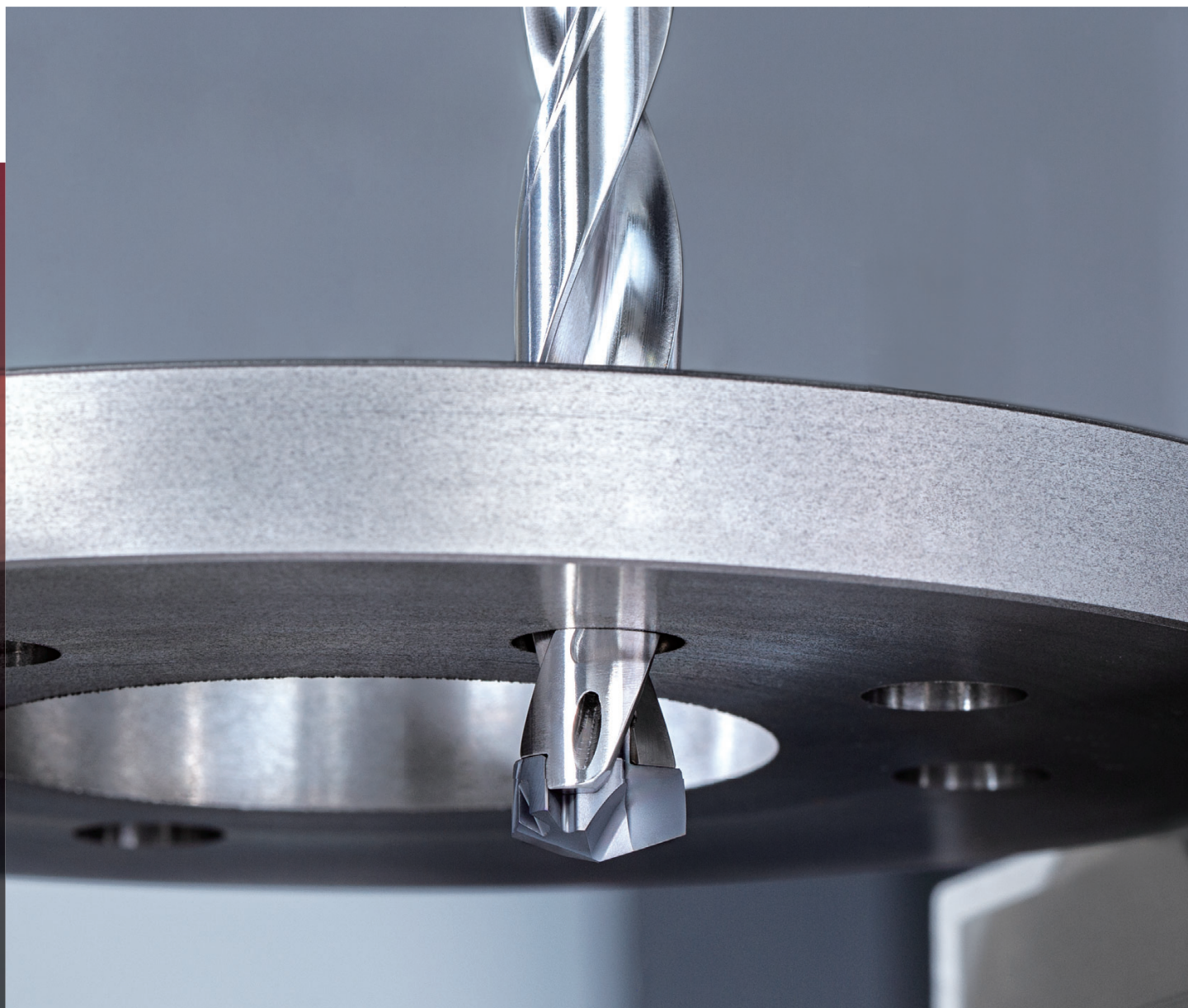


Exchangeable head drill

**DRILLMEISTER**

Tungaloy Report No. 412S9-US

Expansion of **DMH** drill heads with  
new diameters



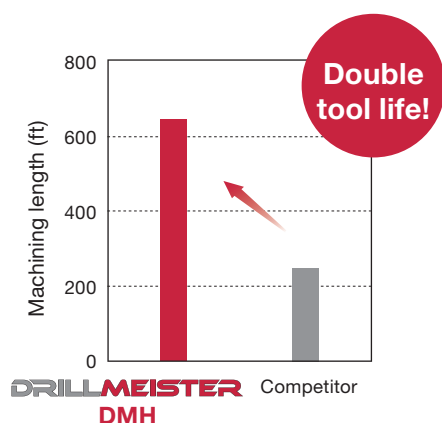


## DMH - Fracture resistance head



- Counter measure solution for corner edge fracture
- Reinforced drill edge design protect the head's corners from both damaging impact of recoiling wall and weak part fixture
- The best solution for short depth through holes with multiple entry and exit
- Perfect solution for hardened steel drilling and especially high carbon steels ( $C > 0.45\%$ )
- Perfect combination with dedicated AH9130 grade for superb results

## Longer tool life without edge fracture



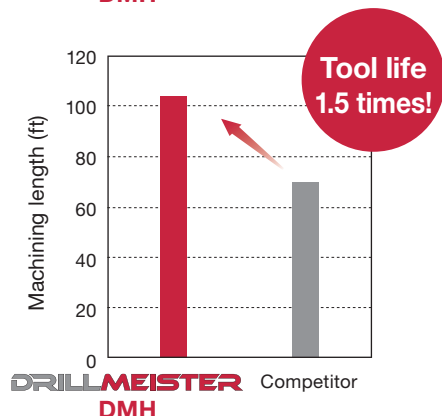
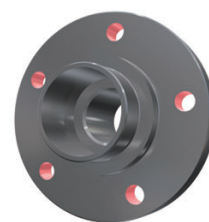
DRILLMEISTER DMH



Competitor



Tool :  $\varnothing 0.539"$ , L/D = 3  
 Drill head : DMH137  
 Grade : AH9130  
 Workpiece material : High carbon steel  
 Cutting speed :  $V_c = 295$  sfm  
 Feed :  $f = 0.012$  ipr  
 Hole depth :  $H = 0.787"$   
 Coolant : Wet (External)



Tool :  $\varnothing 0.402"$ , L/D = 3  
 Drill head : DMH103  
 Grade : AH9130  
 Workpiece material : Tool steel (40HRC)  
 Cutting speed :  $V_c = 179$  sfm  
 Feed :  $f = 0.007$  ipr  
 Hole depth :  $H = 0.906"$   
 Coolant : Wet (Internal)

## Solution for improved tool life, especially for shallow through-holes



Hub



Knuckle

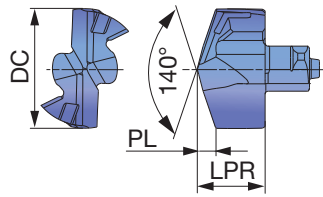
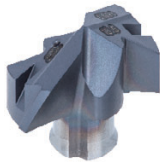


Diff. case



Brake disc

## DMH High strength cutting edge



| Tool diameter (inch) | Head diameter tolerance |
|----------------------|-------------------------|
| ø0.236" - ø0.705"    | +0.0007" / -0.0002"     |
| ø0.709" - ø1.004"    | +0.0008" / -0.0002"     |
| Tool diameter (mm)   | Head diameter tolerance |
| ø6 - ø17.9           | +0.018 / -0.005         |
| ø18 - ø25.5          | +0.021 / -0.005         |

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

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

★ : First choice

| Designation | DC (in) | DC (mm) | LPR  | Coated |  | PL (mm) | Body       |
|-------------|---------|---------|------|--------|--|---------|------------|
|             |         |         |      | AH9130 |  |         |            |
| DMH060      | 0.236   | 6       | 3.85 | ●      |  | 1.09    | TID*060... |
| DMH068      | 0.268   | 6.8     | 4.15 | ●      |  | 1.33    | TID*065... |
| DMH070      | 0.276   | 7       | 4.45 | ●      |  | 1.03    | TID*070... |
| DMH075      | 0.295   | 7.5     | 4.45 | ●      |  | 1.12    | TID*075... |
| DMH080      | 0.315   | 8       | 5.25 | ●      |  | 1.2     | TID*080... |
| DMH085      | 0.335   | 8.5     | 5.25 | ●      |  | 1.29    | TID*085... |
| DMH086      | 0.339   | 8.6     | 5.25 | ●      |  | 1.31    | TID*085... |
| DMH087      | 0.343   | 8.7     | 5.25 | ●      |  | 1.33    | TID*085... |
| DMH088      | 0.347   | 8.8     | 5.25 | ●      |  | 1.35    | TID*085... |
| DMH090      | 0.354   | 9       | 5.65 | ●      |  | 1.37    | TID*090... |
| DMH095      | 0.374   | 9.5     | 5.65 | ●      |  | 1.46    | TID*095... |
| DMH097      | 0.382   | 9.7     | 5.65 | ●      |  | 1.5     | TID*095... |
| DMH100      | 0.394   | 10      | 6.05 | ●      |  | 1.47    | TID*100... |
| New DMH101  | 0.398   | 10.1    | 6.05 | ●      |  | 1.49    | TID*100... |
| DMH103      | 0.406   | 10.3    | 6.05 | ●      |  | 1.52    | TID*100... |
| New DMH104  | 0.409   | 10.4    | 6.05 | ●      |  | 1.54    | TID*100... |
| DMH105      | 0.413   | 10.5    | 6.05 | ●      |  | 1.56    | TID*105... |
| New DMH106  | 0.417   | 10.6    | 6.05 | ●      |  | 1.58    | TID*105... |
| New DMH107  | 0.421   | 10.7    | 6.05 | ●      |  | 1.6     | TID*105... |
| DMH108      | 0.425   | 10.8    | 6.05 | ●      |  | 1.62    | TID*105... |
| DMH110      | 0.433   | 11      | 6.45 | ●      |  | 1.67    | TID*110... |
| New DMH111  | 0.437   | 11.1    | 6.45 | ●      |  | 1.69    | TID*110... |
| New DMH112  | 0.441   | 11.2    | 6.45 | ●      |  | 1.71    | TID*110... |
| New DMH113  | 0.445   | 11.3    | 6.45 | ●      |  | 1.72    | TID*110... |
| New DMH114  | 0.449   | 11.4    | 6.45 | ●      |  | 1.74    | TID*110... |
| DMH115      | 0.453   | 11.5    | 6.45 | ●      |  | 1.76    | TID*115... |
| New DMH117  | 0.461   | 11.7    | 6.45 | ●      |  | 1.8     | TID*115... |
| New DMH118  | 0.465   | 11.8    | 6.45 | ●      |  | 1.82    | TID*115... |
| DMH119      | 0.469   | 11.9    | 6.45 | ●      |  | 1.83    | TID*115... |
| DMH120      | 0.472   | 12      | 6.8  | ●      |  | 1.82    | TID*120... |
| New DMH121  | 0.476   | 12.1    | 6.8  | ●      |  | 1.84    | TID*120... |
| New DMH122  | 0.480   | 12.2    | 6.8  | ●      |  | 1.86    | TID*120... |
| New DMH123  | 0.484   | 12.3    | 6.8  | ●      |  | 1.87    | TID*120... |
| New DMH124  | 0.488   | 12.4    | 6.8  | ●      |  | 1.89    | TID*120... |
| DMH125      | 0.492   | 12.5    | 6.8  | ●      |  | 1.91    | TID*125... |
| DMH126      | 0.496   | 12.6    | 6.8  | ●      |  | 1.93    | TID*125... |
| New DMH127  | 0.500   | 12.7    | 6.8  | ●      |  | 1.95    | TID*125... |
| New DMH128  | 0.504   | 12.8    | 6.8  | ●      |  | 1.97    | TID*125... |
| New DMH129  | 0.508   | 12.9    | 6.8  | ●      |  | 1.98    | TID*125... |
| DMH130      | 0.512   | 13      | 7.4  | ●      |  | 1.96    | TID*130... |
| New DMH131  | 0.516   | 13.1    | 7.4  | ●      |  | 1.98    | TID*130... |
| New DMH132  | 0.520   | 13.2    | 7.4  | ●      |  | 2       | TID*130... |
| DMH133      | 0.524   | 13.3    | 7.4  | ●      |  | 2.01    | TID*130... |

Package Quantity: 0.236" - 0.780" = 2 pcs.  
0.787" - 1.020" = 1 pcs.

| Designation | DC (in) | DC (mm) | LPR  | Coated |  | PL (mm) | Body       |
|-------------|---------|---------|------|--------|--|---------|------------|
|             |         |         |      | AH9130 |  |         |            |
| New DMH134  | 0.528   | 13.4    | 7.4  | ●      |  | 2.03    | TID*130... |
| DMH135      | 0.532   | 13.5    | 7.4  | ●      |  | 2.05    | TID*135... |
| New DMH136  | 0.535   | 13.6    | 7.4  | ●      |  | 2.07    | TID*135... |
| DMH137      | 0.539   | 13.7    | 7.4  | ●      |  | 2.09    | TID*135... |
| DMH138      | 0.543   | 13.8    | 7.4  | ●      |  | 2.11    | TID*135... |
| DMH139      | 0.547   | 13.9    | 7.4  | ●      |  | 2.12    | TID*135... |
| DMH140      | 0.551   | 14      | 7.95 | ●      |  | 2.12    | TID*140... |
| New DMH141  | 0.555   | 14.1    | 7.95 | ●      |  | 2.14    | TID*140... |
| DMH142      | 0.559   | 14.2    | 7.95 | ●      |  | 2.16    | TID*140... |
| New DMH143  | 0.563   | 14.3    | 7.95 | ●      |  | 2.17    | TID*140... |
| New DMH144  | 0.567   | 14.4    | 7.95 | ●      |  | 2.19    | TID*140... |
| DMH145      | 0.571   | 14.5    | 7.95 | ●      |  | 2.21    | TID*145... |
| New DMH146  | 0.575   | 14.6    | 7.95 | ●      |  | 2.23    | TID*145... |
| New DMH147  | 0.579   | 14.7    | 7.95 | ●      |  | 2.25    | TID*145... |
| DMH150      | 0.591   | 15      | 8.53 | ●      |  | 2.27    | TID*150... |
| New DMH151  | 0.594   | 15.1    | 8.53 | ●      |  | 2.29    | TID*150... |
| DMH152      | 0.598   | 15.2    | 8.53 | ●      |  | 2.31    | TID*150... |
| New DMH153  | 0.602   | 15.3    | 8.53 | ●      |  | 2.32    | TID*150... |
| New DMH154  | 0.606   | 15.4    | 8.53 | ●      |  | 2.34    | TID*150... |
| DMH155      | 0.610   | 15.5    | 8.53 | ●      |  | 2.36    | TID*150... |
| New DMH156  | 0.614   | 15.6    | 8.53 | ●      |  | 2.38    | TID*150... |
| New DMH157  | 0.618   | 15.7    | 8.53 | ●      |  | 2.40    | TID*150... |
| New DMH158  | 0.622   | 15.8    | 8.53 | ●      |  | 2.42    | TID*150... |
| DMH160      | 0.630   | 16      | 9.1  | ●      |  | 2.42    | TID*160... |
| New DMH162  | 0.638   | 16.2    | 9.1  | ●      |  | 2.46    | TID*160... |
| New DMH163  | 0.642   | 16.3    | 9.1  | ●      |  | 2.47    | TID*160... |
| DMH165      | 0.650   | 16.5    | 9.1  | ●      |  | 2.51    | TID*160... |
| New DMH166  | 0.654   | 16.6    | 9.1  | ●      |  | 2.53    | TID*160... |
| New DMH167  | 0.657   | 16.7    | 9.1  | ●      |  | 2.55    | TID*160... |
| DMH170      | 0.669   | 17      | 9.7  | ●      |  | 2.59    | TID*170... |
| New DMH171  | 0.673   | 17.1    | 9.7  | ●      |  | 2.61    | TID*170... |
| DMH175      | 0.689   | 17.5    | 9.7  | ●      |  | 2.68    | TID*170... |
| New DMH177  | 0.697   | 17.7    | 9.7  | ●      |  | 2.72    | TID*170... |
| New DMH178  | 0.701   | 17.8    | 9.7  | ●      |  | 2.74    | TID*170... |
| New DMH179  | 0.705   | 17.9    | 9.7  | ●      |  | 2.75    | TID*170... |
| DMH180      | 0.709   | 18      | 10.3 | ●      |  | 2.73    | TID*180... |
| New DMH181  | 0.713   | 18.1    | 10.3 | ●      |  | 2.75    | TID*180... |
| New DMH183  | 0.720   | 18.3    | 10.3 | ●      |  | 2.78    | TID*180... |
| DMH185      | 0.728   | 18.5    | 10.3 | ●      |  | 2.82    | TID*180... |
| New DMH187  | 0.736   | 18.7    | 10.3 | ●      |  | 2.86    | TID*180... |
| DMH190      | 0.748   | 19      | 10.8 | ●      |  | 2.88    | TID*190... |
| DMH191      | 0.752   | 19.1    | 10.8 | ●      |  | 2.90    | TID*190... |
| New DMH192  | 0.756   | 19.2    | 10.8 | ●      |  | 2.92    | TID*190... |

● : New product  
● : Line up

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

★ : First choice

| Designation | DC<br>(in) | DC<br>(mm) | LPR   | Coated |  | PL<br>(mm) | Body       |
|-------------|------------|------------|-------|--------|--|------------|------------|
|             |            |            |       | AH9130 |  |            |            |
| New DMH193  | 0.760      | 19.3       | 10.8  | ●      |  | 2.93       | TID*190... |
| DMH194      | 0.764      | 19.4       | 10.8  | ●      |  | 2.95       | TID*190... |
| DMH195      | 0.768      | 19.5       | 10.8  | ●      |  | 2.97       | TID*190... |
| New DMH196  | 0.772      | 19.6       | 10.8  | ●      |  | 2.99       | TID*190... |
| New DMH197  | 0.776      | 19.7       | 10.8  | ●      |  | 3.01       | TID*190... |
| New DMH200  | 0.787      | 20         | 11.4  | ●      |  | 3.02       | TID*200... |
| DMH205      | 0.807      | 20.5       | 11.4  | ●      |  | 3.11       | TID*200... |
| DMH210      | 0.827      | 21         | 11.98 | ●      |  | 3.18       | TID*210... |
| DMH215      | 0.847      | 21.5       | 11.98 | ●      |  | 3.27       | TID*210... |
| DMH220      | 0.866      | 22         | 12.56 | ●      |  | 3.32       | TID*220... |
| DMH225      | 0.886      | 22.5       | 12.56 | ●      |  | 3.41       | TID*220... |
| DMH230      | 0.906      | 23         | 13.13 | ●      |  | 3.46       | TID*230... |
| DMH235      | 0.925      | 23.5       | 13.13 | ●      |  | 3.55       | TID*230... |
| DMH240      | 0.945      | 24         | 13.7  | ●      |  | 3.62       | TID*240... |
| DMH245      | 0.965      | 24.5       | 13.7  | ●      |  | 3.71       | TID*240... |
| DMH250      | 0.984      | 25         | 14.3  | ●      |  | 3.8        | TID*250... |
| DMH255      | 1.004      | 25.5       | 14.3  | ●      |  | 3.89       | TID*250... |

Package Quantity: 0.236" - 0.780" = 2 pcs.  
0.787" - 1.020" = 1 pcs.

● : New product  
● : Line up

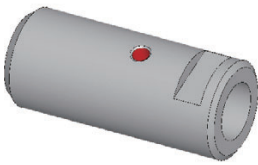
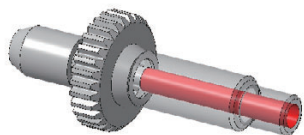
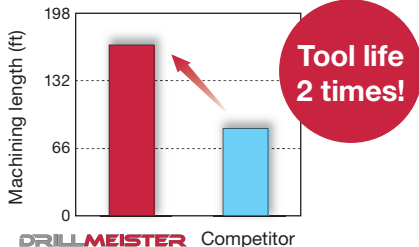
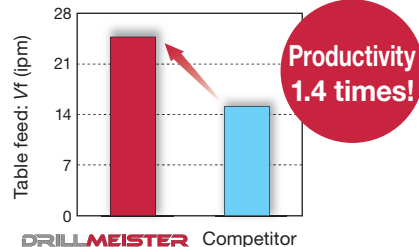
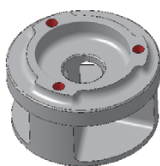
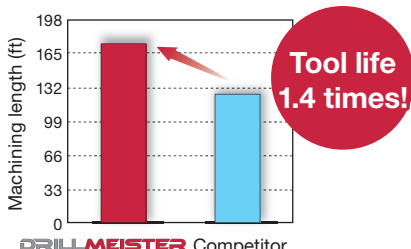
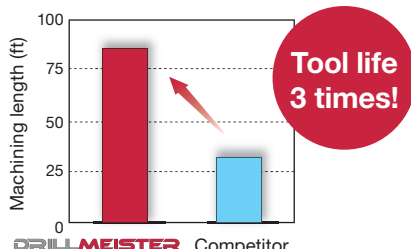


## STANDARD CUTTING CONDITIONS

| ISO      | Workpiece material                                    | Cutting speed<br>Vc (sfm) | Feed: f (ipr)          |                   |                   |                   |                   |                   |                   |
|----------|-------------------------------------------------------|---------------------------|------------------------|-------------------|-------------------|-------------------|-------------------|-------------------|-------------------|
|          |                                                       |                           | Tool diameter: DC (in) |                   |                   |                   |                   |                   |                   |
|          |                                                       |                           | ø0.236" - ø0.311"      | ø0.315" - ø0.390" | ø0.394" - ø0.469" | ø0.472" - ø0.547" | ø0.551" - ø0.626" | ø0.630" - ø0.783" | ø0.787" - ø1.020" |
| <b>P</b> | Low carbon steels (C < 0.3)<br>1018, 1020, 1026, etc. | 262 - 459                 | 0.004 - 0.005          | 0.005 - 0.010     | 0.006 - 0.011     | 0.007 - 0.012     | 0.008 - 0.014     | 0.010 - 0.018     | 0.010 - 0.018     |
|          | High carbon steels (C > 0.3)<br>1045, 1055, etc.      | 230 - 394                 | 0.004 - 0.005          | 0.005 - 0.010     | 0.006 - 0.011     | 0.007 - 0.012     | 0.008 - 0.014     | 0.010 - 0.018     | 0.010 - 0.018     |
|          | Low alloy steels<br>4140, etc.                        | 230 - 394                 | 0.003 - 0.005          | 0.004 - 0.010     | 0.006 - 0.011     | 0.006 - 0.013     | 0.007 - 0.014     | 0.009 - 0.016     | 0.010 - 0.018     |
|          | Alloy steels<br>8620, etc.                            | 131 - 295                 | 0.003 - 0.005          | 0.004 - 0.010     | 0.006 - 0.011     | 0.006 - 0.013     | 0.007 - 0.014     | 0.009 - 0.016     | 0.010 - 0.018     |
| <b>M</b> | Stainless steels<br>304SS, 316SS, etc.                | 98 - 230                  | 0.003 - 0.004          | 0.004 - 0.006     | 0.005 - 0.007     | 0.006 - 0.008     | 0.006 - 0.009     | 0.006 - 0.010     | 0.007 - 0.012     |
| <b>K</b> | Gray cast irons<br>Class 25, etc.                     | 262 - 591                 | 0.005 - 0.007          | 0.006 - 0.012     | 0.008 - 0.014     | 0.010 - 0.016     | 0.012 - 0.018     | 0.014 - 0.022     | 0.014 - 0.024     |
|          | Ductile cast irons<br>100-70-03, etc.                 | 262 - 459                 | 0.005 - 0.007          | 0.006 - 0.012     | 0.008 - 0.014     | 0.010 - 0.016     | 0.012 - 0.018     | 0.014 - 0.022     | 0.014 - 0.024     |
| <b>N</b> | Aluminum alloys                                       | 262 - 722                 | 0.004 - 0.008          | 0.008 - 0.014     | 0.010 - 0.016     | 0.012 - 0.018     | 0.014 - 0.02      | 0.016 - 0.024     | 0.020 - 0.030     |
| <b>S</b> | Titanium alloys<br>Ti-6Al-4V, etc.                    | 66 - 164                  | 0.002 - 0.003          | 0.002 - 0.005     | 0.003 - 0.006     | 0.004 - 0.011     | 0.005 - 0.008     | 0.006 - 0.009     | 0.007 - 0.011     |
|          | Nickel-based alloys                                   | 66 - 164                  | 0.002 - 0.003          | 0.002 - 0.004     | 0.003 - 0.005     | 0.004 - 0.006     | 0.005 - 0.007     | 0.005 - 0.009     | 0.006 - 0.009     |
| <b>H</b> | Hardened steel                                        | 66 - 164                  | 0.002 - 0.003          | 0.002 - 0.005     | 0.003 - 0.006     | 0.004 - 0.007     | 0.005 - 0.008     | 0.006 - 0.009     | 0.006 - 0.010     |

- Cutting conditions in the above table show standard cutting conditions
- Cutting conditions may change due to the rigidity and power of the machine and the workpiece material
- Machined hole diameter may change depending upon the rigidity of the machine tool or cutting conditions

## PRACTICAL EXAMPLES

| Workpiece type     |                          | Shaft pin                                                                                                                                                                                                                                                                                                           | Input shaft                                                                                                                                                                                                                                                                                                             |
|--------------------|--------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Drill body         |                          | TID085R10-8                                                                                                                                                                                                                                                                                                         | TID170R18-6                                                                                                                                                                                                                                                                                                             |
| Head               |                          | DMH088                                                                                                                                                                                                                                                                                                              | DMH170                                                                                                                                                                                                                                                                                                                  |
| Grade              |                          | AH9130                                                                                                                                                                                                                                                                                                              | AH9130                                                                                                                                                                                                                                                                                                                  |
| Workpiece material |                          | 1045                                                                                                                                                                                                                                                                                                                | 4142                                                                                                                                                                                                                                                                                                                    |
|                    |                          |  <b>P</b>                                                                                                                                                                                                                          |  <b>P</b>                                                                                                                                                                                                                            |
| Cutting conditions | Cutting speed : Vc (sfm) | 272                                                                                                                                                                                                                                                                                                                 | 361                                                                                                                                                                                                                                                                                                                     |
|                    | Feed : f (ipr)           | 0.003                                                                                                                                                                                                                                                                                                               | 0.012                                                                                                                                                                                                                                                                                                                   |
|                    | Drill diameter: DC (in)  | 0.346                                                                                                                                                                                                                                                                                                               | 0.669                                                                                                                                                                                                                                                                                                                   |
|                    | Hole depth : H (in)      | 0.787                                                                                                                                                                                                                                                                                                               | 3.504                                                                                                                                                                                                                                                                                                                   |
|                    | Coolant                  | Wet (Internal coolant)                                                                                                                                                                                                                                                                                              | Wet (Internal and external coolant)                                                                                                                                                                                                                                                                                     |
|                    | Machine                  | Vertical M/C                                                                                                                                                                                                                                                                                                        | CNC lathe                                                                                                                                                                                                                                                                                                               |
| Results            |                          |  <p>Existing products suffered from chipping during penetration, and had large deviation of tool life. The <b>DMH</b> head, which has excellent cutting edge strength, has achieved a stable tool life with reduced breakage.</p> |  <p>Existing products had fractured on the cutting edge and limited machining conditions. Cutting edge fracture is suppressed by using a <b>DMH</b> head. Furthermore, it became possible to improve the processing conditions.</p> |
| Workpiece type     |                          | Gear case                                                                                                                                                                                                                                                                                                           | Blade                                                                                                                                                                                                                                                                                                                   |
| Drill body         |                          | TID140F16-3                                                                                                                                                                                                                                                                                                         | TID125F16-3                                                                                                                                                                                                                                                                                                             |
| Head               |                          | DMH140                                                                                                                                                                                                                                                                                                              | DMH125                                                                                                                                                                                                                                                                                                                  |
| Grade              |                          | AH9130                                                                                                                                                                                                                                                                                                              | AH9130                                                                                                                                                                                                                                                                                                                  |
| Workpiece material |                          | 100-70-03                                                                                                                                                                                                                                                                                                           | HARDOX (450HB)                                                                                                                                                                                                                                                                                                          |
|                    |                          |  <b>K</b>                                                                                                                                                                                                                        |  <b>H</b>                                                                                                                                                                                                                          |
| Cutting conditions | Cutting speed : Vc (sfm) | 328                                                                                                                                                                                                                                                                                                                 | 230                                                                                                                                                                                                                                                                                                                     |
|                    | Feed : f (ipr)           | 0.001                                                                                                                                                                                                                                                                                                               | 0.008                                                                                                                                                                                                                                                                                                                   |
|                    | Drill diameter: DC (in)  | 0.551                                                                                                                                                                                                                                                                                                               | 0.492                                                                                                                                                                                                                                                                                                                   |
|                    | Hole depth : H (in)      | 1.181                                                                                                                                                                                                                                                                                                               | 1.260                                                                                                                                                                                                                                                                                                                   |
|                    | Coolant                  | Wet (Internal coolant)                                                                                                                                                                                                                                                                                              | Wet (Internal coolant)                                                                                                                                                                                                                                                                                                  |
|                    | Machine                  | Vertical M/C                                                                                                                                                                                                                                                                                                        | Horizontal M/C                                                                                                                                                                                                                                                                                                          |
| Results            |                          |  <p>Cutting edge fractures occurred frequently due to the impact when the drill penetrated, and the tool life was an issue, but by using the <b>DMH</b> head, fractures were suppressed and the tool life was 1.4 times.</p>     |  <p>The tool life was short due to the high work height and chipping of the cutting edge, but by using the <b>DMH</b> head, chipping was suppressed and the tool life was tripled.</p>                                             |



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