

High speed turning in demanding HRSA materials

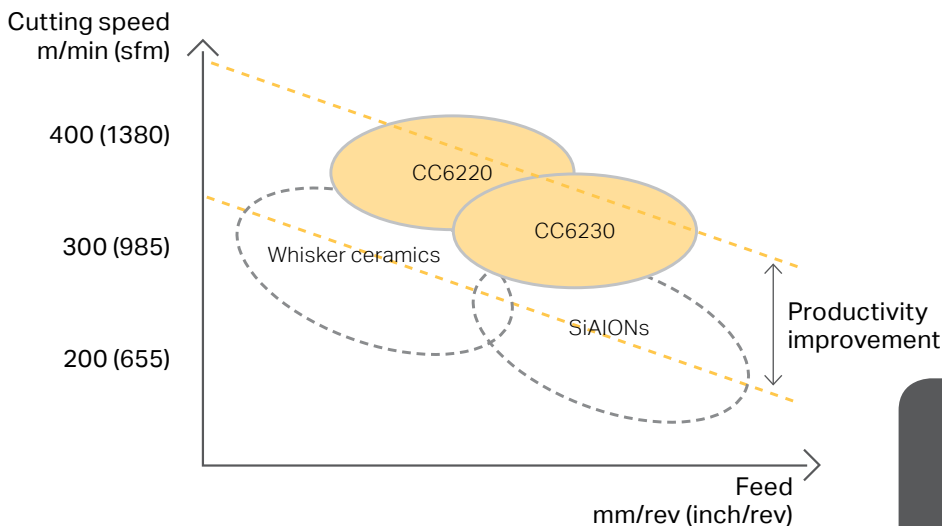
There is a growing demand for aerospace engine parts that can withstand extreme temperatures, beyond the capability of Inconel and other high-performing super alloys. While powder metallurgical materials can be tailored to handle substantially higher temperatures, they are more difficult to machine than Inconel 718.

The new ceramic grades CC6220 and CC6230 are developed to machine demanding materials where whisker ceramics and SiAlONs fall short. Their ability to handle high cutting speeds contributes to reduced cost per component.



Turning productivity enhanced

CC6220 and CC6230 excel in demanding materials in intermediate stage machining. They take productivity to a new level compared to whisker ceramics and SiAlONs both when it comes to cutting speed and feed.



Benefits of CC6220 and CC6230

- High metal removal rate
- Long tool life in powder metallurgical material
- Stable process at high cutting speeds
- Reduced cost per component

Assortment CC6220 & CC6230

Insert code ANSI	Insert code ISO
RCGX 24 T0420	RCGX 060600 T01020
RCGX 35 T0420	RCGX 090700 T01020
RCGX 45 T0420	RCGX 120700 T01020
RNG 45 A	RNGN 120700 E
RNG 45 T0420	RNGN 120700 T01020
RPGX 35 T0420	RPGX 090700 T01020
RPGX 45 T0420	RPGX 120700 T01020

Application area

CC6220 and CC6230 are specifically developed for turbine discs in HRSA material, such as Inconel 718 and powder metallurgical nickel base alloys.

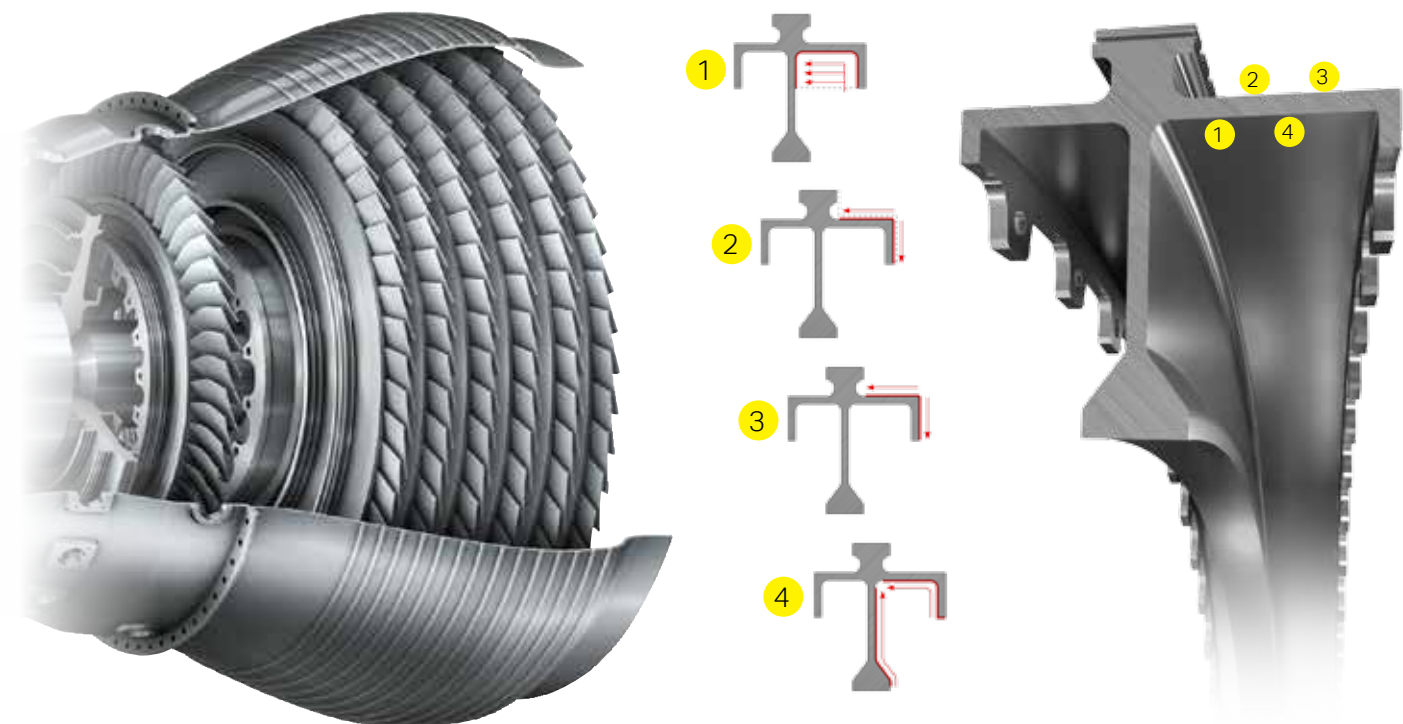
Performance optimization

Component: LPT Disc

Material: René material, 42-45 HRc

Operation: Intermediate, wet

	CC6220	CC6230		
Insert	RPGX120700 T01020	RPGX120700 T01020		
Operation: 1 pocketing, 2 roughing, 3 and 4 semi-finishing				
	①	②	③	④
v_c m/min (sfm)	400 (1380)	400	210 (820)	350 (1150)
f_n mm/rev (inch/rev)	0.2 (0.008)	0.2	0.12 (0.005)	0.15 (0.006)
a_p mm (inch)	1.0 (0.04)	1.0	0.3 (0.012)	0.3
MRR cm ³ /min (inch ³ /min)	80 (5)	80	7.6 (0.46)	15.8 (0.96)
Time in cut, min	2.5	5	6 & 6	13 & 9



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