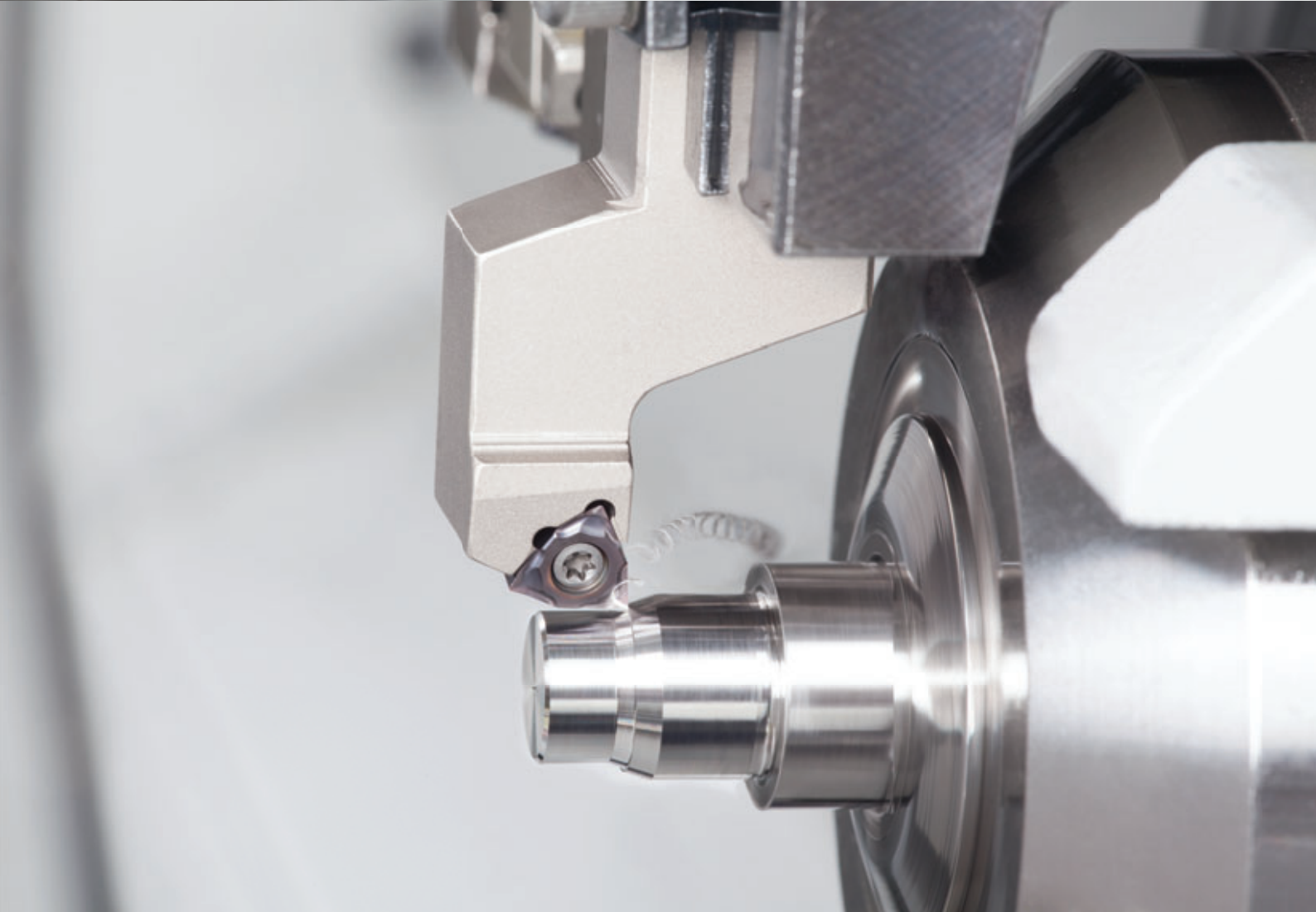
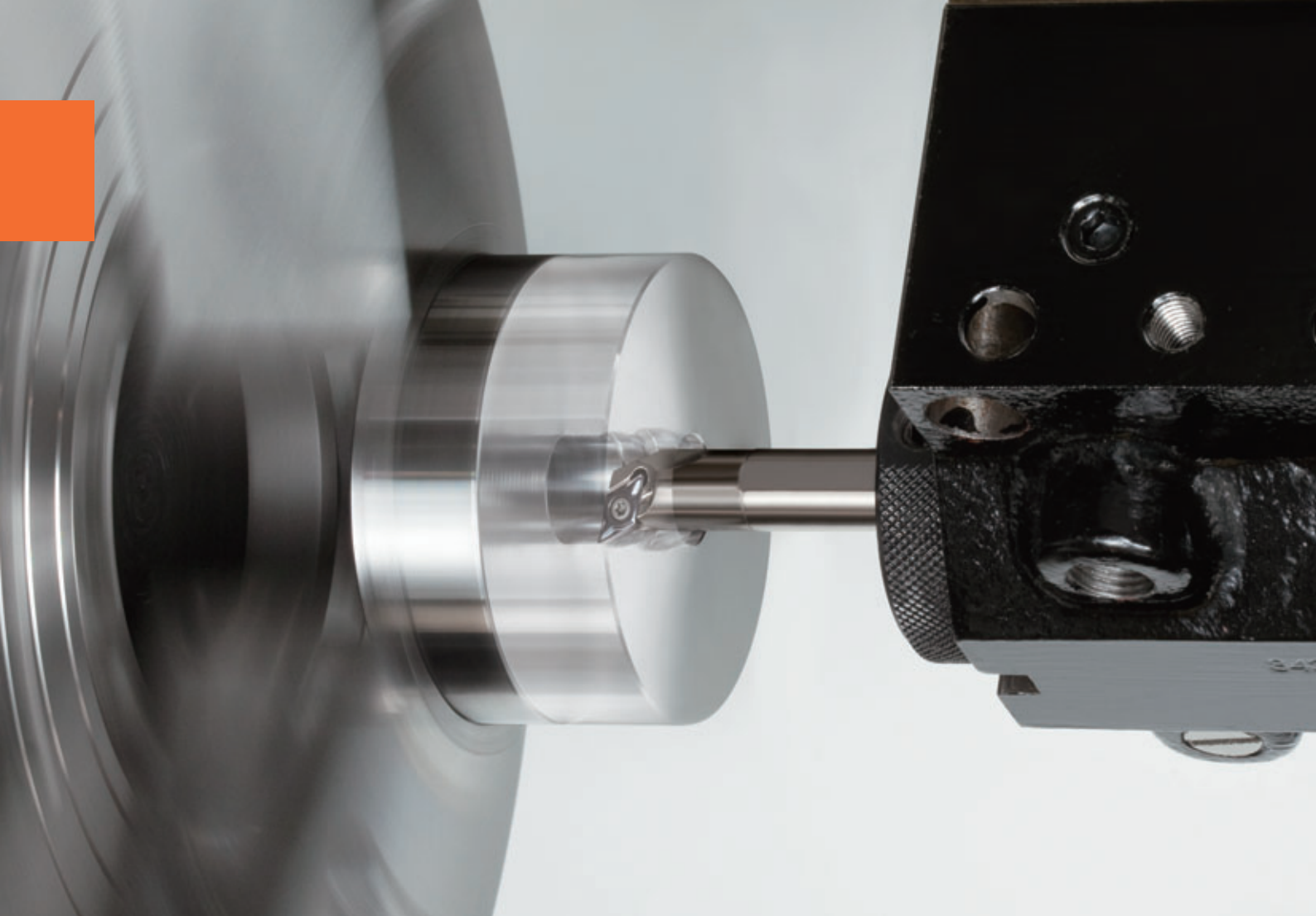


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Innovative insert
provides superior
economic advantages!







MINI^{FORCE}TURN

TUNGALOY

VXGU insert, new tooling,
new chipbreaker, and new grades
are newly added!

MINIFORCE

TUNGALOY



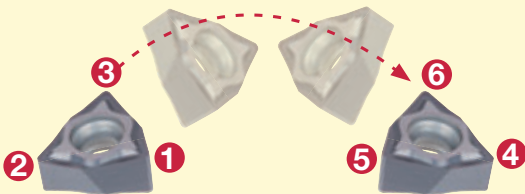
Economical double sided inserts with positive cutting edge

Innovative multi-cornered insert clamped into a unique pocket ensures insert stability resulting in superior machining performance.

● Inserts

● High rake angle

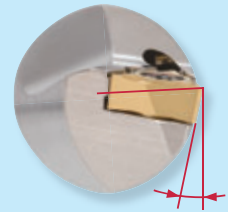
WXGU0403.. Inserts with 6 positive cutting edges



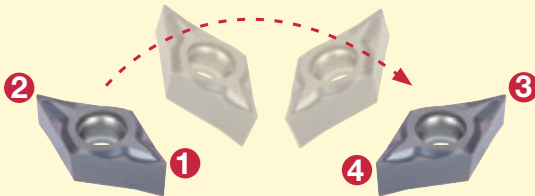
External turning



Internal turning



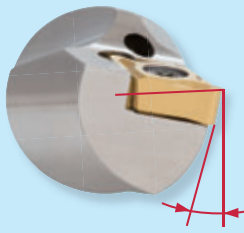
DXGU0703.. Inserts with 4 positive cutting edges



External turning

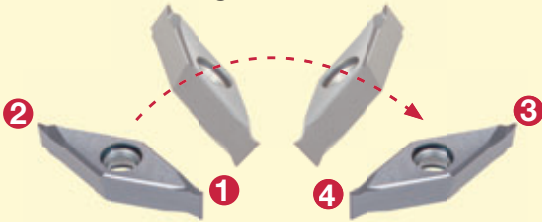


Internal turning



New

VXGU09T2.. Inserts with 4 positive cutting edges

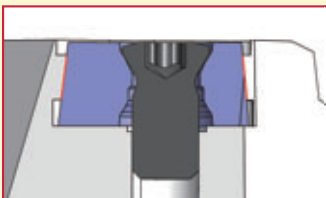


External turning



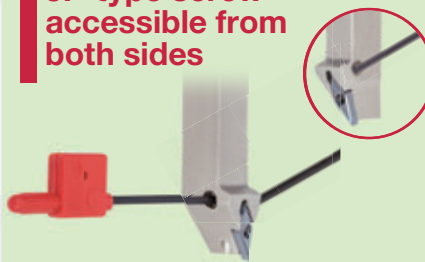
● Toolholders

Dovetail structure ensures secure insert clamping.



External turning

JP-type screw accessible from both sides



Internal turning

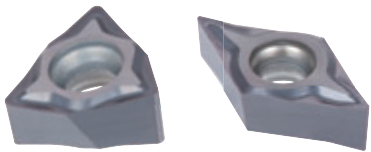
Unique design for optimal chip evacuation



Uniquely designed chipbreakers

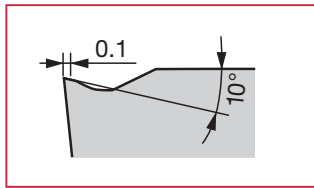
TS / JTS / TSW chipbreaker

P M K



WXGU0403..

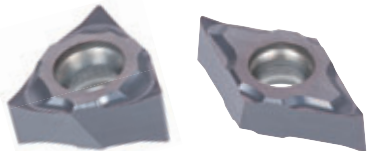
DXGU0703..



Excellent chip control, recommended for steel and stainless steel machining.

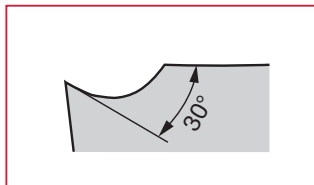
SS / JSS chipbreaker

M P



WXGU0403..

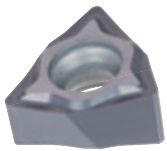
DXGU0703..



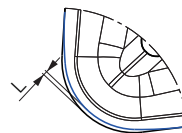
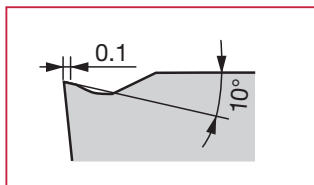
Generates low cutting forces, recommended for steel and stainless steel machining.

TSW chipbreaker (Wiper)

P M K



WXGU0403..

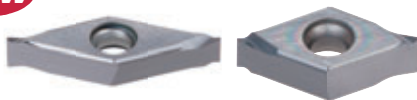


Off set: $L = -0.05 \text{ mm}$

Excellent surface finishing and high efficiency for high feed machining.

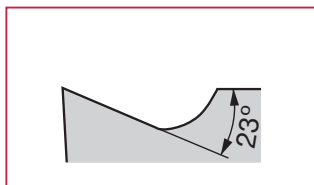
JRP chipbreaker

New



VXGU09T2..

DXGU0703..



Sharp cutting edge and ground chipbreaker with excellent chip control.

Chipbreakers for general purposes

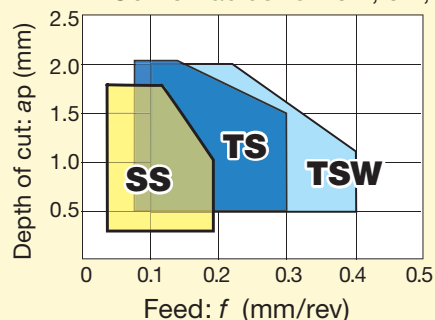
WXGU0403.. - **TS / SS / TSW**

DXGU0703.. - **TS / SS**

Reinforced cutting edge used at medium to low feeds in semi-finishing and finishing operations.

Application area

Corner radius $r_{\epsilon} = 0.2, 0.4, 0.8$



Chipbreakers for small parts machining

WXGU0403.. - **JTS / JSS**

DXGU0703.. - **JTS / JSS**

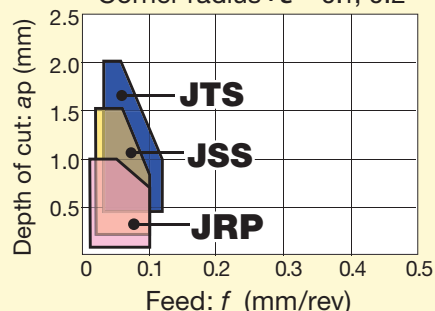
VXGU09T2.. - **JRP**

Extra sharp cutting edge used at low feeds for finishing operations.

An excellent solution to reduce vibration.

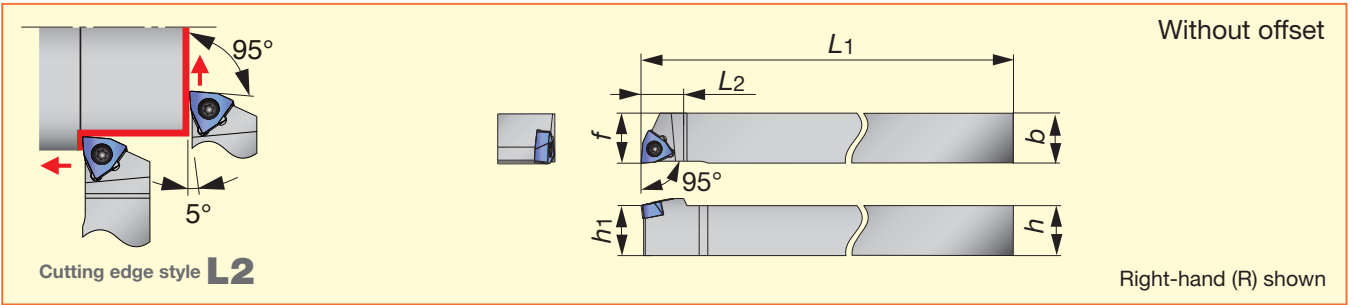
Application area

Corner radius $r_{\epsilon} = 0.1, 0.2$



External toolholders

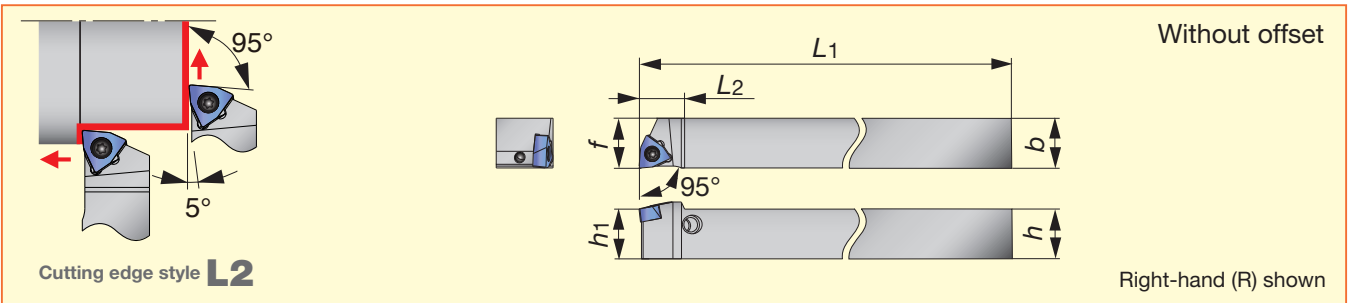
JSWL2XR/L External turning and facing JS type (Positive rake, screw-on system)



Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Clamping screw	Wrench	
JSWL2XR/L1010X04	●	●	10	10	120	11	10	10	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L1212F04	●	●	12	12	85	11	12	12	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L1212X04	●	●	12	12	120	11	12	12	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
JSWL2XR/L1616X04	●	●	16	16	120	13	16	16	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9
New JSWL2XR/L2020H04	●	●	20	20	100	13	20	20	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9

- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

JPWL2XR/L External turning and facing JP type (Positive rake, side-clamping system)

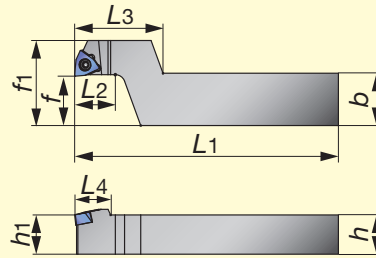
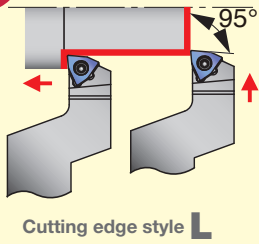


Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_ϵ	Insert	Parts				Torque (N·m)
	R	L	h	b	L ₁	L ₂	h ₁	f			Lever	Pin	Clamping screw	Wrench	
JPWL2XR/L1010X04	●	●	10	10	120	11	10	10	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9
JPWL2XR/L1212F04	●	●	12	12	85	11	12	12	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9
JPWL2XR/L1212X04	●	●	12	12	120	11	12	12	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9
JPWL2XR/L1616X04	●	●	16	16	120	13	16	16	0.2	WXGU0403**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9

- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

JSWLXR-F External turning and facing Stepped-head type (Positive rake, screw-on system)

New



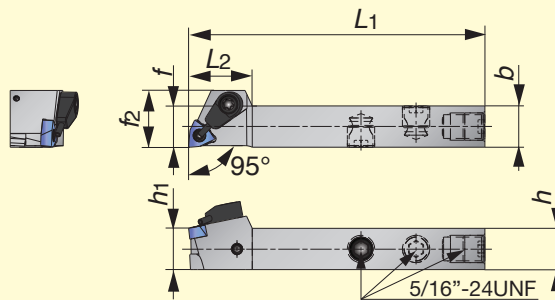
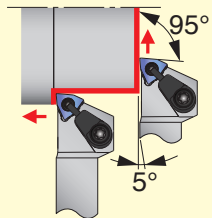
Right-hand (R) shown

Cat. No.	Stock		Dimensions (mm)									Std. corner radius r_e	Insert	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	L_3	L_4	h_1	f	f_1			Clamping screw	Wrench	
JSWLXR1016X04-F15	●		10	16	120	12	27	11	10	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9
JSWLXR1216F04-F15	●		12	16	85	12	27	11	12	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9
JSWLXR1216X04-F15	●		12	16	120	12	27	11	12	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9
JSWLXR1620X04-F15	●		16	20	120	12	27	11	16	15	26	0.2	WXGU0403**L	SR34-514	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

Works with high-pressure coolant

JSWL2XR/L-CHP External turning and facing CHP type (Positive rake, screw-on system)



TUNGJET
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Without offset

Right-hand (R) shown

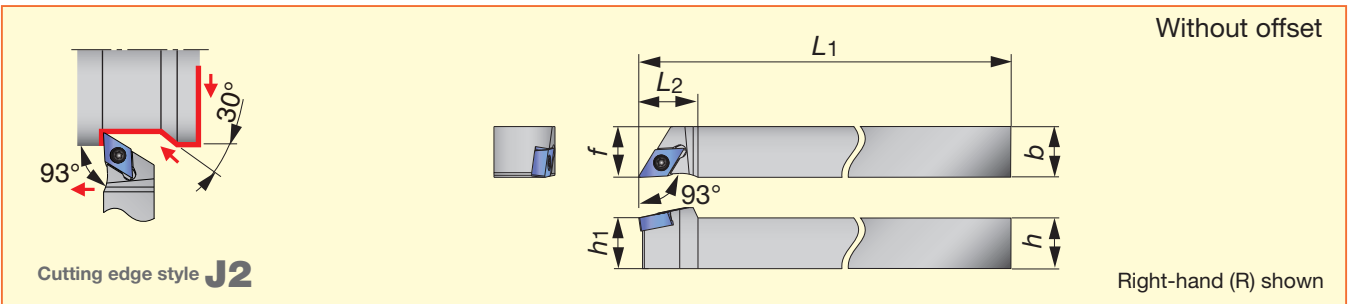
Cat. No	Stock		Dimensions (mm)							Std. corner radius r_e	Insert	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench	
JSWL2XR/L1212F04-CHP	●	●	12	12	85	18	12	12	16.5	0.2	WXGU0403**L/R	SR34-514	T-7F	0.9

- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

TungJet parts
P49 - 50

● : Stocked items

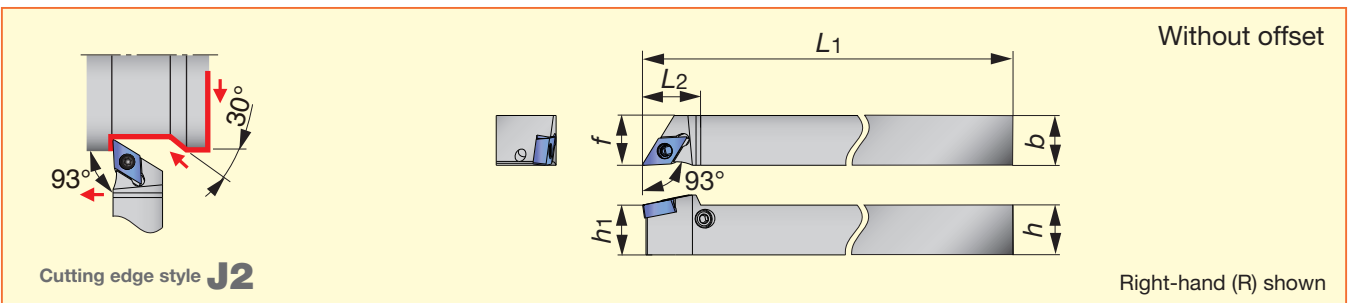
JSDJ2XR/L External turning and profiling JS type (Positive rake, screw-on system)



Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_{ϵ}	Insert	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSDJ2XR/L1010X07	●	●	10	10	120	14	10	10	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L1212F07	●	●	12	12	85	14	12	12	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L1212X07	●	●	12	12	120	14	12	12	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
JSDJ2XR/L1616X07	●	●	16	16	120	18	16	16	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9
New JSDJ2XR/L2020H07	●	●	20	20	100	18	20	20	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9

- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

JPDJ2XR/L External turning and profiling JP type (Positive rake, side-clamping system)

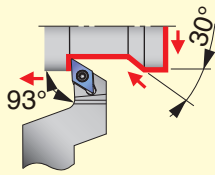


Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_{ϵ}	Insert	Parts				Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Lever	Pin	Clamping screw	Wrench	
JPDJ2XR/L1010X07	●	●	10	10	120	14	10	10	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9
JPDJ2XR/L1212F07	●	●	12	12	85	14	12	12	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9
JPDJ2XR/L1212X07	●	●	12	12	120	14	12	12	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9
JPDJ2XR/L1616X07	●	●	16	16	120	18	16	16	0.2	DXGU0703**L/R	SLLV-2	SL-PI-2	SR10400611	HW 2.0/5 RED	0.9

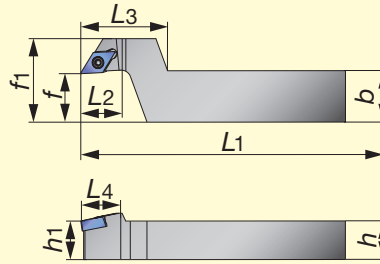
- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

JSDJXR-F External turning and profiling Stepped-head type (Positive rake, screw-on system)

New



Cutting edge style **J**



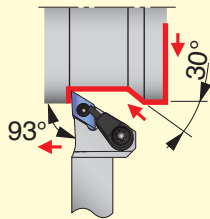
Right-hand (R) shown

Cat. No.	Stock		Dimensions (mm)								Std. corner radius r_e	Insert	Parts		Torque (N·m)	
	R	L	h	b	L_1	L_2	L_3	L_4	h_1	f			f_2	Clamping screw		Wrench
JSDJXR1016X07-F15	●		10	16	120	12	27	14	10	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JSDJXR1216F07-F15	●		12	16	85	12	27	14	12	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JSDJXR1216X07-F15	●		12	16	120	12	27	14	12	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JSDJXR1620X07-F15	●		16	20	120	12	27	14	16	15	26	0.2	DXGU0703**L	SR34-514	T-7F	0.9

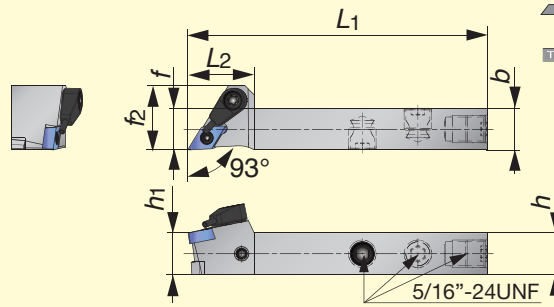
① Right-hand toolholders (R) are used with left-hand inserts (L)

Works with high-pressure coolant

JSDJ2XR/L-CHP External turning and profiling CHP type (Positive rake, screw-on system)



Cutting edge style: **J2**



TUNGJET
TUNGALOY

Without offset

Right-hand (R) shown

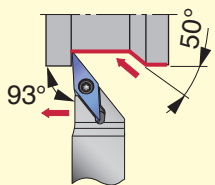
Cat. No	Stock		Dimensions (mm)							Std. corner radius r_e	Insert	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench	
JSDJ2XR/L1212F07-CHP	●	●	12	12	85	19	12	12	18.5	0.2	DXGU0703**L/R	SR34-514	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

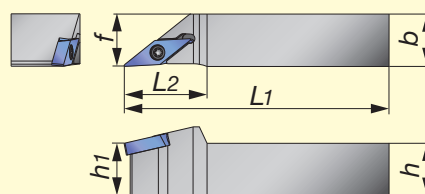
② Left-hand toolholders (L) are used with right-hand inserts (R)

JSVJ2XR/L External turning and profiling JS type (Positive rake, screw-on system)

New



Cutting edge style **J2**



Without offset

Right-hand (R) shown

Cat. No.	Stock		Dimensions (mm)						Std. corner radius r_e	Insert	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f			Clamping screw	Wrench	
JSVJ2XR/L1010X09	●	●	10	10	120	17	10	10	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L1212F09	●	●	12	12	85	19	12	12	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L1212X09	●	●	12	12	120	19	12	12	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L1616X09	●	●	16	16	120	19	16	16	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9
JSVJ2XR/L2020H09	●	●	20	20	100	19	20	20	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9

① Right-hand toolholders (R) are used with left-hand inserts (L)

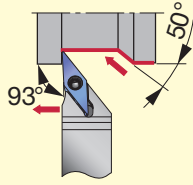
② Left-hand toolholders (L) are used with right-hand inserts (R)

● : Stocked items

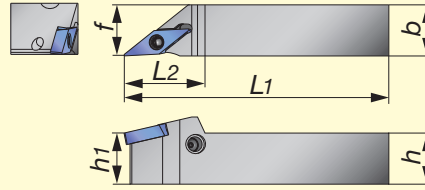
JPVJ2XR/L External turning and profiling JP type (Positive rake, side-clamping system)

New

Without offset



Cutting edge style **J2**

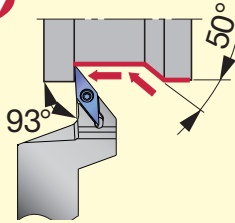


Cat. No.	Stock		Dimensions (mm)							Std. corner radius r_E	Insert	Parts				Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	Lever			Pin	Clamping screw	Wrench		
JPVJ2XR/L1010X09	●	●	10	10	120	19	10	10	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9	
JPVJ2XR/L1212F09	●	●	12	12	85	19	12	12	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9	
JPVJ2XR/L1212X09	●	●	12	12	120	19	12	12	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9	
JPVJ2XR/L1616X09	●	●	16	16	120	19	16	16	0.2	VXGU09T2**L/R	SLLV-1	SL-PI-2	SR 10400611	HW 2.0/5 RED	0.9	

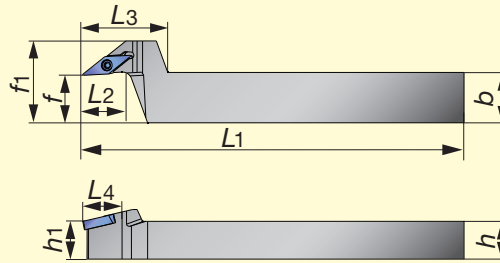
- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

JSVJXR-F External turning and profiling Stepped-head type (Positive rake, screw-on system)

New



Cutting edge style **J**



Right-hand (R) shown

Cat. No.	Stock		Dimensions (mm)								Std. corner radius r_E	Insert	Parts		Torque (N·m)	
	R	L	h	b	L_1	L_2	L_3	L_4	h_1	f			f_1	Clamping screw		Wrench
JSVJXR1016X09-F15	●		10	16	120	12	27	19	10	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JSVJXR1216F09-F15	●		12	16	85	12	27	19	12	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JSVJXR1216X09-F15	●		12	16	120	12	27	19	12	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JSVJXR1620X09-F15	●		16	20	120	12	27	19	16	15	26	0.2	VXGU09T2**L	SR34-508	T-7F	0.9

- ① Right-hand toolholders (R) are used with left-hand inserts (L)

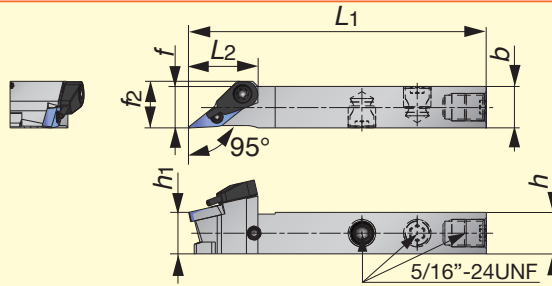
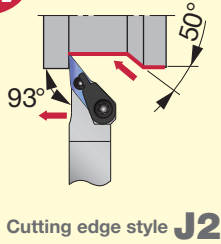
● : Stocked items

Works with high-pressure coolant

JSVJ2XR/L-CHP External turning and profiling

CHP type (Positive rake, screw-on system)

New



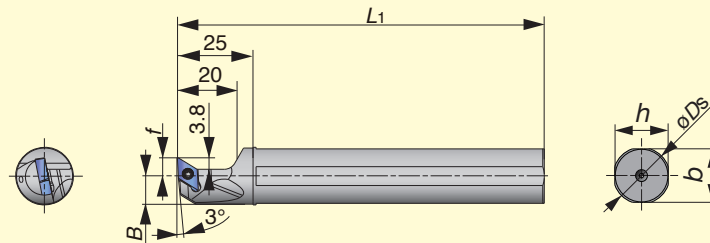
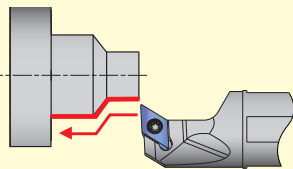
TUNGJET
TUNGALOY
Without offset

Cat. No	Stock		Dimensions (mm)							Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
	R	L	h	b	L_1	L_2	h_1	f	f_2			Clamping screw	Wrench	
JSVJ2XR/L1212F09-CHP	●	●	12	12	85	20.0	12	12	13.5	0.2	VXGU09T2**L/R	SR34-508	T-7F	0.9

- ① Right-hand toolholders (R) are used with left-hand inserts (L)
- ② Left-hand toolholders (L) are used with right-hand inserts (R)

JS-SDUXL External turning and profiling

JS type (Positive rake, screw-on system)



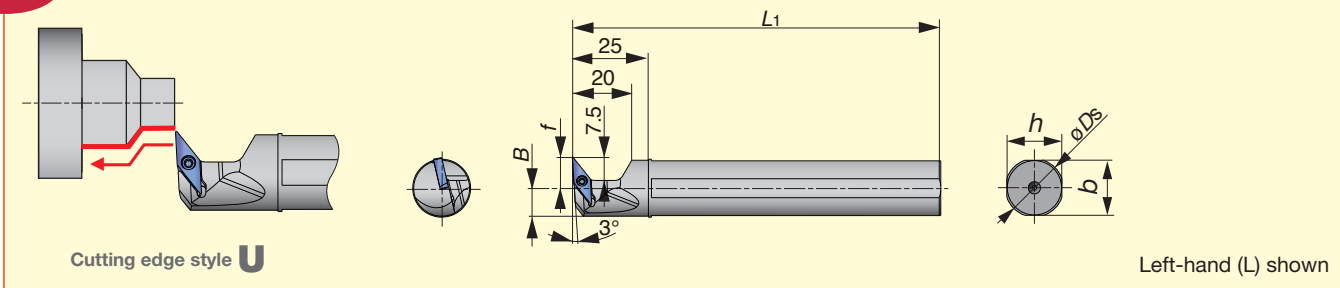
Left-hand (L) shown

Cat. No.	Stock	Dimensions (mm)					Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)
		ϕD_s	f	L_1	h/b	B			Clamping screw	Wrench	
JS14H-SDUXL07	●	14	6	100	13	6.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS159F-SDUXL07	●	15.875	6	85	15	7.687	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS16F-SDUXL07	●	16	6	85	15	7.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS19G-SDUXL07	●	19.05	6	90	18	9.275	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS19X-SDUXL07	●	19.05	6	120	18	9.275	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS20G-SDUXL07	●	20	6	90	19	9.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS20X-SDUXL07	●	20	6	120	19	9.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS22X-SDUXL07	●	22.0	10	120	21	10.75	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS25H-SDUXL07	●	25.0	10	100	24	12.25	0.2	DXGU0703**L	SR34-514	T-7F	0.9
JS254X-SDUXL07	●	25.4	10	120	24	12.45	0.2	DXGU0703**L	SR34-514	T-7F	0.9

- ① Left-hand toolholders (L) are used with left-hand inserts (L)

JS-SVUXL External turning and profiling JS type (Positive rake, screw-on system)

New






Cat. No.	Stock	Dimensions (mm)					Std. corner radius r_E	Insert	Parts		Torque (N·m)
		ϕD_s	f	L_1	h/b	B			Clamping screw	Wrench	
JS159F-SVUXL09	●	15.875	10	85	15	7.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS16F-SVUXL09	●	16	10	85	15	7.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS19G-SVUXL09	●	19.05	10	90	18	9.2	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS19X-SVUXL09	●	19.05	10	120	18	9.2	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS20G-SVUXL09	●	20	10	90	19	9.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS20X-SVUXL09	●	20	10	120	19	9.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS22X-SVUXL09	●	22	10	120	21	10.7	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS25H-SVUXL09	●	25	10	100	24	12.2	0.2	VXGU09T2**L	SR34-508	T-7F	0.9
JS254X-SVUXL09	●	25.4	10	120	24	12.4	0.2	VXGU09T2**L	SR34-508	T-7F	0.9

① Left-hand toolholders (L) are used with left-hand inserts (L)

● : Stocked items

Parts for CHP-type toolholders

Toolholder Cat. No	Applicable inserts	Screw	Wrench	Coolant unit
				
JSDJ2XR/L1212F07-CHP	DXGU0703□□L/R	SR34-514	T-7F	S-CU-CHP
JSWL2XR/L1212F04-CHP	WXGU0403□□L/R	SR34-514	T-7F	S-CU-CHP
JSVJ2XR/L1212F09-CHP	VXGU09T2□□L/R	SR34-514	T-7F	S-CU-CHP

Cutting performance

Unique design which prevents vibration

Workpiece : S45C / C45
 Insert : WXGU040304L-TS AH725
 Toolholder : A12M-SWLXR04-D140
 Cutting speed : $V_c = 150$ m/min
 Overhang length : 36 mm (L/D = 3)
 Coolant : Wet (internal supply)

DOMTURN
BORE LINE

Depth of cut: ap (mm)	2.0	OK	OK	OK	OK
	1.5	OK	OK	OK	OK
	1.0	OK	OK	OK	OK
	0.5	OK	OK	OK	OK
ap/f		0.05	0.10	0.15	0.20
Feed: f (mm/rev)					

ISO positive insert

Depth of cut: ap (mm)	2.0	OK	OK	OK	OK
	1.5	OK	OK	OK	OK
	1.0	OK	OK	OK	OK
	0.5	OK	OK	OK	OK
ap/f		0.05	0.10	0.15	0.20
Feed: f (mm/rev)					

Chip control

P

Depth of cut: ap (mm)	2.0				
	1.5				
	1.0				
	0.5				
ap/f		0.05	0.10	0.15	0.20
Feed: f (mm/rev)					

Workpiece : S45C / C45
 Insert : WXGU040304L-TS AH725
 Toolholder : A12M-SWLXR04-D140
 Cutting speed : $V_c = 150$ m/min
 Boring depth : $H = 36$ mm (L/D = 3)
 Coolant : Wet (internal supply)

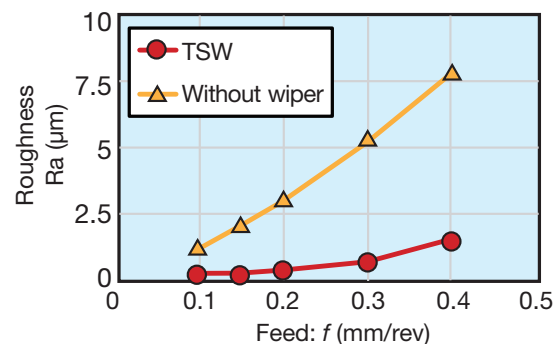
M

Depth of cut: ap (mm)	1.50				
	1.00				
	0.50				
	0.25				
ap/f		0.05	0.075	0.10	0.15
Feed: f (mm/rev)					

Workpiece : SUS304 / X5CrNi18-9
 Insert : WXGU040304L-SS AH725
 Toolholder : E12Q-SWLXR04-D140
 Cutting speed : $V_c = 150$ m/min
 Boring depth : $H = 60$ mm (L/D = 5)
 Coolant : Wet (internal supply)

Wiper performance

Workpiece : S45C / C45
 Insert : WXGU040304L-TSW
 CCMT09T304-*(Without wiper)
 Toolholder : E16R-SWLXR04-D180
 Cutting speed : $V_c = 150$ m/min
 Depth of cut : $a_p = 0.5$ mm
 Hole depth : $H = 48$ mm (L/D = 3)
 Coolant : Wet (internal supply)

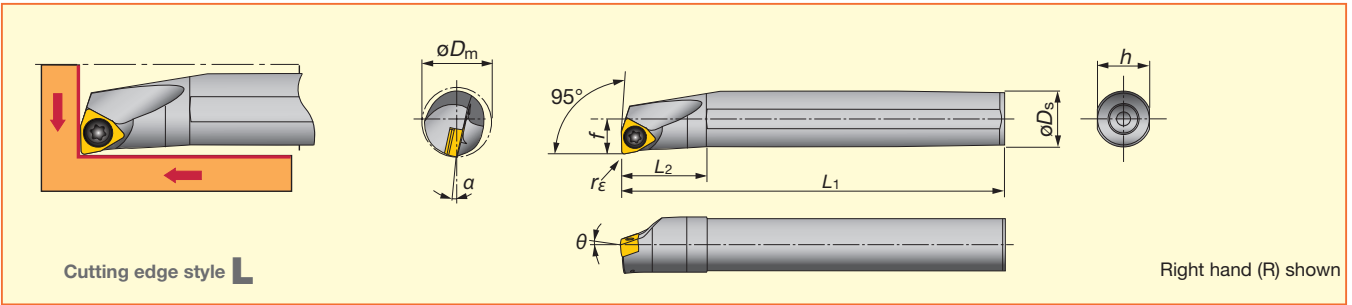


Internal toolholders

SWLXR/L

Boring & internal facing

S-type (Positive rake, screw-on system)



Steel shank

Cat. No	Stock		Dimensions (mm)								Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)	
	R	L	Min bore dia. ϕD_m	ϕD_s	f	L_1	L_2	h	f_2	θ			a	Clamping screw		Wrench
A10K-SWLXR/L04-D120	●	●	12	10	6	125	20	9	-	-10°	-16°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
A12M-SWLXR/L04-D140	●	●	14	12	7	150	24	11	-	-10°	-14°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
A16Q-SWLXR/L04-D180	●	●	18	16	9	180	32	15	-	-10°	-11°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
A20R-SWLXR/L04-D220	●	●	22	20	11	200	36	18	-	-10°	-10°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9

Carbide shank

Cat. No	Stock		Dimensions (mm)								Std. corner radius r_ϵ	Insert	Parts		Torque (N·m)	
	R	L	Min bore dia. ϕD_m	ϕD_s	f	L_1	L_2	h	f_2	θ			a	Clamping screw		Wrench
E10M-SWLXR/L04-D120	●	●	12	10	6	150	25	9	-	-10°	-16°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
E12Q-SWLXR/L04-D140	●	●	14	12	7	180	27	11	-	-10°	-14°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
E16R-SWLXR/L04-D180	●	●	18	16	9	200	32	15	-	-10°	-11°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9
E20S-SWLXR/L04-D220	●	●	22	20	11	250	36	18	-	-10°	-10°	0.4	WXGU0403** L/R	SR34-514	T-7F	0.9

- ① Right hand toolholders (R) are used with left hand inserts (L)
- ② Left hand toolholders (L) are used with right hand inserts (R)



① Right hand toolholder with left hand insert shown

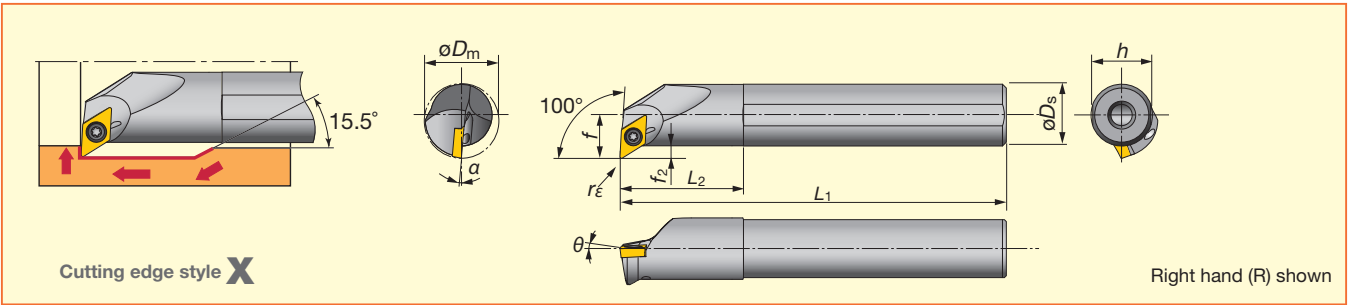


② Left hand toolholder with right hand insert shown

SDXXR/L

Boring & internal profiling

S-type (Positive rake, screw-on system)



Steel shank

Cat. No	Stock		Dimensions (mm)								Std. corner radius f_ϵ	Insert	Parts		Torque (N·m)	
	R	L	Min bore dia. ϕD_m	ϕD_s	f	L_1	L_2	h	f_2	θ			a	Clamping screw		Wrench
A10K-SDXXR/L07-D130	●	●	13	10	7.6	125	20	9	2.6	-14°	-16°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
A12M-SDXXR/L07-D160	●	●	16	12	8.6	150	24	11	2.6	-14°	-14°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
A16Q-SDXXR/L07-D200	●	●	20	16	10.6	180	32	15	2.6	-13°	-13°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
A20R-SDXXR/L07-D240	●	●	24	20	12.6	200	36	18	2.6	-13°	-12°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9

Carbide shank

Cat. No	Stock		Dimensions (mm)								Std. corner radius f_ϵ	Insert	Parts		Torque (N·m)	
	R	L	Min bore dia. ϕD_m	ϕD_s	f	L_1	L_2	h	f_2	θ			a	Clamping screw		Wrench
E10M-SDXXR/L07-D130	●	●	13	10	7.6	150	25	9	2.6	-14°	-16°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
E12Q-SDXXR/L07-D160	●	●	16	12	8.6	180	27	11	2.6	-14°	-14°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
E16R-SDXXR/L07-D200	●	●	20	16	10.6	200	32	15	2.6	-13°	-13°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9
E20S-SDXXR/L07-D240	●	●	24	20	12.6	250	36	18	2.6	-13°	-12°	0.4	DXGU0703** L/R	SR34-514	T-7F	0.9

- ① Right hand toolholders (R) are used with left hand inserts (L)
- ② Left hand toolholders (L) are used with right hand inserts (R)



① Right hand toolholder with left hand insert shown

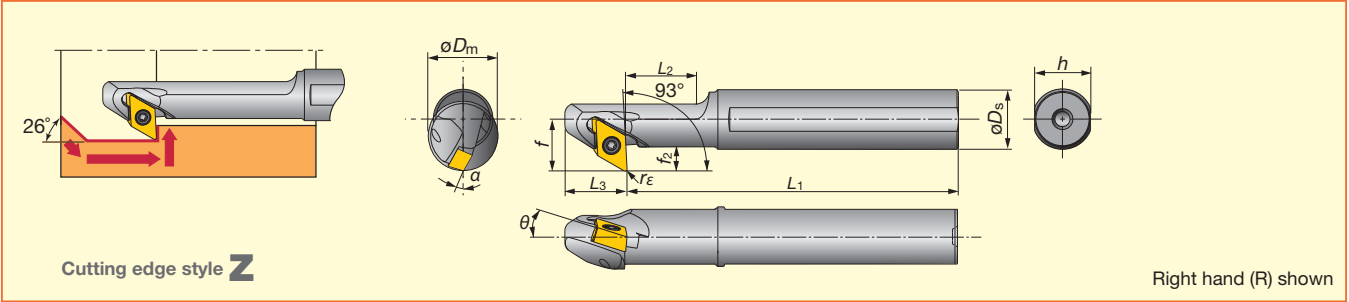


② Left hand toolholder with right hand insert shown

SDZXR/L

Back boring

S-type (Positive rake, screw-on system)



Steel shank

Cat. No	Stock		Dimensions (mm)									Std. corner radius f_ϵ	Insert	Parts		Torque (N·m)	
	R	L	Min bore dia. ϕD_m	ϕD_s	f	L_1	L_2	L_3	h	f_2	θ			α	Clamping screw		Wrench
A12M-SDZXR/L07-D140	●	●	14	12	11	150	30	13	11	4.5	-10°	-14°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9
A16Q-SDZXR/L07-D160	●	●	16	16	13	180	35	13	15	4.5	-10°	-12.5°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9
A20R-SDZXR/L07-D200	●	●	20	20	15	200	40	13	18	4.5	-10°	-10.5°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9

Carbide shank

Cat. No	Stock		Dimensions (mm)									Std. corner radius f_ϵ	Insert	Parts		Torque (N·m)	
	R	L	Min bore dia. ϕD_m	ϕD_s	f	L_1	L_2	L_3	h	f_2	θ			α	Clamping screw		Wrench
E12Q-SDZXR/L07-D180	●	●	18	12	11	180	-	13	11	4.5	-11°	-11°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9
E16R-SDZXR/L07-D220	●	●	22	16	13	200	-	13	15	4.5	-11°	-9°	0.4	DXGU0703** R/L	SR34-514	T-7F	0.9

- ① Right hand toolholders (R) are used with right hand inserts (R)
 ② Left hand toolholders (L) are used with left hand inserts (L)

● : Stocked items

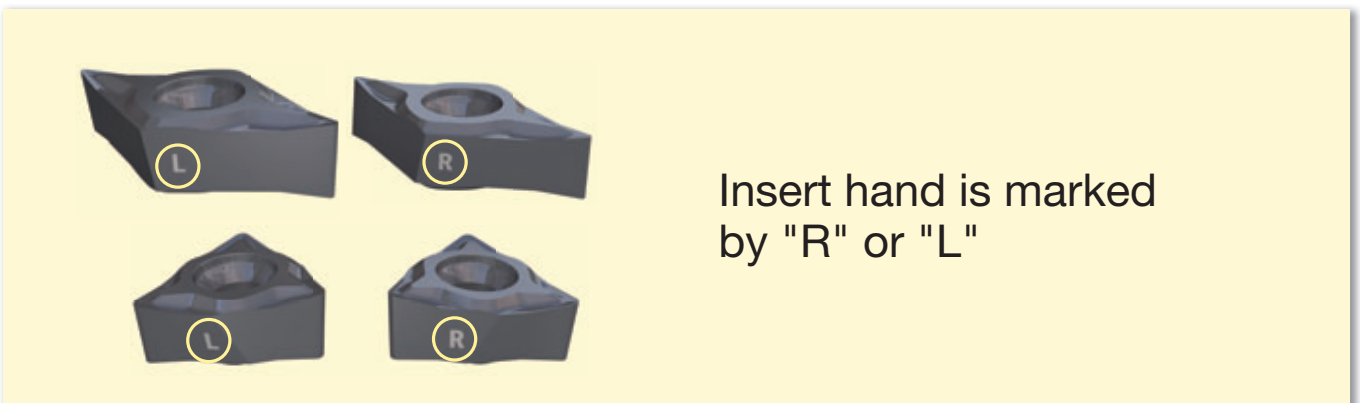


① Right hand toolholder with right hand insert shown



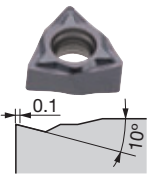
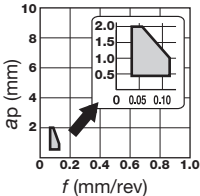
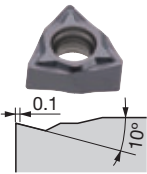
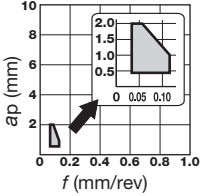
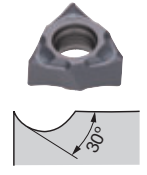
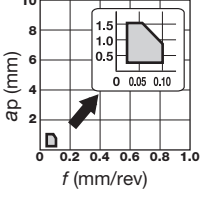
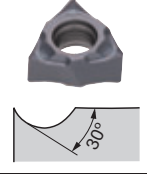
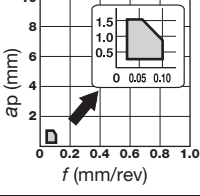
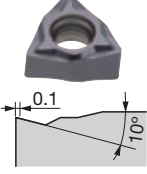
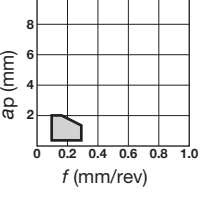
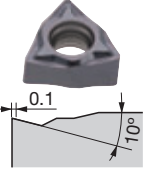
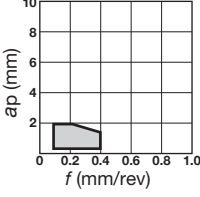
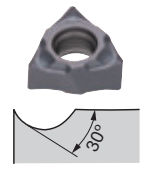
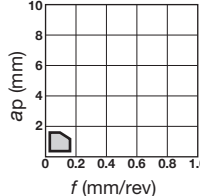
② Left hand toolholder with left hand insert shown

Marking



Inserts

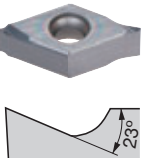
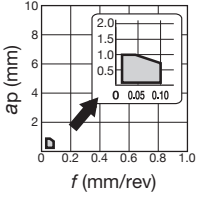
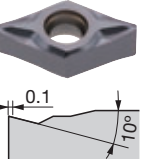
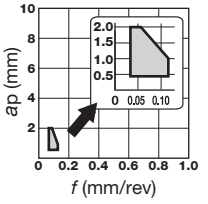
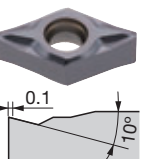
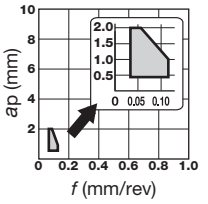
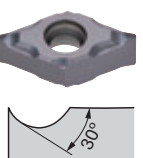
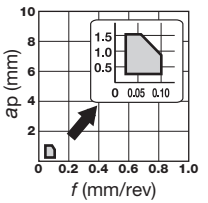
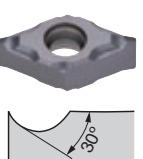
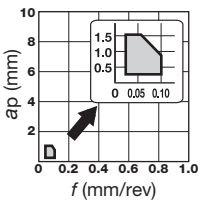
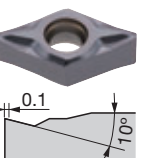
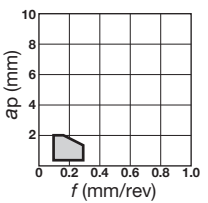
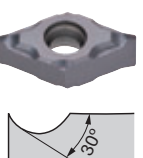
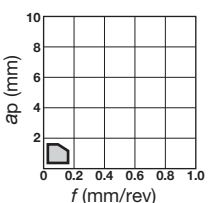
80° Trigon

Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Cat. No.	Grades					Dimensions (mm)			
				Coated		Coated cermet	Cermet	Carbide	I.C. dia. $\varnothing d$	Thick- ness s	Hole dia. $\varnothing d_1$	Corner radius r_E
				AH725	New SH725	GT9530	NS9530	KS05F				
Finishing to medium cutting (For swiss type automatic lathes, sharp edge)	JTS 		WXGU040301MFR-JTS		●				6.35	3.18	2.7	<0.1*
			WXGU040301MFL-JTS		●				6.35	3.18	2.7	<0.1*
			WXGU040302MFR-JTS		●				6.35	3.18	2.7	<0.2*
			WXGU040302MFL-JTS		●				6.35	3.18	2.7	<0.2*
Finishing to medium cutting (For swiss type automatic lathes)	JTS 		WXGU040301MR-JTS	●					6.35	3.18	2.7	<0.1*
			WXGU040301ML-JTS	●					6.35	3.18	2.7	<0.1*
			WXGU040302MR-JTS	●					6.35	3.18	2.7	<0.2*
			WXGU040302ML-JTS	●					6.35	3.18	2.7	<0.2*
Finishing (Low cutting force) (For swiss type automatic lathes, sharp edge)	JSS 		WXGU040301MFR-JSS		●				6.35	3.18	2.7	<0.1*
			WXGU040301MFL-JSS		●				6.35	3.18	2.7	<0.1*
			WXGU040302MFR-JSS		●				6.35	3.18	2.7	<0.2*
			WXGU040302MFL-JSS		●				6.35	3.18	2.7	<0.2*
Finishing (Low cutting force) (For swiss type automatic lathes)	JSS 		WXGU040301MR-JSS	●					6.35	3.18	2.7	<0.1*
			WXGU040301ML-JSS	●					6.35	3.18	2.7	<0.1*
			WXGU040302MR-JSS	●					6.35	3.18	2.7	<0.2*
			WXGU040302ML-JSS	●					6.35	3.18	2.7	<0.2*
Finishing to medium cutting	TS 		WXGU040302R-TS	●		●	●	●	6.35	3.18	2.7	0.2
			WXGU040302L-TS	●		●	●	●	6.35	3.18	2.7	0.2
			WXGU040304R-TS	●		●	●	●	6.35	3.18	2.7	0.4
			WXGU040304L-TS	●		●	●	●	6.35	3.18	2.7	0.4
			WXGU040308R-TS	●		●	●	●	6.35	3.18	2.7	0.8
			WXGU040308L-TS	●		●	●	●	6.35	3.18	2.7	0.8
Finishing (Wiper)	TSW 		WXGU040304R-TSW	●		●	●		6.35	3.18	2.7	0.4
			WXGU040304L-TSW	●		●	●		6.35	3.18	2.7	0.4
			WXGU040308R-TSW	●		●	●		6.35	3.18	2.7	0.8
			WXGU040308L-TSW	●		●	●		6.35	3.18	2.7	0.8
Finishing (Low cutting force)	SS 		WXGU040302R-SS	●		●	●	●	6.35	3.18	2.7	0.2
			WXGU040302L-SS	●		●	●	●	6.35	3.18	2.7	0.2
			WXGU040304R-SS	●		●	●	●	6.35	3.18	2.7	0.4
			WXGU040304L-SS	●		●	●	●	6.35	3.18	2.7	0.4

* JTS and TSS have minus tolerance of corner radius.


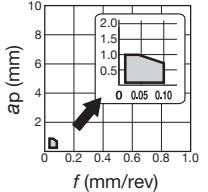
● : Stocked items

55° Rhombic

Application	Chipbreaker Appearance (Cross section)	$f - a_p$	Cat. No.	Grades					Dimensions (mm)			
				Coated		Coated cermet	Cermet	Carbide	I.C. dia. $\varnothing d$	Thick- ness s	Hole dia. $\varnothing d_1$	Corner radius r_E
				AH725	New SH725	New GT9530	New NS9530	New KS05F				
New Finishing (For swiss type automatic lathes, sharp edge)	JRP 		DXGU070301MFRE-JRP	●					6.35	3.18	2.7	<0.1*
			DXGU070301MFLE-JRP	●					6.35	3.18	2.7	<0.1*
			DXGU070302MFRE-JRP	●					6.35	3.18	2.7	<0.2*
			DXGU070302MFLE-JRP	●					6.35	3.18	2.7	<0.2*
Finishing to medium cutting (For swiss type automatic lathes, sharp edge)	JTS 		DXGU070301MFR-JTS	●					6.35	3.18	2.7	<0.1*
			DXGU070301MFL-JTS	●					6.35	3.18	2.7	<0.1*
			DXGU070302MFR-JTS	●					6.35	3.18	2.7	<0.2*
			DXGU070302MFL-JTS	●					6.35	3.18	2.7	<0.2*
Finishing to medium cutting (For swiss type automatic lathes)	JTS 		DXGU070301MR-JTS	●					6.35	3.18	2.7	<0.1*
			DXGU070301ML-JTS	●					6.35	3.18	2.7	<0.1*
			DXGU070302MR-JTS	●					6.35	3.18	2.7	<0.2*
			DXGU070302ML-JTS	●					6.35	3.18	2.7	<0.2*
Finishing (Low cutting force) (For swiss type automatic lathes, sharp edge)	JSS 		DXGU070301MFR-JSS	●					6.35	3.18	2.7	<0.1*
			DXGU070301MFL-JSS	●					6.35	3.18	2.7	<0.1*
			DXGU070302MFR-JSS	●					6.35	3.18	2.7	<0.2*
			DXGU070302MFL-JSS	●					6.35	3.18	2.7	<0.2*
Finishing (Low cutting force) (For swiss type automatic lathes)	JSS 		DXGU070301MR-JSS	●					6.35	3.18	2.7	<0.1*
			DXGU070301ML-JSS	●					6.35	3.18	2.7	<0.1*
			DXGU070302MR-JSS	●					6.35	3.18	2.7	<0.2*
			DXGU070302ML-JSS	●					6.35	3.18	2.7	<0.2*
Finishing to medium cutting	TS 		DXGU070302R-TS	●		●	●	●	6.35	3.18	2.7	0.2
			DXGU070302L-TS	●		●	●	●	6.35	3.18	2.7	0.2
			DXGU070304R-TS	●		●	●	●	6.35	3.18	2.7	0.4
			DXGU070304L-TS	●		●	●	●	6.35	3.18	2.7	0.4
			DXGU070308R-TS	●		●	●	●	6.35	3.18	2.7	0.8
			DXGU070308L-TS	●		●	●	●	6.35	3.18	2.7	0.8
Finishing (Low cutting force)	SS 		DXGU070302R-SS	●		●	●	●	6.35	3.18	2.7	0.2
			DXGU070302L-SS	●		●	●	●	6.35	3.18	2.7	0.2
			DXGU070304R-SS	●		●	●	●	6.35	3.18	2.7	0.4
			DXGU070304L-SS	●		●	●	●	6.35	3.18	2.7	0.4

* JTS and TSS have minus tolerance of corner radius.

● : Stocked items

Application	Chipbreaker	$f - a_p$	Cat. No.	Grades					Dimensions (mm)			
	Appearance (Cross section)			Coated		Coated cermet	Cermet	Carbide	I.C. dia. ϕd	Thick- ness s	Hole dia. ϕd_1	Corner radius r_E
				AH725	New SH725	New GT9530	New NS9530	New KS05F				
New Finishing (For swiss type automatic lathes, sharp edge)	JRP  		VXGU09T201MFRE-JRP		●				5.56	2.78	2.5	<0.1*
			VXGU09T201MFLE-JRP		●				5.56	2.78	2.5	<0.1*
			VXGU09T202MFRE-JRP		●				5.56	2.78	2.5	<0.2*
			VXGU09T202MFLE-JRP		●				5.56	2.78	2.5	<0.2*

* JTS and TSS have minus tolerance of corner radius.

● : Stocked items

Standard cutting conditions

For external turning

Applications	ISO	Workpiece materials	Priority	Chip- breaker	Grades	Cutting speed V_c (m/min)	Depth of cut a_p (mm)	Feed f (mm/rev)
For swiss type automatic lathes	P	Low carbon steels (SS400 / E275A etc.)	With high sharpness	JSS	SH725	50 - 180	0.1 - 1.5	0.03 - 0.10
		Carbon steels (S45C / C45 etc.) Low alloy steels (SCM415 etc.) Alloy steels (SCM440 / 42CrMo4 etc.)	First choice	JTS	AH725	50 - 180	0.1 - 2.0	0.03 - 0.10
	M	Stainless steels (Austenitic) (SUS304 / X5CrNi18-9 etc.)	First choice	JSS	SH725	50 - 180	0.1 - 1.5	0.03 - 0.10
		Stainless steels (Martensitic and ferritic) (SUS430 / X6Cr17 etc.) Stainless steels (Precipitation hardened) (SUS630 / X5CrNiCuNb16-4 etc.)	For impact resistance	JTS	AH725	50 - 180	0.1 - 2.0	0.03 - 0.10
For small size CNC lathes	P	Low carbon steels (SS400 / E275A etc.)	First choice	SS	AH725	50 - 180	0.15 - 1.5	0.05 - 0.2
				TS	AH725	50 - 180	0.3 - 2.0	0.08 - 0.3
		Carbon steels (S45C / C45 etc.) Low alloy steels (SCM415 etc.) Alloy steels (SCM440 / 42CrMo4 etc.)	For improved surface finish	SS	NS9530	80 - 200	0.15 - 1.5	0.05 - 0.2
				TS	NS9530	80 - 200	0.3 - 2.0	0.08 - 0.3
	For wear resistance	SS	GT9530	80 - 250	0.15 - 1.5	0.05 - 0.2		
		TS	GT9530	80 - 250	0.3 - 2.0	0.08 - 0.3		
M	Stainless steels (Austenitic) (SUS304 / X5CrNi18-9 etc.)	First choice	SS	AH725	50 - 150	0.15 - 1.5	0.05 - 0.2	
	Stainless steels (Martensitic and ferritic) (SUS430 / X6Cr17 etc.) Stainless steels (Precipitation hardened) (SUS630 / X5CrNiCuNb16-4 etc.)	For impact resistance	TS	AH725	50 - 150	0.3 - 2.0	0.08 - 0.3	

For internal turning

ISO	Workpiece materials	Grades			Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
		First Choice	For surface finish	For wear resistance (High speed)			
P	Low carbon steels SS400, SM490, S25C etc.	AH725	-	-	50 - 180	0.3 - 2.0	0.08 - 0.3
		-	NS9530	-	80 - 250	0.3 - 2.0	0.08 - 0.3
		-	-	GT9530	80 - 300	0.3 - 2.0	0.08 - 0.3
	Carbon steels S45C, S55C/ C45, C55 etc.	AH725	-	-	50 - 180	0.3 - 2.0	0.08 - 0.3
		-	NS9530	-	80 - 250	0.3 - 2.0	0.08 - 0.3
		-	-	GT9530	80 - 300	0.3 - 2.0	0.08 - 0.3
	Low alloy steels SCM415 etc.	AH725	-	-	50 - 180	0.3 - 2.0	0.08 - 0.3
		-	NS9530	-	80 - 250	0.3 - 2.0	0.08 - 0.3
		-	-	GT9530	80 - 300	0.3 - 2.0	0.08 - 0.3
	Alloy steels SCM440, SCr420 / 42CrMo4, 20Cr4 etc.	AH725	-	-	50 - 180	0.3 - 2.0	0.08 - 0.3
		-	NS9530	-	80 - 250	0.3 - 2.0	0.08 - 0.3
		-	-	GT9530	80 - 300	0.3 - 2.0	0.08 - 0.3
M	Stainless steels (Austenitic) SUS304, SUS316 / X5CrNi18-9, X5CrNiMo17-12-2 etc.	AH725	-	-	50 - 150	0.3 - 2.0	0.08 - 0.3
		AH725	-	-	50 - 150	0.3 - 2.0	0.08 - 0.3
		AH725	-	-	50 - 150	0.3 - 2.0	0.08 - 0.3
K	Grey cast irons FC250 / GG25 etc.	AH725	-	-	50 - 180	0.3 - 2.0	0.08 - 0.3
		-	NS9530	-	80 - 250	0.3 - 2.0	0.08 - 0.3
		-	-	GT9530	80 - 300	0.3 - 2.0	0.08 - 0.3
	Ductile cast irons FCD700 / GGG70 etc.	AH725	-	-	50 - 120	0.3 - 2.0	0.08 - 0.3
		-	NS9530	-	80 - 150	0.3 - 2.0	0.08 - 0.3
		-	-	GT9530	80 - 180	0.3 - 2.0	0.08 - 0.3
N	Non ferrous Metals Aluminum alloy etc.	KS05F	-	-	100 - 300	0.3 - 2.0	0.08 - 0.3
	Non ferrous Metals Cu Alloy etc.	KS05F	-	-	100 - 300	0.3 - 2.0	0.08 - 0.3

● Grades

AH725

P M K

PREMIUMTEC
TUNGALOY

- Versatile PVD coated grade suitable for a wide range of work materials.
- Demonstrates excellent balance of wear and fracture resistance.

New

SH725

P M K

- Ideal PVD coated grade for sharp cutting edge.
- Suitable for machining of small and precise parts.

GT9530

P K

PREMIUMTEC
TUNGALOY

- Coated cermet grade with premium coating demonstrates exceptional wear resistance.
- Provides remarkable performance in finishing of steels during high speed machining.

NS9530

P K

PREMIUMTEC
TUNGALOY

- Versatile cermet grade with incredible fracture and wear resistance.
- Provides long tool life and excellent surface finish in steel finishing applications.

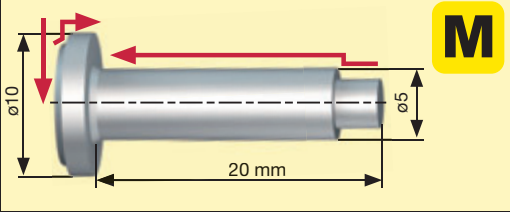
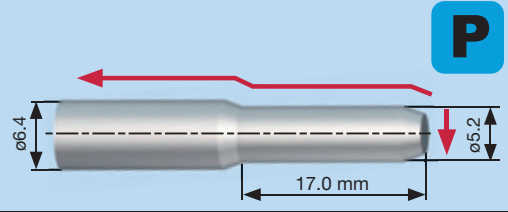
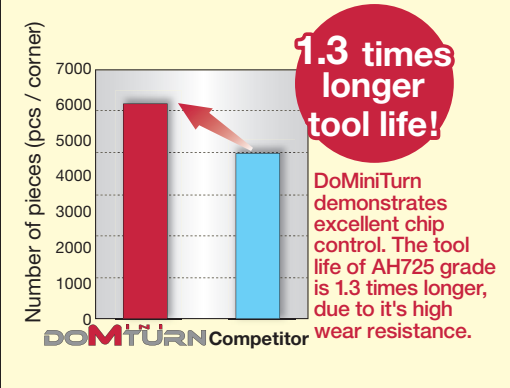
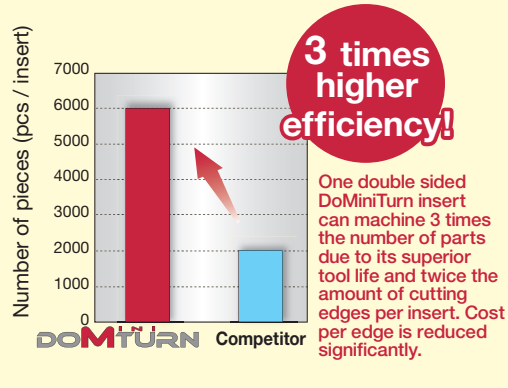
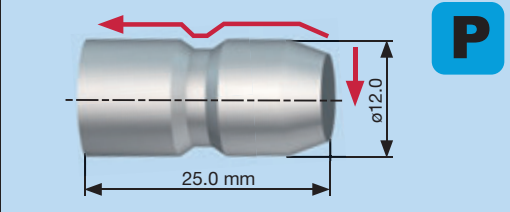
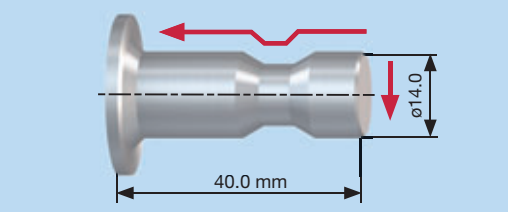
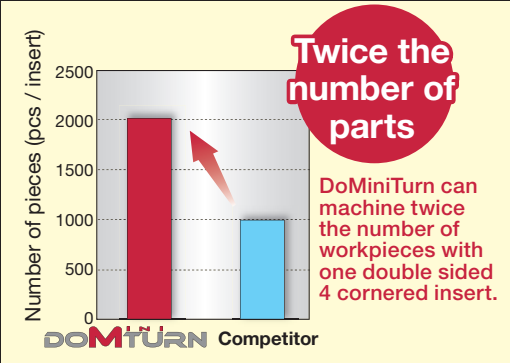
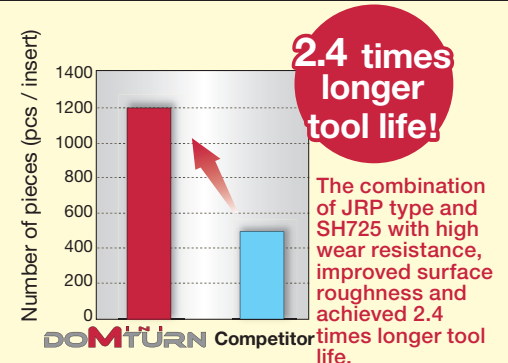
KS05F

N

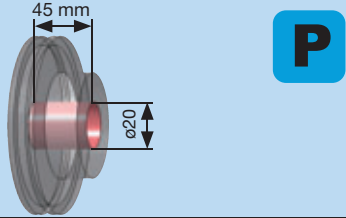
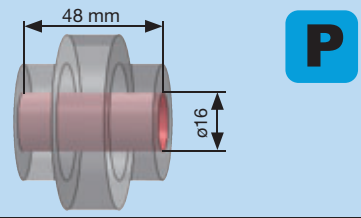
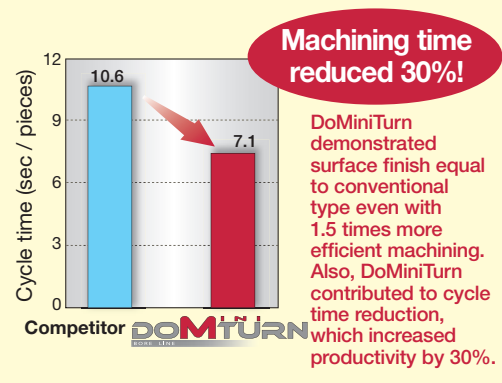
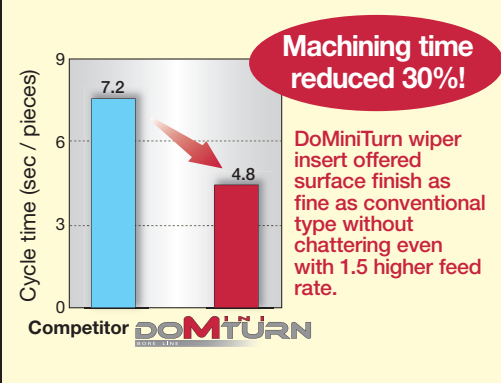
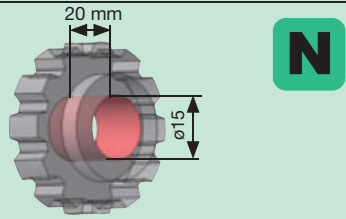
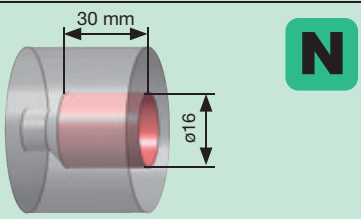
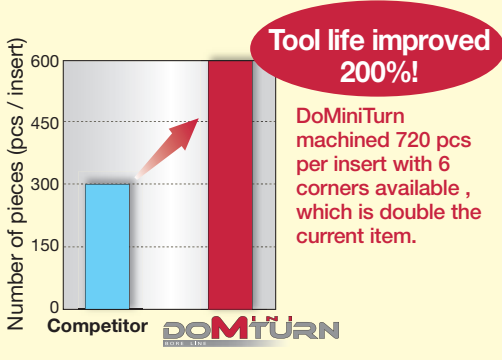
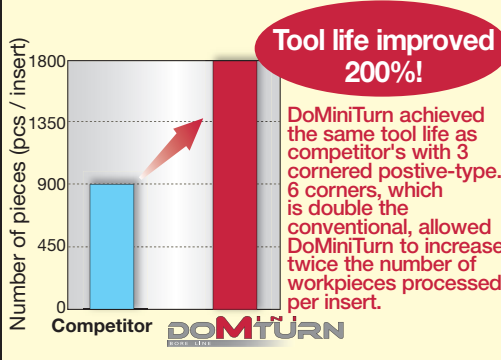
- Micro-grain cemented carbide in which wear resistance and impact resistance are balanced.
- The homogeneous fine-grained structure contribute to the excellent resistance of wear, fracture, and chip welding!

Practical examples

External turning

Workpiece type		Shaft	Shaft
Toolholder		JSDJ2XR1212X07	JSWL2XR1212X04
Insert		DXGU070301ML-JSS	WXGU040302ML-TS
Grade		AH725	AH725
Workpiece material		SUS304 / X5CrNi18-9	S45C / C45
			
Cutting conditions	Cutting speed: V_c (m/min)	110 - 150 (External), 10 - 100 (Facing)	66 - 80
	Feed : f (mm/rev)	0.04 (External), 0.05 (Facing)	0.15
	Depth of cut : a_p (mm)	0.4 (External, facing)	0.6
	Machining	External • Facing	External
	Coolant	Wet	Wet
Results		 <p>1.3 times longer tool life!</p> <p>DoMiniTurn demonstrates excellent chip control. The tool life of AH725 grade is 1.3 times longer, due to its high wear resistance.</p>	 <p>3 times higher efficiency!</p> <p>One double sided DoMiniTurn insert can machine 3 times the number of parts due to its superior tool life and twice the amount of cutting edges per insert. Cost per edge is reduced significantly.</p>
		Results	
Workpiece type		Shaft	Shaft
Toolholder		JSDJ2XR1212X07	JSVJ2XR1212X09
Insert		DXGU070301ML-JSS	VXGU090202MFLE-JRP
Grade		AH725	SH725
Workpiece material		Alloy steels	Low carbon steel (cold drawn)
			
Cutting conditions	Cutting speed: V_c (m/min)	66 - 80	170
	Feed : f (mm/rev)	0.15	0.03
	Depth of cut : a_p (mm)	0.6	0.2
	Machining	External	External
	Coolant	Wet	Wet
Results		 <p>Twice the number of parts!</p> <p>DoMiniTurn can machine twice the number of workpieces with one double sided 4 cornered insert.</p>	 <p>2.4 times longer tool life!</p> <p>The combination of JRP type and SH725 with high wear resistance, improved surface roughness and achieved 2.4 times longer tool life.</p>

Internal turning

Workpiece type		Machine Parts	Machine Parts
Toolholder		A16Q-SWLXR04-D180	E12Q-SWLXR04-D140
Insert		WXGU040304L-TSW New	WXGU040304L-TSW
Grade		AH725	GT9530 New
Workpiece material		S45C / C45	SCM435 / 34CrMo4
			
Cutting conditions	Cutting speed: V_c (m/min)	160	200
	Feed : f (mm/rev)	0.10 → 0.15	0.10 → 0.15
	Depth of cut : a_p (mm)	0.5	0.2
	Machining	Internal Turning (continuous cutting)	Internal Turning (continuous cutting)
	Coolant	Wet	Wet
Results			
Workpiece type		Machine Parts	Machine Parts
Toolholder		A10K-SWLXR04-D120	A12M-SDXXR04-D140
Insert		WXGU040302L-SS	DXGU070304L-TS
Grade		KS05F New	KS05F New
Workpiece material		CAC406 / Bronze casting	A5056 (Al - Mg)
			
Cutting conditions	Cutting speed: V_c (m/min)	70	200
	Feed : f (mm/rev)	0.1	0.1
	Depth of cut : a_p (mm)	1.0	1.0
	Machining	Internal Turning (continuous cutting)	Internal Turning (continuous cutting)
	Coolant	Wet	Wet
Results			

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