16	2.8	0.8	★	
	SPMT090408-UK	9.8	9.8	4.49	4.1	0.8	★	
	SPMT110408-UK	11.5	11.5	4.76	4.4	0.8	★	

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