



DOOCTO
TUNGALOY

DOQUAD
TUNGALOY



MILLLINE

Tungaloy Report No. 385-G

www.tungaloy.com



**Economical face milling
cutter** for various applications

ngaloy

TAN07R0800
MAX. RPM=3000
(10)6800





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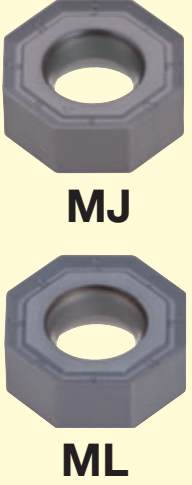
4 types of inserts cover a wide range of face milling operations.

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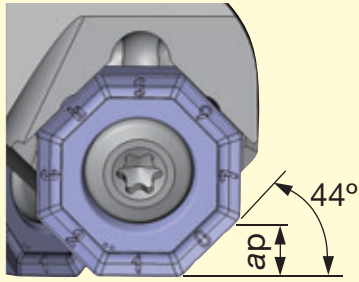
4 types of inserts can be clamped on 1 cutter body, allowing the best tool selection for the given machining requirements.

● Double-sided inserts

ON□U **P K**



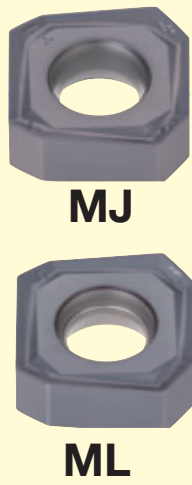
Max. ap = 4.75 mm



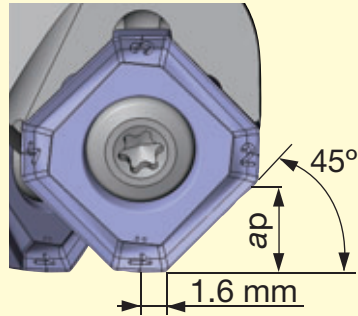
44°
ap

- 16 cutting edges total
- Economical

SN□U **P K**



Max. ap = 7.5 mm



45°
ap
1.6 mm

- 8 cutting edges total
- Suitable for large DOC

● Single-sided inserts

NEW **OWMT**

P M S




Max. ap = 3.5 mm



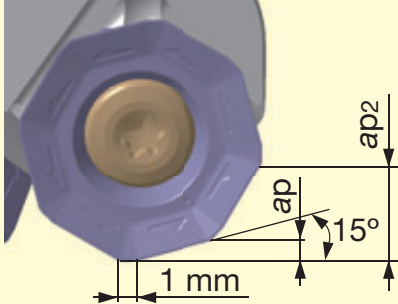
43°
ap
1.2 mm

- 8 cutting edges total
- Low cutting force
- Recommended for stainless steel and high-temperature materials
- Excellent for workpieces with low rigidity and weak clamping

P M H



Max. ap = 1.5 mm
Max. ap2 = 7.5 mm (2 corners used)



15°
ap
ap2
1 mm

- 8 cutting edges total
- Suitable for high-feed machining
- Excellent for rough machining of gummy material

Cutter bodies



Screw on

- Contains air holes
- Large gullets for excellent chip evacuation



Wedge

- Extra close pitch for high productivity

How to select the cutter

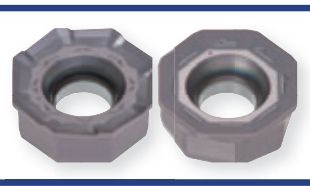
Workpiece material	Clamping system	Pitch	Shape
Cast Iron K	Screw	Coarse	
Steel P	Screw	Close	
Stainless M	Screw	Extra close	

Applicable only for screw-on type (Not applicable for wedge type)



Screw-on type

OK
✓



Single-sided inserts

No
⊘



Wedge type

Long tool life due to newly developed coated grade

NEW

AH3135

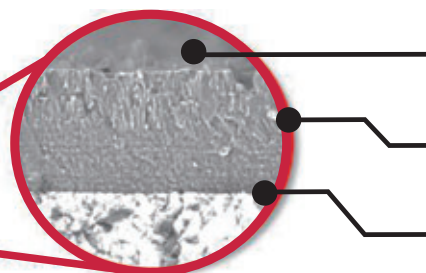


Improved fracture and chipping resistance

Structure of AH3135



Highly tough substrate



Special Surface Technology

PREMIUMTEC
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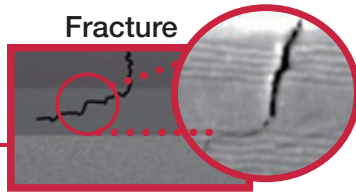
Wear-resistant layer

Alternately stacked layer and adhesion layer

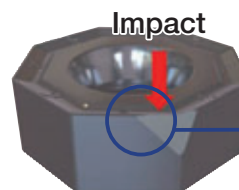
The effect of alternately stacked layer



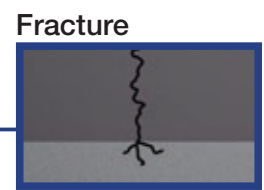
AH3135



The layer prevents cracks from penetrating into the substrate.

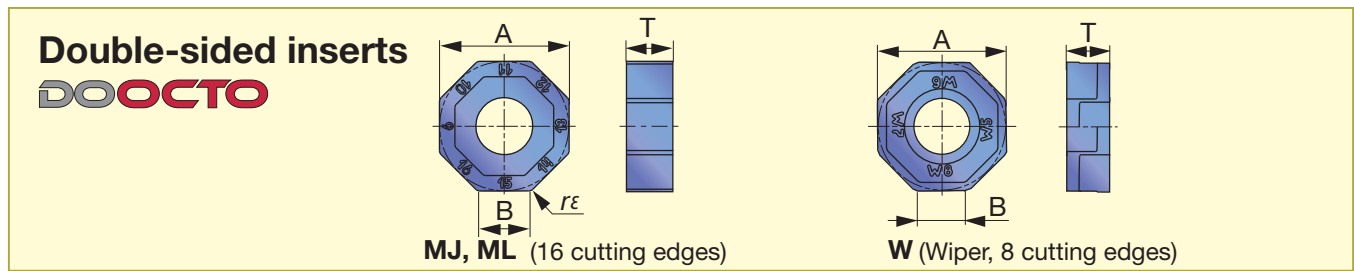


Old product



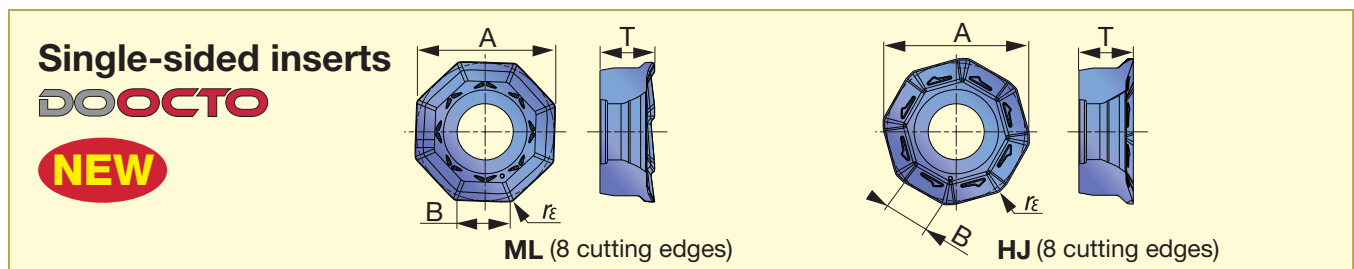
Cracks from the surface penetrating into substrate.

● Insert

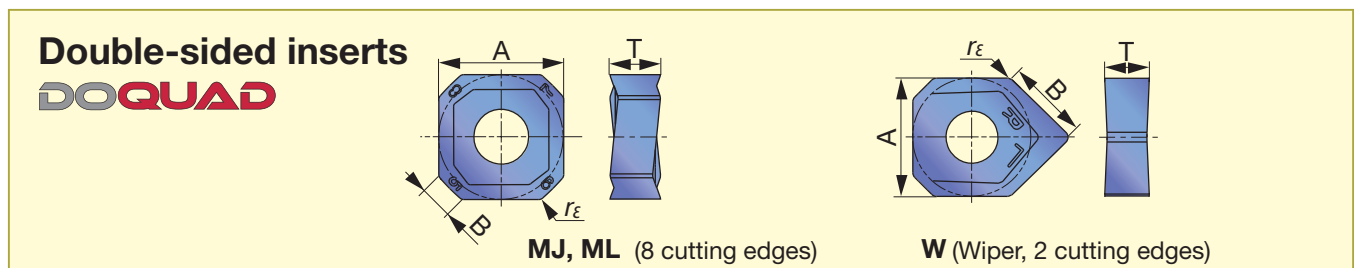


Cat. No.	Accuracy	Honing	Stocked grades					Dimensions (mm)			
			AH120	AH140	AH725	NEW AH3135	NEW T1115	A	B	T	r_{ϵ}
ONMU0705ANPN-MJ	M	with	●	●	●	●	★	17.3	7.2	6.2	0.8
ONHU0705ANPN-MJ	H	with	●	●				17.3	7.2	6.2	0.8
ONMU0705ANPN-ML	M	with	●			●		17.3	7.2	6.2	0.8
ONHU0705ANTN-ML	H	with	●	●	●			17.3	7.2	6.2	0.8
ONHU0705ANPR-W*	H	with	●					17.5	6.4	5.8	-

* Pay attention to the wiper insert installation procedure on the next page.



Cat. No.	Accuracy	Honing	Stocked grades		Dimensions (mm)				
			AH3135	AH130	A	B	T	r_{ϵ}	
OWMT0807AAER-ML	M	with	●	●	18.9	5.1	7.4	0.8	
OWMT0807ZNER-HJ	M	with	●		19.0	5.7	7.4	1.2	



Cat. No.	Accuracy	Honing	Stocked grades				Dimensions (mm)			
			AH120	AH140	AH725	NEW AH3135	A	B	T	r_{ϵ}
SNMU1706ANPR-MJ	M	with	●	●	●	●	17.3	4.4	6.98	0.8
SNHU1706ANPR-MJ	H	with	●	●			17.3	4.4	6.98	0.8
SNMU1706ANTR-ML	M	with	●			●	17.3	4.4	6.98	0.8
SNHU1706ANTR-ML	H	with	●				17.3	4.4	6.98	0.8
SNHU1706ANFN-W*	H	without	●				17.3	11	6.5	0.4

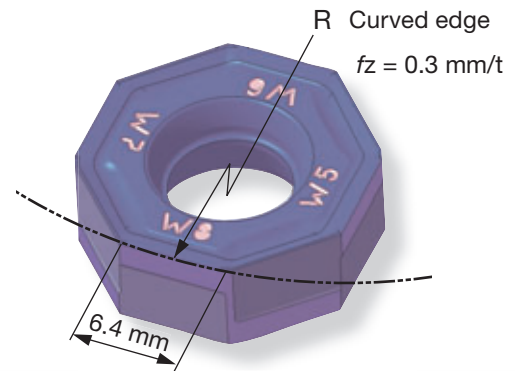
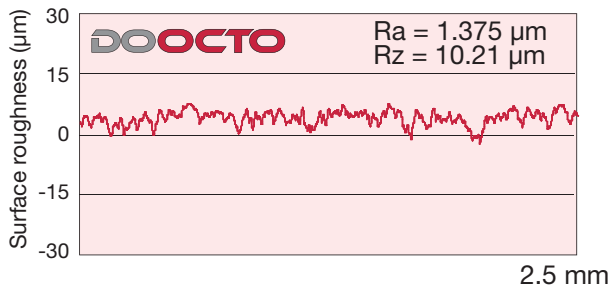
* Pay attention to the wiper insert installation procedure on the next page.

● : Stocked items
★ : Available in 2015

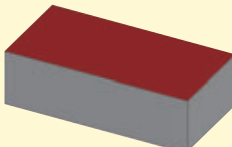
Wiper insert

Wide and curved edge

Surface roughness with wiper insert



Cutter	: TAN07R080M25.4-08 TAN07R080M27.0E08 ($\phi 80, z = 8$)
Insert	: ONHU0705ANTN-ML ONHU0705ANFN-W
Grade	: AH120
Workpiece	: FC250 / GG25 (180HB)
Cutting speed	: $V_c = 250 \text{ m/min}$
Feed per tooth	: $f_z = 0.2 \text{ mm/t}$
Depth of cut	: $a_p = 3.0 \text{ mm}$
Width of cut	: $a_e = 60 \text{ mm}$
Coolant	: Dry



Attention for wiper inserts

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1 2

Attach only one wiper insert on the cutter and make sure the wiper edge faces the machining surface.
Feed rate: $f < 5.5 \text{ mm/rev}$

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1 2

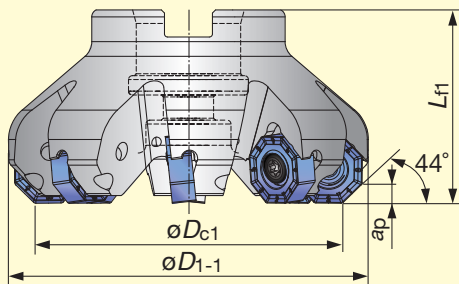
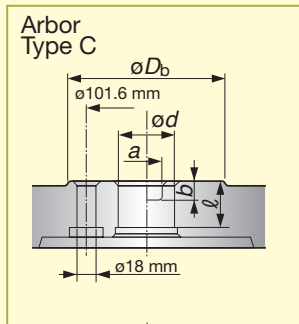
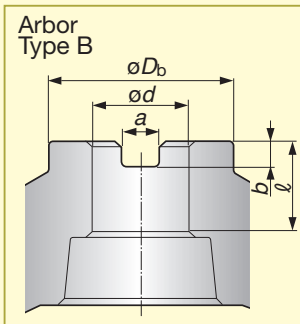
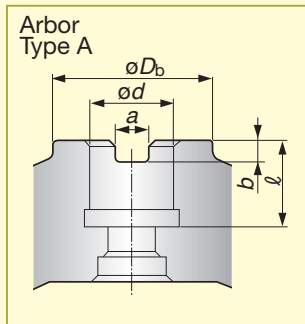
Attach only one wiper insert on the cutter and make sure the wiper edge faces the machining surface.
Feed rate: $f < 9.5 \text{ mm/rev}$



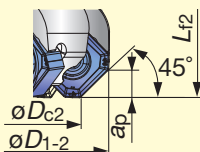
Cutter

Screw-on type

DOOCTO
Double-sided
octagonal inserts

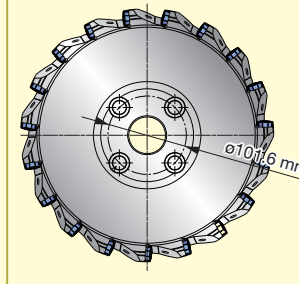


DOQUAD
Double-sided square inserts



$ap = 4.75\text{ mm}$

$ap = 7.5\text{ mm}$



Please see the attention for parts on next page.

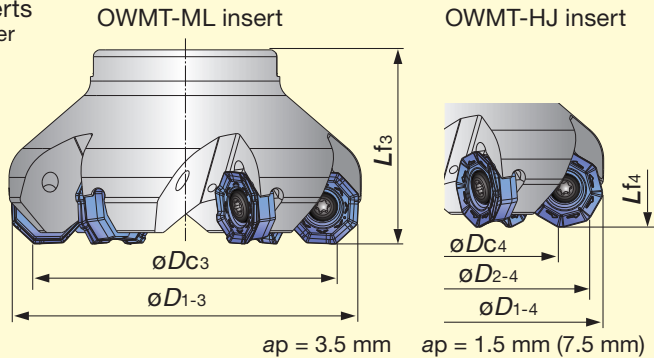
Cat. No.	Stock	No. of inserts	Dimensions (mm)										Weight (kg)	Air hole	Center bolt	Arbor type	
			ϕD_{c1}	ϕD_{c2}	ϕD_{1-1}	ϕD_{1-2}	ϕD_b	ϕd	ℓ	L_{f1}	L_{f2}	b					a
TAN07R063M22.0E05	●	5	63	60.3	76	76.3	41	22	20	40	41.4	6.3	10.4	0.5	with	CM10x30H	A
TAN07R063M22.0E06	●	6	63	60.3	76	76.3	41	22	20	40	41.4	6.3	10.4	0.5	with	CM10x30H	A
TAN07R080M25.4-06	●	6	80	77.3	93	93.3	50	25.4	26	50	51.4	6	9.5	1	with	CM12x30H	A
TAN07R080M25.4-08	●	8	80	77.3	77.3	93	50	25.4	26	50	51.4	6	9.5	1	with	CM12x30H	A
TAN07R080M27.0E06	●	6	80	77.3	93	93.3	50	27	22	50	51.4	7	12.4	1	with	CM12x30H	A
TAN07R080M27.0E08	●	8	80	77.3	93	93.3	50	27	22	50	51.4	7	12.4	1	with	CM12x30H	A
TAN07R100M31.7-07	●	7	100	97.3	113	113.3	60	31.75	32	50	51.4	8	12.7	1.5	with	TMBA-M16H	B
TAN07R100M31.7-10	●	10	100	97.3	97.3	113	60	31.75	32	50	51.4	8	12.7	1.5	with	TMBA-M16H	B
TAN07R100M32.0E07	●	7	100	97.3	113	113.3	60	32	28.5	50	51.4	8	14.4	1.5	with	TMBA-M16H	B
TAN07R100M32.0E10	●	10	100	97.3	113	113.3	60	32	28.5	50	51.4	8	14.4	1.5	with	TMBA-M16H	B
TAN07R125M38.1-08	●	8	125	122.3	138	138.3	80	38.1	38	63	64.4	10	15.9	2.5	with	TMBA-M20H	B
TAN07R125M38.1-12	●	12	125	122.3	122.3	138	80	38.1	38	63	64.4	10	15.9	2.5	with	TMBA-M20H	B
TAN07R125M40.0E08	●	8	125	122.3	138	138.3	71	40	29	63	64.4	9	16.4	2.5	with	TMBA-M20H	B
TAN07R125M40.0E12	●	12	125	122.3	138	138.3	71	40	29	63	64.4	9	16.4	2.5	with	TMBA-M20H	B
TAN07R160M40.0E10	●	10	160	157.3	173	173.3	100	40	29	63	64.4	9	16.4	4	without	-	C
TAN07R160M40.0E15	●	15	160	157.3	173	173.3	100	40	29	63	64.4	9	16.4	4	without	-	C
TAN07R160M50.8-10	●	10	160	157.3	173	173.3	100	50.8	38	63	64.4	11	19	4	without	-	B
TAN07R160M50.8-15	●	15	160	157.3	157.3	173	100	50.8	38	63	64.4	11	19	4	without	-	B
TAN07R200M47.6-12	●	12	200	197.3	213	213.3	130	47.625	38	63	64.4	14	25.4	6.6	without	-	C
TAN07R200M47.6-18	●	18	200	197.3	197.3	213	130	47.625	38	63	64.4	14	25.4	6.7	without	-	C
TAN07R200M60.0E12	●	12	200	197.3	213	213.3	135	60	39	63	64.4	14	25.7	6.5	without	-	C
TAN07R200M60.0E18	●	18	200	197.3	213	213.3	135	60	39	63	64.4	14	25.7	6.5	without	-	C
TAN07R250M47.6-15	●	15	250	247.3	263	263.3	130	47.625	38	63	64.4	14	25.4	9.3	without	-	C
TAN07R250M47.6-21	●	21	250	247.3	247.3	263	130	47.625	38	63	64.4	14	25.4	9.4	without	-	C
TAN07R250M60.0E15	●	15	250	247.3	263	263.3	130	60	39	63	64.4	14	25.7	9	without	-	C
TAN07R250M60.0E21	●	21	250	247.3	263	263.3	130	60	39	63	64.4	14	25.7	9	without	-	C
TAN07R315M47.6-18	●	18	315	312.3	328	328.3	220	47.625	38	63	64.4	14	25.4	17.9	without	-	C
TAN07R315M47.6-24	●	24	315	312.3	312.3	328	220	47.625	38	63	64.4	14	25.4	18	without	-	C
TAN07R315M60.0E18	●	18	315	312.3	328	328.3	220	60	39	80	81.4	14	25.7	18	without	-	C
TAN07R315M60.0E24	●	24	315	312.3	328	328.3	220	60	39	80	81.4	14	25.7	18	without	-	C

● : Stocked items

Screw-on type

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Single-sided octagonal inserts
- Cutter diameter and height



Parts for screw-on type

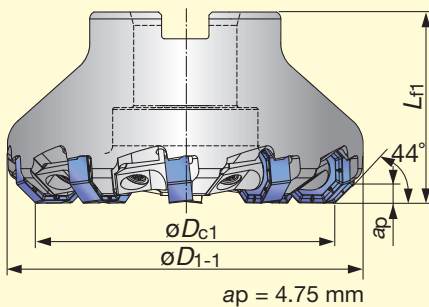
Description		Cat. No.	
Applicable cutter		TAN07R...	TAN07R160M...
Clamping screw		CSPE-5L150	
Wrench	Torx bit	BLD IP20/S7	BLD IP20/M7
	Grip	H-TB	H-TB
Mono block type substitution wrench		IP-20T	

Cat. No.	Dimensions (mm)						
	$\varnothing D_{C3}$	$\varnothing D_{1-3}$	$\varnothing D_{C4}$	$\varnothing D_{2-4}$	$\varnothing D_{1-4}$	L_{f3}	L_{f4}
TAN07R063M***	63.5	76	55.7	67.2	76.4	41	41.4
TAN07R080M***	80.5	93	72.7	84.2	93.4	51	51.4
TAN07R100M***	100.5	113	92.7	104.2	113.4	51	51.4
TAN07R125M***	125.5	138	117.7	129.2	138.4	64	64.4
TAN07R160M***	160.5	173	152.7	164.2	173.4	64	64.4
TAN07R200M***	200.5	213	192.7	204.2	213.4	64	64.4
TAN07R250M***	250.5	263	242.7	252.2	263.4	64	64.4
TAN07R315M***	315.5	328	307.7	319.2	328.4	64	64.4

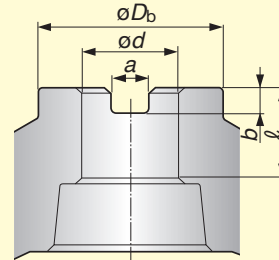
Wedge type

DOOCTO

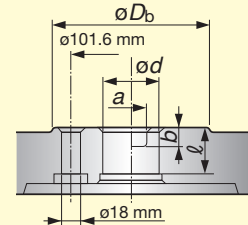
Double-sided octagonal inserts



Arbor Type B

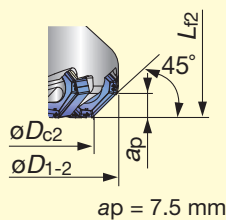


Arbor Type C



DOQUAD

Double-sided square inserts



Parts for wedge type

Description		Cat. No.	
Applicable cutter		TAN07R...W	
Clamping screw		DS-6P	
Wedge		CL ARM-10-TUNG1	
Wrench	Torx bit	BLD IP15/S7	
	Grip	H-TBS	

Cat. No.	Stock	No. of Inserts	Dimensions (mm)											Weight (kg)	Air hole	Arbor type
			$\varnothing D_{C1}$	$\varnothing D_{C2}$	$\varnothing D_{C1-1}$	$\varnothing D_{C1-2}$	$\varnothing D_b$	$\varnothing d$	ℓ	L_{f1}	L_{f2}	b	a			
TAN07R063M22.0E08W	●	8	63	60.3	76	76.3	41	22	20	40	41.4	6.3	10.4	0.6	without	B
TAN07R080M25.4-10W	●	10	80	77.3	93	93.3	50	25.4	26	50	51.4	6	9.5	1	without	B
TAN07R080M27.0E10W	●	10	80	77.3	93	93.3	50	27	25	50	51.4	7	12.4	1.1	without	B
TAN07R100M31.7-14W	●	14	100	97.3	113	113.3	60	31.75	32	50	51.4	8	12.7	1.3	without	B
TAN07R100M32.0E14W	●	14	100	97.3	113	113.3	60	32	28.5	50	51.4	8	14.4	1.6	without	B
TAN07R125M38.1-18W	●	18	125	122.3	138	138.3	80	38.1	38	63	64.4	10	15.9	2.8	without	B
TAN07R125M40.0E18W	●	18	125	122.3	138	138.3	71	40	29	63	64.4	9	16.4	2.5	without	B
TAN07R160M40.0E22W	●	22	160	157.3	173	173.3	100	40	29	63	64.4	9	16.4	3.6	without	C
TAN07R160M50.8-22W	●	22	160	157.3	173	173.3	100	50.8	38	63	64.4	11	19	4	without	B
TAN07R200M60.0E28W	●	28	200	197.3	213	213.3	135	60	39	63	64.4	14	25.7	5.8	without	C

● : Stocked items

Standard cutting conditions

Double-sided inserts

ISO	Workpiece material	Hardness	Priority	Recommendation		Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
				Grade	Chipbreaker		
P	Low carbon steel S15C, SS400, etc. C15E, etc.	- 200 HB	First choice	AH3135	ML	100 - 300	0.2 - 0.5
		- 200 HB	For wear resistance	AH725	ML	100 - 300	0.2 - 0.5
		- 200 HB	For fracture resistance	AH140	MJ	80 - 180	0.2 - 0.5
	High carbon steel S45C, S55C, etc. C45E, C55E, etc.	200 - 300 HB	First choice	AH3135	MJ	100 - 230	0.2 - 0.4
		200 - 300 HB	For wear resistance	AH725	MJ	100 - 230	0.2 - 0.4
		200 - 300 HB	For fracture resistance	AH140	MJ	80 - 180	0.2 - 0.4
	Alloy steel SCM440, SCr415, etc. 42CrMo4, 17Cr3, etc.	150 - 330 HB	First choice	AH3135	MJ	100 - 200	0.2 - 0.4
		150 - 330 HB	For wear resistance	AH725	MJ	100 - 200	0.2 - 0.4
		150 - 330 HB	For fracture resistance	AH140	MJ	80 - 150	0.2 - 0.4
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	- 200 HB	First choice	AH3135	ML	100 - 150	0.1 - 0.3
		- 200 HB	For fracture resistance	AH130	ML	80 - 120	0.1 - 0.3
K	Grey cast iron FC350, FC450 etc. GG35, GG45, etc.	150 - 250 HB	First choice	AH120	ML	100 - 250	0.1 - 0.5
		150 - 250 HB	For fracture resistance	AH725	MJ	100 - 250	0.1 - 0.5
		150 - 250 HB	For wear resistance	T1115	MJ	150 - 300	0.1 - 0.5
	Ductile cast iron FCD600, etc. GGG60, etc.	150 - 300HB	First choice	AH120	ML	80 - 200	0.1 - 0.4
		150 - 300 HB	For fracture resistance	AH725	MJ	80 - 200	0.1 - 0.4
		150 - 300 HB	For wear resistance	T1115	MJ	100 - 250	0.1 - 0.4
H	Hardened steel	HRC 40 - 50	First choice	AH3135	MJ	80 - 130	0.1 - 0.2
		HRC 40 - 50	For fracture resistance	AH140	MJ	80 - 130	0.1 - 0.2
		HRC 50 - 60	First choice	AH3135	MJ	50 - 70	0.05 - 0.1
		HRC 50 - 60	For fracture resistance	AH140	MJ	50 - 70	0.05 - 0.1

Single-sided inserts

ISO	Workpiece material	Hardness	Priority	Grade	Cutting speed Vc (m/min)	Feed per tooth: fz (mm/t)	
						ML	HJ*
P	Low carbon steel S15C, SS400, etc. C15E, etc.	- 200	First choice	AH3135	100 - 300	0.1 - 0.5	0.5 - 2.0
		- 200	For fracture resistance	AH130	100 - 300	0.1 - 0.5	-
	High carbon steel S45C, S55C, etc. C45E, C55E, etc.	200 - 300 HB	First choice	AH3135	100 - 230	0.1 - 0.4	0.5 - 1.5
		200 - 300 HB	For fracture resistance	AH130	100 - 230	0.1 - 0.4	-
	Alloy steel SCM440, SCr415, etc. 42CrMo4, 17Cr3, etc.	150 - 330 HB	First choice	AH3135	100 - 200	0.1 - 0.4	0.5 - 1.5
		150 - 330 HB	For fracture resistance	AH130	100 - 200	0.1 - 0.4	-
M	Stainless steel SUS304, etc. X5CrNi18-9, etc.	- 200 HB	First choice	AH3135	100 - 150	0.1 - 0.3	0.3 - 0.7
		- 200 HB	For fracture resistance	AH130	100 - 150	0.1 - 0.3	-
K	Grey cast iron FC350, FC450 etc. GG35, GG45, etc.	150 - 250 HB	First choice	AH3135	100 - 250	0.1 - 0.5	0.5 - 2.0
		150 - 250 HB	For fracture resistance	AH130	100 - 250	0.1 - 0.5	-
	Ductile cast iron FCD600, etc. GGG60, etc.	150 - 250 HB	First choice	AH3135	80 - 200	0.1 - 0.4	0.5 - 1.5
		150 - 250 HB	For fracture resistance	AH130	80 - 200	0.1 - 0.4	-
S	Titanium alloy Ti-6Al-4V, etc.	- HRC 40	First choice	AH3135	30 - 60	0.1 - 0.3	0.3 - 0.7
		- HRC 40	For fracture resistance	AH130	30 - 60	0.1 - 0.3	-
	Heat resistant alloy Inconel	- HRC 40	First choice	AH3135	10 - 40	0.05 - 0.15	0.1 - 0.3
		- HRC 40	For fracture resistance	AH130	10 - 40	0.05 - 0.15	-
H	Hardened steel	HRC 40 - 50	First choice	AH3135	80 - 130	-	0.1 - 0.3
		HRC 50 - 60	First choice	AH3135	50 - 70	-	0.03 - 0.07

* Apply 20% of recommended feed when using HJ insert with ap over 1.5 mm.

Practical examples

Workpiece type		Cylinder block	Crank shaft
Cutter		TAN07R160M50.8-15 ($\phi 160$ mm, $z = 15$)	TAN07R100M31.7-07
Insert		ONHU0705ANTN-ML	ONMU0705ANPN-ML
Grade		AH120	AH3135
Workpiece material		FC250 / GG25	SCM435 / 34CrMo4
Cutting conditions	Cutting speed: V_c (m/min)	180	80
	Feed per tooth: f_z (mm/t)	0.18 → 0.2	0.18
	Feed speed: V_f (mm/min)	780 → 1080	320
	Depth of cut: a_p (mm)	3	3
	Cutting width: a_e (mm)	100	75
	Method of machining	Face milling	Face milling
	Coolant	Dry	Wet
	Machine	Vertical M/C, BT50	Specialized machine
Results			
Workpiece type		Elbow	Mold base
Cutter		TAN07R200M47.6-12	TAN07R125M40.0E08
Insert		OWMT0807AAER-ML	OWMT0807ZNER-HJ
Grade		AH3135	AH3135
Workpiece material		SCS10 / 25Cr5NiMoN	SS400
Cutting conditions	Cutting speed: V_c (m/min)	70	200
	Feed per tooth: f_z (mm/t)	0.2	1.5
	Feed speed: V_f (mm/min)	267	6100
	Depth of cut: a_p (mm)	1	1
	Cutting width: a_e (mm)	180	110
	Method of machining	Face milling	Face milling
	Coolant	Wet	Dry
	Machine	Horizontal M/C, BT50	Vertical M/C, BT50
Results			

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