Tungaloy
Member IMC Group

Keeping the Customer First

Tungaloy Report No. 402-E

TURNLINE

Solid carbide boring bars for small diameter turning

NEW

TINYTURN

JB type

Solid boring bars applicable for min ø0.6 mm bore!

Excellent cutting edge offers high precision machining for a wide range of internal applications!

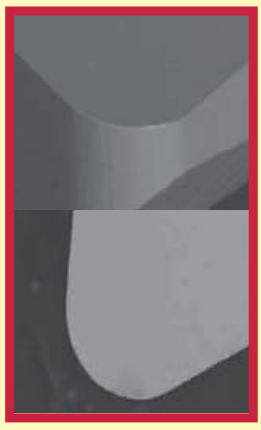
Features

Well-designed edge provides highly accurate machining

1 Super fine cutting edges

Comparison of tool surface and cutting edge

TINYTURN



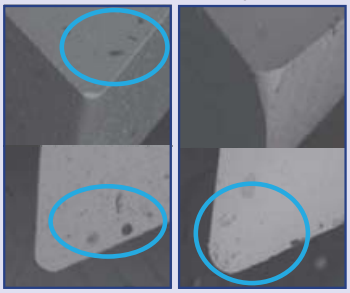
Fine edge and smooth coating

Improvement

Cutting edge is extremely fine compared to competitors!!

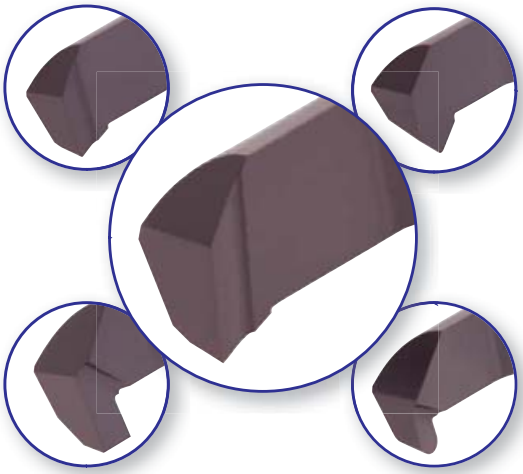
- Generates fine surface finishes and prevents edge chipping.
- Smooth cutting edge leads to high precision products.

Competitor A Competitor B

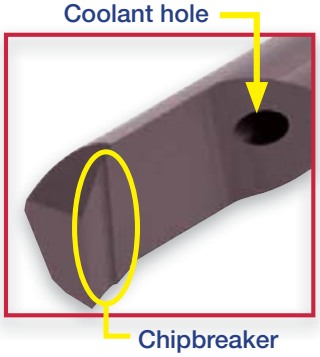


Foreign particles on surface, small chippings

Rough surface finish
Decreased tool life due to welding



Coolant hole



Chipbreaker

2 Coolant hole

- Supplies coolant directly to the cutting edge.
- Offers remarkable chip evacuation.

3 Wide range of items can be applied to a variety of internal operations.

- 146 solid bar items in a wide range of geometries
- Minimum boring diameter: *øD*m = 0.6 mm

Boring, profiling, chamfering

Type	Application	Shank diameter *øD*s (mm)	Min. bore dia. *øD*m (mm) 0 2 4 6 8 10
JBT (P. 6)	Boring, profiling, chamfering	ø4, ø7	ø0.6 – ø7.0
JBP (P. 7)	Boring, chamfering	ø4, ø7	ø2.8 – ø5.0
JBU (P. 7)	Back boring, chamfering	ø7	ø5.0
JBC (P. 7)	Boring, 45° chamfering	ø7	ø5.0 – ø6.8
JBB (P. 8)	Back boring	ø4, ø7	ø3.0 – ø7.0

Threading

Type	Application	Shank diameter *øD*s (mm)	Min. bore dia. *øD*m (mm) 0 2 4 6 8 10
JBI (P. 8)	Threading (Metric thread)	ø4, ø7	ø4.0 – ø7.0

Grooving

Type	Application	Shank diameter *øD*s (mm)	Groove width W (mm)	Min. bore dia. *øD*m (mm) 0 2 4 6 8 10 12 14 15
JBG (P. 9)	Grooving	ø4, ø7	0.5 - 2.0	ø2.0 – ø6.8
JBF (P. 10)	Face grooving	ø7	1.0 - 3.0	ø6.0 – ø15.0
JBS (P. 10)	Face grooving (for shaft)	ø7	2.0	ø6.0
JBR (P. 11)	Boring, profiling (full radius type)	ø7	1.0	ø5.0 – ø6.8

Well-designed edges with a wide range of items to generate high productivity for small parts machining!

Ideal sleeve with easy operation

1 Excellent repeatability of solid bars

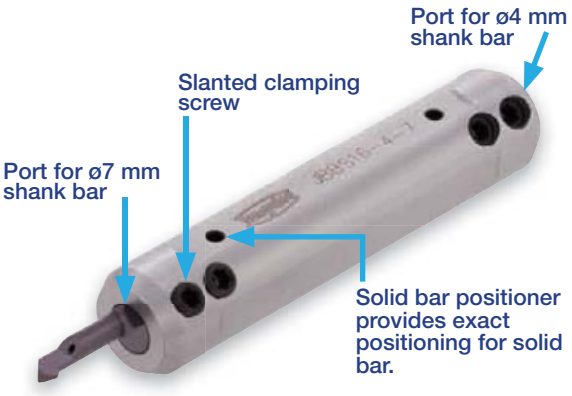
Exact positioning provides exceptional stability and reliability in tool changeovers.

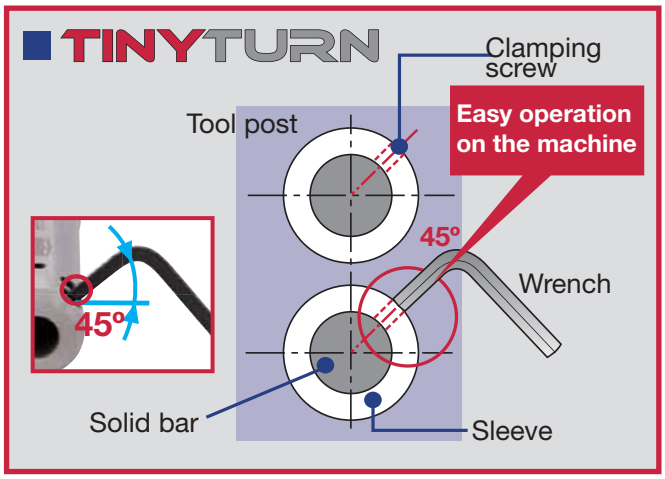
2 Double ported

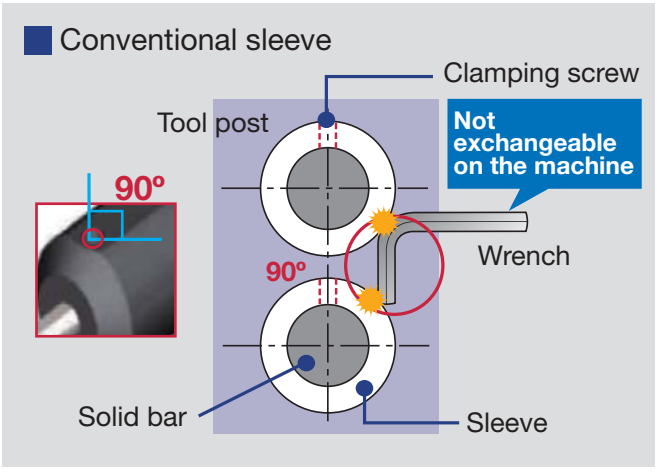
ø4 mm and ø7 mm shank can be set on ONE sleeve.

3 Easy tool changeovers

Solid bar can be changed to suit any type of tool head on the machine credit to the clamping screw tilted with 45°.



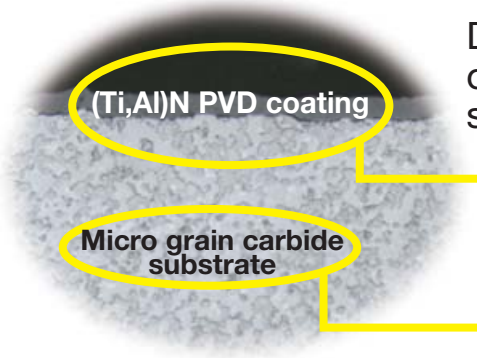




Highly functional sleeve creates extremely stable machining!

Grade

SH730 PVD coated grade



Delivers a stable performance with the combination of exclusive (Ti,Al)N coating and extremely tough substrate.

Excellent chipping & welding resistance

Thin (T,iAl)N coated layers are tightly adhered to create a sharp cutting edge.

Improved plastic deformation resistance and toughness

Application	Application code	Grade	Substrate			Coating layer		Features
			Specific gravity	Hardness (HRA)	T.R.S. (GPa)	Main Composition	Thickness (µm)	
P Steel	P20 - P30	SH730	14.4	91.5	3.0	(Ti,Al)N	1.0	Versatile PVD coated grade for wide range of materials and applications.
M Stainless	M20 - M30							
K Cast iron	K20 - K30							
N Non-ferrous	N20 - N30							
S Superalloys	S20 - S30							

Standard cutting condition

Boring, profiling, chamfering, back boring

Work materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
Steel S45C, SCM435 (C45, 34CrMo4)	SH730	**90** (40 - 140)	**0.05** (0.01 - 0.08) *
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9)		**90** (40 - 140)	
Grey cast irons, ductile cast irons FC250, FCD (GG25, GGG)		**60** (30 - 100)	
Aluminium alloys, copper alloys Si < 12%		**150** (90 - 200)	
Titanium alloys Ti-6Al-4V		**60** (30 - 100)	

* JBTR/L04020004-D006, JBTR/L04030004-D006 Max. *f* = 0.01 mm/rev

Threading (metric thread)

Work materials	Grade	Cutting speed *Vc* (m/min)	Number of passes				
			Pitch (mm)				
			0.5	0.75	1	1.25	1.5
Steel S45C, SCM435 (C45, 34CrMo4)	SH730	140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9)		105	8	10	12	15	18
Grey cast irons, ductile cast irons FC250, FCD (GG25, GGG)		115	7	9	12	14	17
Aluminium alloys, copper alloys Si < 12%		350	6	8	10	12	15

Internal grooving

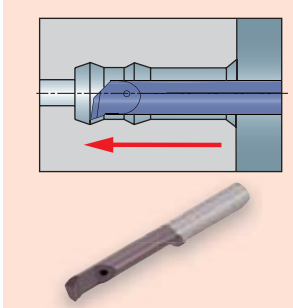
Work materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
Steel S45C, SCM435 (C45, 34CrMo4)	SH730	**90** (40 - 140)	**0.02** (0.01 - 0.03)
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9)		**90** (40 - 140)	
Grey cast irons, ductile cast irons FC250, FCD (GG25, GGG)		**60** (30 - 100)	
Aluminium alloys, copper alloys Si < 12%		**150** (90 - 200)	
Titanium alloys Ti-6Al-4V		**60** (30 - 100)	

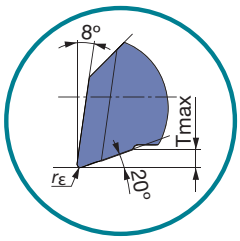
Face grooving

Work materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
Steel S45C, SCM435 (C45, 34CrMo4)	SH730	**90** (40 - 140)	**0.03** (0.01 - 0.05)
Stainless steels SUS303, SUS304 (X10CrNiS18-9, X5CrNi18-9)		**90** (40 - 140)	
Grey cast irons, ductile cast irons FC250, FCD (GG25, GGG)		**60** (30 - 100)	
Aluminium alloys, copper alloys Si < 12%		**150** (90 - 200)	
Titanium alloys Ti-6Al-4V		**60** (30 - 100)	

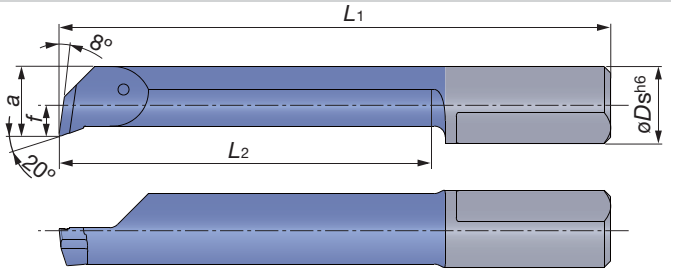
Solid boring bars

JBT R/L — Boring, profiling, chamfering





Details of edge

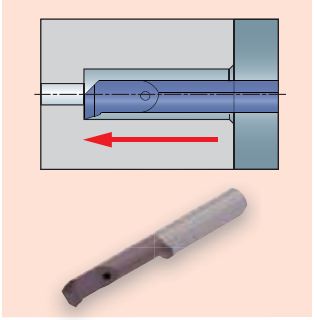


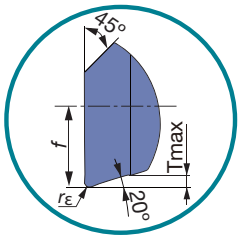
Right hand (R) shown.

Cat. No.	Grade SH730 R	Grade SH730 L	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBTR/L04020004-D006	●		0.6	4	-	0.5	18.5	2	0.08	0.04
JBTR/L04030004-D006	●		0.6	4	-	0.5	19.5	3	0.08	0.04
JBTR/L04045005-D010	●		1	4	-	0.9	21	4.5	0.1	0.05
JBTR/L04065005-D010	●		1	4	-	0.9	23	6.5	0.1	0.05
JBTR/L04040005-D020	●		2	4	-	1.7	20.5	4	0.1	0.05
JBTR/L04090005-D020	●		2	4	-	1.7	25.5	9	0.1	0.05
JBTR/L04140005-D020	●		2	4	-	1.7	30.5	14	0.1	0.05
JBTR/L04090010-D028	●	●	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBTR/L04150010-D028	●	●	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBTR/L04190010-D028	●	●	2.8	4	0.6	2.6	35.5	19	0.2	0.10
JBTR/L04090010-D040	●	●	4	4	1.5	3.5	25.5	9	0.3	0.10
JBTR/L04150010-D040	●	●	4	4	1.5	3.5	31.5	15	0.3	0.10
JBTR/L04190010-D040	●	●	4	4	1.5	3.5	35.5	19	0.3	0.10
JBTR/L04230010-D040	●		4	4	1.5	3.5	39.5	23	0.3	0.10
JBTR/L04270010-D040	●		4	4	1.5	3.5	43.5	27	0.3	0.10
JBTR/L07090015-D050	●	●	5	7	0.9	4.4	25	9	0.5	0.15
JBTR/L07140015-D050	●	●	5	7	0.9	4.4	30	14	0.5	0.15
JBTR/L07190015-D050	●	●	5	7	0.9	4.4	35	19	0.5	0.15
JBTR/L07240015-D050	●	●	5	7	0.9	4.4	40	24	0.5	0.15
JBTR/L07290015-D050	●	●	5	7	0.9	4.4	45	29	0.5	0.15
JBTR/L07340015-D050	●		5	7	0.9	4.4	50	34	0.5	0.15
JBTR/L07140015-D060	●	●	6	7	1.8	5.3	30	14	0.5	0.15
JBTR/L07210015-D060	●	●	6	7	1.8	5.3	37	21	0.5	0.15
JBTR/L07240015-D060	●	●	6	7	1.8	5.3	40	24	0.5	0.15
JBTR/L07290015-D060	●	●	6	7	1.8	5.3	45	29	0.5	0.15
JBTR/L07340015-D060	●		6	7	1.8	5.3	50	34	0.5	0.15
JBTR/L07410015-D060	●		6	7	1.8	5.3	57	41	0.5	0.15
JBTR/L07190015-D068	●	●	6.8	7	2.8	6.3	35	19	0.6	0.15
JBTR/L07240015-D068	●		6.8	7	2.8	6.3	40	24	0.6	0.15
JBTR/L07290015-D068	●	●	6.8	7	2.8	6.3	45	29	0.6	0.15
JBTR/L07340015-D070	●	●	7	7	2.8	6.3	50	34	0.6	0.15
JBTR/L07390015-D070	●		7	7	2.8	6.3	55	39	0.6	0.15
JBTR/L07440015-D070	●		7	7	2.8	6.3	60	44	0.6	0.15
JBTR/L07490015-D070	●		7	7	2.8	6.3	65	49	0.6	0.15

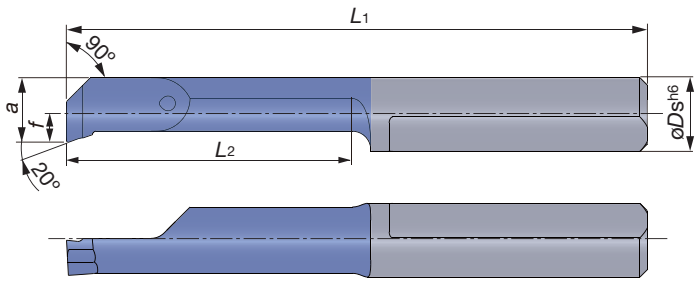
● : Stocked items

JBP R — Boring, chamfering



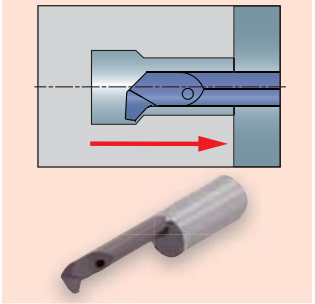


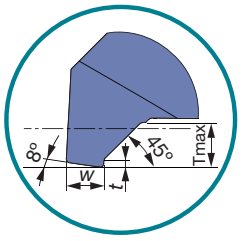
Details of edge



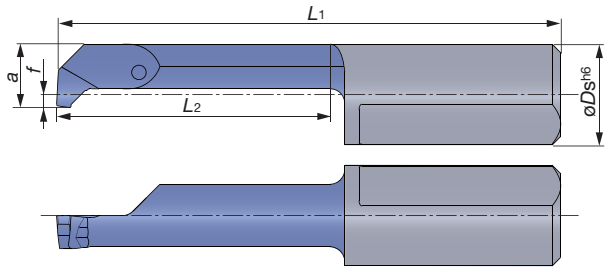
Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBPR04090010-D028	●	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBPR04150010-D028	●	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBPR04090010-D040	●	4	4	1.5	3.5	25.5	9	0.3	0.10
JBPR04150010-D040	●	4	4	1.5	3.5	31.5	15	0.3	0.10
JBPR07140015-D050	●	5	7	0.9	4.4	30	14	0.5	0.15
JBPR07190015-D050	●	5	7	0.9	4.4	35	19	0.5	0.15

JBU R/L — Back boring, chamfering





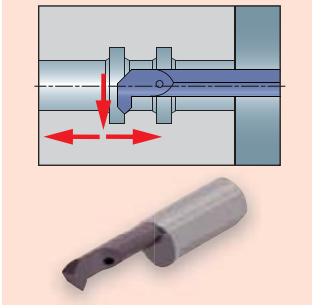
Details of edge

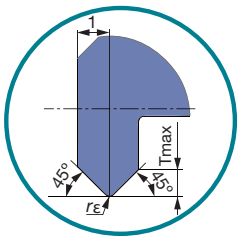


Right hand (R) shown.

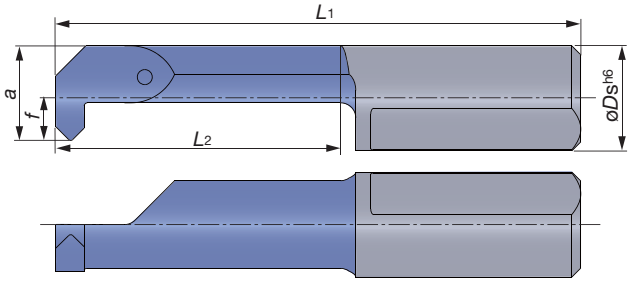
Cat. No.	Grade		Min. bore dia. øDm (mm)	Dimensions (mm)							Groove width (mm)
	SH730			øDs	f	a	L1	Overhang length L2	t	Tmax	W +0.05 0
	R	L									
JBUR/L07140010-D050	●		5	7	0.9	4.4	30	14	0.2	1	1
JBUR/L07190010-D050	●		5	7	0.9	4.4	35	19	0.2	1	1

JBC R — Boring, 45° chamfering





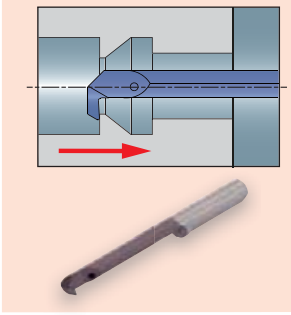
Details of edge

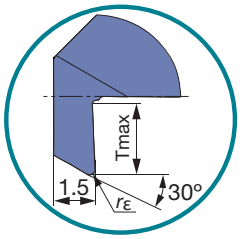


Cat. No.	Grade	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730		øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBCR07140020-D050	●	5	7	0.9	4.4	30	14	0.7	0.2
JBCR07190020-D050	●	5	7	0.9	4.4	35	19	0.7	0.2
JBCR07190020-D068	●	6.8	7	2.8	6.3	35	19	0.7	0.2

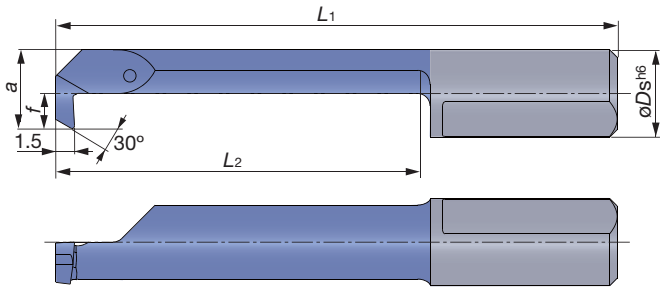
● : Stocked items

JBB R — Back boring



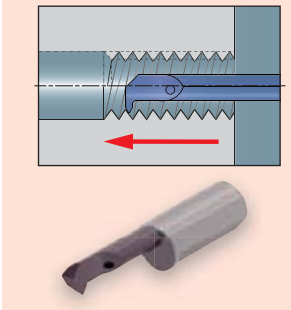


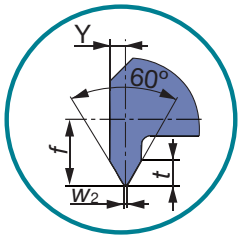
Details of edge



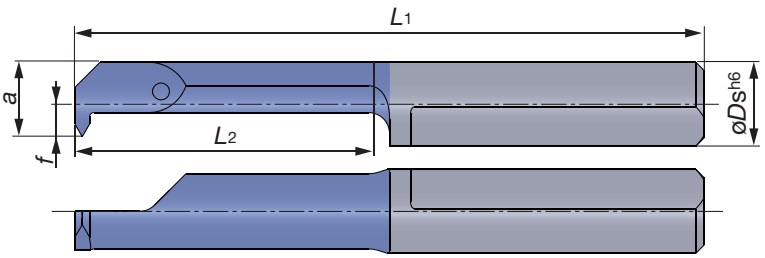
Cat. No.	Grade	Min. bore dia.	Dimensions (mm)						
	SH730	øDm (mm)	øDs	f	a	L1	Overhang length L2	Tmax	Corner radius rε ± 0.05
JBBR04140020-D030	●	3	4	0.6	2.6	30	14	0.5	0.2
JBBR04190020-D030	●	3	4	0.6	2.6	35	19	0.5	0.2
JBBR04140015-D040	●	4	4	1.5	3.5	30	14	0.8	0.15
JBBR04240015-D040	●	4	4	1.5	3.5	40	24	0.8	0.15
JBBR07190020-D050	●	5	7	0.9	4.4	35	19	1	0.2
JBBR07290020-D050	●	5	7	0.9	4.4	45	29	1	0.2
JBBR07190020-D060	●	6	7	1.8	5.3	35	19	1.8	0.2
JBBR07290020-D060	●	6	7	1.8	5.3	45	29	1.8	0.2
JBBR07190020-D070	●	7	7	2.8	6.3	35	19	2.5	0.2
JBBR07290020-D070	●	7	7	2.8	6.3	45	29	2.5	0.2

JBI R — Threading (metric thread)





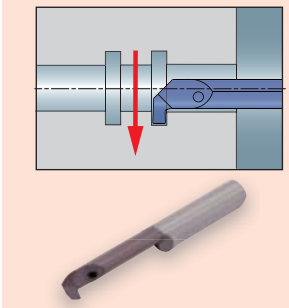
Details of edge

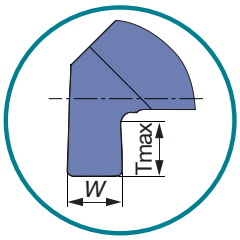


Cat. No.	Grade	Pitch	Min. bore dia.	Flat width	Dimensions (mm)						
	SH730	(mm)	øDm (mm)	W2 0 -0.02	øDs	f	a	L1	Overhang length L2	t	Y
JBIR04140050-D040	●	0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
JBIR07140050-D050	●	0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
JBIR07140075-D050	●	0.75	5	0.09	7	0.9	4.4	30	14	0.4	0.45
JBIR07140100-D048	●	1	4.8	0.12	7	0.9	4.4	30	14	0.6	0.55
JBIR07140100-D060	●	1	6	0.12	7	1.8	5.3	30	14	0.6	0.55
JBIR07140125-D060	●	1.25	6	0.15	7	1.8	5.3	30	14	0.7	0.65
JBIR07140150-D060	●	1.5	6	0.18	7	1.8	5.3	30	14	0.8	0.75
JBIR07140150-D070	●	1.5	7	0.18	7	2.8	6.3	30	14	0.8	0.75

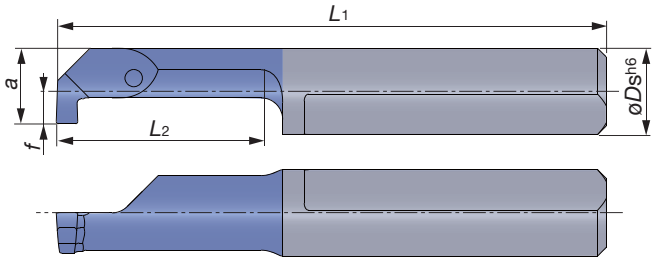
● : Stocked items

JBG R/L Grooving





Details of edge

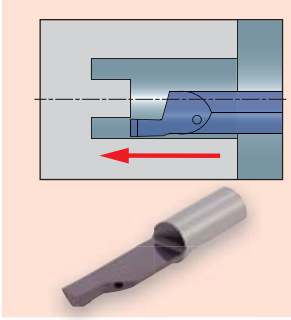


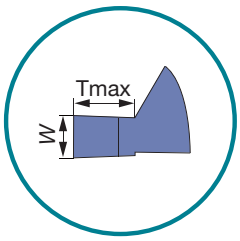
Right hand (R) shown.

Cat. No.	Grade SH730 R	Grade SH730 L	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm) øDs	f	a	L1	Overhang length L2	Tmax
JBGR/L04050050-D020	●		0.5	2	4	0.2	1.8	21	5	0.4
JBGR/L04100050-D020	●		0.5	2	4	0.2	1.8	26	10	0.4
JBGR/L04050070-D030	●		0.7	3	4	0.7	2.7	21	5	0.6
JBGR/L04100070-D030	●		0.7	3	4	0.7	2.7	26	10	0.6
JBGR/L04090100-D040	●		1	4	4	1.5	3.5	25.5	9	0.8
JBGR/L04150100-D040	●		1	4	4	1.5	3.5	31.5	15	0.8
JBGR/L07090100-D050	●		1	5	7	0.9	4.4	25	9	1
JBGR/L07140100-D050	●		1	5	7	0.9	4.4	30	14	1
JBGR/L07090150-D050	●		1.5	5	7	0.9	4.4	25	9	1
JBGR/L07140150-D050	●		1.5	5	7	0.9	4.4	30	14	1
JBGR/L07090200-D050	●		2	5	7	0.9	4.4	25	9	1
JBGR/L07190200-D050	●		2	5	7	0.9	4.4	35	19	1
JBGR/L07090100-D060	●	●	1	6	7	1.8	5.3	25	9	1.8
JBGR/L07140100-D060	●		1	6	7	1.8	5.3	30	14	1.8
JBGR/L07210100-D060	●		1	6	7	1.8	5.3	37	21	1.8
JBGR/L07290100-D060	●		1	6	7	1.8	5.3	45	29	1.8
JBGR/L07090150-D060	●	●	1.5	6	7	1.8	5.3	25	9	1.8
JBGR/L07140150-D060	●		1.5	6	7	1.8	5.3	30	14	1.8
JBGR/L07210150-D060	●		1.5	6	7	1.8	5.3	37	21	1.8
JBGR/L07240150-D060	●		1.5	6	7	1.8	5.3	40	24	1.8
JBGR/L07290150-D060	●		1.5	6	7	1.8	5.3	45	29	1.8
JBGR/L07090200-D060	●		2	6	7	1.8	5.3	25	9	1.8
JBGR/L07140200-D060	●		2	6	7	1.8	5.3	30	14	1.8
JBGR/L07210200-D060	●		2	6	7	1.8	5.3	37	21	1.8
JBGR/L07240200-D060	●		2	6	7	1.8	5.3	40	24	1.8
JBGR/L07290200-D060	●		2	6	7	1.8	5.3	45	29	1.8
JBGR/L07090100-D068	●		1	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140100-D068	●		1	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210100-D068	●		1	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07090150-D068	●		1.5	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140150-D068	●		1.5	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210150-D068	●		1.5	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07290150-D068	●		1.5	6.8	7	2.7	6.2	45	29	2.5
JBGR/L07090200-D068	●		2	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140200-D068	●	●	2	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210200-D068	●		2	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07250200-D068	●		2	6.8	7	2.7	6.2	40	25	2.5
JBGR/L07290200-D068	●		2	6.8	7	2.7	6.2	45	29	2.5

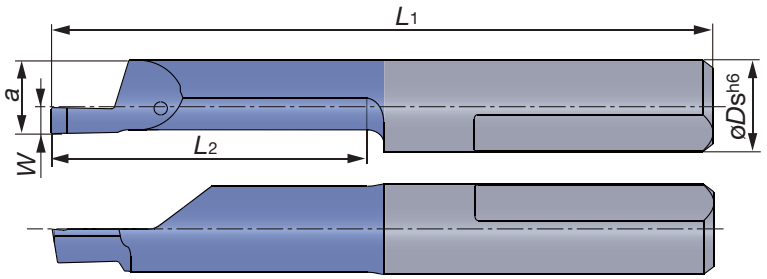
● : Stocked items

JBF R/L — Face grooving





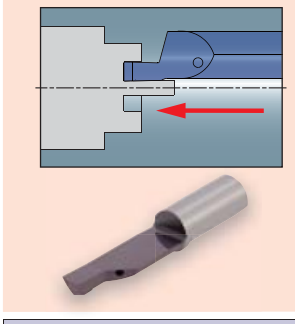
Details of edge

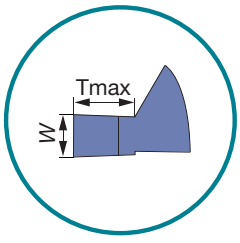


Right hand (R) shown.

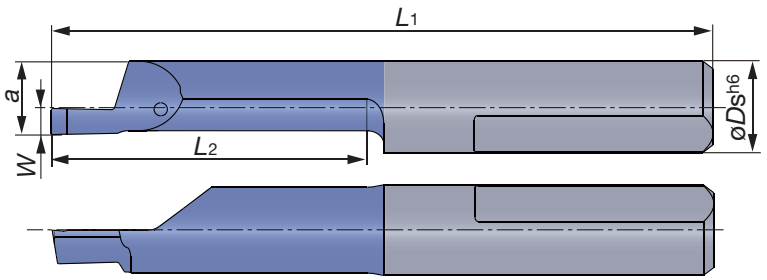
Cat. No.	Grade		Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm)				
	SH730				øDs	a	L1	Overhang length L2	Tmax
	R	L							
JBFR/L07110100-D060	●		1	6	7	5.2	26	11	1.5
JBFR/L07110150-D060	●		1.5	6	7	5.2	26	11	2
JBFR/L07110200-D060	●		2	6	7	5.2	26	11	3
JBFR/L07110250-D080	●		2.5	8	7	5.9	27	11	3.5
JBFR/L07110300-D080	●		3	8	7	5.9	27	11	3.5
JBFR/L07210150-D080	●	●	1.5	8	7	5.9	36	21	2.5
JBFR/L07210200-D080	●		2	8	7	5.9	36	21	3
JBFR/L07210250-D080	●		2.5	8	7	5.9	36	21	3.5
JBFR/L07210300-D080	●		3	8	7	5.9	36	21	3.5
JBFR/L07300200-D080	●	●	2	8	7	5.9	46	30	3
JBFR/L07300300-D080	●		3	8	7	5.9	46	30	3.5
JBFR/L07110100-D080	●		1	8	7	5.9	27	11	1.5
JBFR/L07110150-D080	●		1.5	8	7	5.9	27	11	2.5
JBFR/L07110200-D080	●		2	8	7	5.9	27	11	3
JBFR/L07200200-D080	●		2	8	7	5.9	36	20	3
JBFR/L07200250-D150	●		2.5	15	7	5.9	36	20	20
JBFR/L07200300-D150	●		3	15	7	5.9	36	20	20
JBFR/L07300300-D150	●		3	15	7	5.9	46	30	30

JBS R — Face grooving (for machining shaft)





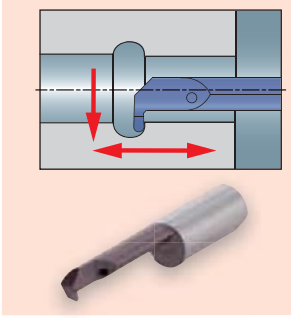
Details of edge

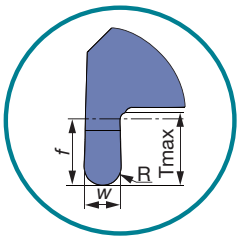


Cat. No.	Grade	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm)				
	SH730			øDs	a	L1	Overhang length L2	Tmax
JBSR07200200-D060	●	2	6	7	5.2	36	20	4

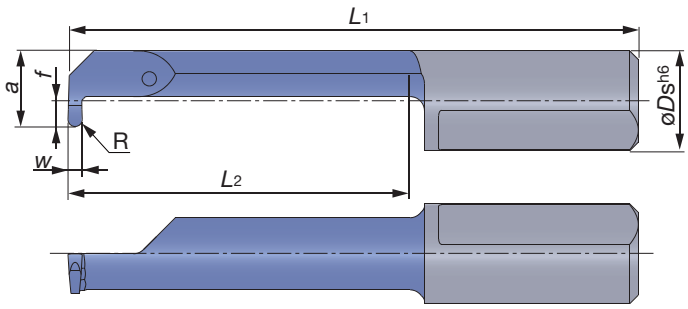
● : Stocked items

JBR R — Boring, profiling (full radius type)





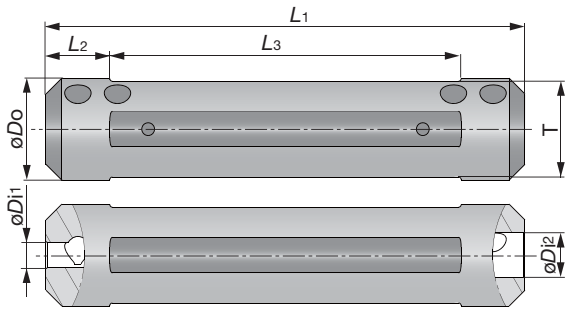
Details of edge



Cat. No.	Grade	Groove width $W^{+0.05}_{0}$ (mm)	Min. bore dia. øDm (mm)	Dimensions (mm)						
	SH730			øDs	f	a	L1	Overhang length L2	Tmax	R
JBRR07190050-D050	●	1	5	7	0.9	4.4	35	19	1	0.5
JBRR07240050-D060	●	1	6	7	1.8	5.3	40	24	1.8	0.5
JBRR07290050-D068	●	1	6.8	7	2.8	6.3	45	29	2.5	0.5

Sleeves

JBBS — For TinyTurn



Cat. No.	Stock	Dimensions (mm)							Replacement parts	
		øDo	øDi1	øDi2	L1	L2	L3	T	Clamping screw	Wrench
JBBS12-4-4	●	12	4	4	75	10	55	10.3	SSHM5-4PF-S	P-2.5
JBBS127-4-4	●	12.7	4	4	76.2	10	56.2	11.6	SSHM5-6PF-S	P-2.5
JBBS14-4-4	●	14	4	4	75	10	55	12	SSHM5-4PF-S	P-2.5
JBBS159-4-7	●	15.875	4	7	76.2	10	56.2	14	SSHM5-6PF-S	P-2.5
JBBS16-4-7	●	16	4	7	75	10	55	15	SSHM5-6PF-S	P-2.5
JBBS19-4-7	●	19.05	4	7	89	10	69	17.2	SSHM5-6PF-S	P-2.5
JBBS20-4-7	●	20	4	7	90	10	70	18	SSHM5-6PF-S	P-2.5
JBBS22-4-7	●	22	4	7	90	10	70	20	SSHM5-6PF-S	P-2.5
JBBS25-4-7	●	25	4	7	100	10	80	23	SSHM5-6PF-S	P-2.5
JBBS254-4-7	●	25.4	4	7	90	10	70	23.4	SSHM5-6PF-S	P-2.5

● : Stocked items

Tungaloy
Member IMC Group

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.tungaloyamerica.com

Tungaloy Canada
432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779 Fax: +1-519-758-5791
www.tungaloyamerica.com

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.tungaloyamerica.com

Tungaloy do Brasil Comércio de Ferramentas de Corte Ltda.
Rua dos Sabias N.104
13280-000 Vinhedo, São Paulo, Brazil
Phone:+55-19-38262757 Fax:+55-19-38262757
www.tungaloy.co.jp/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.de

Tungaloy France S.A.S.
ZA Courtaboeuf - Le Rio, 1 rue de la Terre de feu
F-91952 Courtaboeuf Cedex, France
Phone: +33-1-6486-4300 Fax: +33-1-6907-7817
www.tungaloy.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.it

Tungaloy Czech s.r.o
Tuřanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391 Fax: +420-532 123 392
www.tungaloy.cz

Tungaloy Ibérica S.L.
C/La Pau, nº46
E-08243 Manresa (BCN), SPAIN
Phone:+34 93 1131360 Fax:+34 93 1131361
www.tungaloy.es

Tungaloy Scandinavia AB
S:t Lars Väg 42A
SE-22270 Lund, Sweden
Phone:+46-462119200 Fax:+46-462119207
www.tungaloy.co.jp/se

Tungaloy Rus, LLC
36-G Kostukova str.
308012 Belgorod, Russia
Phone:+7 4722 58 57 57 Fax:+7 4722 58 57 83
www.tungaloy.co.jp/ru

Tungaloy Polska Sp. z o.o.
ul. Genewska 24
03-963 Warszawa, Poland
Phone: +48-22-617-0890 Fax: +48-22-617-0890
www.tungaloy.co.jp/pl

Tungaloy U.K. Ltd
Hilton Hall Business Centre, Essington
Staffordshire, WV11 2BQ, UK
Phone:+44 121 309 0163 Fax: +44 121 270 9694
www.tungaloy.co.jp/uk salesinfo@tungaloyuk.co.uk

Tungaloy Hungary Kft
Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: (0036) 1 781-6846 Fax: (0036) 1 781-6866
www.tungaloy.co.jp/hu info@tungaloytools.hu

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.co.jp/tcts

Tungaloy Cutting Tool (Thailand) Co.,Ltd.
11th Floor, Sorachai Bldg. 23/7, Soi Sukhumvit 63
Klongtonnue, Wattana, Bangkok 10110, Thailand
Phone: +66-2-714-3130 Fax: +66-2-714-3134
www.tungaloy.co.th

Tungaloy Singapore (Pte.), Ltd.
50 Kallang Avenue #06-03 Noel Corporate Building
Singapore 339505
Phone:+65-6391-1833 Fax:+65-6299-4557
www.tungaloy.co.jp/tspl

Tungaloy India Pvt. Ltd.
Unit#13, B wing, 8th Floor, Kamala Mills Compound
Trade World, Lower Parel (West), Mumbai - 4000 13. India
Phone: +91-22-6124-8804 Fax: +91-22-6124-8899
www.tungaloy.co.jp/in

Tungaloy Korea Co., Ltd
#1312, Byucksan Digital Valley 5-cha
60-73 Gasan-dong, Geumcheon-gu
153-788 Seoul, Korea
Phone:+82-2-6393-8930 Fax:+82-2-6393-8952
www.tungaloy.co.jp/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.co.jp/my

Tungaloy Australia Pty Ltd
Unit 308/33 Lexington Drive
Bella Vista NSW 2153, Australia
Phone:+612-9672-6844 Fax:+612-9672-6866
www.tungaloy.co.jp/au

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