

we improve...
we evolve...
we **ADD**



Tungalooy Accelerated Lines - Leading in Innovation



www.tungalooy.com



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.

Find all product details in Tungaloy's updated e-catalog.



E-Catalog

Find tools and download CAD drawings and 3D models
www.tungaloy.com/ecatalog



TungNavi

Tungaloy Tool Advisor
www.tungaloy.com/tungnavi



Turning Insert Selector

Tungaloy's first recommendations for Turning operations
www.tungaloy.com/insertguide



High-Feed Milling Guide

Tungaloy selection guide for high-feed milling tools
www.tungaloy.com/highfeed



MATRIX

Tool management system
www.tungaloy.com/matrix



06

GRADES

Superior CVD & PVD Grades
CBN Innovations



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GROOVING

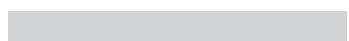
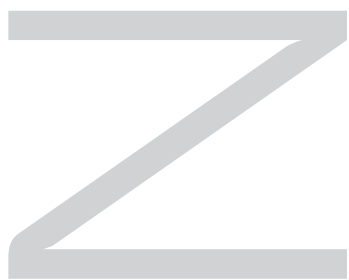
AddForceCut
AddInternalCut
TetraForce-Cut 38
TungFeed-Blade



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TURNING

AddMultiTurn
AddY-axisTurn
TungTurn-Jet
ISO-EcoTurn
BoreMeister
ModuMiniTurn
TinyMini-Turn



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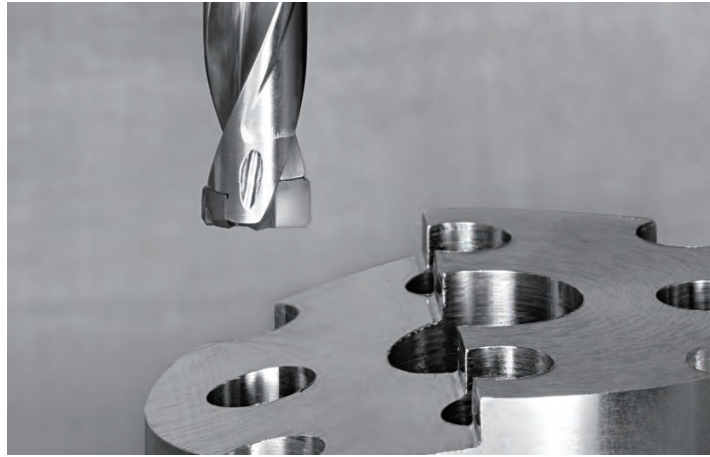
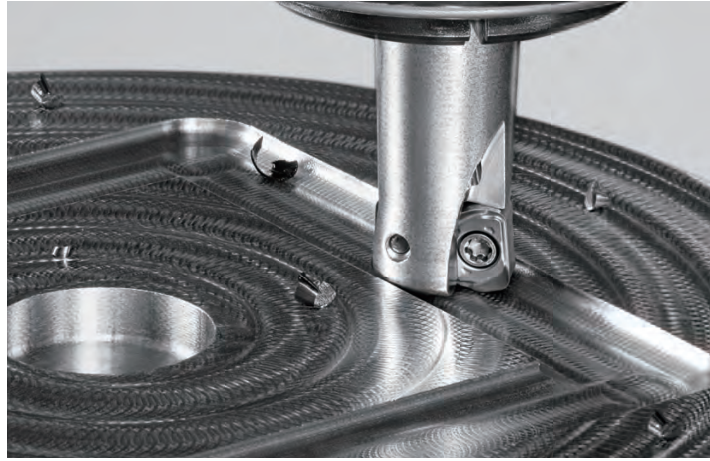
MILLING

AddDoFeed

DoFeedTri

Tung-Tri 04

TungMeister



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DRILLING

DrillMeister

AddMeisterDrill

Solid4FlutesDrill



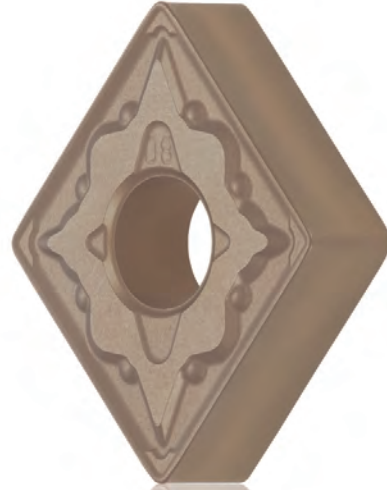
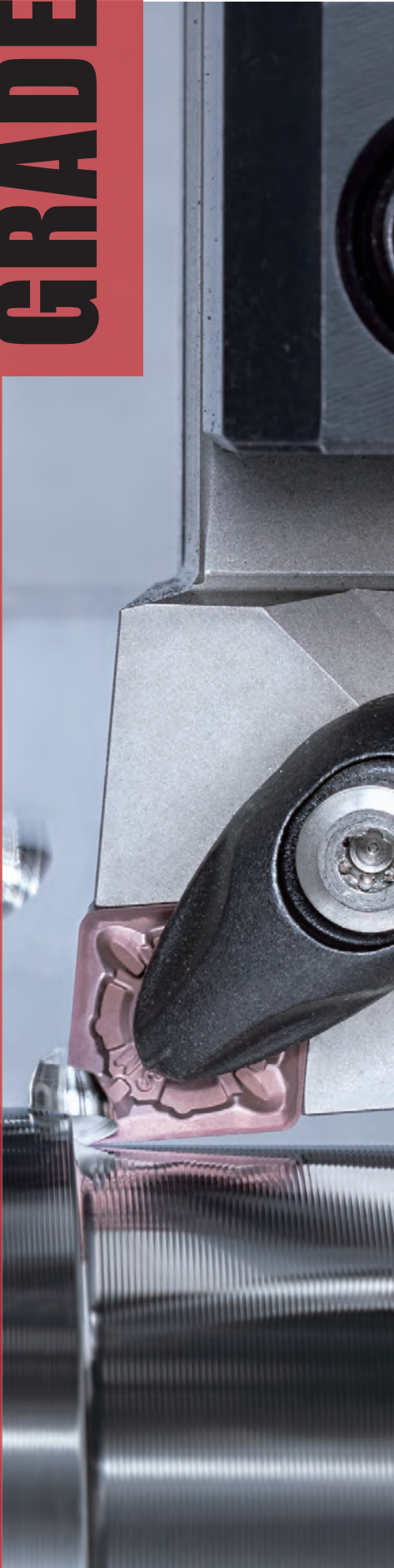
48

MATRIX

The first step to
your cost reduction



SUPERIOR CVD & PVD GRADES

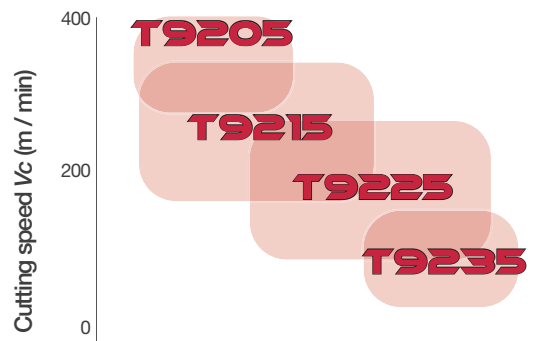


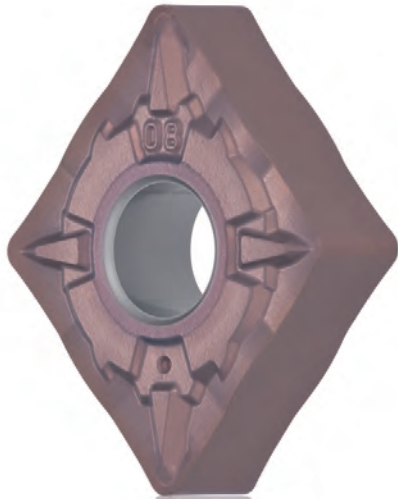
T9200 **P** **M** **K**

CVD grades with outstanding productivity, especially for steel turning

Nearly unbreakable CVD series for improved machining efficiency

APPLICATION AREA **P**





T6200 AH6200 **M**

Highly reliable CVD & PVD grades for stainless steel turning

Complete grade line up for stainless steel turning

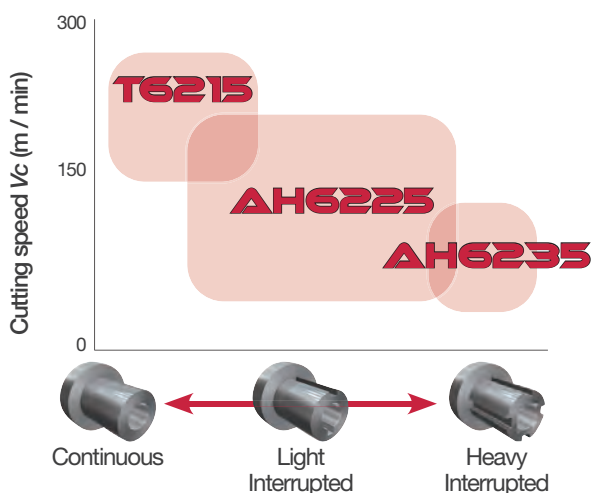


T500 **K**

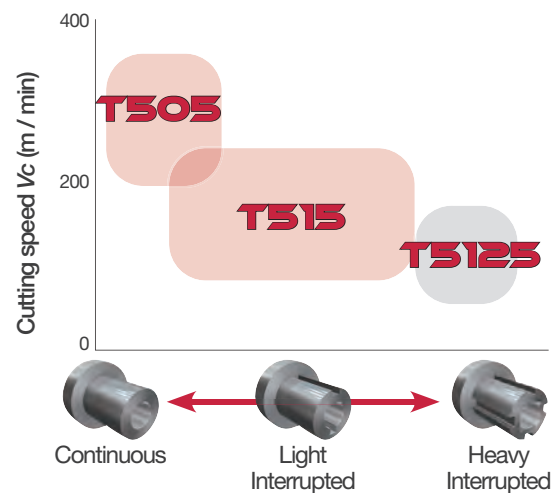
Most optimal CVD grades for high speed machining of cast iron

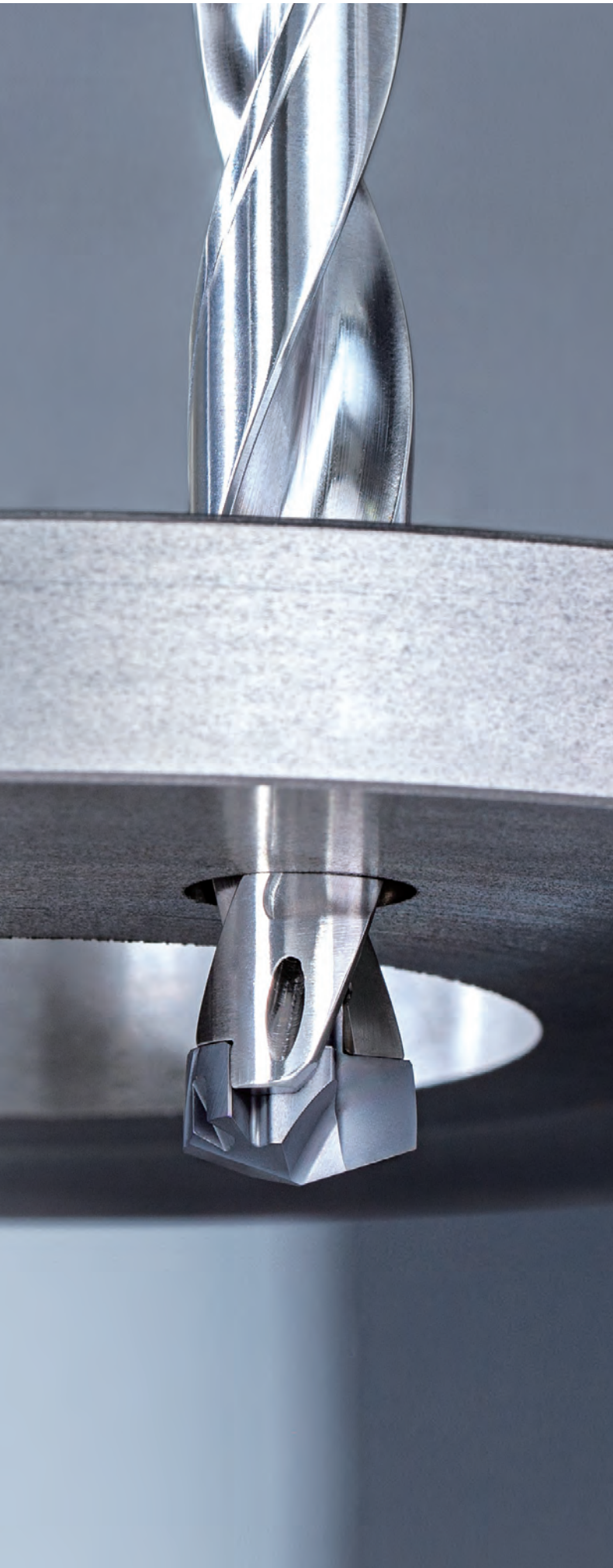
The thickest coating layer of all Tungaloy's CVD grades ever

APPLICATION AREA **M**



APPLICATION AREA **K**





DMC drilling head for DrillMeister

AH9130

The latest PVD grade developed specifically for hole making applications

A good combination of wear and fracture resistance enhances the grade's tool life and wear prediction.

APPLICATION AREA

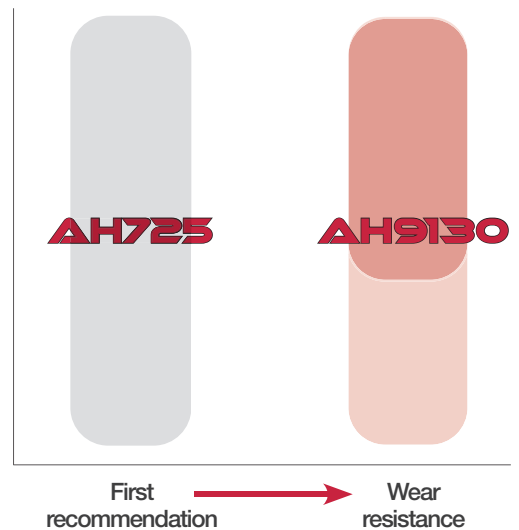
P

M

K

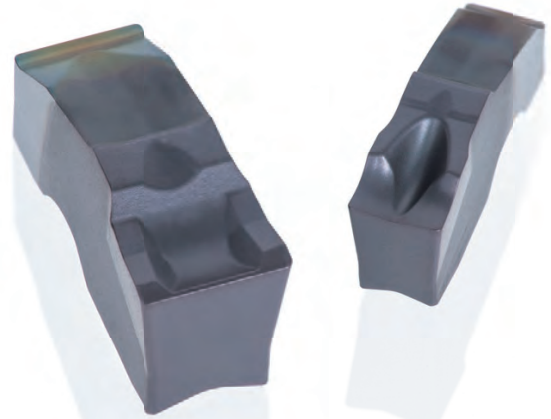
S

H





LNMU insert for AddDoFeed



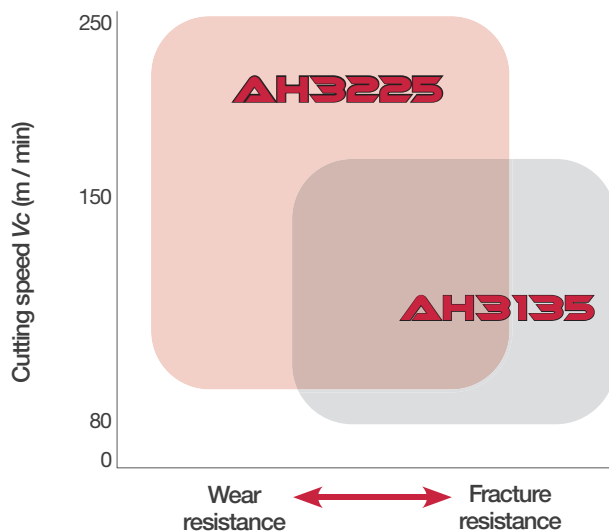
QGM / QGS inserts for AddForceCut

AH3225 P M

A highly reliable grade for milling operations

Eliminates coating delamination and micro edge-chipping while impeding the progression of normal flank wear, providing long and predictable tool life in steel milling operations.

APPLICATION AREA



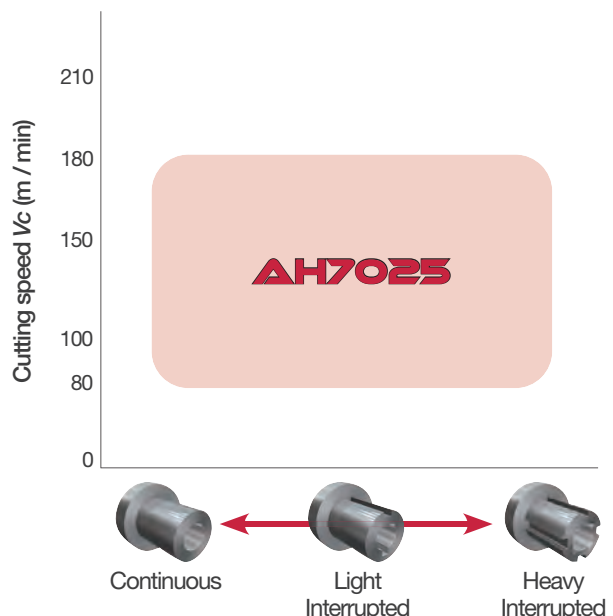
AH7025 P M

K S

Dedicated grade for grooving applications featuring a good balance of wear and chipping resistance.

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

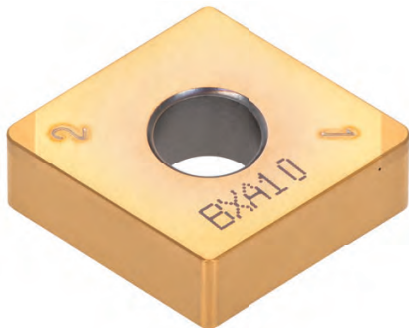
APPLICATION AREA



LATEST CBN INNOVATIONS

BXA20

Wavy Joint



BXA10

Coated CBN grade for hardened steel

Incredible reliability in hardened steel turning. First choice for continuous to light interrupted cuts.

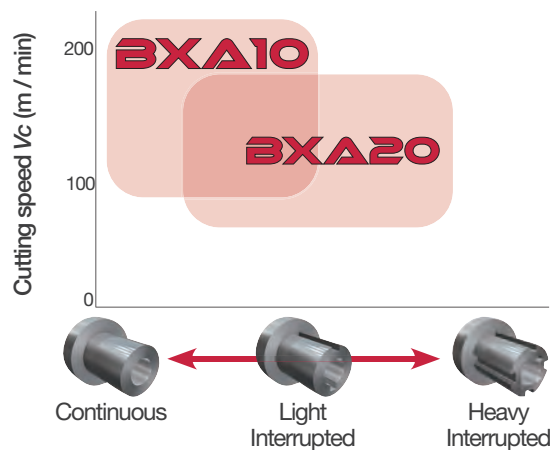


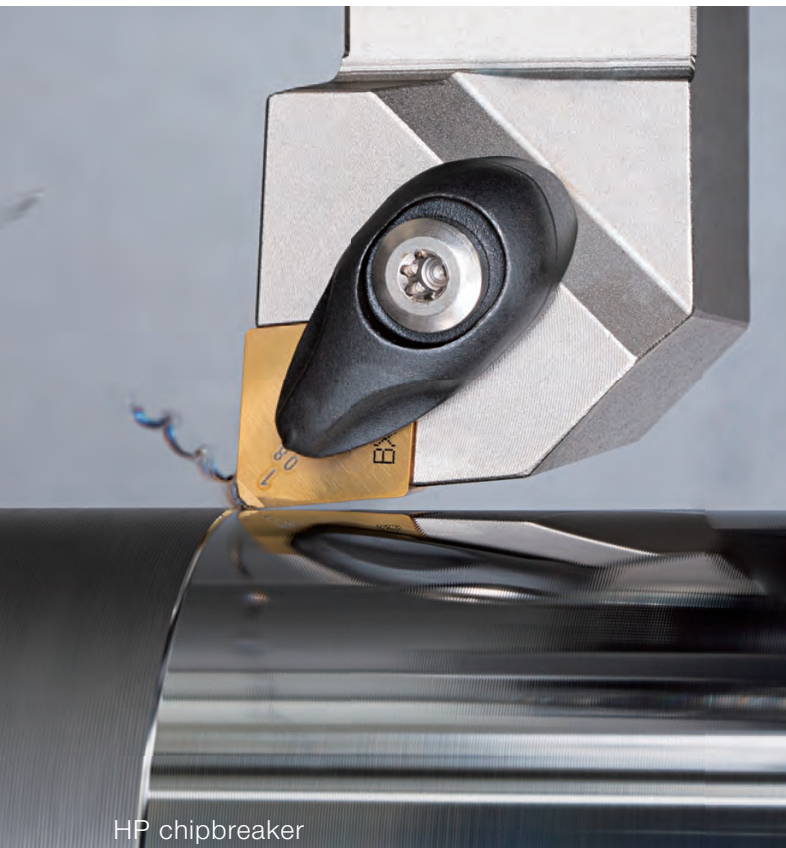
BXA20

Coated CBN grade for hardened steel

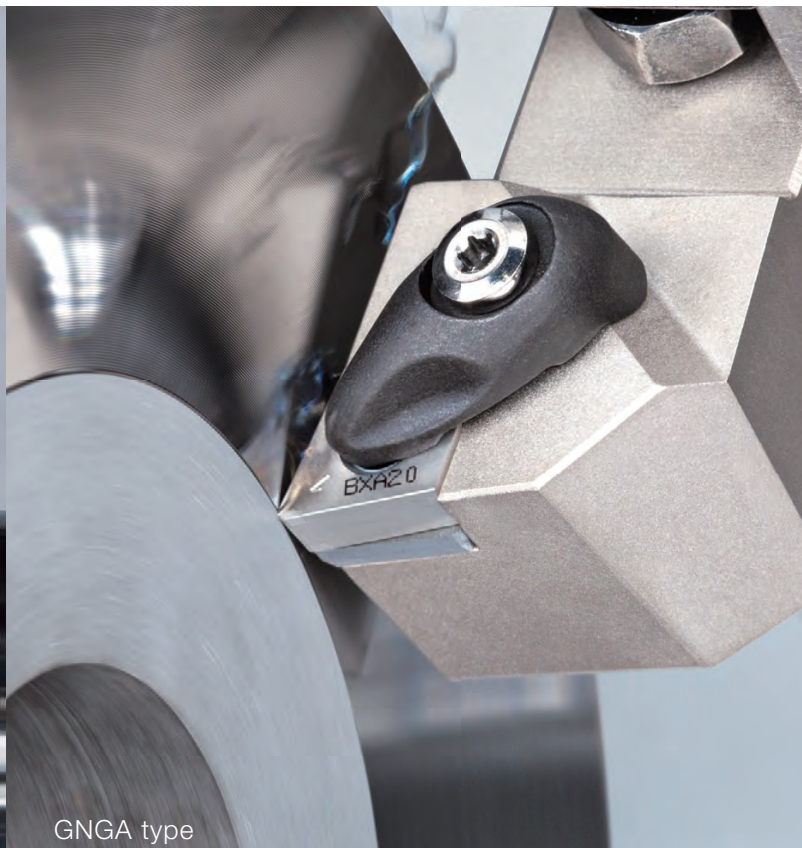
Incredible reliability in hardened steel turning. Covers a wide range of application areas from continuous to heavy interrupted cutting.

APPLICATION AREA **H**





HP chipbreaker



GNGA type

Unique Solutions



GNGA / FNGA YNGA type

For smooth chip evacuation

Cutting edge angle is designed to ensure easy cutting with low cutting forces.



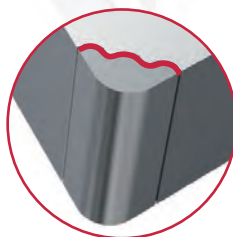
Large clearance reduces cutting force and edge wear, allowing smooth chip flow and scratch prevention on machined surface.



WAVYJOINT

For large depth of cut in hard turning up to 0.8 mm

The unique "wavy" contact surface enhances the brazing strength thus improves productivity with 1.6 times higher depth-of-cut compared to the conventional type.



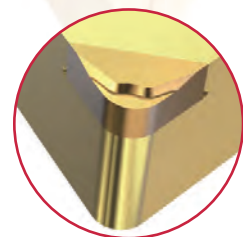
CBN Tip Size: 200% larger for reducing the temperature at the cutting zone
Brazing Area: 160% increase for enhanced brazing strength



HP chipbreaker

For chatter prevention and the finest machined surfaces

Suitable for turning operation of hardened steel materials.



The **HP chipbreaker** provides excellent surface quality and good chip control.

ADDFORCE CUT

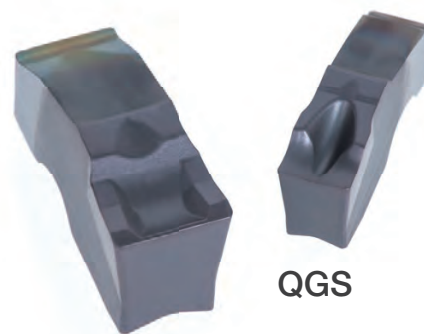
Newly designed insert profile ensures unobstructed chip flow and consistent chip evacuation.

The insert is locked in three positions with the use of an insert stopper in the pocket. This design provides extremely rigid insert clamping.

QGM and **QGS** inserts

CW = 2, 3, 4, and 5 mm

Max. grooving depths (for monoblock shanks): **CDX** = 33 mm



QGS

QGM





SUPERB STABILITY AND PRODUCTIVITY IN DEEP GROOVING AND PARTING-OFF OPERATIONS

ADD *Highly rigid self-clamping system improves productivity for deep grooving and parting-off operations*

video



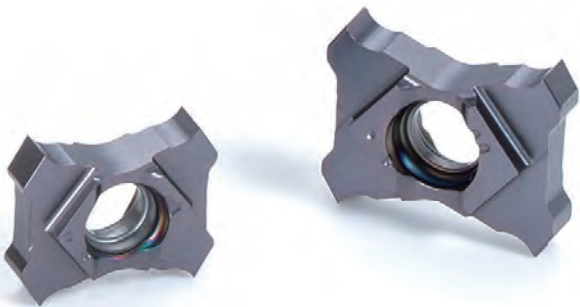
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For more information

UNIQUE 4-EDGED INSERT FOR SMALL INTERNAL GROOVING OPERATIONS

ADD stability and repeatability in small internal grooving operations with the unique insert clamping system



TCIG10... and **TCIG12...**

CW = 1.5, 2, 2.5, and 3 mm

Max. insert cutting depth:

CDX = 3 mm

Min grooving dia:

DMIN = \varnothing 10.5 mm



The logo for ADDICUT INTERNAL. 'ADD' is in a bold, yellow-to-orange gradient font. 'ICUT' is in a bold, black font. 'INTERNAL' is written in a smaller, red, sans-serif font above the 'I' and 'C' of 'ICUT'.

The innovative clamping system eliminates insert movement caused by cutting forces.

Through-coolant holder delivers coolant from the outlet located near the insert, promoting effective chip evacuation from the cutting area.

Neutral designed insert can be mounted on either right- or left-handed holder.

video



e-catalog



For more information



BIGGER SIZE FOR BIGGER CHALLENGES

ADD deeper and accurate grooves
to your machining operations

TETRA^{FORCE}CUT



New TCL38 insert capable of up to 10 mm groove depth, making it an effective tool for cutting off thick-walled tubes, as well as precision grooving operations.

Unique insert seat design ensures secure insert clamping, providing excellent indexing accuracy and repeatability.

Neutral design insert can be mounted on either right- or left-handed holder.

Insert clamping screw can be operated from either side of the holder, significantly reducing tool change time.

Through-coolant toolholders are also available for improved chip evacuation, promoting long tool life and superior part quality.

TCL38 inserts

CW = 1.5 - 4 mm

Max. insert cutting depth:

CDX = 10 mm

Max. parting diameters:

CUTDIA = \varnothing 20 mm

video



e-catalog



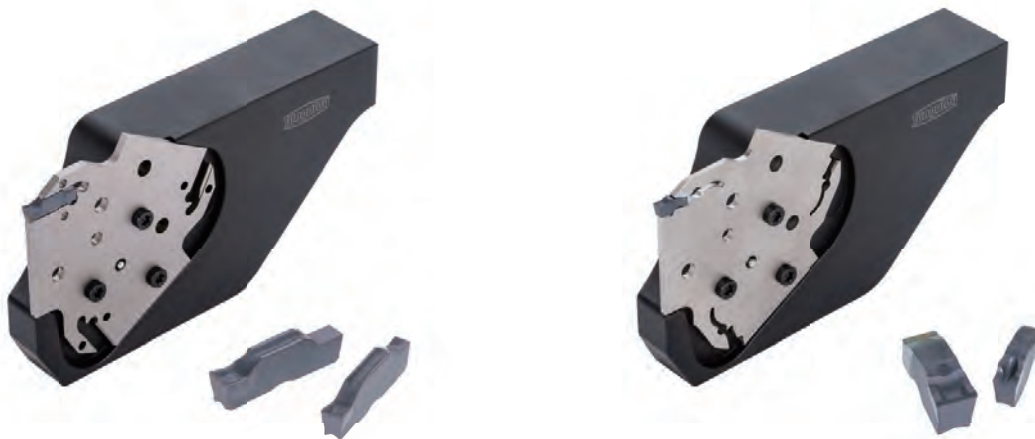
For more information

EXTREMELY RIGID POCKET DESIGN FOR THE MOST DEMANDING CUTTING CONDITIONS

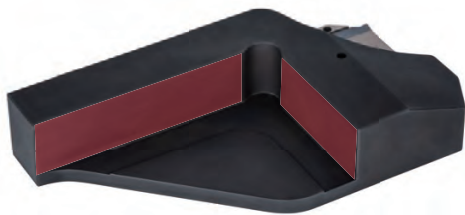
ADD speed and feed to
your grooving and
parting-off operations

TUNG^{FEED}BLADE

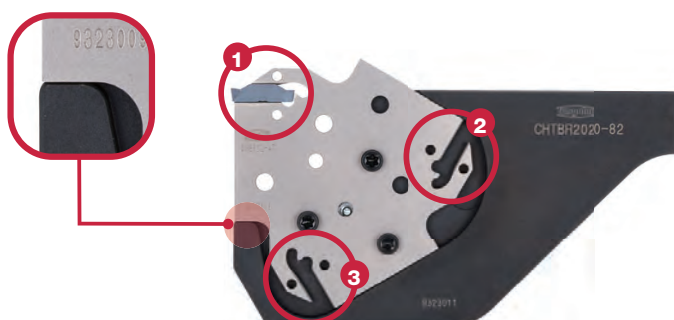
Strong holder design ensures tool stability and productivity gains during demanding cutting conditions.



Specially designed tool block has two contact faces to provide enhanced tool rigidity.



The blade provides reduced tooling cost with three insert pockets, while its strong backing beneath the insert withstands heavy cutting loads during machining.



The blades for TungCut series and the blades for the latest **AddForceCut** can share the same tool block.

The blade for TungCut inserts also ensures strong insert clamping, providing high tool reliability.

The latest **AddForceCut** blades that use a single-ended insert improves parting/cutting-off operations at increased feed rates.

Available inserts: **DGM, DGS, SGM, SGS, DGL, QGM, and QGS**

Max. parting diameters:
CUTDIA = \varnothing 52, \varnothing 82, and \varnothing 120 mm

video



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For more information

ADD^{ULTI}TURN



THE ULTIMATE TOOL FOR MULTIPLICITY

ADD Front Turning, Back Turning, Profiling, and Face Turning, with **ONE SINGLE TOOL**



6C-TOMG 80° negative insert 6 cutting edges

Unique concave-convex shape on the bottom of the insert provides outstanding clamping rigidity and securely locks the insert in place ensuring tool reliability when turning in any direction.

Cutting edge with a low approach angle allows high feed machining.

Also effective for removing burrs.

The positive triangular insert features 86° nose angle for enhanced cutting edge robustness.

The positive triangular insert has integrated wipers, which provide high surface finish quality at significantly increased feed rate.

Two types of double-sided negative inserts are available with 80° or 35° nose angles.

AddMultiTurn can combine multiple processes in a single operation, maximizing machine utilization and productivity.



6V-TOMG 35° negative insert 6 cutting edges



3C-TCMT 86° positive insert 3 cutting edges

ADDY^{AXIS}TURN

LEADING IN A NEW DIRECTION

ADD a turning point to increase your productivity

By using the Y-axis instead of the conventional X-axis the tool can direct the cutting force in the longitudinal axis of the holder, the strongest part of the tool. This provides more security during the cutting process.

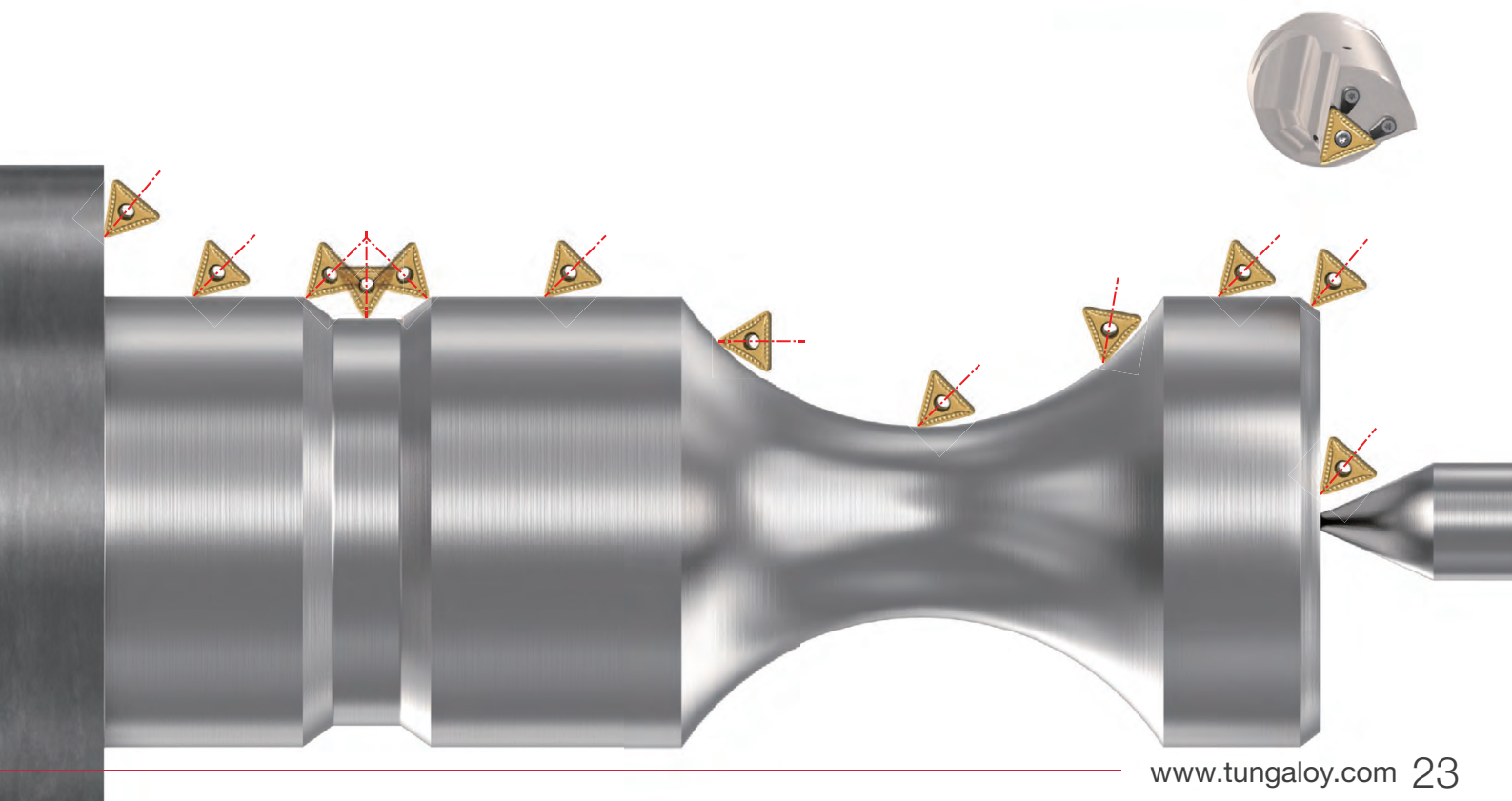
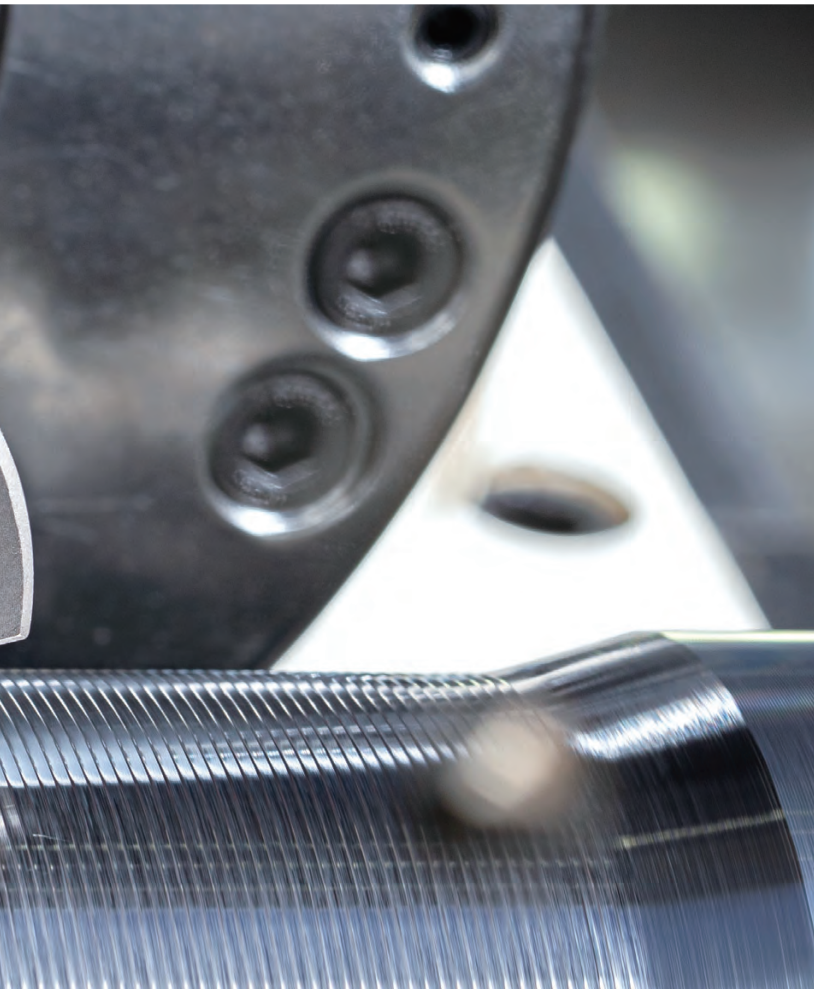
With unique concave-convex shape on the bottom of the insert, the insert is securely locked in place, ensuring tool reliability when performing turning in any direction.

By simply rotating the tool along the axis, the cutting edge angle can be set to an optimum angle that enables the most effective entry into the cut.

The same tool can be used when turning either from the end of the part towards the chuck or turning away from the chuck to the end of the part.

TCMT 35° positive insert 3 cutting edges

AddY-axisTurn
combines multiple processes into a single operation, providing reduced tool inventory and costs.





HIGH PRESSURE COOLANT SYSTEM

ADD productivity,
including turning of exotic materials

TUNG^{URN}TJET

Maximize your productivity with a wide range of high pressure coolant tools for each application

*General Turning - TungCap - Modular Tools
Grooving Tools - Threading Tools - Miniature Tools*



Two streams of coolant jets are directed to the rake and clearance surfaces of the cutting point, significantly increasing productivity.

Helps prevent crater wear from developing on the insert rake surface during high speed machining.

Provides effective chip breaking in high temperature alloys with chip control difficulty.

Provides extended tool life in stainless steel and high temperature alloys.

Also available in through-coolant toolholder system for Swiss machine applications that requires no coolant hose connection. Improves tool setup and machine downtime.

The top coolant nozzle can be adjusted for optimum coolant direction close to the cutting point.

video



e-catalog



For more information

ISO **E^{CO}**TURN

**SMALL-SIZED
INSERTS, IDENTICAL
MACHINING
PERFORMANCE**

ADD *cost-efficiency and effectiveness to
your turning operations*

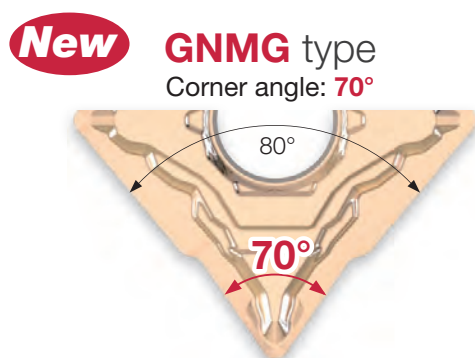
Available in the most common geometries, chipbreakers and innovative Tungaloy grades

Equal machining performance for d.o.c. of up to 3 mm when compared with regular sized ISO inserts.

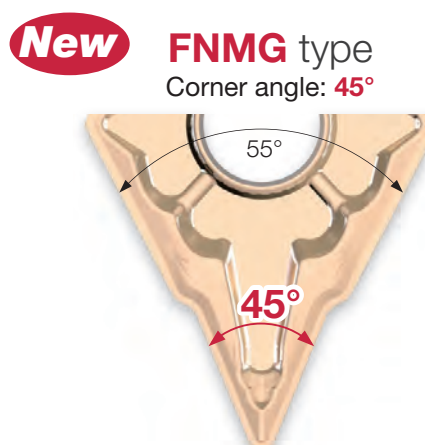
ISO-EcoTurn inserts have an identical thickness as regular sized ISO inserts of the same size, providing equivalent fracture resistance.

GNMG with nose angles of 70° and FNMG inserts with 45° are now available, making **ISO-EcoTurn** a more flexible solution in a wide range of turning applications.

Suitable for general OD turning, facing, profiling, and ID turning applications.



GNMG0904 insert with 70° corners: good alternative to CNMG with 80° corners



FNMG1104 insert with 45° corners: good alternative to DNMG with 55° corners

ISO-EcoTurn Cartridges, an innovative system for use of ISO-EcoTurn inserts in standard ISO holders



video

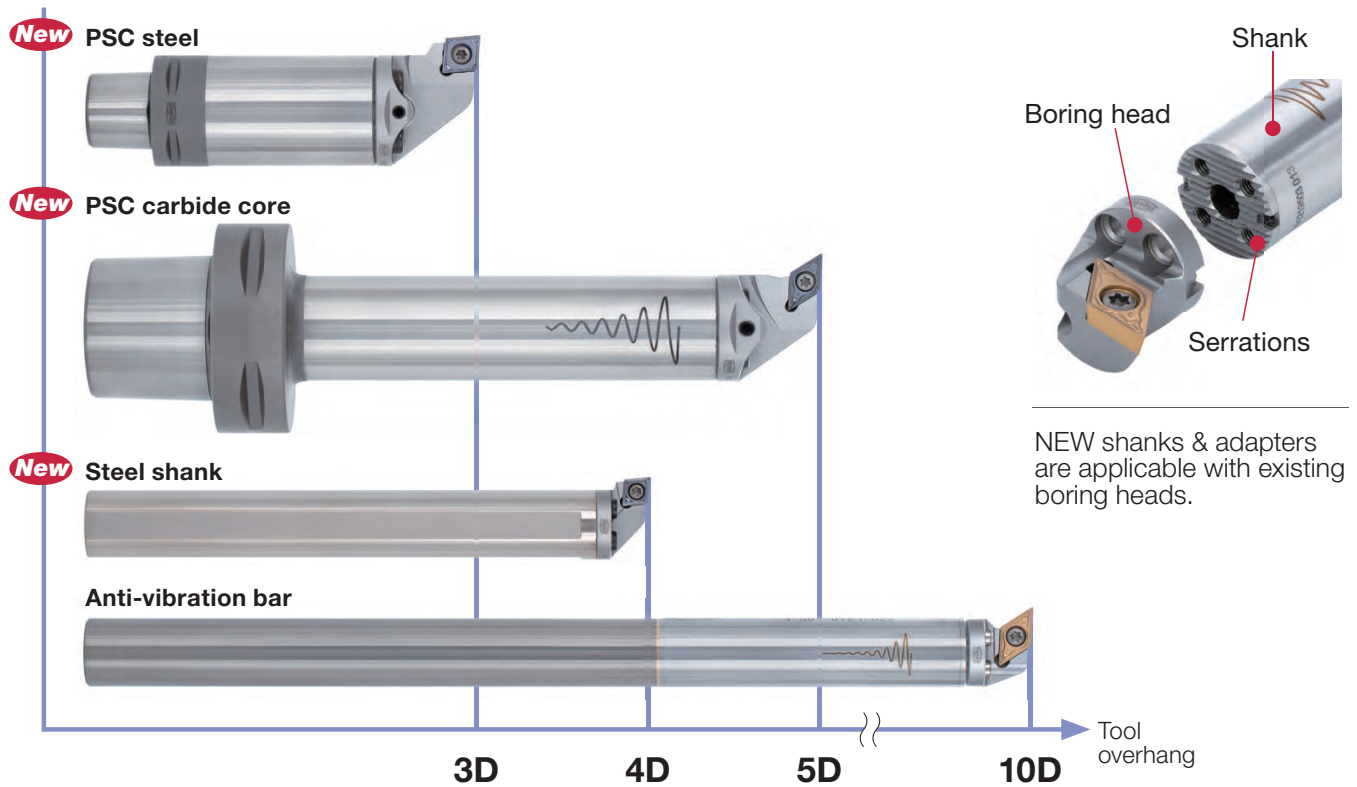
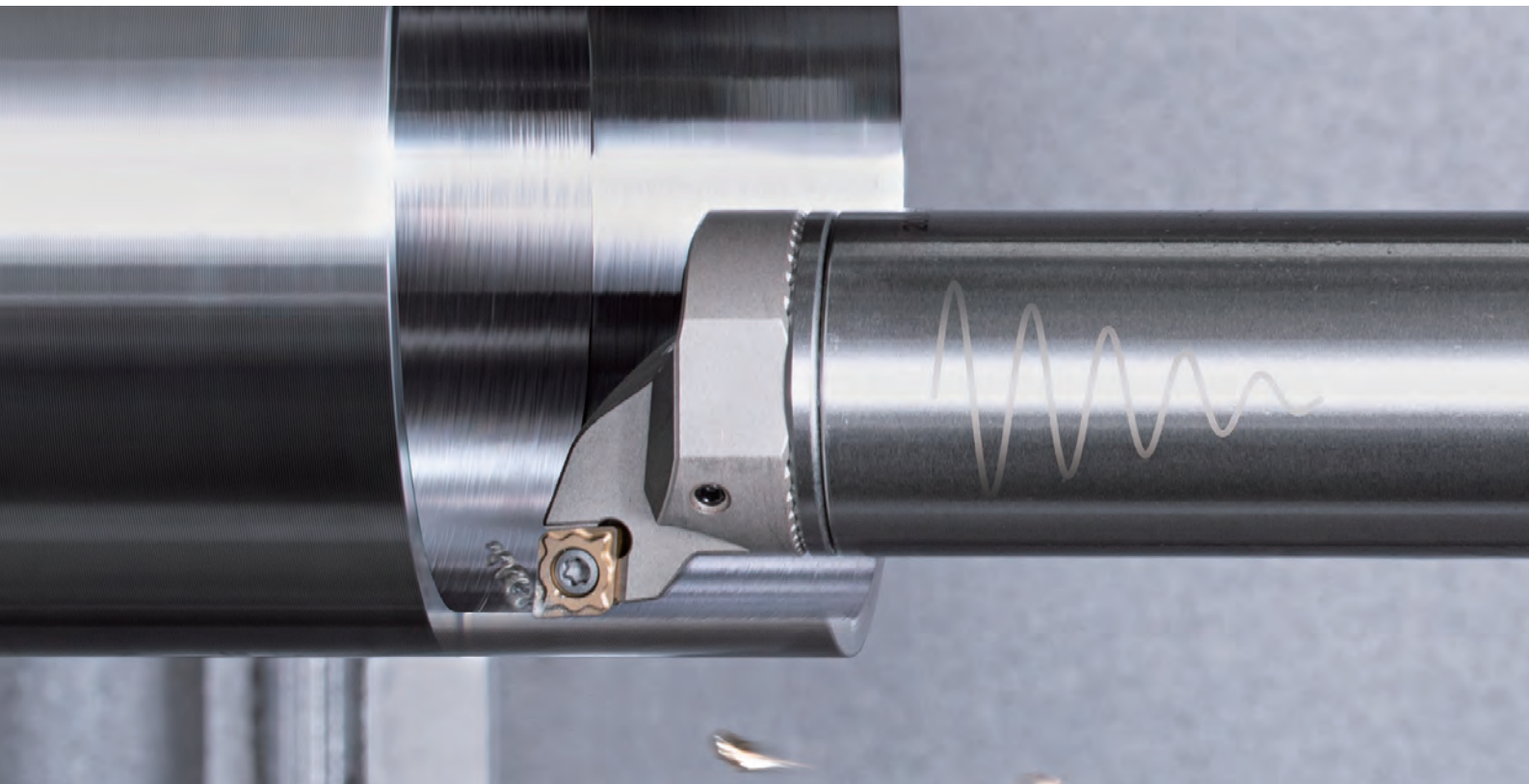


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For more information

BOREMEISTER



VIBRATION-FREE SOLUTION FOR DEEP HOLE BORING

ADD *stability and precision*

Ultimate solution to conquer tool overhang challenges, chattering, noise and short tool life of up to 10xD.

Exchangeable head boring tool system with serrated interfaces for high precision and high rigidity indexing.

Through-coolant capability allows smooth chip evacuation in deep boring operations of up to 10xD.

PSC holders are also available, allowing coupling with a range of machine tools.

Dedicated setting device allows quick and accurate center height settings of the boring bar.

A wide range of boring heads are available, providing high parts quality in various boring operations



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For more information

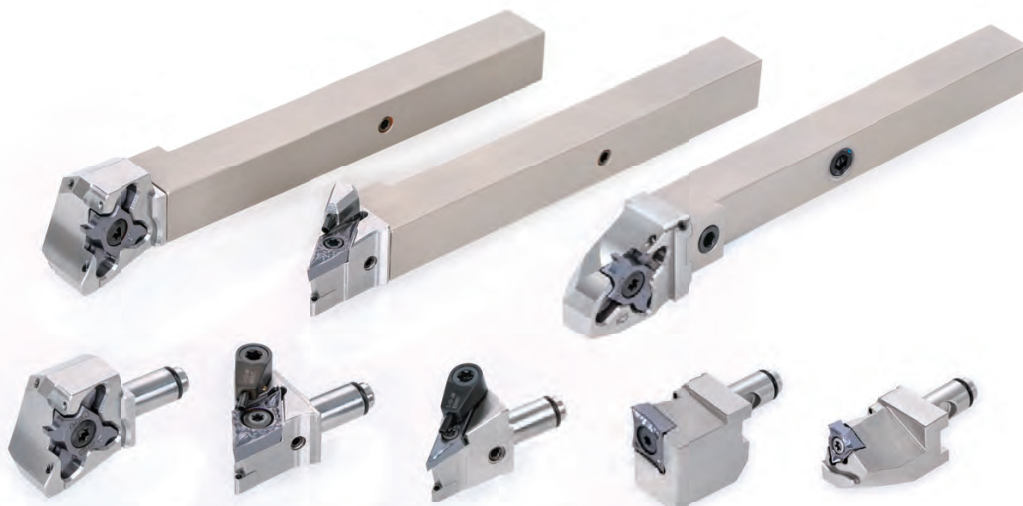
A detailed close-up photograph of a turning operation on a Swiss machine. The image shows a complex, multi-axis modular head system in the foreground, which is precisely positioned to machine a rotating workpiece. The workpiece is blurred due to its high speed, creating a sense of motion. The machine's components are made of polished metal, reflecting light and highlighting the intricate details of the tooling and the precision of the manufacturing process. The overall scene conveys a sense of advanced technology and high-speed production.

INNOVATIVE MODULAR HEAD SYSTEM FOR SWISS MACHINES

ADD flexibility and productivity
to your turning operations

MODUM^{INI}TURN

Modularity and productivity with a wide selection of turning, grooving and threading heads



Substantially reduced setup time for maximum machine utilization.

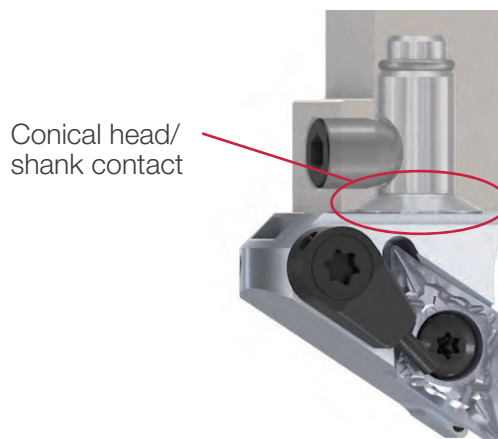
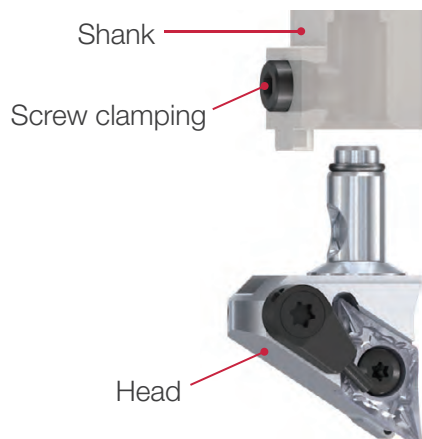
Quick tool change and setup is possible with simple exchanges of turning heads.

Unique coupling method provides stable head-shank connection and secure insert edge position for good repeatability and accuracy.

Positioning accuracy for the same insert: $\pm 5 \mu\text{m}$

ModuMiniTurn offers precision internal coolant delivery, which improves chip control and tool life.

By feeding in the Y-axis direction, downward-facing chipbreaker directs the chip flow down and away from the cutting point.



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For more information

MINIATURE SOLID BORING TOOLS FOR HIGH ACCURACY

ADD efficiency and profitability to your small boring operations as small as $\varnothing 0.6$ mm

Ingenious through-coolant sleeve design optimally directs 4 streams of coolant jets close to the cutting zone, providing long tool life, controlled chips formation and evacuation for better part quality.



TINY^{INI}MTURN

Available with a wide selection of heads for boring, profiling, chamfering, threading and grooving

New **SH725** insert grade provides a good combination of wear and fracture resistance, ensuring long tool life and wear prediction.

Expanded indexable type holders, and inserts with 3D chip breaker for better chip control.

Ideal for machining extremely small diameter bores in a wide range of materials.



e-catalog



For more information



MAXIMUM SPEED AND EFFICIENCY AT MINIMUM SIZE

ADD more feed and speed in small milling operations for higher productivity



ADD^DFEED

*Small diameter high-feed milling cutter
for expanded application coverage,
featuring cutter bodies as small as $\varnothing 8$ mm*

Close pitch cutter design enables high efficiency machining.

Insert clamping screws are optimized to provide correct clamping force, sustaining high feed rates up to 1.2 mm per tooth.

Unique insert design with cutting edge inclination provides gradual workpiece engagement for light cutting action, while guiding chips away from the cutting area. Ideal for slot milling and pocketing applications.

Cutter bodies:

Shank type: **EXN02R...** (Short type)
EXN02RL** (Long type)

DCX = $\varnothing 8$ - $\varnothing 25$ mm

Modular type: **HXN02R...**

DCX = $\varnothing 8$ - $\varnothing 25$ mm



LNMU02-MM

Double-sided,
4-edged insert
APMX = 0.5 mm

video



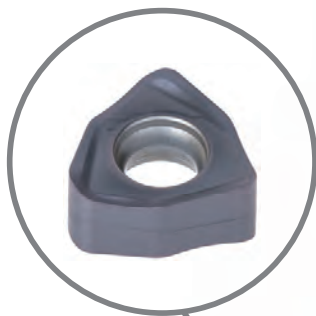
e-catalog



For more information

HIGH PERFORMANCE AND PROFITABILITY IN HIGH-FEED MILLING OPERATIONS

ADD more cutting
edges per insert to your
machining operations



WXMU03-MM

Double-sided,
6-edged insert
APMX = 1 mm



DOF^{FEED}TRI

The cutter features a small entry angle, providing smooth access into the material, making it an ideal tool for long reach setups

Steep ramping capability makes the cutter ideal for pocketing and cavity milling applications.

Large effective cutter diameter leaves less uncut material.

Cutter bodies:

Bore type: **TXWX03** DCX = $\varnothing 40 - \varnothing 50$ mm

Shank type: **EXWX03** DCX = $\varnothing 16 - \varnothing 32$ mm

Modular type: **HXWX03** DCX = $\varnothing 16 - \varnothing 32$ mm

A close-up photograph of a Tungaloy Addforce shoulder mill in operation. The mill is a cylindrical tool with a textured upper section and a polished lower section. It is cutting a metal workpiece, creating a smooth, finished shoulder. The lighting highlights the metallic surfaces and the precision of the machining process.

RIGIDITY AND RELIABILITY FOR SMALL SHOULDER MILLING OPERATIONS

ADD *productivity and
surface quality with
optimized wiper
insert design*



TUNG-TRI

*Small 90° shoulder
milling cutter down to
ø8 mm for maximum
performance*

Close-pitch cutter for high efficiency machining.

The thick core cutter diameter provides increased rigidity.



TOMT04-MM

Single-sided,
3 edged insert
APMX = 3.5 mm
RE = 0.4, 0.8 mm

Cutter bodies:

Shank type: **EPA04R...** (Short type)

DC = ø8 – ø25 mm

EPA04RL** (Long type)

DC = ø10 – ø25 mm

e-catalog



For more information

TUNGMEISTER



MORE THAN 13,000 POSSIBLE COMBINATIONS

ADD *an extensive array of exchangeable milling heads for higher productivity*

Easy and accurate head-holder coupling provides reduced tool change time and high accuracy of cutting point repeatability

Offers milling solutions for square shoulder milling, high feed milling, ball nose milling, chamfering, hole making, and slotting.

A flexible mix of heads and holders allows an optimum tool assembly in all end milling applications.

**VFM**

for face milling
DC = $\varnothing 12 - \varnothing 25$ mm

**VEH**

with long edges
 for efficient square
 shoulder milling
DC = $\varnothing 8 - \varnothing 32$ mm

**VBO & VBN**

with larger radius cutting
 edges for 3D milling on
 5-axis machines
DC = $\varnothing 10 - \varnothing 16$ mm



e-catalog



For more information

DRILLMEISTER

FOR DRILLING EFFICIENCY

ADD higher productivity in
your drilling operations

*Exchangeable head drill
system for superior drilling
performance and long tool life*

Quick drill tip change for reduced machine downtime.

Tool inventory and management costs are significantly reduced as there is no need for regrinding.

Drill bodies are offered in a wide range of sizes and styles, allowing optimal tool assembly for secure and productive drilling.

Drill bodies:

TID-F, Flange type:

Available in 1.5xD, 3xD, 5xD, and 8xD

TID-R, Cylindrical shank type:

Available in 3.5xD, 6xD, 8xD, and 12xD

TIDC:

Available in 3xD and 5xD suitable for use with TIDCF chamfer holders.

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



The right geometry for the right operation



DMP

Drill dia.:
ø6 - ø25.9 mm

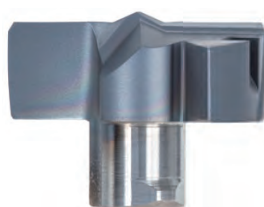
General purpose drilling head ideal for various drilling applications



DMC

Drill dia.:
ø6 - ø25.9 mm

High precision drilling head with double-margined drill periphery and self-centering chisel edge



DMF

Drill dia.:
ø6 - ø25.9 mm

180° flat edges for counterboring and flat bottoms



DMH

Drill dia.:
ø10 - ø19.5 mm

General purpose head with enhanced cutting edge



DMN

Drill dia.:
ø10 - ø19.5 mm

Drill head with sharp edges for non-ferrous materials


video



e-catalog



For more information



Through-coolant capability allows superior chip evacuation and long and predictable tool life.

WORLD'S SMALLEST EXCHANGEABLE DRILL HEADS SERIES

ADD superb performance
in small drilling operations



ADD M DRILL EISTER

Provides even better hole tolerances than solid drills

Drill bodies:

TID-R, Cylindrical shank type:
Available in 3xD and 5xD



DMP

Drill dia.:
ø4 - ø5.9 mm

General purpose drilling head ideal for various drilling applications



DMC

Drill dia.:
ø4 - ø5.9 mm

High precision drilling head with self-centering chisel edge



The tiny drill head is supplied in a dedicated user-friendly key, enabling easy and secure mounting with no setup time



4-FLUTE SOLID DRILLS FOR EXCEPTIONAL PERFORMANCE

ADD 4 cutting edges for
*highly productive drilling
and longer tool life*

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Self-centering chisel tip provides secure drill engagement.

Optimal cutting edge and flute profiles promotes smooth chip evacuation.

Four margins on the drill periphery provides close tolerance holes.

Optimal cutting edge profile for cast iron drilling.

4 flutes drill **DSQ** DC = $\varnothing 6 - \varnothing 16$ mm
Available in 3xD and 5xD

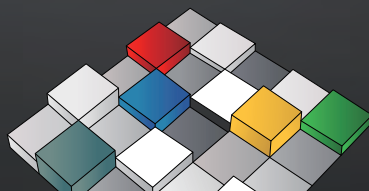


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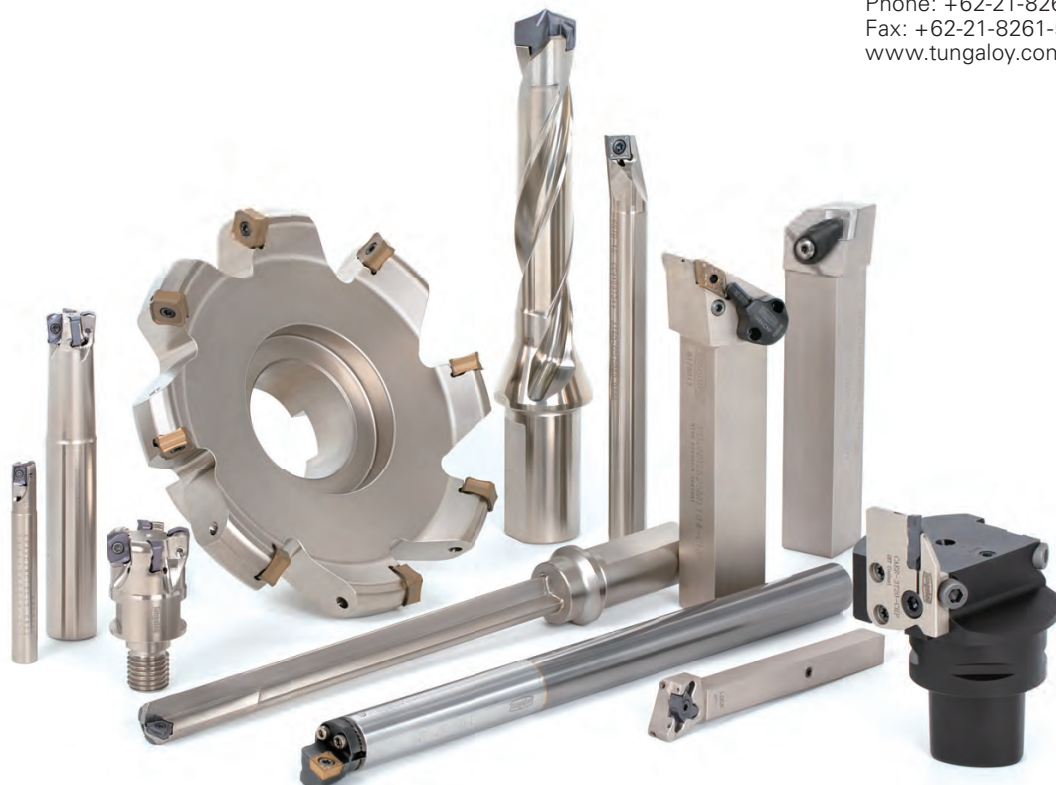
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