

# CREATIVE

machining  
solutions

LATEST INNOVATIONS IN GEOMETRIES AND GRADES



Member IMC Group  
**Tungaloy**

**INDUSTRY 4.0**  
*FEED the SPEED!*



## *Tungaloy's Insights – Smart Manufacturing*

Tungaloy, as one of the leaders in the metal removal industry, offers the latest innovations in grades and geometries for superb performance and tool life. In a competitive world eager to embrace Industry 4.0, Tungaloy provides an extensive portfolio with the latest digital tools to support our customers in making better tooling decisions to improve their competitiveness and productivity.





### E-Catalog

Find Tools and download CAD drawings and 3D models  
[www.tungaloy.com/ecatalog](http://www.tungaloy.com/ecatalog)



### ThreadMilling Advisor

Tungaloy's new CNC program generator facilitates thread milling programming  
[www.tungaloy.com/threadmilling](http://www.tungaloy.com/threadmilling)



### Tungaloy Atlas

New Smartphone Application to explore the wide range of Tungaloy solutions  
[www.tungaloy.com/atlas](http://www.tungaloy.com/atlas)



### Insert Selection Guide

Tungaloy's first recommendations for Turning operations  
[www.tungaloy.com/insertguide](http://www.tungaloy.com/insertguide)



### TungNavi

Tungaloy Tool Advisor  
[www.tungaloy.com/tungnavi](http://www.tungaloy.com/tungnavi)



### Dr. Carbide

A package of comprehensive Applications with digital solutions from Tungaloy  
[www.tungaloy.com/drcarbide](http://www.tungaloy.com/drcarbide)



### High-Feed Milling Guide

Tungaloy selection guide for high-feed milling tools  
[www.tungaloy.com/highfeed](http://www.tungaloy.com/highfeed)



### Matrix

Tool management system  
[www.tungaloy.com/matrix](http://www.tungaloy.com/matrix)

# WHAT'S

i n s i d e ?







Superior Grades  
*CVD & PVD*

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*Shoulder Milling*  
Milestones

*Making Hard Turning*  
less Hard than it seems

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An invaluable  
*Face Milling Cutter*

*Vibration-Free for*  
Deep-Hole Boring

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Latest Milling  
Solutions for  
*Difficult-to-cut*  
& *Non-Ferrous*  
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*Masters of*  
Hole Making

*No Tool*  
*Interference,*  
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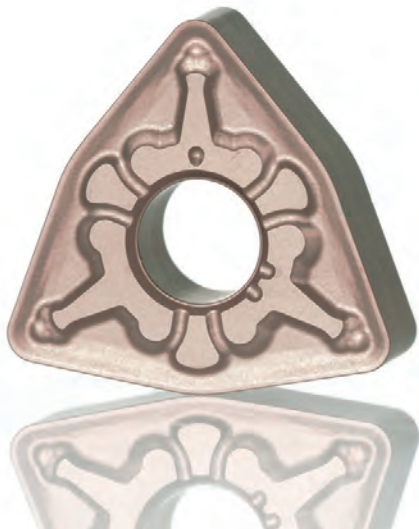
*Matrix* the Perfect  
Partner for your  
Business

# SUPERIOR GRADES

CVD & PVD



# TURNING & GROOVING



**T9200**  
TUNGALOY

**P** Steel  
**M** Stainless Steel  
**K** Cast Iron

**New generation CVD grade** for steel turning with outstanding productivity

Nearly unbreakable CVD series for improved machining efficiency



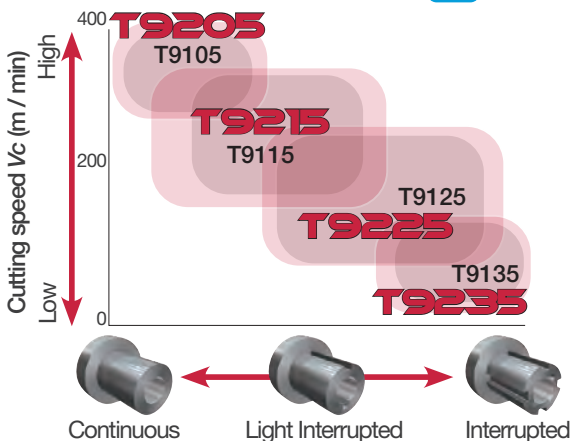
**AH7025**  
TUNGALOY

**P** Steel  
**M** Stainless Steel  
**K** Cast Iron  
**S** Super alloys

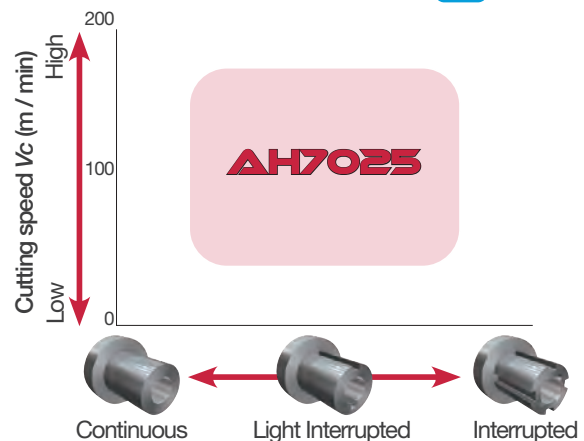
**Ideal grade** for grooving & side-turning applications

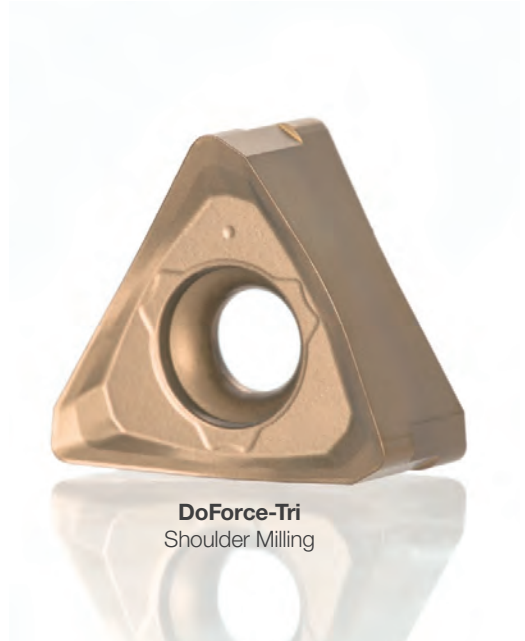
AH7025 uses the world's first coating technology of a nano-scale multi-layered AlTiN PVD coating with high Al content

APPLICATION AREA **P**



APPLICATION AREA **P**





DoForce-Tri  
Shoulder Milling

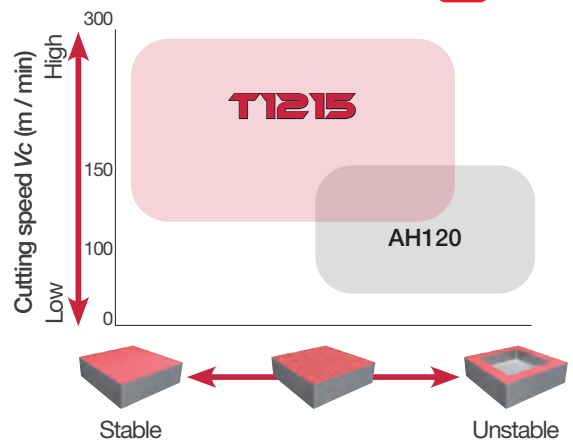
**T1215**  
TUNGALOY



Best for cast iron  
high-speed machining

**CVD-coated grade with superb resistance to wear and chipping** in a broad range of cast iron milling applications for medium to high cutting speeds.

APPLICATION AREA 





# MILLING



**DoTriple-Mill**  
Face Milling

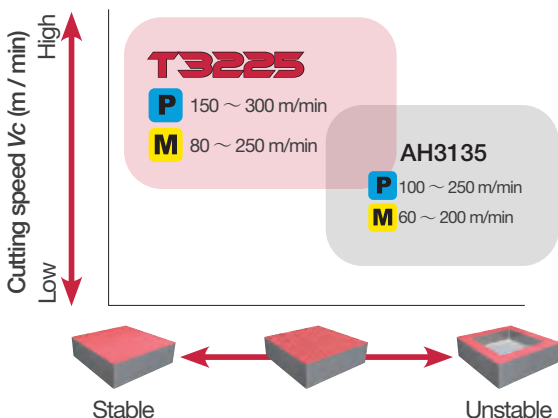
**T3225**  
TUNGALOY

**P** **M**  
Steel Stainless Steel

Most suited for steel and stainless steel **high-speed machining**

**Extremely fracture resistant CVD-coated grade** most suited for high speed milling of steel and stainless steel in stable conditions.

## APPLICATION AREA



**TungForce-Feed**  
High-Feed Milling

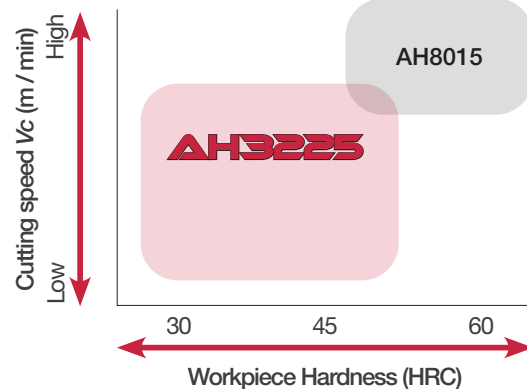
**AH3225**  
TUNGALOY

**P** **M**  
Steel Stainless Steel

Nano multi-layer PVD coating technology with extended tool life

**Resistance to built-up edge**  
**Resistance to wear, oxidation and fracture**  
**Strong coating/substrate adhesion**

## APPLICATION AREA



# MAKING HARD TURNING

less hard than it seems

Wavy Joint

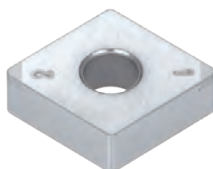
## Quick guide

Since the introduction of our very first T-CBN grade, Tungaloy's devotion to innovation has consistently brought its T-CBN grades to higher levels of perfection. Designed with optimal material matrices and tested to prove its performance both in-house and the field, T-CBN assures the best performance in every hard turning application.

### Grade

### Parameter recommendation

#### BXA20



#### CUTTING SPEED RANGE (m/mm)

min.	First choice	max.
70 m/mm	140 m/mm	200 m/mm

#### APPLICATION AREA



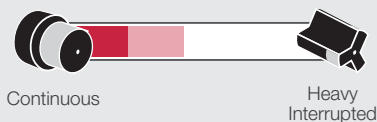
#### BXM10



#### CUTTING SPEED RANGE (m/mm)

min.	First choice	max.
150 m/mm	200 m/mm	350 m/mm

#### APPLICATION AREA



#### BXM20



#### CUTTING SPEED RANGE (m/mm)

min.	First choice	max.
80 m/mm	150 m/mm	220 m/mm

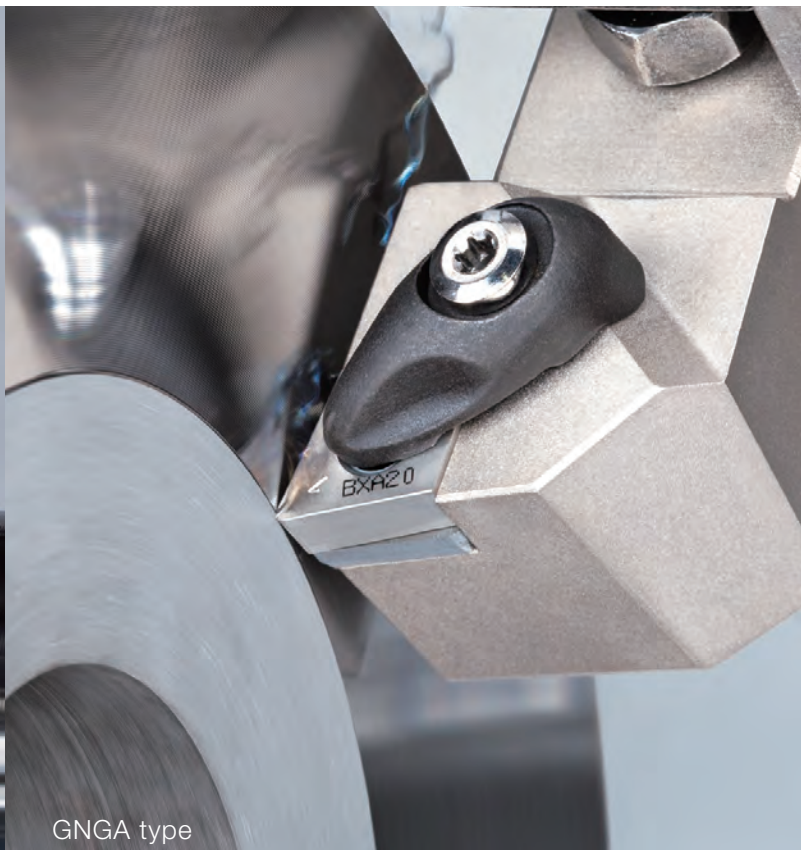
#### APPLICATION AREA







HP hardbreaker



GNGA type

## Unique Solutions

### GNGA type



*for smooth chip evacuation*  
A 70° corner angle provides a large clearance between insert and workpiece.

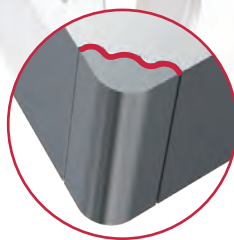


Large clearance reduces cutting force and edge wear, and provides smooth chip flow to prevent scratches on machined surface from chips.

### WAVY joint



*for high depth of cut in hard turning up to 0.8 mm*  
Great performance for continuous to heavy interrupted cutting at low and medium speeds.

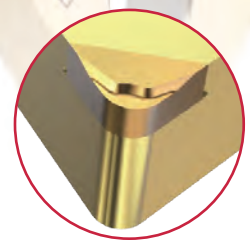


**CBN Tip Size:** 200% larger for improved wear control in the cutting zone  
**Brazing Area:** 160% larger for enhanced brazing strength

### HP hardbreaker

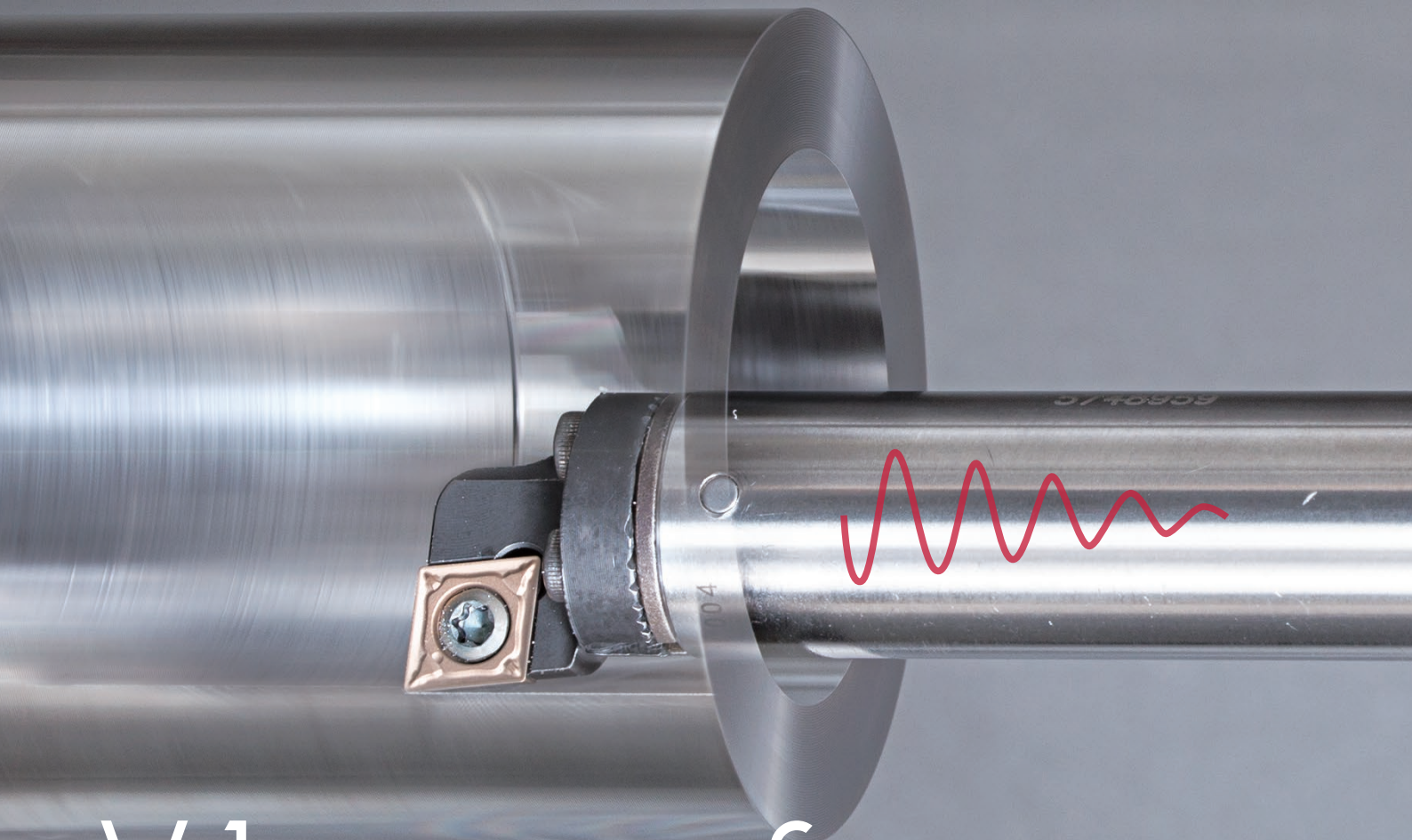


*for chatter prevention and the finest machined surfaces*  
The cutting edge preparation is designed to ensure easy cutting at low cutting forces.



The **HP style chipbreaker**, with its built-in wipers, yields excellent surface quality and good chip control.





Vibration-free  
**FOR DEEP-  
HOLE  
BORING**



# BOREMEISTER

Vibration and chatter are no longer an issue with *Tungaloy's new BoreMeister ID turning tool!*

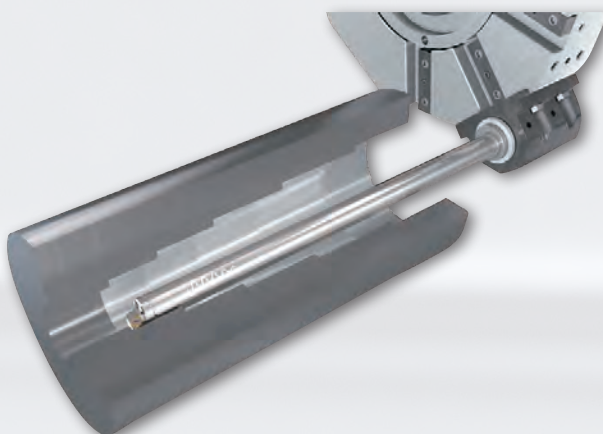
BoreMeister offers the ultimate solution for overcoming tool overhang challenges of up to 10xBD, while enhancing stability in deep hole boring, which is not possible with traditional steel or carbide shanks.

**- Shank diameters available in**

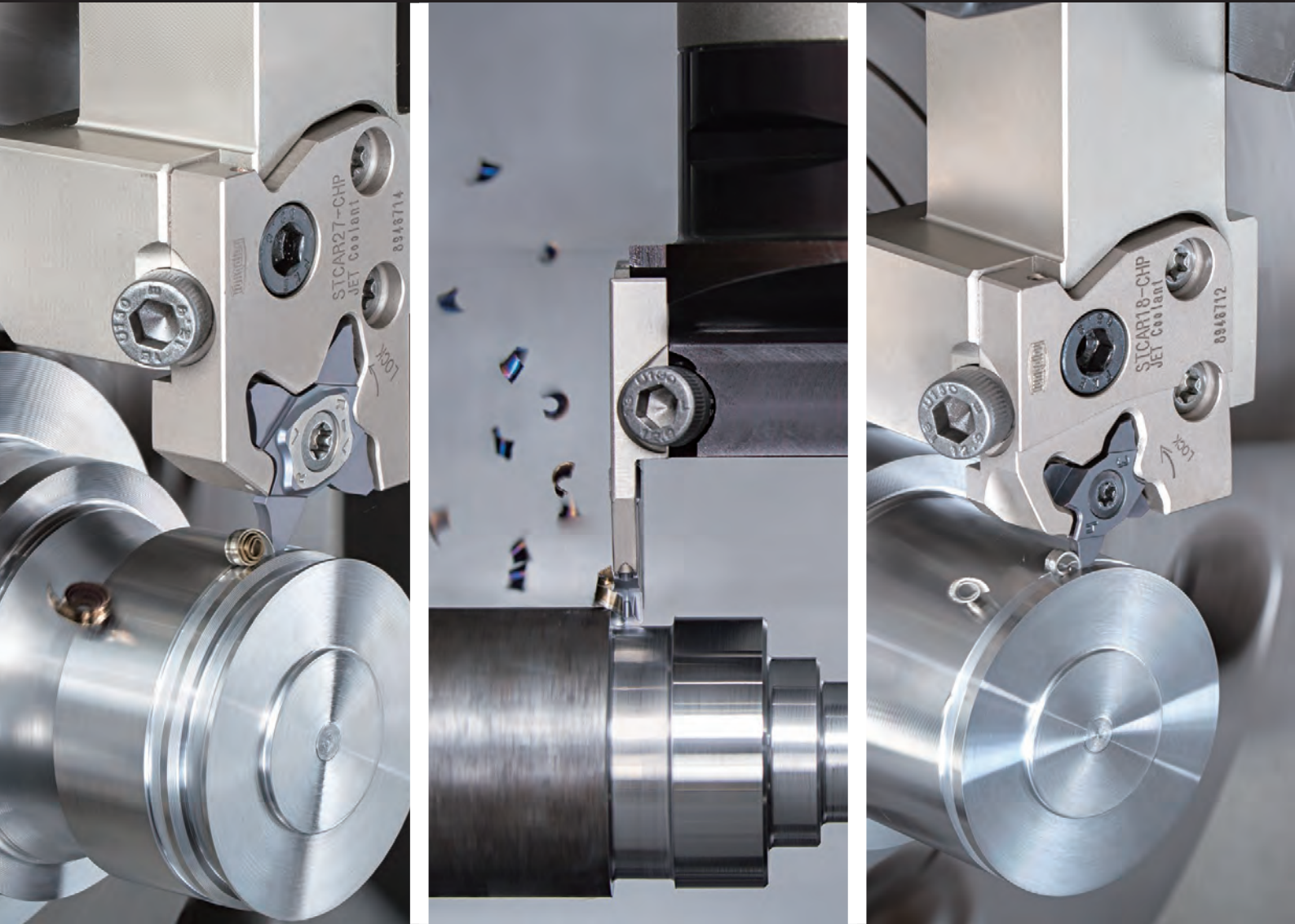
ø16 mm, ø20 mm, ø25 mm,  
ø32 mm, ø40 mm, ø50 mm,  
and ø60 mm.



**- Overhangs available in 7xBD or 10xBD** depending on the tool diameter. Internal coolant supply for efficient chip evacuation.



# THE PATH OF



# VERSATILITY

Modular System for Grooving & Parting-off



# TUNG<sup>MODULAR</sup>MSYSTEM

Cost-efficient and **exchangeable CHP blade system** for side-turning, grooving and parting-off operations

Regular toolholder



TungCap toolholder



## TETRAM<sup>MINI</sup>CUT

Groove widths:  
0.33 - 3 mm



Multi-purpose grooving insert with economical 4-cutting edged insert. Unique 3-point clamping system and insert pocket protects all unused cutting edges.

## TETRA<sup>FORCE</sup>CUT

Groove widths:  
0.5 - 3.18 mm



## TUNG<sup>MINI</sup>CUT

Groove widths:  
1.4 - 8 mm



Wide range of grades, geometries, and holder variations for maximum versatility and profitability

### AH7025

**NEW Grade for TetraMini-Cut and TungCut**

**First recommended grade** for general purpose.

New PVD coating with high Al content provides excellent adhesion strength.

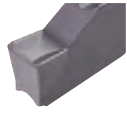
**Improved wear and chipping resistance.**



# TUNGALLOY

## Chipbreaker Selection Guide

for Grooving and Parting-off



**DGM**

for medium  
feed rates



**DGS**

for lower  
feed rates  
(sharpened insert)



**DGL**

for low carbon  
steels

for Grooving and side-Turning



**DTM**

First choice for  
a wide range  
of applications



**DTX**

Versatile  
chipbreaker

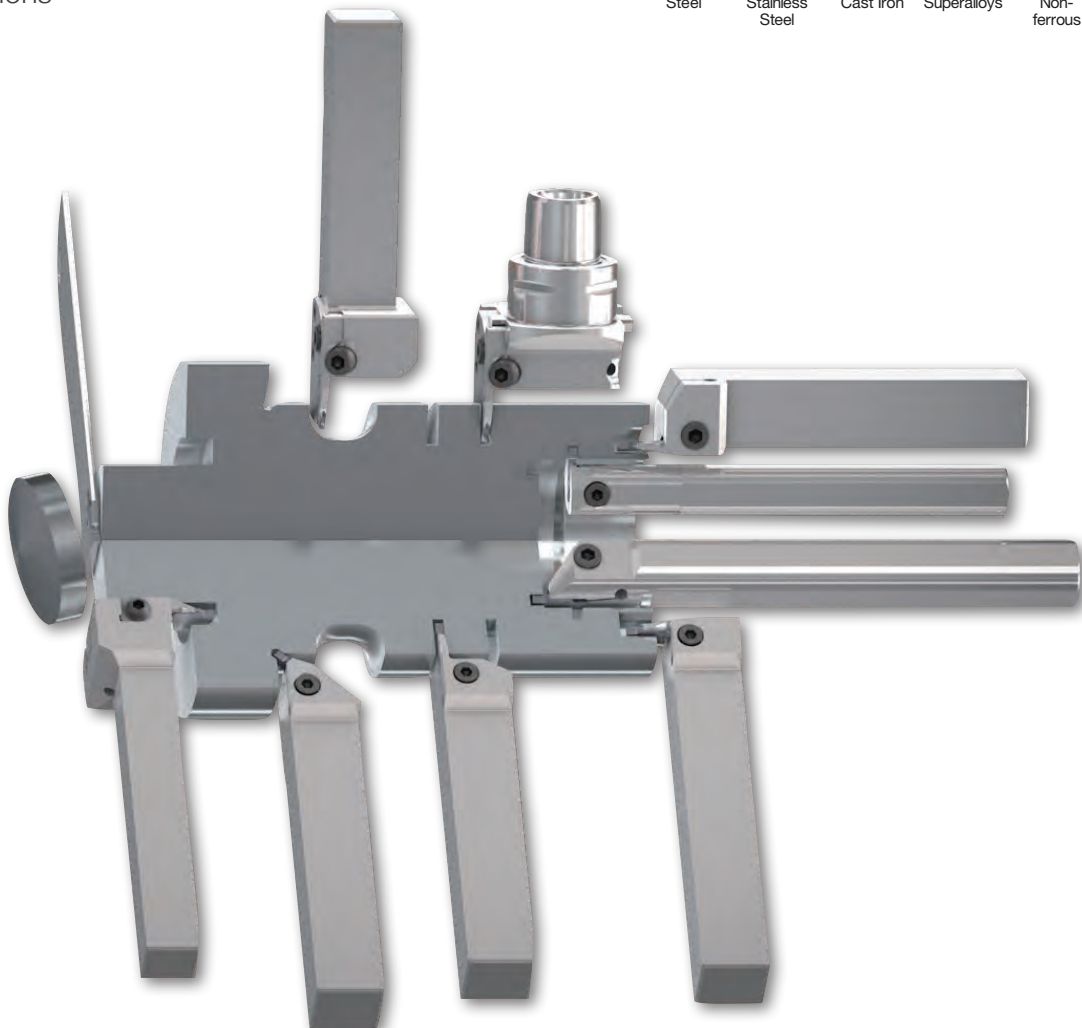


**DTE**

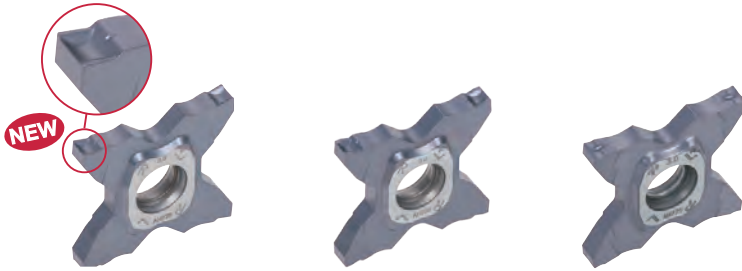
for external  
applications

## Grade Chart

<b>NEW</b> PVD <b>AH7025</b>	●	●		●		
AH725	●	●		●		
GH130	●	●	●			
AH905				●		
CVD T9125	●					
<b>NEW</b> T515			●			
CERMET NS9530	●					
UNCOATED TH10					●	
KS05F				●	●	
CBN BX360						●
	<b>P</b> Steel	<b>M</b> Stainless Steel	<b>K</b> Cast Iron	<b>S</b> Superalloys	<b>N</b> Non- ferrous	<b>H</b> Hard materials

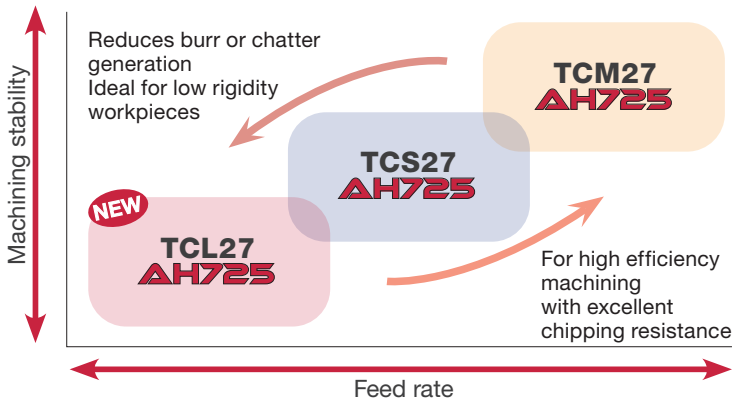


# TETRA<sup>FORCE</sup>CUT



**TCL chipbreaker** For light cutting  
**TCM chipbreaker** For higher machining efficiency  
**TCS chipbreaker** For general applications

## Quick Selection Guide

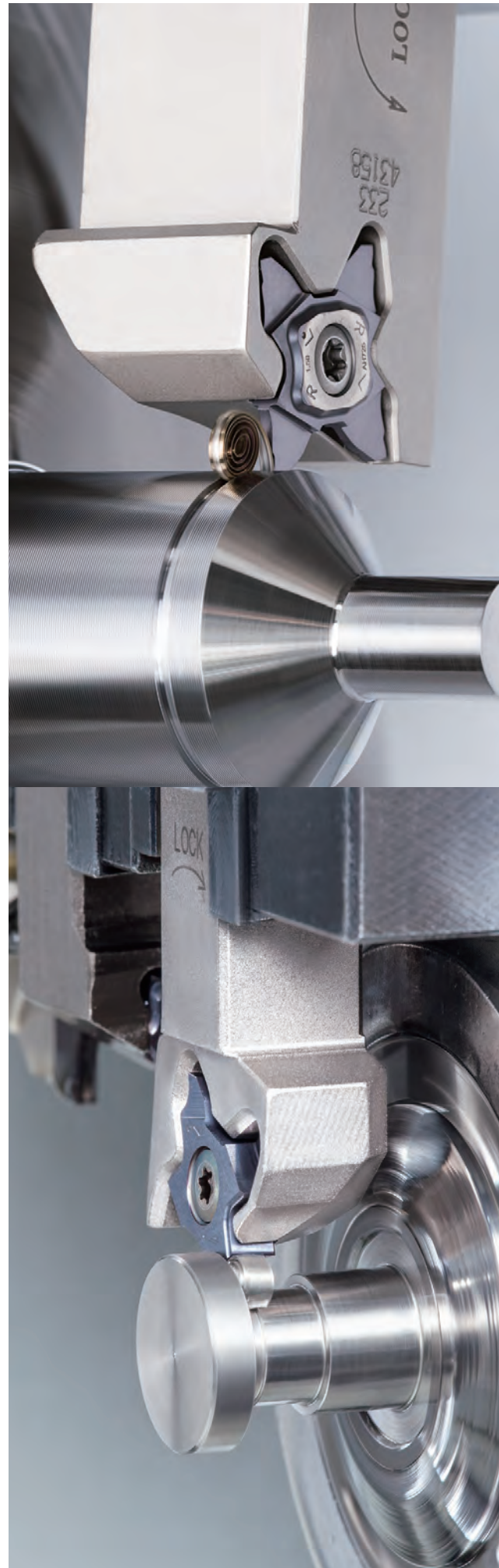
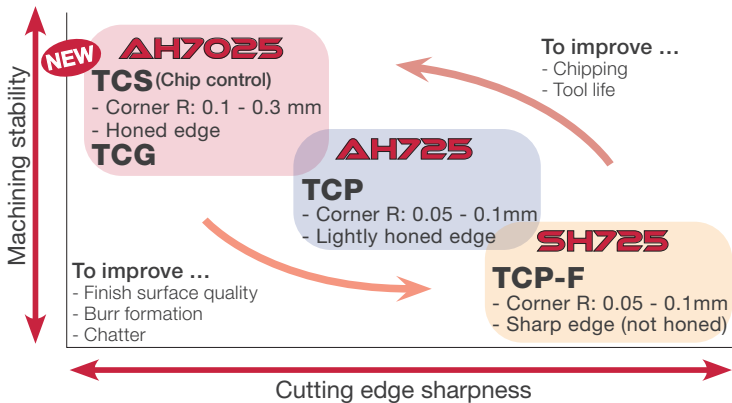


# TETRA<sup>M</sup>CUT



**TCS type** 3D Chipbreaker  
**TCG type** Honed edge  
**TCP type** Lightly honed edge  
**TCP-F type** Sharp edge

## Quick Selection Guide





# HIGH FEED

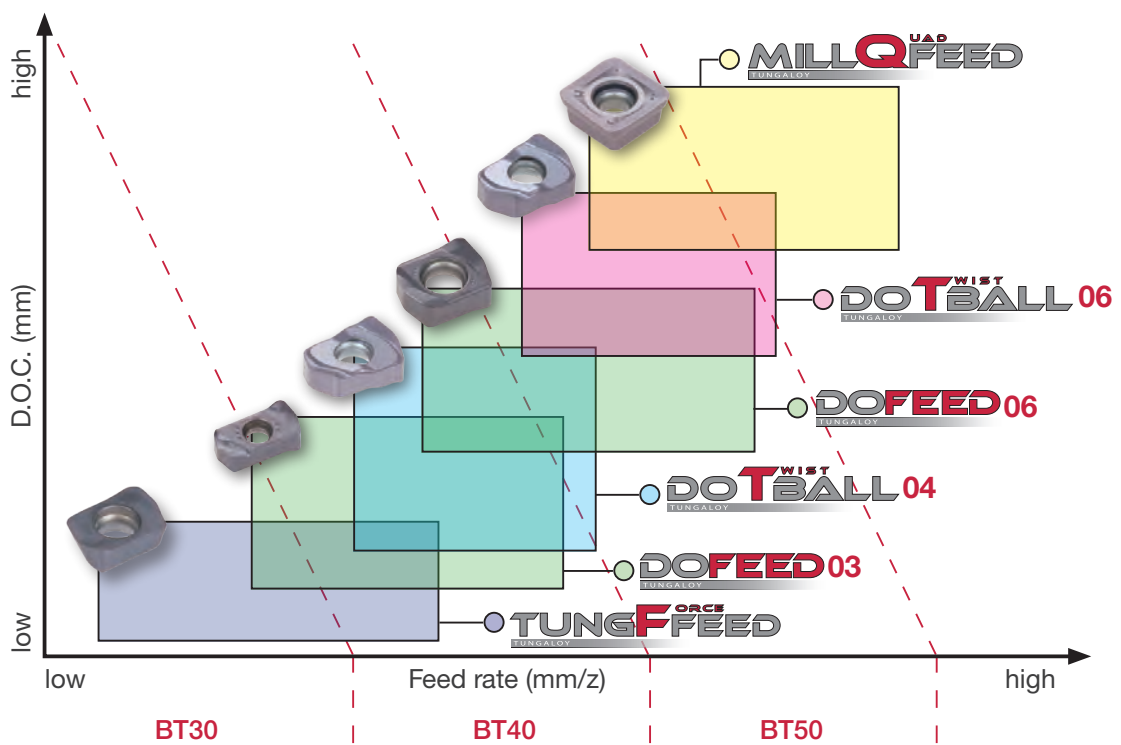
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# MILLING OVERVIEW

Tungaloy's renowned solutions for **High-Feed Milling (HFM)**  
*have been around for decades*



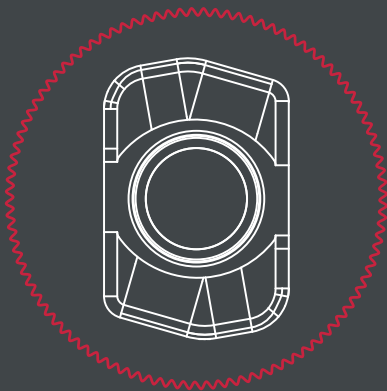
*A wide range of solutions to suit every need*



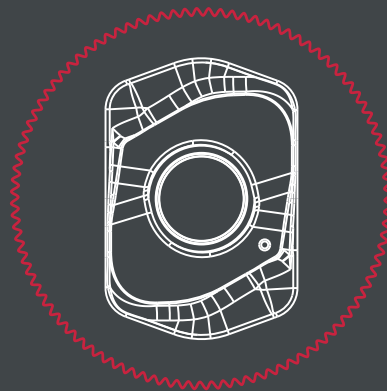


# ALL STAR

## High-Feed Milling



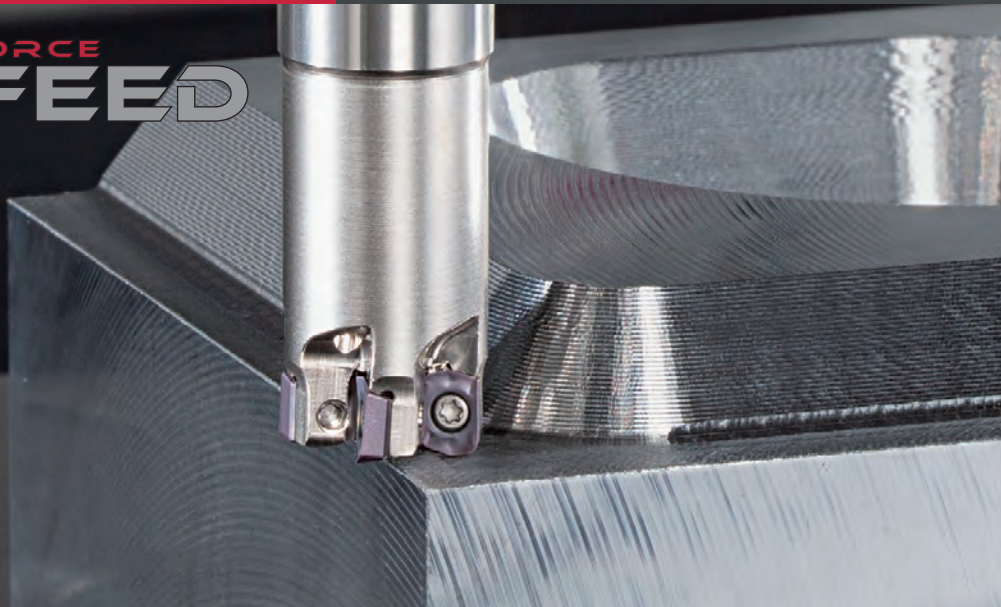
TungForce-Feed



DoTwist-Ball

# TUNG<sup>ORCE</sup>FEED

Small diameter  
high-feed milling  
cutter for increased  
productivity



**Robust cutter body design**  
and rigid insert retention ensures  
machining stability

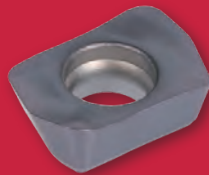
Single-sided insert with **high  
inclination angle for better chip  
evacuation**

Free cutting geometry to **ensure  
stability** in long overhang  
applications

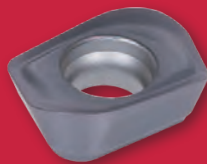
Available in a wide lineup of cutter  
bodies and inserts for various  
application needs

**Cutter bodies:**

Shank type **EXLS** DCX 8 – 16 mm,  
Modular type **HXLS** DCX 8 – 16 mm



LSMT-HM insert  
for High-Feed milling



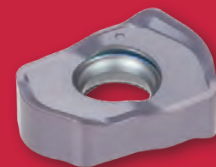
LSMT-MM insert  
for Profile milling

The large clamping screw and twisted  
contact surface **increases reliability  
at high-feed rates.**

**2 types of inserts** fit into the same  
pocket, **radius type** for profile milling  
and **high-feed type** for high-feed  
milling.

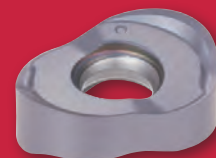
**Cutter bodies:**

Bore type **TXLN** (DCX 40 - 63 mm),  
Shank type **EXLN** (DCX 20 - 40 mm),  
Modular type **HXLN** (DCX 20 - 32 mm)



**LNMX04/06-HJ**

High-feed type applicable for  
depths of cut up to 1.3 mm  
and 2.0 mm respectively.



**LNMX04/05/06 MJ & ML**

Radius type available in R4, R5,  
R6 corner radii for profile milling  
of various materials.

# DOT<sup>WIST</sup>BALL

Super high-feed  
cutter for profile  
milling with rigid  
clamping





A close-up photograph of a Tungaloy face mill cutting a metal workpiece. The mill is positioned vertically, and the workpiece is being machined horizontally. The cutting process is shown in progress, with a chip being removed. The mill's cutting edges are sharp and well-defined. The workpiece has a fine, cross-hatched texture. The background is a soft, out-of-focus grey.

# NO TOOL INTERFERENCE IN FACE MILLING *operations*

# DOQ<sup>UAD</sup>MILL

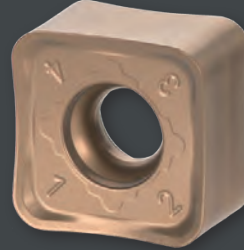
## No Tool Interference in Face Milling Operations

Ideal for machining close to side walls and part-clamping systems.

**Low cutting force ensures stability** when machining workpieces with thin walls or weak fixtures

### Cutter bodies:

Bore type : **THSN** (DCX 50-100 mm)



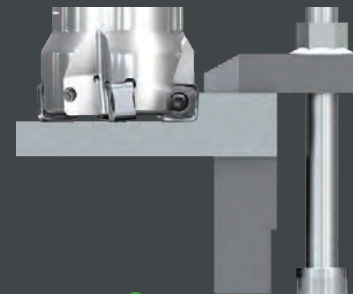
### SNMU1206... MM

With 8 cutting edges, Max DOC: 9 mm  
Available in R0.8 (with wiper), R1.2, and R2.0

Designed to avoid tool interference in rough and finish face milling operations with side walls, fixtures, and clamping systems



✓ Clear



✓ Clear





# SHOULDER MILLING

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## milestone

# DOF<sup>ORCE</sup>TRI

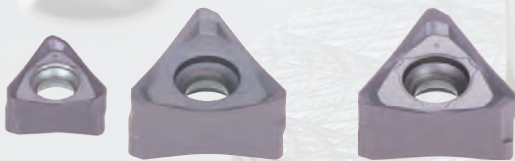
## High-precision shoulder milling cutter with economical double-sided triangular inserts

New inserts **TN MU07** for small parts machining

Inserts with **concave shaped cutting edge** improves chip formation and evacuation

### Cutter bodies:

Bore type: **TPTN07/12** (DC 40 – 125 mm)  
Shank type: **EPTN07/12** (DC 18 – 40 mm)



### TN MU07/12-MJ

First choice, versatile geometry with good surface finish

### TNGU12-MJ

For close tolerances



### TN MU12-NMJ

Ensures free cutting and good chip control during heavy milling



### TN MU-R-MJ

Strong cutting edge design with large corner radius



### High efficiency

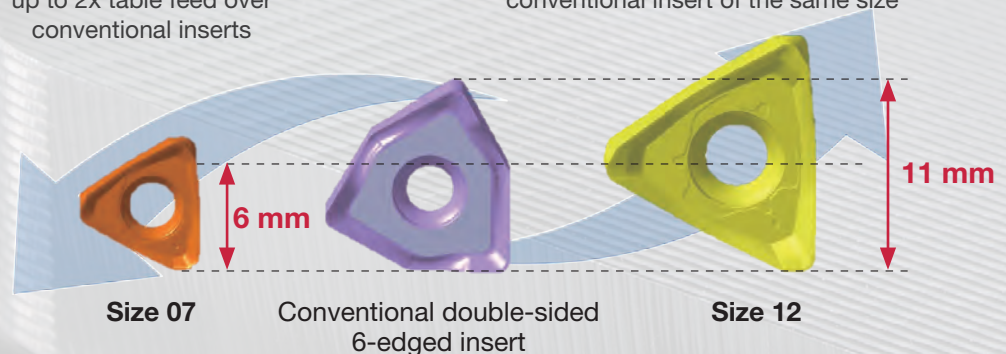
Inserts are available in 2 sizes for maximum density and cutting depths over conventional double-sided 6-edged inserts

### Higher number of teeth

Smaller inserts provide up to 2x table feed over conventional inserts

### Greater depths of cut

Allows up to 2x depth of cut over a conventional insert of the same size





**F** AN INVALUABLE  
**FACE**  
**Milling**  
**CUTTER**



# TUNGEMILL

Face milling cutter with 8-edged inserts  
**for extremely low cutting force**

Positive inserts with 8 cutting edges featuring **double relief on the flank surface** for improved durability

**Cutter bodies:**

Bore type: **TAOW05** (DC 40 – 160 mm)

Shank type: **EAOW05** (DC 32 – 40 mm)



**OWMT05-MM**

First choice for general  
machining



**OWHT05-MM**

For finishing and  
minimized burrs



**OWHT05-MW**

For better surface  
roughness



# LATEST MILLING SOLUTIONS FOR

Non-ferrous materials **N**

## TUNG <sup>PEED</sup>SMILL

Super high density PCD cutter with innovative insert clamping design for quick and easy insert setting

**22 inserts per  $\varnothing$ 100 mm cutter diameter.**  
Allows a cutting speed of 3,000 m/min or higher

**CamAdjust system - innovative insert axial adjusting mechanism**

**Cutter bodies:**

Bore type : **TPYD06** (DC 63-160 mm)

Shank type : **EPYD06** (DC 50 mm)



**YDEN0603PD(F/S)R-D**

Standard insert with built-in deburrer



**YDEN0603PDFR-WD**

Wiper insert - for superior surface finishing



**YDEN0603PDFR-BD**

Dedicated deburring insert - Tungaloy's exclusive insert design

**Unique axial adjusting mechanism - Cam Adjust**

A single key wrench is all it takes from mounting the inserts to precision adjustments, saving a great amount of presetting work. Setting range: 1 mm

**Internal coolant in each pocket**

Coolant is directed to the cutting edge, facilitating smooth chip evacuation

**Steel body**

the cutter body is made of durable steel  
**Extremely high balancing quality for high speed milling**  
G6.3 under ISO1940/1





# LATEST MILLING SOLUTIONS FOR

Difficult-to-cut materials **S**



# CERAMIC<sup>SPEED</sup>MILL

High efficiency milling cutter with ceramic inserts for high temperature alloy machining

**New SiAlON grade inserts features high reliability**

These two new ceramic grades are characterized by their excellent toughness and anti-chipping capabilities

**TS200:**

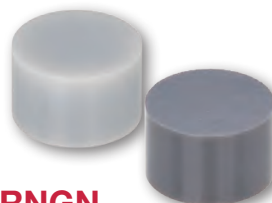
Superior wear resistance due to high chemical stability  
Superior flank and notch wear resistance

**TS300:**

Extreme toughness allows for higher feed and greater depth of cut machining  
Suitable for scaling and roughing applications

**Cutter bodies:**

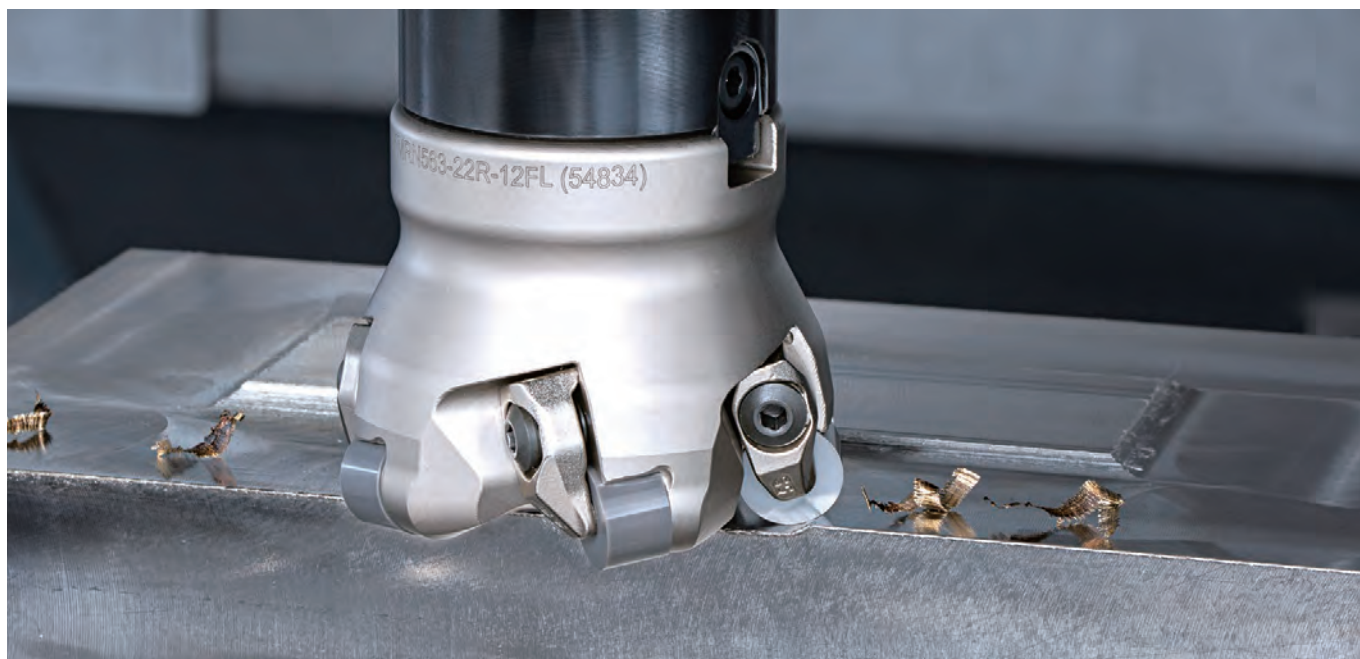
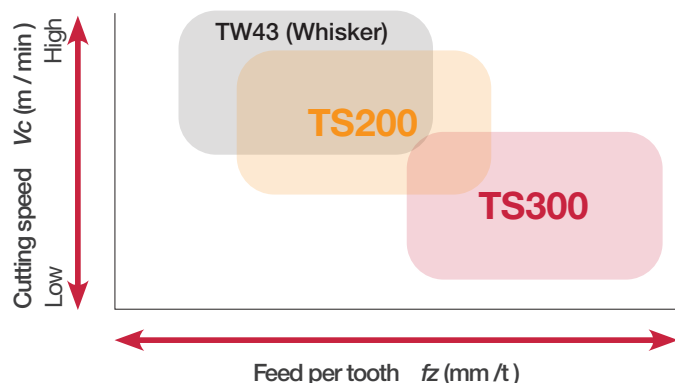
Bore type : **TFMRN** (D1 63 - 80 mm)



**RNGN**

TS200 & TS300

## APPLICATION AREA





# THE PERFECT PITCH

for ThreadMilling





# THREADMILLING

Economical thread-milling solutions  
providing versatility for high productivity

## **Indexable thread milling cutters – ETLN**

Various multi-point inserts fit one shank to cover a wide range of threading diameters and pitches, reducing tool inventory and costs.

## **Indexable threading mills – single-point insert design**

Suitable for deep hole and large-pitch threading, its light cutting geometry ensures high stability and accuracy threading up to a 6 mm pitch.

## **TungMeister**

Head changeable milling tools for reduced set-up time compared to solid tapping tools.

## **SolidThread**

Solid carbide thread milling tool series for diameters as small as M1x0.25 and 0-80UNF.



**ETLN type**



# MASTERS

OF HOLE MAKING

- REAMING -





# REAMMEISTER

Interchangeable Head Reamer with improved set-up time and high productivity

**High cutting speeds and feeds** (for higher productivity)

**Low runout and indexing repeatability** (maximum 3 $\mu$ m)

Able to finish **H7 hole tolerance**

One shank can be used for a wide range of diameters, various types of cutting edges and grades

Internal coolant is directed optimally to the cutting edges for the most efficient head lubrication for extremely long tool life

**Bodies:**

**TRM:** Available in 1.5xD, 3xD, 5xD, and 8xD

**Heads:**

**HRM: DC:**  $\varnothing$ 11.5 -  $\varnothing$ 32 mm (2 types of head are available)



Blind hole straight flutes



Through hole left-hand flutes





# MASTERS

OF HOLE MAKING

- DRILLING -



# DRILLMEISTER

## Interchangeable Head System with Quick Indexing

**Excellent cutting performance and tool life** due to new head geometries and innovative grade AH9130

**Dovetail interlocking system** prevents the drill head from falling during replacement, **simplifying drill setup.**

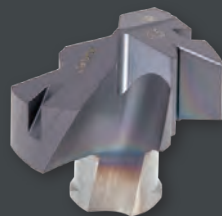
**Drill bodies:**

**TID flange type:** Available in 1.5xD, 3xD, 5xD, 8xD, and 12xD (12xD to be used with collets or hydro-grips)

**TIDC straight type:** Suitable for use with TIDCF chamfer holders

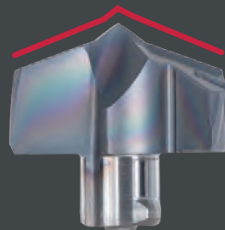
**TIDCF chamfer holder:** Available with 3 types of inserts in chamfering angles of 30°, 45°, and 60°

**Drill head: DMP... (AH725) DMC...**  
DC:  $\phi 6$  -  $\phi 25.9$  mm in increments of 0.1 mm



**DMP (AH725)**

General purpose for various materials and machining operations

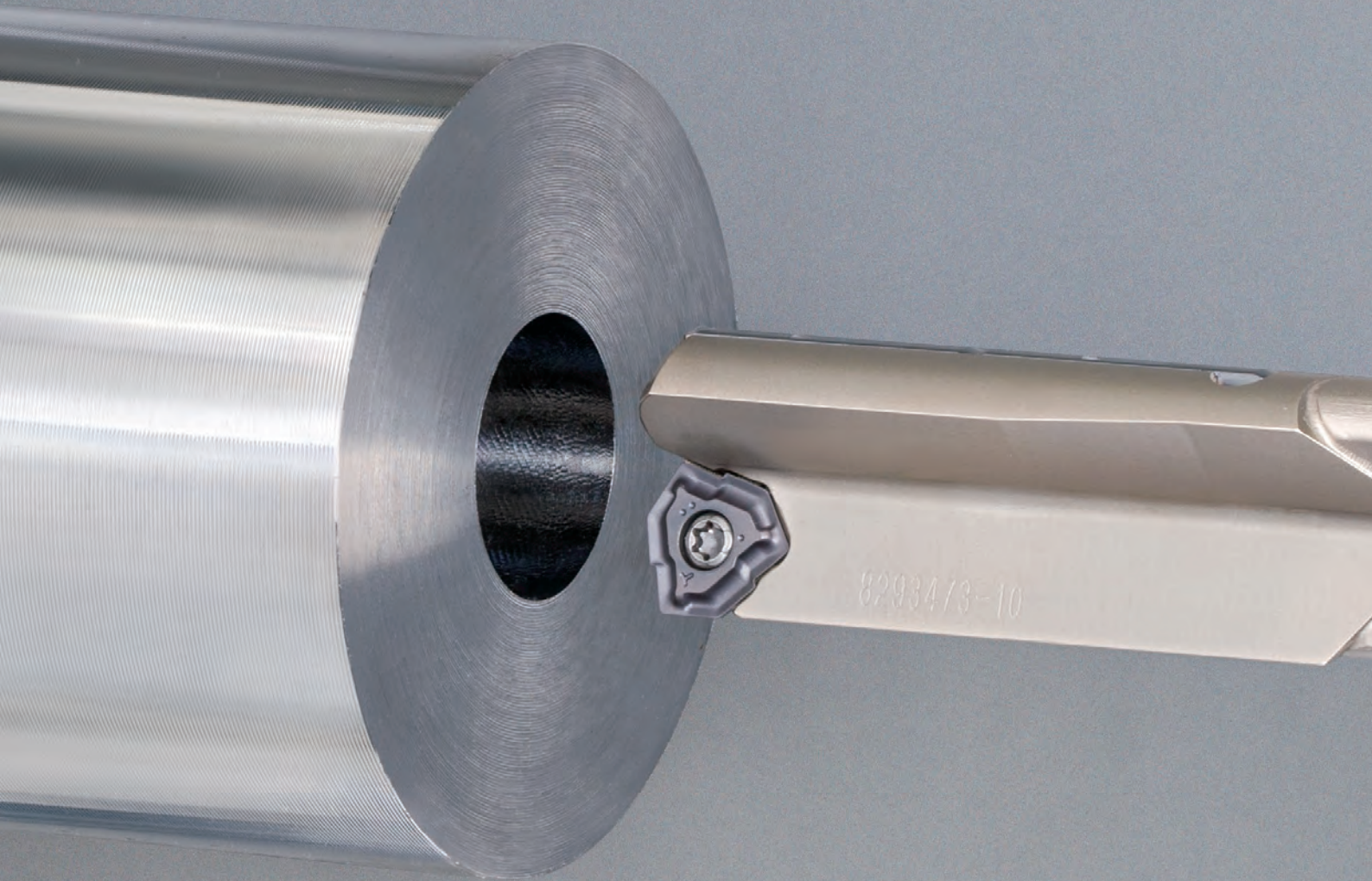


**DMC (AH9130)**

Self centering point and double margins ensure excellent hole diameter accuracy and roundness







# MASTERS

OF HOLE MAKING

-DEEP DRILLING-



# DEEPT<sup>RI</sup> DRILL

## Deep Hole Drilling - Exceptional Straightness

**Good chip control and smooth chip evacuation** from special insert geometries

Also available in a variety of drill holding drivers for different types of spindle interfaces.

**Drill bodies for lathes, machining centers, and gundrill machines:**

Guide pads **GP...**: Equipped with 2 usable edges.

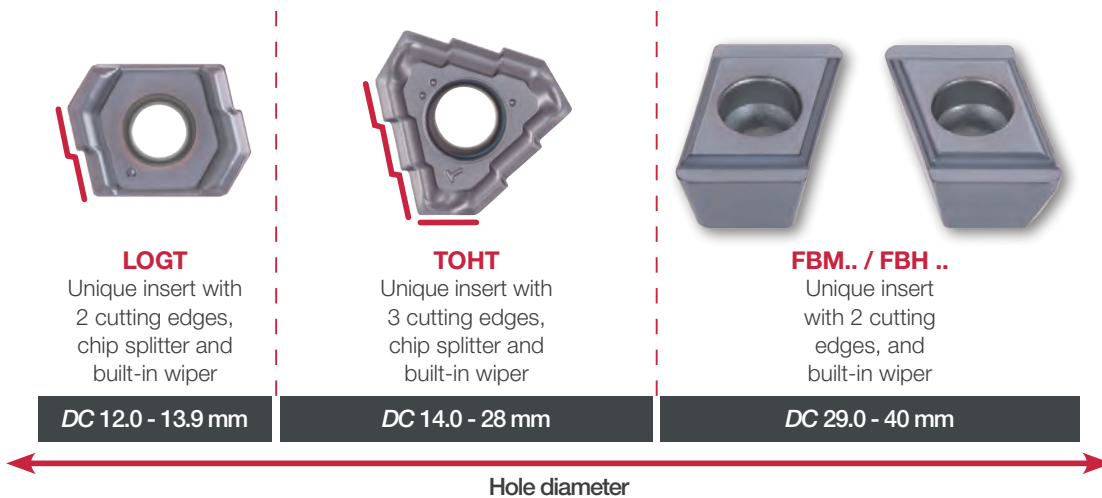
**MCTR...** for machining centers:  
Stocked in 8xD, 10xD, 15xD, and 25xD for drilling depths from 170 to 775 mm, depending on the diameter.

**Insert: LOGT...** (with chip splitter)  
Available in 1 size to cover *DC* 12.0 to 13.9 mm

**TRLG...** for gundrill machines:  
Offered up to 2400 mm in length with a minimum length of 400 mm.

**Insert: TOHT...** (with chip splitter)  
Available in 6 sizes to cover *DC* 14.0 to 28.0 mm

**Insert: FBH... FBM...** Available in 3 and 4 sizes respectively to cover *DC* 29.0 to 40.0 mm



**DeepTri-Drill features double guide pads to ensure hole accuracy and straightness in cross hole drilling**



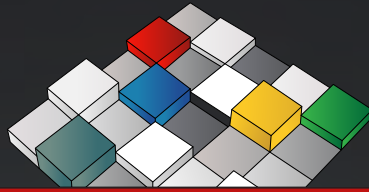
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