

Profile milling cutter

ADD^{FORCE}BARREL

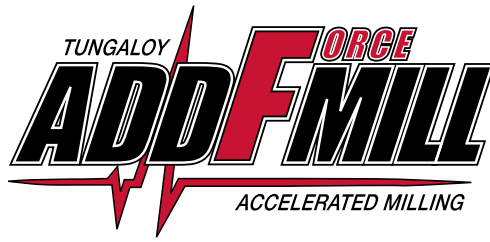
Tungaloy Report No. 552-US

Barrel-shaped inserts for profile milling with productivity boost





INDUSTRY 4.0
FEED the SPEED!



ADDFORCE BARREL



High productivity profile milling cutter

Large R cutting edge and multi-flute design for unparalleled productivity



Large R
for small
cusp height



Close pitch design

ADD^{FORCE}BARREL

DCX = 20 mm (0.787"),
PRFRAD = 30 mm (1.181")



Large
pitch

Cusp height

Ball endmill

DCX = 20 mm (0.787"),
R = 10 mm (0.394")



Small
pitch

Cusp height

AddForceBarrel reduces the number of passes by 40% compared to ball endmill with 10 mm (0.394") radius without compromising the surface quality (cusp height).

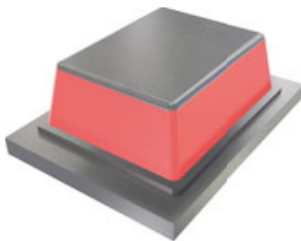
Practical example

Performance comparison of **AddForceBarrel** with indexable ball endmill

P

Carbon steel
S55C / C55 (1055)
(204HB)

Dry condition
Width of cut: ae = 0.1 mm (0.004")



	ADD^{FORCE}BARREL DCX = 20 mm (0.787"), CICT = 4	Ball endmill DCX = 20 mm (0.787"), CICT = 2
Cutter	HFZN10M020M10R04	Indexable endmill
Insert	ZNHU1003R30-MM AH9130	R = 10 mm (0.394")
Cutting speed: Vc	250 m/min (820 sfm)	
Feed per tooth: fz	0.2 mm/t (0.008 ipt)	
Feed speed: Vf	3180 mm/min (125.2 ipm)	1590 mm/min (62.6 ipm)
Pitch (depth of cut): p	1.7 mm (0.067")	1 mm (0.040")
Theoretical cusp height	12 µm (472 Micro inches)	12 µm (472 micro inches)

ADD^{FORCE}BARREL

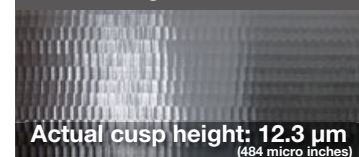
Machining time: 210 sec.



Actual cusp height: 12.5 µm
(492 micro inches)

Ball endmill

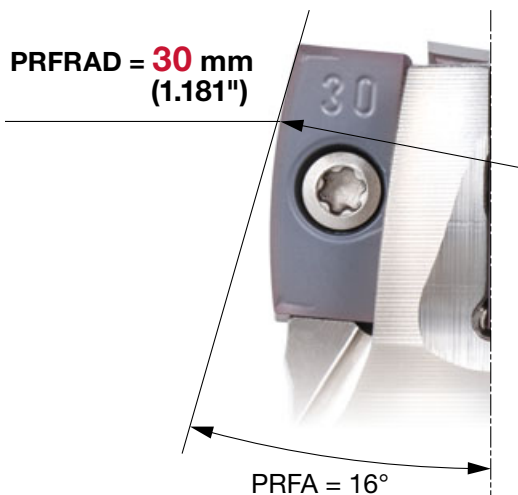
Machining time: 570 sec.



Actual cusp height: 12.3 µm
(484 micro inches)

AddForceBarrel saved 64% of machining time.

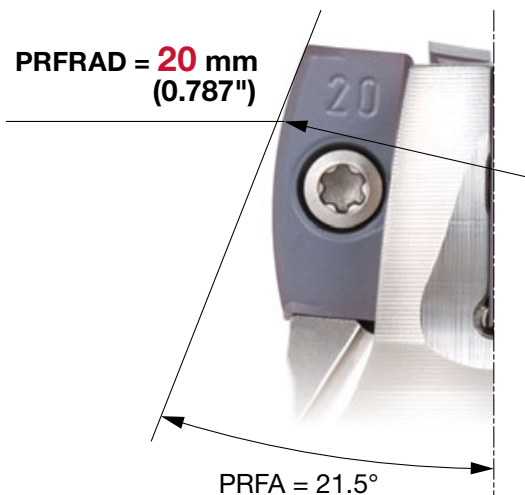
Two kinds of barrel-shaped cutting edge profiles (PRFRAD)



1st choice ZNHU1003R30...

2-corner double sided insert

High productive geometry that provides a large stepover distance for reduced cusp height

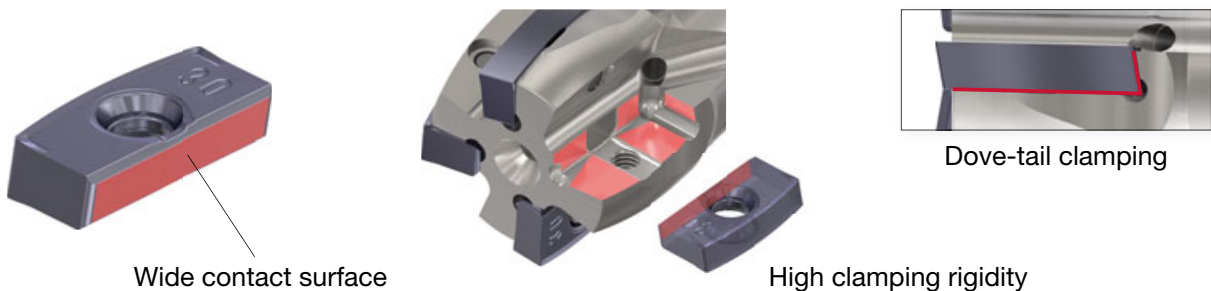


ZNHU1003R20...

2-corner double sided insert

Profiling geometry with an increased tilt angle for enhanced application versatility

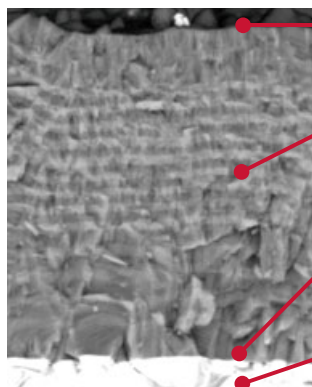
Excellent clamping reliability with dove-tail back support



Grade with high wear resistance

AH9130 **P M K S H**

- Nano multi-layer coating technology with three major properties for optimal cutting edge integrity
- Increased resistance to wear, fracture, oxidation, built-up edge, and delamination



Resistance to built-up edge

The coating surface prevents built-up edge

Resistance to wear, oxidation, and fracture

Multi-layered coating is designed to resist wear and oxidation, while preventing micro-cracks from propagating in the coating layer for improved resistance to edge chipping

Strong coating / substrate adhesion

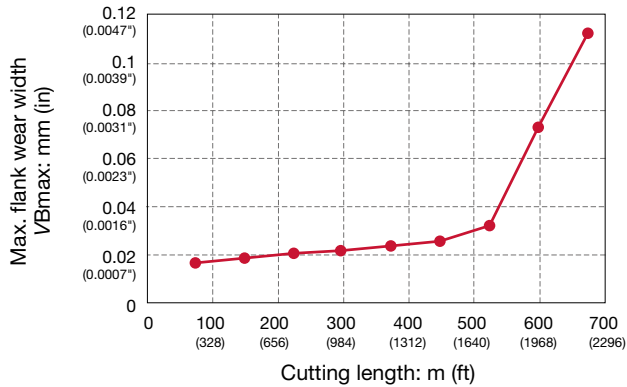
Coating is optimized for strong adhesion property with substrate to maintain strong cutting edge integrity

Carbide substrate

Provides a good combination of wear and fracture resistance

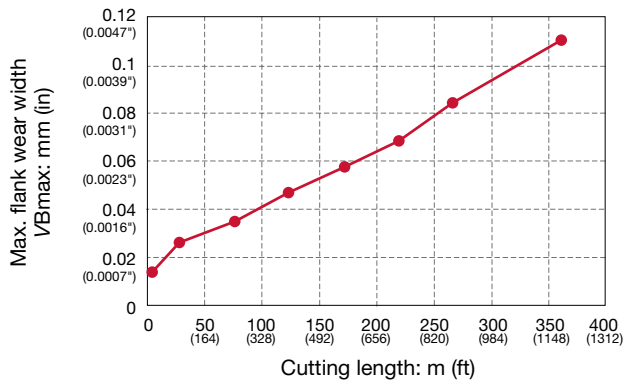
TOOL LIFE

P Carbon steel S55C / C55 (1055) (204HB)



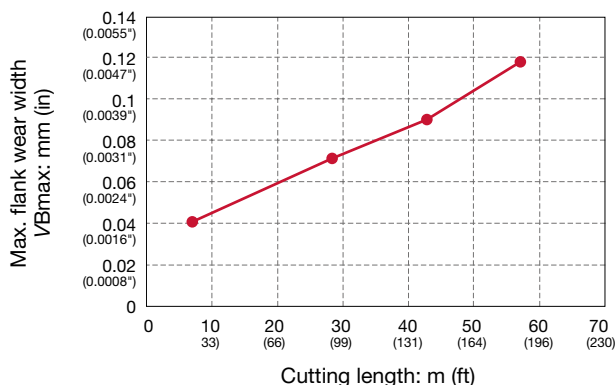
Cutter : HFZN10M020M10R04
 (DCX = 20 mm (0.787"), CICT = 4)
 Insert : ZNHU1003R30-MM AH9130
 Cutting speed : $V_c = 600$ m/min (1969 sfm)
 Feed per tooth : $f_z = 0.2$ mm/t (0.008 ipt)
 Pitch (depth of cut) : $p = 2$ mm (0.079")
 Width of cut : $a_e = 0.1$ mm (0.004")
 Coolant : Dry
 Overhang length : 110 mm (4.331")
 Machine : Vertical M/C, BT40 (CAT40)
 Performed with only one insert on the cutter

M Martensitic stainless steel SUS420J1 / X20Cr13 (420) (281HB)



Cutter : HFZN10M020M10R04
 (DCX = 20 mm (0.787"), CICT = 4)
 Insert : ZNHU1003R30-MM AH9130
 Cutting speed : $V_c = 500$ m/min (1640 sfm)
 Feed per tooth : $f_z = 0.15$ mm/t (0.006 ipt)
 Pitch (depth of cut) : $p = 2$ mm (0.079")
 Width of cut : $a_e = 0.1$ mm (0.004")
 Coolant : Dry
 Overhang length : 110 mm (4.331")
 Machine : Vertical M/C, BT40 (CAT40)
 Performed with only one insert on the cutter

H Hardened steel DH31S (50HRC)



Cutter : HFZN10M020M10R04
 (DCX = 20 mm (0.787"), CICT = 4)
 Insert : ZNHU1003R30-MM AH9130
 Cutting speed : $V_c = 200$ m/min (656 sfm)
 Feed per tooth : $f_z = 0.1$ mm/t (0.004 ipt)
 Pitch (depth of cut) : $p = 2$ mm (0.079")
 Width of cut : $a_e = 0.1$ mm (0.004")
 Coolant : Dry
 Overhang length : 110 mm (4.331")
 Machine : Vertical M/C, BT40 (CAT40)
 Performed with only one insert on the cutter

MODULAR TYPE

TUNGFLEX

HFZN10-M

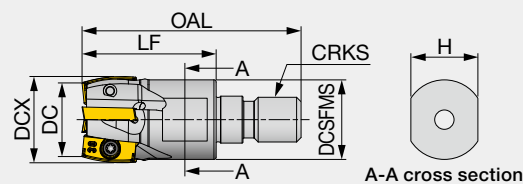
Profiling endmill, modular type (TungFlex), for 2-corner double sided inserts

GAMP = +7.1° ~ +9.2°, GAMF = -20.8° ~ -17.9°

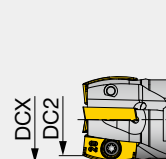
New



with ZNHU1003R30-MM



with ZNHU1003R20-MM



Metric	DCX	CICT	DC	DC2	OAL	LF	DCSFMS	CRKS	H	WT(kg)	Air hole	Insert
HFZN10M016M08R03	16	3	13	12.5	42	25	14.5	M8	10	0.02	With	ZNHU1003...
HFZN10M020M10R04	20	4	17	16.5	49	30	17.8	M10	15	0.05	With	ZNHU1003...
HFZN10M025M12R05	25	5	22	21.5	57	35	23	M12	17	0.1	With	ZNHU1003...
HFZN10M035M16R07	35	7	31.9	31.4	63	40	28.8	M16	22	0.22	With	ZNHU1003...
HFZN10M040M16R08	40	8	36.9	36.4	63	40	28.8	M16	22	0.25	With	ZNHU1003...

SPARE PARTS



Designation	Clamping screw	Wrench
HFZN10...	SR-M2.5X0.45-L6IP7	IP-7D

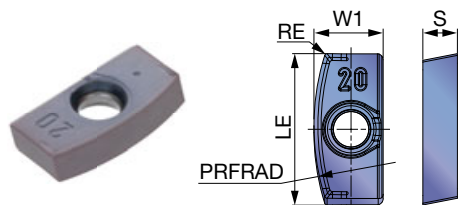
*Recommended clamping torque (N·m): SR-M2.5x0.45-L6IP7 = 1

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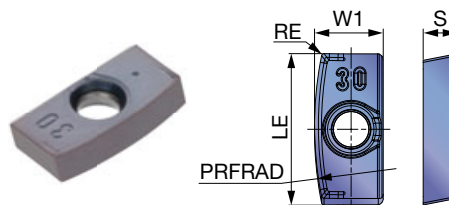


INSERTS

ZNHU1003R20-MM



ZNHU1003R30-MM



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

★ : First choice
☆ : Second choice

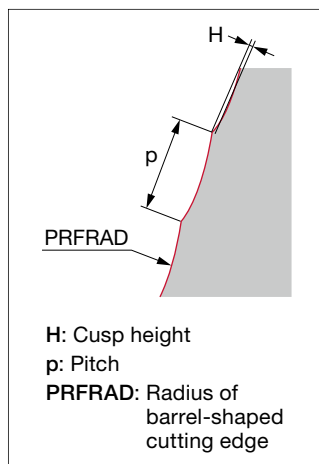
Designation	PRFRAD (in)	RE (in)	Coated								LE (in)	W1 (in)	S (in)
			AH9130										
ZNHU1003R20-MM	0.787	0.008	●								0.453	0.221	0.110
ZNHU1003R30-MM	1.181	0.008	●								0.453	0.219	0.110

● : Line up

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)	Width of cut ae (in)
P	Low carbon steel 1020, etc.	- 200HB	328 - 1969	0.002 - 0.012	< 0.016
	Carbon steel 1045, etc.	- 300HB	328 - 1969	0.002 - 0.012	< 0.012
	Prehardened steel NAK80, PX5, etc.	30 - 40HRC	328 - 1969	0.002 - 0.012	< 0.012
M	Austenitic stainless steel 304SS, etc.	- 200HB	328 - 1640	0.002 - 0.012	< 0.012
	Precipitation hardening stainless steel 17-4 PH, etc.	- 45HRC	328 - 984	0.002 - 0.01	< 0.008
K	Gray cast iron Class 25, etc.	150 - 250HB	328 - 1969	0.002 - 0.012	< 0.012
	Ductile cast iron 60-40-18, etc.	150 - 250HB	328 - 1969	0.002 - 0.012	< 0.012
S	Titanium alloys Ti-6Al-4V, etc.	- 45HRC	131 - 394	0.002 - 0.008	< 0.008
	Superalloys Inconel718, etc.	- 45HRC	66 - 262	0.002 - 0.008	< 0.008
H	Hardened steel H-13, etc.	40 - 55HRC	164 - 984	0.002 - 0.008	< 0.008

Cusp height and pitch



To obtain the pitch (p) from the given cusp height (H)

H (in)	0.00004	0.00008	0.00012	0.00016	0.00020	0.00039	0.00059	0.00079
PRFRAD (in)								
20 (ZNHU1003R20...)	0.016	0.022	0.027	0.031	0.035	0.050	0.061	0.070
30 (ZNHU1003R30...)	0.020	0.027	0.033	0.039	0.043	0.061	0.075	0.086

$$p = \sqrt{8 \times H \times \text{PRFRAD}}$$

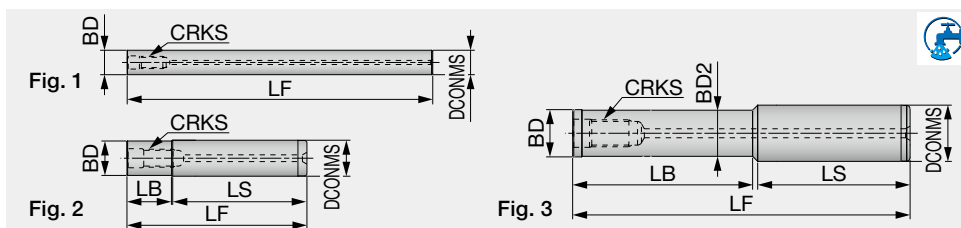
(mm)

To obtain the cusp height (H) from the given pitch (p)

p (in)	0.020	0.030	0.039	0.049	0.059	0.069	0.079
PRFRAD (in)							
20 (ZNHU1003R20...)	0.00008	0.00016	0.00024	0.00039	0.00055	0.00075	0.00098
30 (ZNHU1003R30...)	0.00004	0.00008	0.00016	0.00028	0.00035	0.00051	0.00067

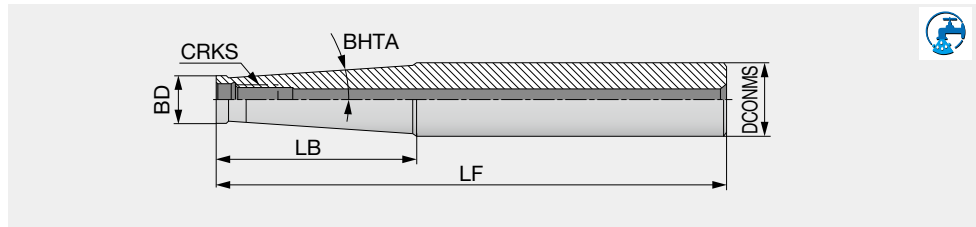
$$H = \frac{p^2}{8 \times \text{PRFRAD}}$$

(mm)



Metric	CRKS	DCONMS	LF	LB	LS	BD	BD2	Fig.
SM06-L100-C10-C-H	M6	10	100	-	-	10	-	1
SM06-L150-C10-C-H	M6	10	150	-	-	10	-	1
SM06-L100-C12-C-H	M6	12	100	-	-	12	-	1
SM06-L150-C12-C-H	M6	12	150	-	-	12	-	1
SM08-L80-20-C16-C-H	M8	16	80	20	59.6	15.3	-	2
SM08-L100-40-C16-C-H	M8	16	100	40	59.6	15.3	-	2
SM08-L150-80-C16-C-H	M8	16	150	80	69.6	15.3	-	2
SM08-L200-100-C16-C-H	M8	16	200	100	98.2	13	12.5	3
SM08-L200-140-C16-C-H	M8	16	200	140	59.6	15.3	-	2
SM08-L250-180-C16-C-H	M8	16	250	180	69.6	15.3	-	2
SM10-L80-20-C20-C-H	M10	20	80	20	59.2	18.5	-	2
SM10-L100-40-C20-C-H	M10	20	100	40	59.2	18.5	-	2
SM10-L150-80-C20-C-H	M10	20	150	80	69.2	18.5	-	2
SM10-L200-100-C20-C-H	M10	20	200	100	99.2	18.5	-	2
SM10-L200-140-C20-C-H	M10	20	200	140	58.7	18	17.5	3
SM10-L200-140-C20-C-H-N	M10	20	200	140	59.2	18.5	-	2
SM10-L250-130-C20-C-H	M10	20	250	130	118.7	18	17.5	3
SM10-L250-180-C20-C-H	M10	20	250	180	68.7	18	17.5	3
SM10-L250-180-C20-C-H-N	M10	20	250	180	69.2	18.5	-	2
SM10-L300-180-C20-C-H	M10	20	300	180	118.7	18	17.5	3
SM10-L300-230-C20-C-H	M10	20	300	230	68.7	18	17.5	3
SM12-L100-40-C25-C-H	M12	25	100	40	59.5	24	-	2
SM12-L150-80-C25-C-H	M12	25	150	80	67.7	21	20.5	3
SM12-L150-80-C25-C-H-N	M12	25	150	80	69.5	24	-	2
SM12-L200-100-C25-C-H	M12	25	200	100	97.7	21	20.5	3
SM12-L200-100-C25-C-H-N	M12	25	200	100	99.5	24	-	2
SM12-L200-140-C25-C-H	M12	25	200	140	57.7	21	20.5	3
SM12-L250-130-C25-C-H	M12	25	250	130	117.7	21	20.5	3
SM12-L250-180-C25-C-H	M12	25	250	180	69.5	24	-	2
SM12-L300-180-C25-C-H	M12	25	300	180	117.7	21	20.5	3
SM12-L300-180-C25-C-H-N	M12	25	300	180	119.5	24	-	2
SM12-L300-230-C25-C-H	M12	25	300	230	67.7	21	20.5	3
SM16-L100-40-C32-C-H	M16	32	100	40	58.5	29	-	2
SM16-L150-80-C32-C-H	M16	32	150	80	68.5	29	-	2
SM16-L200-100-C32-C-H	M16	32	200	100	98.5	29	-	2
SM16-L200-140-C32-C-H	M16	32	200	140	58.5	29	-	2
SM16-L250-130-C32-C-H	M16	32	250	130	118.5	29	-	2
SM16-L250-180-C32-C-H	M16	32	250	180	68.5	29	-	2
SM16-L300-180-C32-C-H	M16	32	300	180	118.5	29	-	2
SM16-L300-230-C32-C-H	M16	32	300	230	68.5	29	-	2
SM16-L350-230-C32-C-H	M16	32	350	230	118.5	29	-	2
SM16-L350-280-C32-C-H	M16	32	350	280	68.5	29	-	2



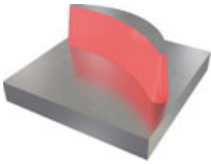
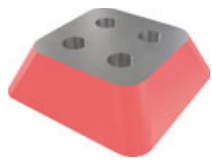
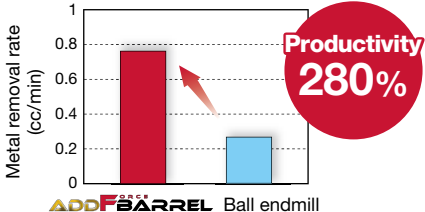
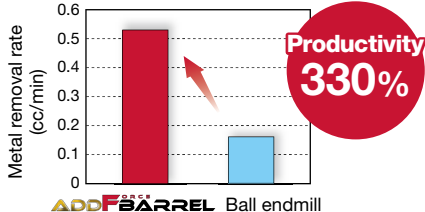


Metric	CRKS	DCONMS	LF	LB	BD	BHTA
SM06-L60C10	M6	10	60	20	9.7	0°
SM06-L105-C12	M6	12	105	60	9.7	1.2°
SM06-L125-C16	M6	16	125	60	9.7	3.3°
SM08-L73C16	M8	16	73	25	13	0°
SM08-L128-C16	M8	16	128	80	13	0.9°
SM08-L170-C20	M8	20	170	66.8	13	3.3°
SM10-L80C20	M10	20	80	30	18	0°
SM10-L130-C20	M10	20	130	80	18	0.6°
SM10-L200-C25	M10	25	200	57.2	19	3.3°
SM12-L86-C25	M12	25	86	30	21	5.1°
SM12-L200-C32	M12	32	200	78	21	4.4°
SM16-L95-C32	M16	32	95	35	29	1.7°
SM16-L230-C32	M16	32	230	50	29	1.8°

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PRACTICAL EXAMPLES

Workpiece type		Test piece	
Cutter		HFZN10M020M10R04 (DCX = 0.787", CICT = 4)	
Insert		ZNHU1003R20-MM	
Grade		AH9130	
Workpiece material		1055	304SS
			
Cutting conditions	Cutting speed: Vc (sfm)	1640	1148
	Feed per tooth: fz (ipt)	0.004	0.005
	Pitch : p (in)	0.031	0.039
	Width of cut : ae (in)	0.012	0.008
	Machining	Profiling	Profiling
	Coolant	Dry	Wet
	Machine	Vertical M/C, BT40	Vertical M/C, BT40
Results			
		A large PRFRAD and close pitch cutter body provided increased pitch and feed per tooth, boosting productivity by 2.8 times.	Thanks to large R cutting edge and close pitch design, increased pitch and feed speed could be used, boosting productivity by 3.3 times over ball endmill.

FIXED TORQUE WRENCH

Achieves high cutting edge precision thanks to uniform clamping force

Easy setting

Handle

Multi-component handle optimally designed for the hand enables ideal power transmission.



Mechanism

Driver clicks to alert the operator when the preset torque is attained. IDs printed on the handle end allow easy identification of the driver specs. Driver has unlimited loosening torque. Driver mechanism is industrial-lubricant-resistant.

High repeatability & robustness

Robustness / Fitting

Wiha ChromTop® finish on tip for a perfect fit every time. Durability thanks to high quality chrome-vanadium-molybdenum steel, through hardened, chrome-plated.

Versatility

Extra slim blade geometry is particularly suitable for applications with confined narrow access.

Dark green: TORX

Light green: TORX PLUS



Handle

Ex)

TW - D - 0.6NM

1

2

3

1 Torque Wrench

2 Driver type

3 Torque



Designation	Stock	Torque (N-m)	Accuracy (%)	øD	L
TW-D-0.6NM	●	0.6	10	34	130
TW-D-0.9NM	●	0.9	10	34	130
TW-D-1.1NM	●	1.1	10	34	130
TW-D-1.4NM	●	1.4	10	34	130
TW-D-2.5NM	●	2.5	10	34	130
TW-D-3.0NM	●	3.0	10	34	130
TW-D-3.5NM	●	3.5	10	34	130

1 piece per package

Blade

Ex)

TW - B - T6

1

2

3

1 Torque Wrench

2 Blade

3 TORX geom.

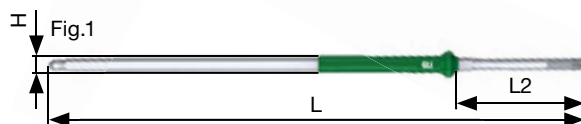


Fig.2



Designation	Stock	TORX geom.	H	L	L2	Fig.
TW-B-T6	●	T6	4	175	42	1
TW-B-T7	●	T7	4	175	42	1
TW-B-T8	●	T8	4	175	42	1
TW-B-T9	●	T9	4	175	42	1
TW-B-T10	●	T10	4	175	42	1
TW-B-T15	●	T15	4	175	42	1
TW-B-6IP	●	6IP	4	175	42	2
TW-B-7IP	●	7IP	4	175	42	2
TW-B-8IP	●	8IP	4	175	42	2
TW-B-10IP	●	10IP	4	175	42	2
TW-B-15IP	●	15IP	4	175	42	2

1 piece per package

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