



Grades for small parts machining

SH7025

Tungaloy Report No. 561-G

For more information

Superior surface quality and process security in small part machining







SH7025



Cutting edge sharpness is maintained over a long period of time, providing light cutting and excellent surface finish

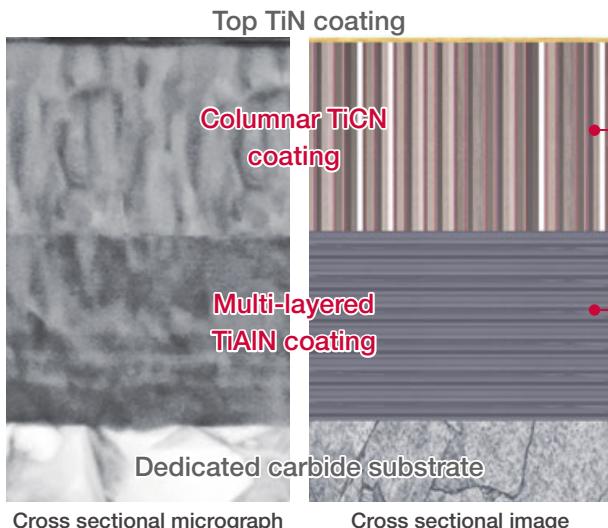
New insert grade for high surface quality



SH7025

- The latest grade with sharp cutting edge designed for small part machining.
- A combination of a columnar-structured TiCN coating and multilayered TiAlN coating provides superior surface quality and process security.

Designed to prevent built-up edge, wear, and edge chipping, SH7025 provides long, predictable tool life and superior surface quality



① For high surface quality

Built-up edge resistant TiCN coating improves surface finish quality.

② For extremely long tool life

Wear-resistant columnar-structured TiCN coating ensures long tool life.

③ For superior process security

Chipping-resistant multi-layered TiAlN coating provides process security.

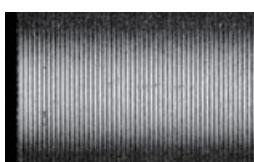
① For high surface quality

Built-up edge resistant TiCN coating improves surface finish quality

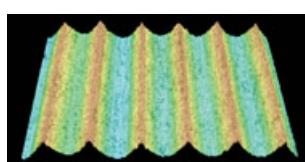
SH7025



O.D. surface quality



Actual image



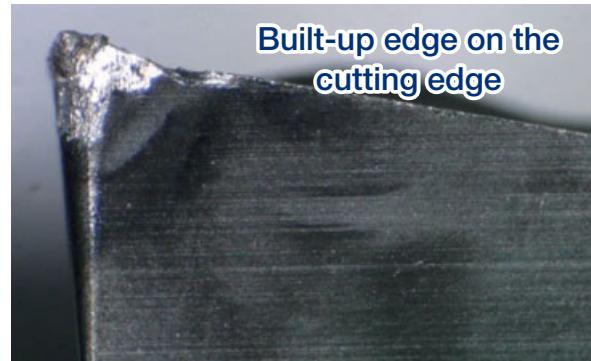
3D surface profile

Surface roughness chart

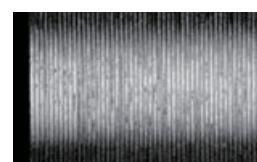


High quality surface finish!

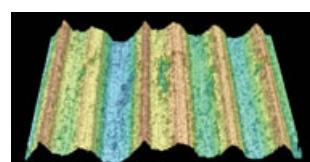
Conventional



O.D. surface quality



Actual image



3D surface profile

Surface roughness chart



Poor surface quality due to built-up edge

② Extremely long tool life

Wear-resistant columnar-structured TiCN coating ensures long tool life

SH7025



Columnar-structured TiCN coating slows wear progression



Extended tool life

Maintains excellent surface quality with no part scraps

Conventional



Rapid flank wear progression



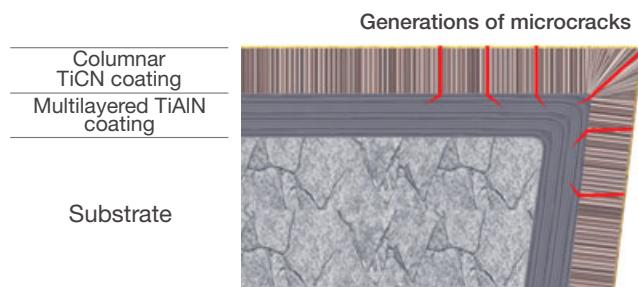
Poor surface quality, creating a pile of part scraps

SH7025

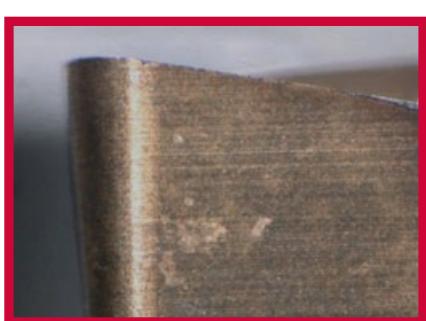
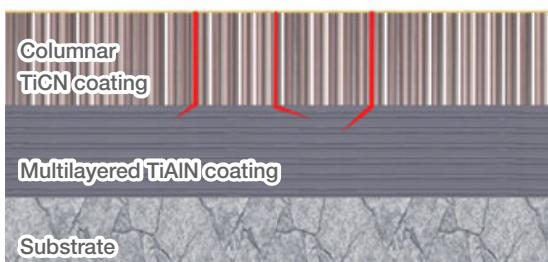
③ Superior process security

Chipping-resistant multi-layered TiAlN coating provides process security.

SH7025

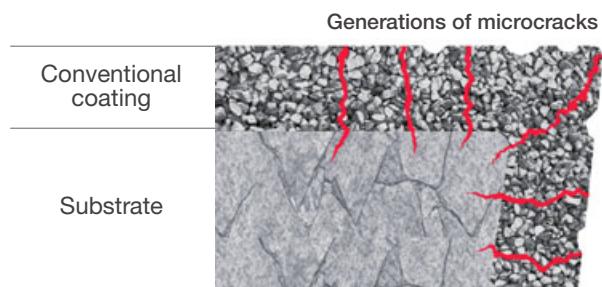


TiAlN coating prevents cracks from further propagation

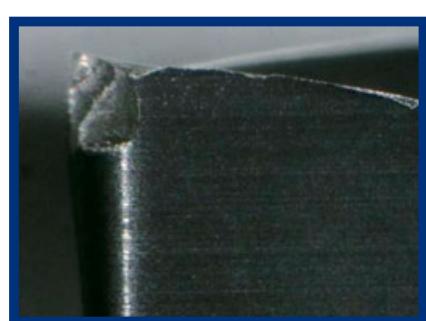
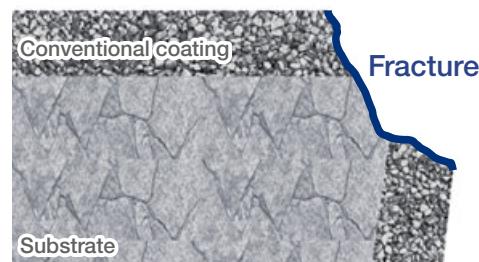


Eliminates fractures and provides security

Conventional



Crack reaches the substrate causing catastrophic failure



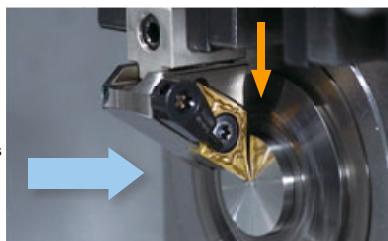
Catastrophic failure

CUTTING PERFORMANCE

3D surface profiling analysis

Face turning

Below images
are viewed in
this direction



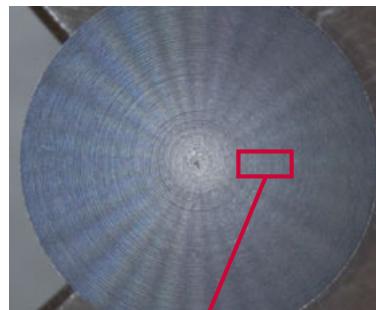
Case 1

P SUJ2 / 100Cr6

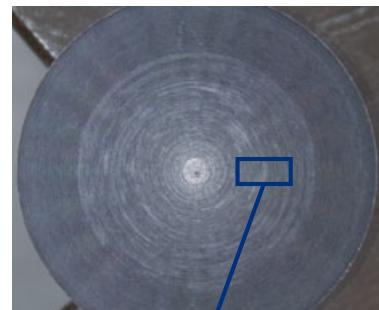
Insert : DCGT11T302 type
Cutting speed : $V_c = 150$ m/min
Feed : $f = 0.05$ mm/rev
Depth of cut : $a_p = 0.3$ mm
Coolant : Wet

Provides high quality
surface finish

SH7025



Conventional



Case 2

M SUS316L / X2CrNiMo17-12-2

Insert : DCGT11T302 type
Cutting speed : $V_c = 100$ m/min
Feed : $f = 0.05$ mm/rev
Depth of cut : $a_p = 0.3$ mm
Coolant : Wet

Provides high quality
surface finish

SH7025



Conventional

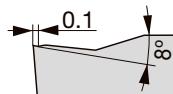


3D pressed-in chipbreaker series dedicated for turning small parts

Now available in SH7025 to ensure consistent and reliable chip control

New

JP First choice chipbreaker for high precision finishing

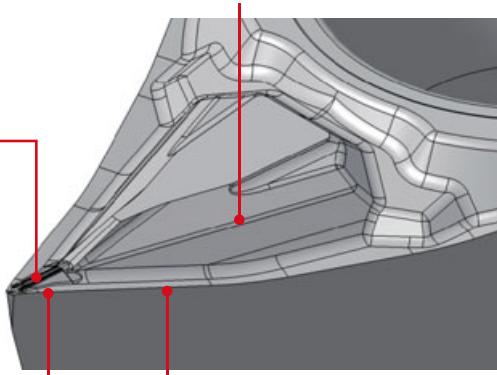


Eliminates chip nesting and other chip-associated issues that impede the shop's productivity and provides stable chip breaking over a wide range of feed rates and D.O.C.

- Effective chip breaking for high part quality
- Versatile geometry designed for a broad application range
- Eliminates burr generation and controls vibration during aggressive D.O.C.

Secondary rake with multiple facets

Guides and redirects chips generated during machining at great cutting depths



A protrusion extending towards the nose radius

Provides excellent chip control in finish to super-finish cutting

Cutting edge with a steep inclination angle

- For better chip evacuation
- For reduced cutting loads

Primary rake with variable angles

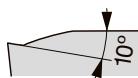
Controls the generation of burrs and vibration when machining at a maximum cutting depth capability

■ Chip control

JP	Competitor	JP	Competitor	JP	Competitor
P Insert : DCGT11T301FN-JP Workpiece material : S45C / C45 Cutting speed : $V_c = 80$ m/min Feed : $f = 0.02$ mm/rev Depth of cut : $ap = 0.5$ mm Coolant : Wet	P Insert : DCGT11T301FN-JP Workpiece material : S45C / C45 Cutting speed : $V_c = 80$ m/min Feed : $f = 0.03$ mm/rev Depth of cut : $ap = 3$ mm Coolant : Wet	M Insert : DCGT11T301FN-JP Workpiece material : SUS304 / X5CrNi18-9 Cutting speed : $V_c = 80$ m/min Feed : $f = 0.03$ mm/rev Depth of cut : $ap = 0.05$ mm Coolant : Wet			

JP chipbreaker provides superior chip control over a broad range of applications from super-finishing with light D.O.C. to aggressive cutting depth.

JS First choice chipbreaker for finish cutting

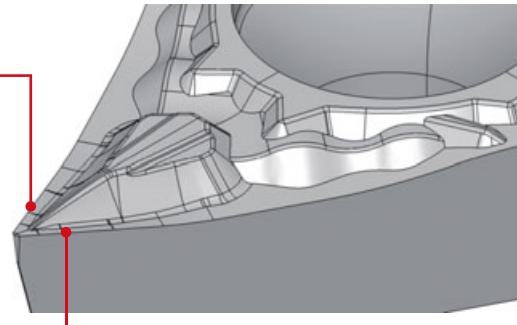


Chipbreaker geometry that allows light cutting action and excellent chip breaking

- A steep cutting edge inclination angle for better chip control and reduced cutting load
- A unique protrusion that extends towards the radius effectively controls chip flow from small to large cutting depths

Cutting edge with a steep inclination angle

Provides good chip evacuation and reduced cutting loads

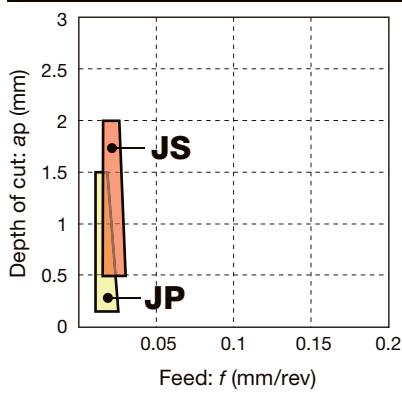


Rake with variable angles and steep protrusion

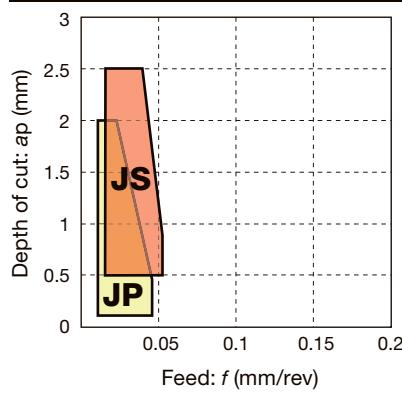
Provides stable chip control in the small to large cutting depth range and also maintains cutting edge integrity and sharpness over extended period of time

■ Chip control range

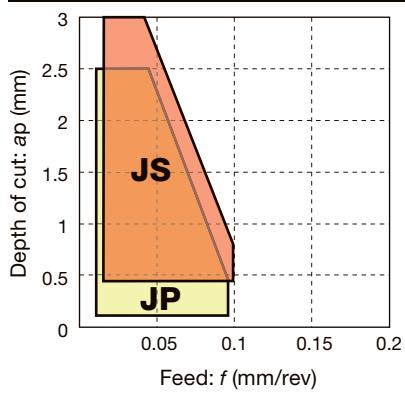
RE < 0.05 mm



RE < 0.1 mm

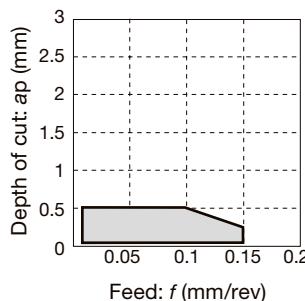
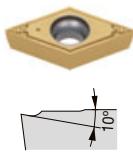


RE < 0.2 mm



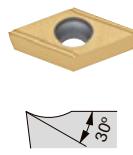
■ Complementary chipbreakers

01

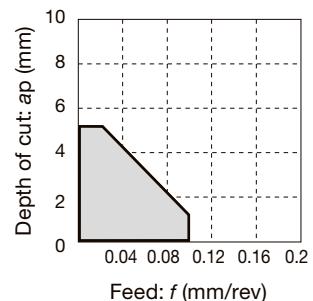


Pressed-in chipbreaker for high part quality that provides good chip control in the light D.O.C. range.

J10



Ground-in chipbreaker that demonstrates good chip control when machining at varying cutting depths.



■ STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Chip-breaker	Grade	Cutting speed Vc (m/min)	Depth of cut ap (mm)	Feed: f (mm/rev)			
						RE < 0.03	RE < 0.1	RE < 0.2	RE < 0.4
P	Carbon steel Alloy steel	JP	SH7025	10 - 200	0.05 - 2.5	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	-
		JS	SH7025	10 - 200	0.5 - 3	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	0.05 - 0.2
M	Stainless steel	JP	SH7025	10 - 200	0.05 - 2.5	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	-
		JS	SH7025	10 - 200	0.5 - 3	0.02 - 0.03	0.02 - 0.05	0.02 - 0.1	0.05 - 0.2

Insert POSITIVE TYPE

● : Continuous cutting
 • : Light interrupted cutting
 * : Heavy interrupted cutting

CC		P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material					RE S	D1	IC	
Rhombic, 80° with hole Positive 7°		● ●	● ●	● ●	● ●	● ●	● ●								
Application	Designation	Coated								Dimension (mm)					
Precision finishing (sharp edge)	Chipbreaker	SH7025								RE	IC	S	D1		
	JP	CCGT060200FN-JP	●								<0.05	6.35	2.38	2.8	
		CCGT060201FN-JP	●								<0.1	6.35	2.38	2.8	
		CCGT060202FN-JP	●								<0.2	6.35	2.38	2.8	
		CCGT09T300FN-JP	●								<0.05	9.525	3.97	4.4	
		CCGT09T301FN-JP	●								<0.1	9.525	3.97	4.4	
		CCGT09T302FN-JP	●								<0.2	9.525	3.97	4.4	
	01	CCGT060202F-01	●								<0.2	6.35	2.38	2.8	
		CCGT060204F-01	●								<0.4	6.35	2.38	2.8	
		CCGT09T302F-01	●								<0.2	9.525	3.97	4.4	
Finishing (sharp edge)		CCGT09T304F-01	●								<0.4	9.525	3.97	4.4	
	JS	CCGT03X101F-JS	●								<0.1	3.57	1.39	1.9	
		CCGT03X102F-JS	●								<0.2	3.57	1.39	1.9	
		CCGT03X104F-JS	●								<0.4	3.57	1.39	1.9	
		CCGT04T101F-JS	●								<0.1	4.37	1.79	2.2	
		CCGT04T102F-JS	●								<0.2	4.37	1.79	2.2	
		CCGT04T104F-JS	●								<0.4	4.37	1.79	2.2	
	JS	CCGT060200FN-JS	●								<0.05	6.35	2.38	2.8	
		CCGT060201FN-JS	●								<0.1	6.35	2.38	2.8	
		CCGT060202FN-JS	●								<0.2	6.35	2.38	2.8	
Finishing (sharp edge)		CCGT060204FN-JS	●								<0.4	6.35	2.38	2.8	
		CCGT09T300FN-JS	●								<0.05	9.525	3.97	4.4	
		CCGT09T301FN-JS	●								<0.1	9.525	3.97	4.4	
		CCGT09T302FN-JS	●								<0.2	9.525	3.97	4.4	
		CCGT09T304FN-JS	●								<0.4	9.525	3.97	4.4	
	W08	CCGT03X100FL-W08	●								0.03	3.57	1.39	1.9	
		CCGT03X101FL-W08	●								0.1	3.57	1.39	1.9	
		CCGT03X102FL-W08	●								0.2	3.57	1.39	1.9	
		CCGT03X102FR-W08	●								0.2	3.57	1.39	1.9	
		CCGT03X104FL-W08	●								0.4	3.57	1.39	1.9	
Finishing (sharp edge)		CCGT03X104FR-W08	●								0.4	3.57	1.39	1.9	
		CCGT04T100FL-W08	●								0.03	4.37	1.79	2.2	
		CCGT04T101FL-W08	●								0.1	4.37	1.79	2.2	
		CCGT04T102FL-W08	●								0.2	4.37	1.79	2.2	
		CCGT04T102FR-W08	●								0.2	4.37	1.79	2.2	
		CCGT04T104FL-W08	●								0.4	4.37	1.79	2.2	
		CCGT04T104FR-W08	●								0.4	4.37	1.79	2.2	

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New

Insert POSITIVE TYPE

● : Continuous cutting
 ● : Light interrupted cutting
 * : Heavy interrupted cutting

CC

Rhombic, 80°
with hole
Positive 7°



P	Steel	●c
M	Stainless	●c
K	Cast iron	*
N	Non-ferrous	*
S	Superalloy	*
H	Hard material	*

SH7025

Insert POSITIVE TYPE

● : Continuous cutting
 ● : Light interrupted cutting
 * : Heavy interrupted cutting

DC

Rhombic, 55°
with hole
Positive 7°



P	Steel	●
M	Stainless	●
K	Cast iron	
N	Non-ferrous	
S	Superalloy	
H	Hard material	

Insert **POSITIVE TYPE**

- : Continuous cutting
- ◐ : Light interrupted cutting
- ◑ : Heavy interrupted cutting



**Rhombic, 75°
with hole
Positive 11°**

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

: New

Insert POSITIVE TYPE

● : Continuous cutting
 ● : Light interrupted cutting
 * : Heavy interrupted cutting

TC

Triangular
with hole
Positive 7°



	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material	RE	S	IC
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Application	Chipbreaker	Designation	Coated							Dimension (mm)			
			SH7025							RE	IC	S	D1
Precision finishing (sharp edge)	JP	TCGT110200FN-JP	●										<0.05 6.35 2.38 2.8
		TCGT110201FN-JP	●										<0.1 6.35 2.38 2.8
		TCGT110202FN-JP	●										<0.2 6.35 2.38 2.8
Finishing (sharp edge)	01	TCGT110202F-01	●										<0.2 6.35 2.38 2.8
		TCGT110204F-01	●										<0.4 6.35 2.38 2.8
Finishing (sharp edge)	JS	TCGT110200FN-JS	●										<0.05 6.35 2.38 2.8
		TCGT110201FN-JS	●										<0.1 6.35 2.38 2.8
		TCGT110202FN-JS	●										<0.2 6.35 2.38 2.8
Finishing (sharp edge)	J08	TCGT080200FR-J08	●										0.03 4.76 2.38 2.3
		TCGT080201FR-J08	●										0.1 4.76 2.38 2.3
		TCGT080202FR-J08	●										0.2 4.76 2.38 2.3
Finishing (sharp edge)	J10	TCGT080202FL-J08	●										0.2 4.76 2.38 2.3
		TCGT080204FR-J08	●										0.4 4.76 2.38 2.3
	TC	TCGT110200FR-J10	●										0.03 6.35 2.38 2.8
		TCGT110201FR-J10	●										0.1 6.35 2.38 2.8
		TCGT110202FR-J10	●										0.2 6.35 2.38 2.8
		TCGT110202FL-J10	●										0.2 6.35 2.38 2.8
		TCGT110204FR-J10	●										0.4 6.35 2.38 2.8
		TCGT110300FR-J10	●										0.03 6.35 3.18 2.8
		TCGT110301FR-J10	●										0.1 6.35 3.18 2.8
		TCGT110302FR-J10	●										0.2 6.35 3.18 2.8
		TCGT110302FL-J10	●										0.2 6.35 3.18 2.8

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New

Insert POSITIVE TYPE

● : Continuous cutting
 ● : Light interrupted cutting
 * : Heavy interrupted cutting

TP

Triangular with hole Positive 11°

Application	Chipbreaker	Designation	Coated	Dimension (mm)			
				RE	IC	S	D1
Finishing (sharp edge)	JS	TPGT070101F-JS	●				
		TPGT070102F-JS	●				
		TPGT070104F-JS	●				
Finishing (sharp edge)	W08	TPGT070100FL-W08	●				
		TPGT070101FL-W08	●				
		TPGT070102FR-W08	●				
		TPGT070102FL-W08	●				
		TPGT070104FR-W08	●				
		TPGT070104FL-W08	●				

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New

VB

Rhombic, 35° with hole Positive 5°

Application	Chipbreaker	Designation	Coated	Dimension (mm)			
				RE	IC	S	D1
Precision finishing (sharp edge)	JP	VBGT110300FN-JP	●				
		VBGT110301FN-JP	●				
		VBGT110302FN-JP	●				
Finishing (sharp edge)	JS	VBGT110300FN-JS	●				
		VBGT110301FN-JS	●				
		VBGT110302FN-JS	●				
		VBGT110304FN-JS	●				
For external turning on Swiss lathes (sharp edge)	J10	VBGT110300FR-J10	●				
		VBGT110301FR-J10	●				
		VBGT110302FR-J10	●				
		VBGT110302FL-J10	●				
		VBGT110304FR-J10	●				
		VBGT110304FL-J10	●				

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New

Insert POSITIVE TYPE

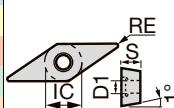
● : Continuous cutting
● : Light interrupted cutting
✖ : Heavy interrupted cutting

VP

35° Rhombic
with hole
Positive 11°



	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material	RE	IC	S	D1
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Application	Chipbreaker	Designation	Coated								Dimension (mm)			
			SH7025								RE	IC	S	D1
Precision finishing (sharp edge)	JP	VPGT110300FN-JP	●								<0.05	6.35	3.18	2.8
		VPGT110301FN-JP	●								<0.1	6.35	3.18	2.8
		VPGT110302FN-JP	●								<0.2	6.35	3.18	2.8
Finishing (sharp edge)	JS	VPGT110300FN-JS	●								<0.05	6.35	3.18	2.8
		VPGT110301FN-JS	●								<0.1	6.35	3.18	2.8
		VPGT110302FN-JS	●								<0.2	6.35	3.18	2.8
		VPGT110304FN-JS	●								<0.4	6.35	3.18	2.8

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

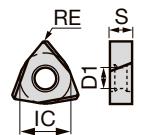
● : New

WB

Trigon, 80°
with hole
Positive 5°



	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material	RE	IC	S	D1
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Application	Chipbreaker	Designation	Coated								Dimension (mm)			
			SH7025								RE	IC	S	D1
Finishing (sharp edge)	JS	WBGT030101FR-JS	●								<0.1	3.97	1.59	2.3
		WBGT030101FL-JS	●								<0.1	3.97	1.59	2.3
		WBGT030102FR-JS	●								<0.2	3.97	1.59	2.3
		WBGT030102FL-JS	●								<0.2	3.97	1.59	2.3
		WBGT030104FR-JS	●								<0.4	3.97	1.59	2.3
		WBGT030104FL-JS	●								<0.4	3.97	1.59	2.3
Finishing (sharp edge)	W08	WBGT030100FL-W08	●								0.03	3.97	1.59	2.3
		WBGT030101FL-W08	●								0.1	3.97	1.59	2.3
		WBGT030102FL-W08	●								0.2	3.97	1.59	2.3
		WBGT030102FR-W08	●								0.2	3.97	1.59	2.3
		WBGT030104FL-W08	●								0.4	3.97	1.59	2.3
		WBGT030104FR-W08	●								0.4	3.97	1.59	2.3

Corner radius (RE) with a sign of inequality (<) means minus tolerance.

● : New

Insert POSITIVE TYPE

- : Continuous cutting
- ◐ : Light interrupted cutting
- ✖ : Heavy interrupted cutting



Front turning

● : New



Back turning

● : New



Back turning

JTB													
Back turning													
Application	Chipbreaker	Designation	Coated										Dimension (mm)
			SH7025										
Back turning	-	JTBR3000F											0.03 9.5 3.18 4.4
		JTBR3005F											0.05 9.5 3.18 4.4
		JTBR3010F											0.10 9.5 3.18 4.4
		JTBR3015F											0.15 9.5 3.18 4.4

● : New

SH7025

Insert POSITIVE TYPE

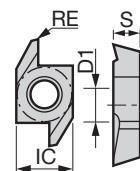
- : Continuous cutting
- : Light interrupted cutting
- ✿ : Heavy interrupted cutting

J10E



Back turning

	P Steel	M Stainless	K Cast iron	N Non-ferrous	S Superalloy	H Hard material	RE	D1	S
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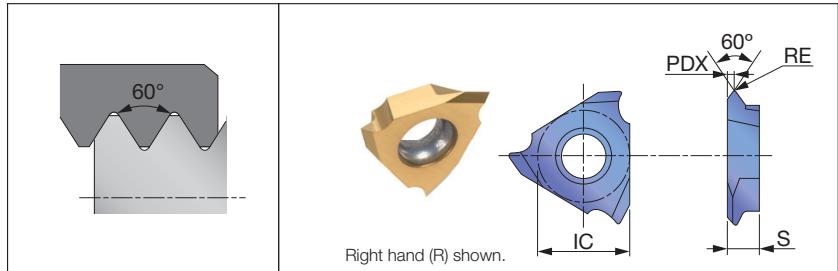
Application	Chipbreaker	Designation	Coated								Dimension (mm)			
			SH7025								RE	IC	S	D1
Back turning	-	J10ER005BF	●								0.05	6.35	3.18	3.0
		J10EL005BF	●								0.05	6.35	3.18	3.0
		J10ER010BF	●								0.10	6.35	3.18	3.0
		J10EL010BF	●								0.10	6.35	3.18	3.0
		J10EL015BF	●								0.15	6.35	3.18	3.0
		J10ER015BF	●								0.15	6.35	3.18	3.0

● : New

J-SERIES

INSERT

60° thread angle

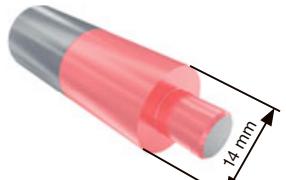
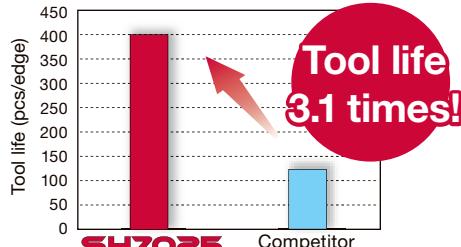
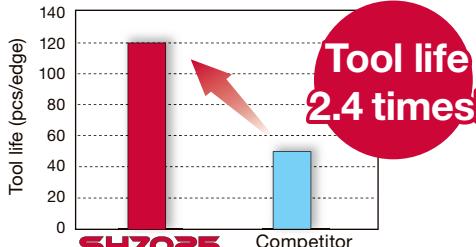
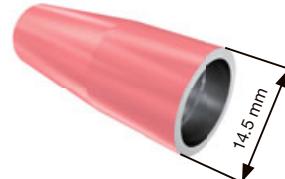
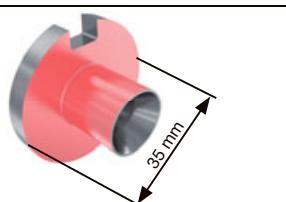
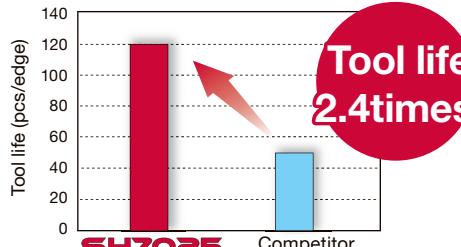
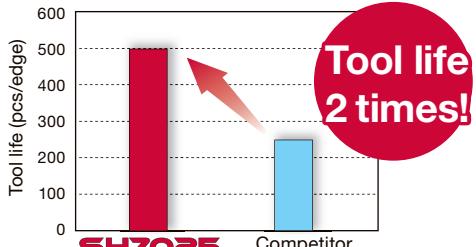


Partial-profile insert

Pitch	TPI	Hand of cut	External insert						
			Designation	Grade	IC	PDX	S	RE	
				Coated					SH7025
0.5 - 1	25 - 48	R/L	JTTR3005F	●	9.525	0.6	3.18	0.05	
0.5 - 1	25 - 48	R/L	JTTR3010F	●	9.525	1.1	3.18	0.1	

● : New / 10 pieces per package

PRACTICAL EXAMPLES

Workpiece type	Guide for linear motion bearing	Spool pin
Insert	DCGT11T302FN-JP	DCGT11T302FN-JP
Grade	SH7025	SH7025
Workpiece material		
Cutting conditions		
Cutting speed: V_c (m/min)	150	150
Feed : f (mm/rev)	0.03	0.03
Depth of cut : ap (mm)	0.1	0.05
Machining	External and face turning	External and face turning
Coolant	Wet	Wet
Results	 <p>SH7025 grade insert eliminated built-up edge while substantially extending tool life.</p>	 <p>SH7025 significantly prolonged tool life over the competitor grade with no part scraps.</p>
Workpiece type	Pin	Flange
Insert	DCGT11T301FN-JP	DCGT11T302FN-JS
Grade	SH7025	SH7025
Workpiece material		
Cutting conditions		
Cutting speed: V_c (m/min)	2,000	1,300
Feed : f (mm/rev)	0.05	0.03 - 0.05
Depth of cut : ap (mm)	0.5	3
Machining	External turning	External and face turning
Coolant	Wet	Wet
Results	 <p>SH7025 eliminated insert fracture that caused part surface deterioration and provided long, predictable tool life.</p>	 <p>SH7025 provided slower flank wear progression and eliminated part surface deterioration.</p>

Other processing examples



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