

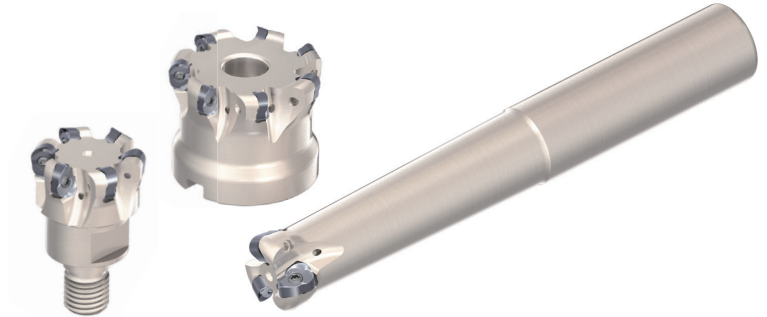
Expansion with the latest grade **AH3225**,
high-feed geometry, and cutter bodies





Cutter body lineup expansions for LNMX04 inserts

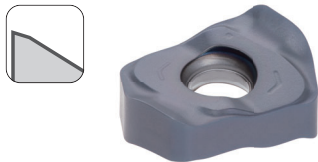
Now offering additional sizes of cylindrical, modular, and shell mill cutter bodies for expanded application coverages



New high-feed geometry lineup with low cutting force

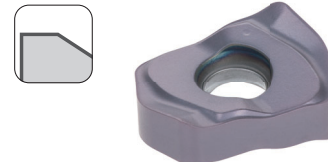
New

HL



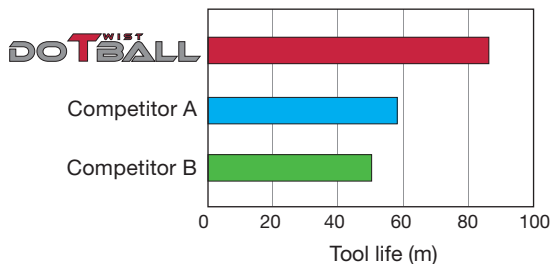
- Low cutting force (10% lower than HJ)
- Suitable for stainless steel & heat resistant alloys
- Suitable for long overhang

HJ



- Well-balanced geometry between sharpness and toughness
- Suitable for steel & cast iron
- Suitable for interrupted machining

Tool life in stainless steel of HL geometry



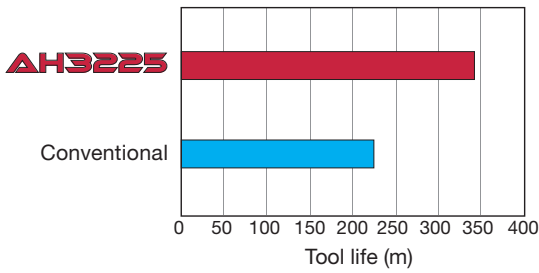
M

Cutter	: EXLN04M025C25.0R03 ($\phi 25$ mm, z = 1)
Insert	: LNMX0405ZER- HL AH3135
Workpiece material	: SUS304 / X5CrNi18-9 (160HB)
Cutting speed	: $V_c = 150$ m/min
Feed per tooth	: $f_z = 0.8$ mm/t
Depth of cut	: $a_p = 0.8$ mm
Width of cut	: $a_e = 10$ mm
Coolant	: Dry

New grades: AH3225 and AH8015

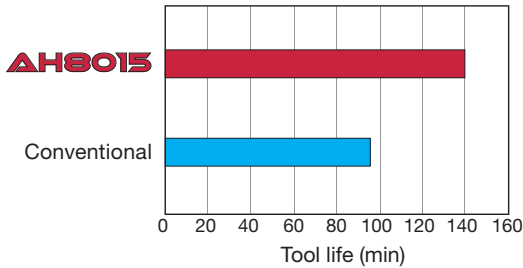


■ Tool life in alloy steel of AH3225



P Cutter : EXLN04M025C25.0R03
 (ø25 mm, z = 1)
 Insert : LNMX0405ZER-HJ **AH3225**
 Workpiece material : SCM440 / 42CrMo4 (300HB)
 Cutting speed : Vc = 200 m/min
 Feed per tooth : fz = 0.5 mm/t
 Depth of cut : ap = 1 mm
 Width of cut : ae = 11 mm
 Coolant : Dry

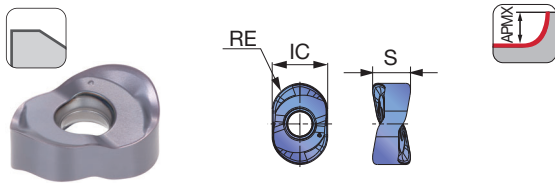
■ Tool life in heat resistant alloy of AH8015



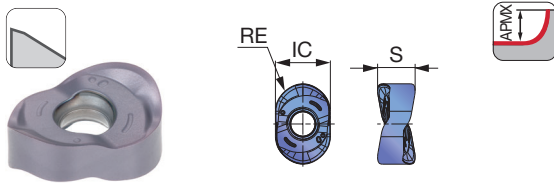
S Cutter : EXLN04M025C25.0R03
 (ø25 mm, z = 1)
 Insert : LNMX0405ZER-HJ **AH8015**
 Workpiece material : Inconel718 (40HRC)
 Cutting speed : Vc = 30 m/min
 Feed per tooth : fz = 0.2 mm/t
 Depth of cut : ap = 0.5 mm
 Width of cut : ae = 13 mm
 Coolant : Wet

INSERT

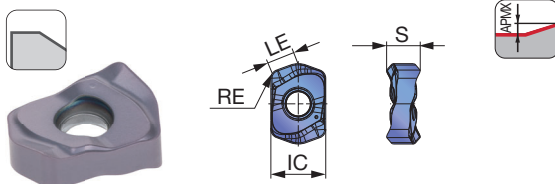
LNMX-MJ (Radius)



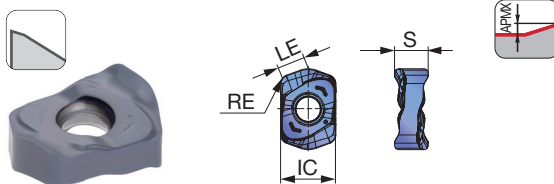
LNMX-ML (Radius)



LNMX-HJ (High feed)



LNMX-HL (High feed)



New

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

★ : First choice
 ☆ : Second choice

Designation	RE	APMX	Coated				LE	IC	S
			AH8015	AH3225	AH120	AH3135			
LNMX0405R4-MJ	4	4	●	●	●	●	-	8.2	5.6
LNMX0405R4-ML	4	4			●	●	-	8.2	5.6
LNMX0405ZER-HJ	1.3	1.3	●	●	●	●	4.3	8.2	5
New LNMX0405ZER-HL	1.3	1.3	●	●		●	4.3	8.2	5
LNMX0506R5-MJ	5	5	●	●	●	●	-	10.4	6.1
LNMX0607R6-MJ	6	6	●	●	●	●	-	12.6	7.4
LNMX0607ZER-HJ	2	2	●	●	●	●	6.7	12.7	7.2

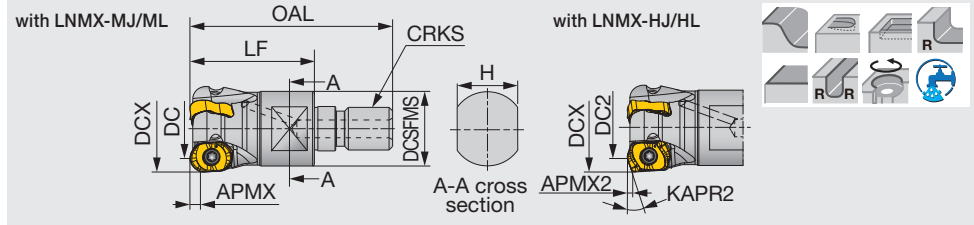
● : New lineup

TUNGFLEX

HXLN04-M

Radius endmill, modular type, for 4-corner double sided inserts (TungFlex)

GAMP= +3°, GAMF= -12° ~ -14°



Designation	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	OAL	LF	H	DCSFMS	CRKS	WT(kg)	Air hole	Insert
HXLN04M020M10R02	4	1.3	20	2	12.2	11.6	20°	49	30	15	18	M10	0.07	With	LNMX04...
HXLN04M025M12R03	4	1.3	25	3	17.2	16.6	20°	57	35	17	21	M12	0.16	With	LNMX04...
HXLN04M032M16R04	4	1.3	32	4	24.2	23.6	20°	63	40	22	29	M16	0.2	With	LNMX04...
New HXLN04M032M16R05	4	1.3	32	5	24.2	23.6	20°	63	40	22	29	M16	0.2	With	LNMX04...
New HXLN04M040M16R06	4	1.3	40	6	32.2	31.6	20°	63	40	22	29	M16	0.24	With	LNMX04...
HXLN05M025M12R02	5	-	25	2	15	-	-	57	35	17	21	M12	0.1	With	LNMX05...
HXLN05M032M16R04	5	-	32	4	21.9	-	-	63	40	22	28.8	M16	0.2	With	LNMX05...
HXLN06M032M16R02	6	2	32	2	19.6	19.3	25°	63	40	22	28.8	M16	0.24	With	LNMX06...

SPARE PARTS

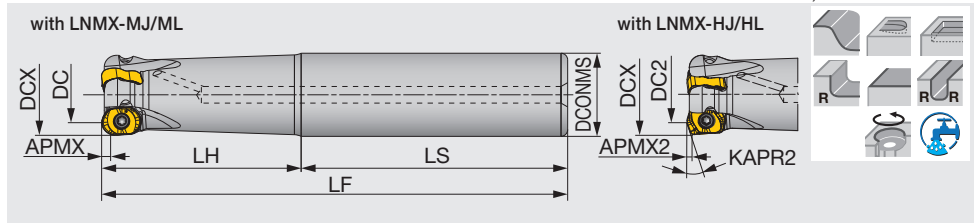
Designation	Clamping screw	Mono block wrench	Torx bit	Grip
HXLN04...	CSPD-3	IP-10D	-	-
HXLN05...	CSPB-4S	-	BLDIP15/S7	H-TB2W
HXLN06...	CSPB-5	-	BLDIP20/S7	H-TB2W

· Recommended clamping torque (N·m): CSPD-3=2.5, CSPB-4S=3.5, CSPB-5=5

EXLN

Radius endmill, shank type, for 4-corner double sided inserts

GAMP= +3°, GAMF= -12° ~ -14°



Designation	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	DCONMS	LS	LH	LF	WT(kg)	Air hole	Insert
EXLN04M020C20.0R02	4	1.3	20	2	12.2	11.6	20°	20	80	50	130	0.28	With	LNMX04...
New EXLN04M020C20.0R02L	4	1.3	20	2	12.2	11.6	20°	20	80	80	160	0.34	With	LNMX04...
EXLN04M025C25.0R03	4	1.3	25	3	17.2	16.6	20°	25	80	60	140	0.46	With	LNMX04...
New EXLN04M025C25.0R03L	4	1.3	25	3	17.2	16.6	20°	25	80	100	180	0.6	With	LNMX04...
EXLN04M032C32.0R04	4	1.3	32	4	24.2	23.6	20°	32	80	70	150	0.83	With	LNMX04...
EXLN04M032C32.0R05	4	1.3	32	5	24.2	23.6	20°	32	80	70	150	0.83	With	LNMX04...
New EXLN04M032C32.0R05L	4	1.3	32	5	24.2	23.6	20°	32	80	120	200	1.09	With	LNMX04...
EXLN05M025C25.0R02	5	-	25	2	15	-	-	25	90	60	150	0.54	With	LNMX05...
EXLN05M032C32.0R04	5	-	32	4	21.9	-	-	32	80	70	150	0.87	With	LNMX05...
EXLN06M032C32.0R02	6	2	32	2	19.6	19.3	25°	32	80	70	150	0.9	With	LNMX06...
EXLN06M040C32.0R04	6	2	40	4	27.6	27.3	25°	32	100	50	150	0.95	With	LNMX06...

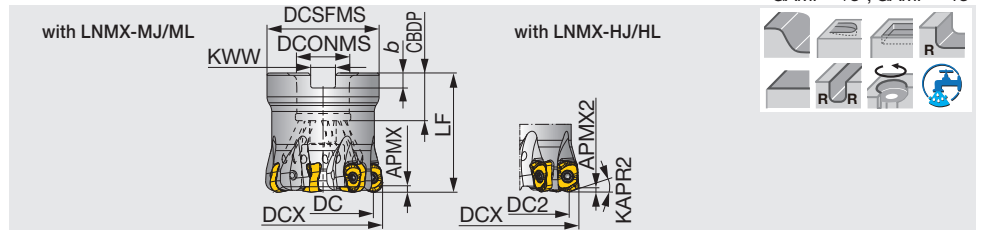
SPARE PARTS

Designation	Clamping screw	Mono block wrench	Torx bit	Grip
EXLN04...	CSPD-3	IP-10D	-	-
EXLN05...	CSPB-4S	-	BLDIP15/S7	H-TB2W
EXLN06...	CSPB-5	-	BLDIP20/S7	H-TB2W

· Recommended clamping torque (N·m): CSPD-3=2.5, CSPB-4S=3.5, CSPB-5=5

TXLN

Radius mill, for 4-corner double sided inserts



Designation	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	DCSFMS	LF	DCONMS	CBDF	KWW	b	WT(kg)	Air hole	Insert
TXLN04M040B16.0R06	4	1.3	40	6	32.2	31.6	20	35	40	16	18	8.4	5.6	0.21	With	LNMX04...
New TXLN04M042B16.0R06	4	1.3	42	6	34.2	33.6	20	35	40	16	18	8.4	5.6	0.21	With	LNMX04...
TXLN04M050B22.0R07	4	1.3	50	7	42.2	41.6	20	47	50	22	20	10.4	6.3	0.45	With	LNMX04...
New TXLN04M052B22.0R07	4	1.3	52	7	44.2	43.6	20	47	50	22	20	10.4	6.3	0.47	With	LNMX04...
New TXLN04M063B22.0R07	4	1.3	63	7	55.2	54.6	20	59	50	22	20	10.4	6.3	0.76	With	LNMX04...
TXLN05M040B16.0R05	5	-	40	5	29.8	-	-	35	40	16	18	8.4	5.6	0.26	With	LNMX05...
TXLN05M050B22.0R06	5	-	50	6	39.8	-	-	47	50	22	20	10.4	6.3	0.50	With	LNMX05...
TXLN06M050B22.0R05	6	2	50	5	37.6	37.3	25	47	50	22	20	10.4	6.3	0.50	With	LNMX06...
TXLN06M052B22.0R05	6	2	52	5	39.6	39.3	25	49	50	22	20	10.4	6.3	0.55	With	LNMX06...
TXLN06M063B22.0R06	6	2	63	6	50.6	50.3	25	59	50	22	20	10.4	6.3	0.82	With	LNMX06...

SPARE PARTS



Designation	Clamping screw	Torx bit	Grip	Shell locking bolt
TXLN04M04*B16.0R06	CSPD-3	BLD IP10/S7	SW6-SD	FSHM8-30H
TXLN04M05*B22.0R07	CSPD-3	BLD IP10/S7	SW6-SD	CM10X30H
TXLN04M063B22.0R07	CSPD-3	BLD IP10/S7	SW6-SD	CM10X30H
TXLN05M040B16.0R05	CSPB-4S	BLDIP15/S7	H-TB2W	FSHM8-30H
TXLN05M050B22.0R06	CSPB-4S	BLDIP15/S7	H-TB2W	CM10X30H
TXLN06M050B22.0R05	CSPB-5	BLDIP20/S7	H-TB2W	FSHM10-40H
TXLN06M052B22.0R05	CSPB-5	BLDIP20/S7	H-TB2W	CM10X30H
TXLN06M063B22.0R06	CSPB-5	BLDIP20/S7	H-TB2W	CM10X30H

• Recommended clamping torque (N·m): CSPD-3=2.5, CSPB-4S=3.5, CSPB-5=5

STANDARD CUTTING CONDITIONS FOR RADIUS (MJ, ML)

ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
P	Low carbon steel	- 200 HB	First choice	AH3225	MJ	100 - 300	0.2 - 0.6
	S15C, SS400, etc. C15, C20, etc.	- 200 HB	Low cutting force	AH3135	ML	100 - 300	0.2 - 0.6
	Carbon steel, Alloy steel	- 300 HB	First choice	AH3225	MJ	100 - 250	0.2 - 0.6
	S55C, SCM440, etc. C55, 42CrMoS4, etc.	- 300 HB	Low cutting force	AH3135	ML	100 - 250	0.2 - 0.6
M	Prehardened steel	30 - 40 HRC	First choice	AH3225	MJ	100 - 200	0.15 - 0.4
	NAK80, PX5, etc.	30 - 40 HRC	Low cutting force	AH3135	ML	100 - 200	0.15 - 0.4
M	Austenitic Stainless steel	- 200 HB	First choice	AH3135	MJ	100 - 200	0.2 - 0.6
	SUS304, SUS304, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	- 200 HB	Low cutting force	AH3135	ML	100 - 200	0.2 - 0.6
	Martensitic Stainless steel	- 200 HB	First choice	AH3135	ML	100 - 300	0.2 - 0.6
K	SUS410, SUS420J1, etc. X12Cr13, X20Cr13, etc.	- 200 HB	Fracture resistance	AH3135	MJ	100 - 300	0.2 - 0.6
	Grey cast iron	150 - 250 HB	First choice	AH120	MJ	100 - 300	0.2 - 0.6
	FC250, FC300, etc. 250, 300, etc.	150 - 250 HB	Fracture resistance	AH3225	MJ	100 - 300	0.2 - 0.6
	Ductile cast iron	150 - 250 HB	First choice	AH120	MJ	80 - 250	0.2 - 0.6
S	FCD400, etc. 400-15, 600-3, etc.	150 - 250 HB	Fracture resistance	AH3225	MJ	80 - 250	0.2 - 0.6
	Titanium alloy	-	First choice	AH3135	ML	30 - 60	0.15 - 0.6
	Ti-6Al-4V, etc.	-	Fracture resistance	AH3135	MJ	30 - 60	0.15 - 0.6
H	Superalloys	-	First choice	AH8015	MJ	20 - 50	0.05 - 0.3
	Inconel718, etc.	-	Low cutting force	AH120	ML	20 - 50	0.05 - 0.3
	Hardened steel	40 - 50 HRC	First choice	AH3225	MJ	50 - 150	0.1 - 0.3
H	SKD61, etc.	40 - 50 HRC	Wear resistance	AH8015	MJ	50 - 150	0.1 - 0.3
	X40CrMoV5-1, etc.	40 - 50 HRC	First choice	AH8015	MJ	50 - 70	0.05 - 0.15
H	SKD11, etc. X153CrMoV12, etc.	50 - 60 HRC	First choice	AH8015	MJ	50 - 70	0.05 - 0.15

• When using a long shank or modular head with long overhang, please lower the cutting conditions (Vc, fz, ap) to 70% of the maximum conditions for the standard shank.

STANDARD CUTTING CONDITIONS FOR HIGH FEED (HJ, HL)

LNMX04-HJ/HL

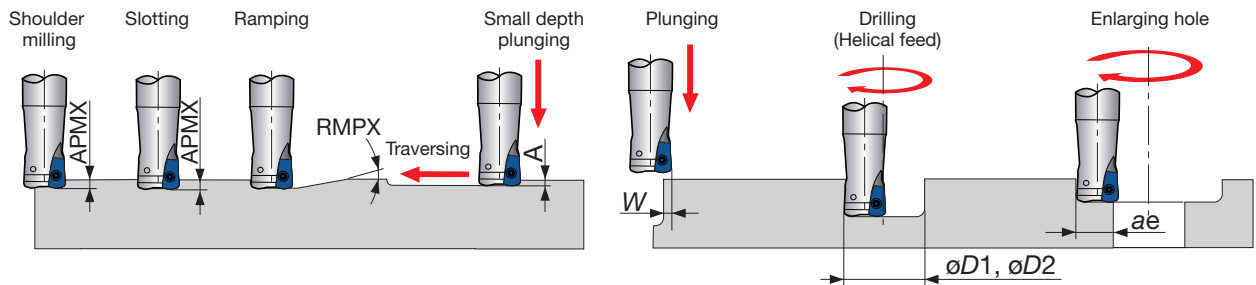
ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
P	Low carbon steel S15C, SS400, etc. C15, C20, etc.	- 300HB	First choice	AH3225	HJ	100 - 300	0.5 - 1.3
			Wear resistance	AH8015	HJ		
			Low cutting force	AH3225	HL		
	Carbon steel, Alloy steel S55C, SCM440, etc. C55, 42CrMoS4, etc.	- 300HB	First choice	AH3225	HJ	100 - 250	0.5 - 1.3
			Wear resistance	AH8015	HJ		
			Low cutting force	AH3225	HL		
Prehardened steel NAK80, PX5, etc.	30 - 40HRC	First choice	AH3225	HJ	100 - 200	0.4 - 1	
		Wear resistance	AH8015	HJ			
		Low cutting force	AH3225	HL			
M	Austenitic Stainless steel SUS304, SUS304, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	- 200HB	First choice	AH3135	HL	100 - 200	0.3 - 0.9
			Fracture resistance	AH3135	HJ		
	Martensitic Stainless steel SUS410, SUS420J1, etc. X12Cr13, X20Cr13, etc.	- 200HB	First choice	AH3135	HL	100 - 300	0.3 - 0.9
			Fracture resistance	AH3135	HJ		
K	Grey cast iron FC250, FC300, etc. 250, 300, etc.	150 - 250HB	First choice	AH120	HJ	100 - 300	0.5 - 1.3
			Fracture resistance	AH3225			
K	Ductile cast iron FCD400, etc. 400-15, 600-3, etc.	150 - 250HB	First choice	AH120	HJ	80 - 250	0.5 - 1.3
			Fracture resistance	AH3225			
S	Titanium alloy Ti-6Al-4V, etc.	150 - 250HB	First choice	AH3135	HL	30 - 60	0.3 - 0.7
			Fracture resistance	AH3135	HJ		
S	Superalloys Inconel718, etc.	150 - 250HB	First choice	AH8015	HL	20 - 50	0.1 - 0.3
			Fracture resistance	AH8015	HJ		
H	Hardened steel	SKD61, etc. X40CrMoV5-1, etc.	40 - 50HRC	First choice	AH3225	HJ	50 - 150
				Wear resistance	AH8015		
		SKD11, etc. X153CrMoV12, etc.	50 - 60HRC	First choice	AH8015	HJ	50 - 70

LNMX06-HJ

ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
P	Low carbon steel S15C, SS400, etc. C15, C20, etc.	- 300HB	First choice	AH3225	HJ	100 - 300	0.3 - 1.1
			Wear resistance	AH8015			
	Carbon steel, Alloy steel S55C, SCM440, etc. C55, 42CrMoS4, etc.	- 300HB	First choice	AH3225	HJ	100 - 250	0.3 - 1.1
			Wear resistance	AH8015			
P	Prehardened steel NAK80, PX5, etc.	30 - 40HRC	First choice	AH3225	HJ	100 - 200	0.2 - 0.7
			Wear resistance	AH8015			
M	Austenitic Stainless steel SUS304, SUS304, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	- 200HB	First choice	AH3135	HJ	100 - 200	0.2 - 0.7
			Fracture resistance	AH3135			
	Martensitic Stainless steel SUS410, SUS420J1, etc. X12Cr13, X20Cr13, etc.	- 200HB	First choice	AH3135	HJ	100 - 300	0.2 - 0.7
			Fracture resistance	AH3135			
K	Grey cast iron FC250, FC300, etc. 250, 300, etc.	150 - 250HB	First choice	AH120	HJ	100 - 300	0.3 - 1.1
			Fracture resistance	AH3225			
K	Ductile cast iron FCD400, etc. 400-15, 600-3, etc.	150 - 250HB	First choice	AH120	HJ	80 - 250	0.3 - 1.1
			Fracture resistance	AH3225			
S	Titanium alloy Ti-6Al-4V, etc.	150 - 250HB	First choice	AH3135	HJ	30 - 60	0.15 - 0.6
			Fracture resistance	AH3135			
S	Superalloys Inconel718, etc.	150 - 250HB	First choice	AH8015	HJ	20 - 50	0.05 - 0.3
			Fracture resistance	AH8015			
H	Hardened steel	SKD61, etc. X40CrMoV5-1, etc.	40 - 50HRC	First choice	AH3225	HJ	50 - 150
				Wear resistance	AH8015		
		SKD11, etc. X153CrMoV12, etc.	50 - 60HRC	First choice	AH8015	HJ	50 - 70

· When using a long shank or modular head with long overhang, please lower the cutting conditions (Vc, fz, ap) to 70% of the maximum conditions for the standard shank.

MACHINING APPLICATIONS



MJ, ML

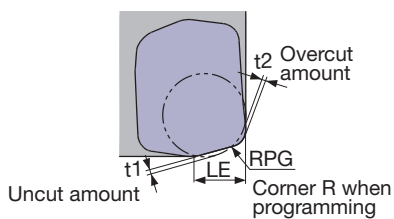
Designation	DCX	Max. depth of cut		Max. plunging	Max. cutting width in plunging	Min. machining dia.	Max. machining dia.	Max. cutting width in enlarging
		APMX	RMPX					
New E/HXLN04M020...	20	4	4.5°	0.75	4	28	38	15
New E/HXLN04M025...	25	4	2.9°	0.75	4	38	48	20
New E/HXLN04M032...	32	4	1.9°	0.75	4	52	62	27
New H/TXLN04M040...	40	4	1.2°	0.6	4	68	78	35
New TXLN04M042B16.0R06	42	4	1.1°	0.6	4	72	82	37
TXLN04M050B22.0R07	50	4	0.9°	0.6	4	88	98	45
New TXLN04M052B22.0R07	52	4	0.8°	0.6	4	92	102	47
New TXLN04M063B22.0R07	63	4	0.7°	0.7	4	114	124	58
E/HXLN05M025...	25	5	2.3°	0.5	5	35	48	17
E/HXLN05M032...	32	5	2.1°	0.6	5	48	62	24
TXLN05M040B16.0R05	40	5	2°	1	5	64	78	31
TXLN05M050B22.0R06	50	5	1.3°	1	5	84	98	41
E/HXLN06M032...	32	6	3.7°	1	6	52	62	22
EXLN06M040C32.0R04	40	6	3.4°	1	6	60	78	29
TXLN06M050B22.0R05	50	6	2.8°	1.7	6	79	98	39
TXLN06M052B22.0R05	52	6	2.5°	1.6	6	81	102	41
TXLN06M063B22.0R06	63	6	1.8°	1.6	6	105	124	52

HJ, HL

Designation	DCX	Max. depth of cut		Max. plunging	Max. cutting width in plunging	Min. machining	Max. machining	Max. cutting width in enlarging
		APMX	RMPX					
New E/HXLN04M020...	20	1.3	4.9°	0.7	4.1	27	38	15.5
New E/HXLN04M025...	25	1.3	3°	0.7	4.1	37	48	20.5
New E/HXLN04M032...	32	1.3	2°	0.7	4.1	51	62	27.5
New E/TXLN04M040...	40	1.3	1.4°	0.7	4.1	67	78	35.5
New TXLN04M042B16.0R06	42	1.3	1.3°	0.7	4.1	71	82	37.5
TXLN04M050B22.0R07	50	1.3	1°	0.7	4.1	87	98	45.5
New TXLN04M052B22.0R07	52	1.3	0.9°	0.7	4.1	91	102	47.5
New TXLN04M063B22.0R07	63	1.3	0.8°	0.7	4.1	113	124	58.5
E/HXLN06M032...	32	2	5.7°	1.4	6.1	42	62	20
EXLN06M040C32.0R04	40	2	3.8°	1.5	6.1	57	78	28
TXLN06M050B22.0R05	50	2	2.7°	1.6	6.1	77	98	38
TXLN06M052B22.0R05	52	2	2.5°	1.6	6.1	81	102	40
TXLN06M063B22.0R06	63	2	1.8°	1.5	6.1	104	124	51

TOOL GEOMETRY ON PROGRAMMING FOR HIGH FEED (HJ, HL)

The following table shows the amount left uncut (t1) and overcut (t2).



	Max. depth of cut APMX (mm)	LE (mm)	Programmed corner R (mm)	Amount left uncut t1 (mm)	Amount left overcut t2 (mm)
LNMX04-HJ LNMX04-HL	1.3	4.1	R1.5	0.8	0
	1.3	4.1	R2.0	0.65	0
	1.3	4.1	R2.5	0.5	0.05
LNMX06-HJ	1.3	4.1	R3.0	0.36	0.2
	2	6.1	R2.0	1.4	-
	2	6.1	R3.0	1.1	-
	2	6.1	R3.5	0.91	-
	2	6.1	R4.0	0.74	0.05
	2	6.1	R5.0	0.41	0.35

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 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 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 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 Germany GmbH

An der Alten Ziegelei 1
D-40789 Monheim, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.com/de

Tungaloy France S.A.S.

ZA Courtaboef - Le Rio
1 rue de la Terre de feu
F-91952 Courtaboef Cedex, 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 U.K. Ltd

Gallan Park, Watling Street,
Cannock, WS110XG, 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,
Xinzhuang Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy Cutting Tools (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.

Indiabulls Finance Centre,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai-400013, India
Phone: +91-22-6124-8804
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

Kompleks Grand Wisata Block AA-10 No.3-5
Cibitung
Bekasi 17510, Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
www.tungaloy.com/id

Schnyder + Minder AG | Zielmattenring 11 | CH-4563 Gerlafingen | Phone: +41 31 832 77 00 | info@smtools.ch | www.smtools.ch

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