

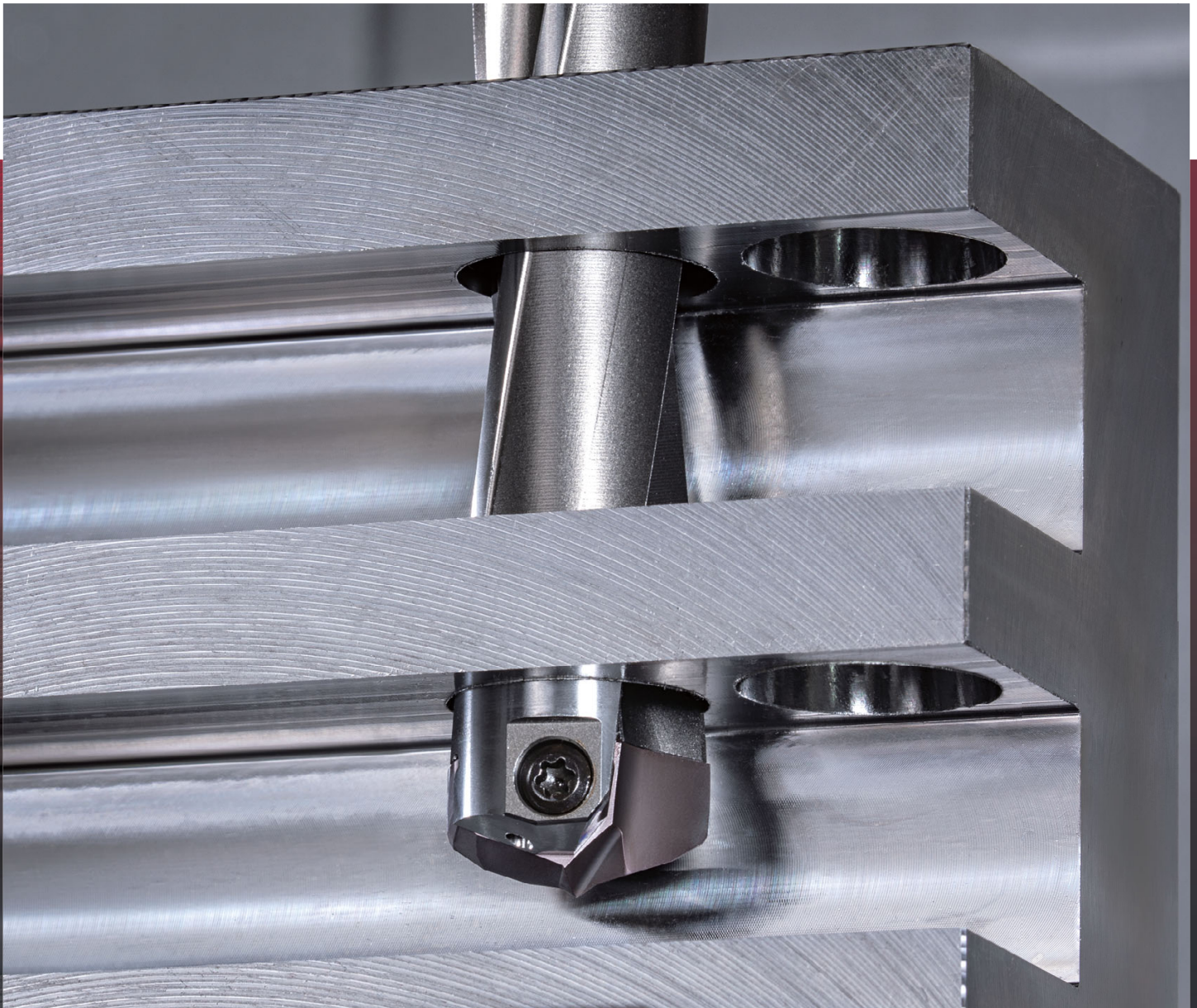


Exchangeable head drill

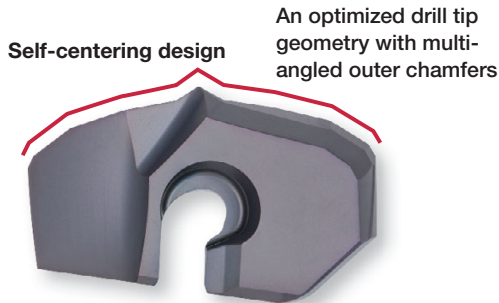
DRILL **F**ORCE MEISTER

Tungaloy Report No. 509S5-G

Introducing self-centering SMC heads for drilling long depths without pre-hole



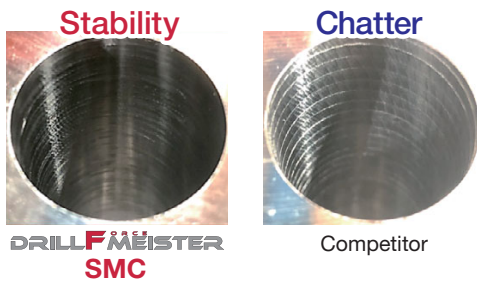
SMC - High precision drilling



- Pre-drilling is unnecessary
- Outstanding **drilling stability**
- Sophisticated geometry prevents cutting edge fracture and burr formation on the workpiece

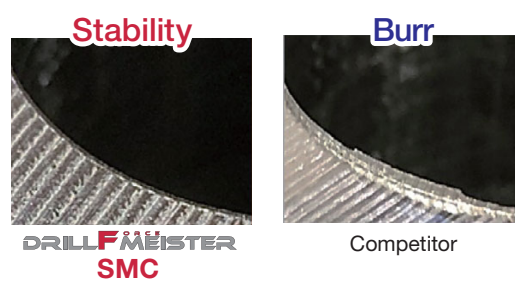
Cutting performance

Hole quality



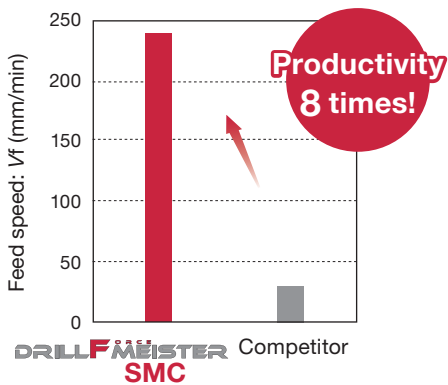
P	Tool	: ø26 mm, L/D = 8
	Workpiece material	: Alloy steel
	Cutting speed	: $V_c = 100$ m/min
	Feed	: $f = 0.3$ mm/rev

Burr formation



P	Tool	: ø26 mm, L/D = 8
	Workpiece material	: Low carbon steel
	Cutting speed	: $V_c = 100$ m/min
	Feed	: $f = 0.3$ mm/rev

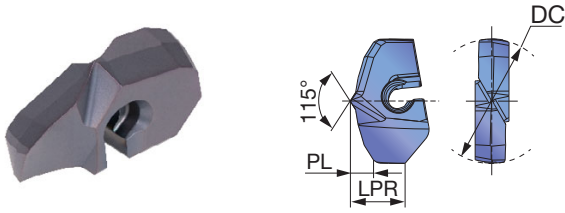
Stable long-overhang drilling with no need for pre-drilling



K	Tool	: TIS260F32-8
	Drill head	: SMC260
	Grade	: AH9130
	Workpiece material	: FCD600
	Cutting speed	: $V_c = 80$ m/min
	Feed	: $f = 0.25$ mm/rev
	Hole depth	: $H = 150$ mm
	Hole type	: Through holes
	Coolant	: Wet



SMC High precision drilling



Tool diameter	Head diameter tolerance
ø26 - ø33	+0.025 / 0

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

★ : First choice
☆ : Second choice

Designation	DC	LPR	Coated		PL	Pocket size	Body
			AH9130				
SMC260	26	13.78	●		6.26	26	TIS260F32-*
SMC265	26.5	13.73	●		6.35	26	TIS260F32-*
SMC267	26.7	13.71	●		6.39	26	TIS260F32-*
SMC270	27	13.73	●		6.43	27	TIS270F32-*
SMC275	27.5	13.69	●		6.52	27	TIS270F32-*
SMC280	28	14.15	●		6.48	28	TIS280F32-*
SMC290	29	14.24	●		6.62	29	TIS290F32-*
SMC300	30	16.78	●		6.67	30	TIS300F32-*
SMC310	31	16.66	●		6.84	31	TIS310F32-*
SMC315	31.5	16.62	●		6.93	31	TIS310F32-*
SMC320	32	17.34	●		6.94	32	TIS320F40-*
SMC330	33	17.2	●		7.1	33	TIS330F40-*

● : New product
Package quantity = 1 pc

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Cutting speed Vc (m/min)	Feed: f (mm/rev)
			ø26 - ø33
P	Low carbon steel S15C, S20C, etc. C15E4, etc.	80 - 140	0.2 - 0.5
	Carbon steel and alloy steel S55C, SCM440, etc. C55, 42CrMo4, etc.	80 - 130	0.2 - 0.5
	Prehardened steel NAK80, PX5, etc.	50 - 100	0.2 - 0.5
K	Grey cast iron FC250, FC300, etc. 250, 300, etc.	80 - 180	0.25 - 0.55
	Ductile cast iron FCD400, FCD600, etc. 400-15, 600-3, etc.	80 - 140	0.25 - 0.55
N	Non ferrous materials	100 - 200	0.4 - 0.6
H	Hard materials	20 - 60	0.1 - 0.2

Tungaloy Corporation (Head office)

11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima 970-1144 Japan
Phone: +81-246-36-8501
Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy-NTK America Inc.

3726 N Ventura Drive
Arlington Heights, IL 60004, U.S.A.
Phone: +1-888-554-8394
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada

432 Elgin St. Unit 3
Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779
Fax: +1-519-758-5791
www.tungaloy.com/ca

Tungaloy-NTK De Mexico S.A.

C. Los Arellano 113,
Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410
Fax: +52-449-929-5411
www.tungaloy.com/mx

Tungaloy-NTK do Brasil Ltda.

Avd. Independencia N4158 Residencial Flora
13280-000 Vinhedo, São Paulo, Brasil
Phone: +55-19-38262757
Fax: +55-19-38262757
www.tungaloy.com/br

Tungaloy-NTK Germany GmbH.

Katzbergstr. 3a
D-40764 Langenfeld, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.com/de

Tungaloy France s.a.s

Les Fjords
19 avenue de Norvège
91140 Villebon Sur Yvette, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.com/fr

Tungaloy Italia S.r.l.

Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1
Fax: +39-02-252012-65
www.tungaloy.com/it

Tungaloy Czech s.r.o.

Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391
Fax: +420-532 123 392
www.tungaloy.com/cz

Tungaloy Ibérica S.L.

C/Miquel Servet, 43B, Nau 7
Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360
Fax: +34 93 876 2798
www.tungaloy.com/es

Tungaloy Scandinavia AB

Bultgatan 38
442 40 Kungälv, Sweden
Phone: +46-462119200
Fax: +46-462119207
www.tungaloy.com/se

Tungaloy Rus, LLC

Andropova avenue, h.18/7,
11 floor, office 3, 115432,
Moscow, Russia
Phone: +7-499-683-01-80
Fax: +7-499-683-01-81
www.tungaloy.com/ru

Tungaloy Polska Sp. z o.o.

Ul. Irysowa 1, 55-040 Bielany
Wroclawskie, Poland
Phone: +48 607 907 237
www.tungaloy.com/pl

Tungaloy-NTK UK Ltd.

Suite 3, Pioneer House, Mill Street,
Cannock, WS11 0EF, UK
Phone: +44 121 4000 231
Fax: +44 121 270 9694
www.tungaloy.com/uk

Tungaloy Hungary Kft

Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846
Fax: +36 1 781-6866
www.tungaloy.com/hu

Tungaloy Turkey

Serifali Mah.bayraktar Bulvari Kule Sk. No:26
34775 Umraniye / Istanbul / Turkey
Phone: +90 216 540 04 67
Fax: +90 216 540 04 87
www.tungaloy.com/tr

Tungaloy Benelux b.v.

Tjalk 70
NL-2411 NZ Bodegraven, Netherlands
Phone: +31 172 630 420
Fax: +31 172 630 429
www.tungaloy.com/nl

Tungaloy Croatia

Ulica bana Josipa Jelačića 87,
10430, Samobor, Croatia
Phone: +385 1 3326 604
Fax: +385 1 3327 683
www.tungaloy.com/hr

Tungaloy Cutting Tool (Shanghai) Co. Ltd.

Rm No 401 No.88 Zhabei
Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880
Fax: +86-21-3621-1918
www.tungaloy.com/cn

Tungaloy Cutting Tools Taiwan Co. Ltd.

9F, No.293, Zhongyang Rd,
Xinzhuan Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy-NTK Cutting Tool (Thailand) Co.,Ltd.

Interlink tower 4th Fl.
1858/5-7 Bangna-Trad Road
km.5 Bangna, Bangna, Bangkok 10260
Thailand
Phone: +66-2-751-5711
Fax: +66-2-751-5715
www.tungaloy.com/th

Tungaloy Singapore (Pte.), Ltd.

62 Ubi Road 1, #06-11 Oxley BizHub 2
Singapore 408734
Phone: +65-6391-1833
Fax: +65-6299-4557
www.tungaloy.com/sg

Tungaloy Vietnam

LE04.38, Lexington Residence
67 Mai Chi Tho St., Dist. 2,
Ho Chi Minh City, Vietnam
Phone: +84-2837406660
www.tungaloy.com/sg

Tungaloy India Pvt. Ltd.

One International Center,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai 400013, India
Phone: +91-22-6124-8803
Fax: +91-22-6124-8899
www.tungaloy.com/in

Tungaloy Korea Co., Ltd

#1312, Byucksan Digital Valley 5-cha
Beotkkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161
Fax: +82-2-6393-8952
www.tungaloy.com/kr

Tungaloy Malaysia Sdn Bhd

50 K-2, Kelana Mall, Jalan SS6/14
Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan
Malaysia
Phone: +603-7805-3222
Fax: +603-7804-8563
www.tungaloy.com/my

Tungaloy Australia Pty Ltd

Unit 68 1470 Ferntree Gully Road
Knoxfield 3180 Victoria, Australia
Phone: +61-3-9755-8147
Fax: +61-3-9755-6070
www.tungaloy.com/au

PT. Tungaloy Indonesia

Ruko Blok AA.10 No3&5, Grand Wisata,
Lambangjaya, Tambun Selatan, Bekasi,
17510 Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
www.tungaloy.com/id



tungaloy.com

follow us at:

facebook.com/tungaloyjapan

twitter.com/tungaloyjapan

www.youtube.com/tungaloycorporation

Distributed by:



Tungaloy APP & SNS

FIND US ON THE CLOUD!
machingcloud.com



AS9100 Certified
78006
2015.11.04
ISO 14001 Certified
EC97J1123
1997.11.26