

MillLine

SLOTMILL SERIES

www.tungaloy.com

Tungaloy Report No. 423-G

SLOTMILL SERIES

Stable slot milling operation with
excellent chip control!





ACCELERATED MACHINING

MillLine

SLOTMILL SERIES

TUNGALOY



Tungaloy SlotMill Series is an **economical and well-designed** slot milling line for improved surface finish in slotting, face milling, and back-face milling.

An **economical** slot milling solution with stable chip formation allowing deeper slots thus **increasing productivity** and **stability** in machining!

Exceptional chip evacuation

Offers stable deep slot milling!

SLOTMILL SERIES

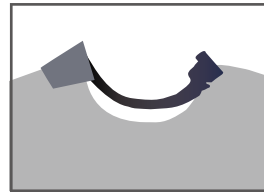
OK



Optimum chipbreaker and big gullets create compact chip formation and smooth evacuation!

Competitor

X



Unformed chip and narrow gullet cause chip packing.

Innovative inserts

Tough cutting edges lead to high stability

TUNG M^{SLIT}

S/ASG type

For parting-off and thin slotting
Precision insert ($W \pm 0.04$)

$W = 1.6, 1.85, 2.65, 4.0 \text{ mm}$



TUNG T^{SLIT}

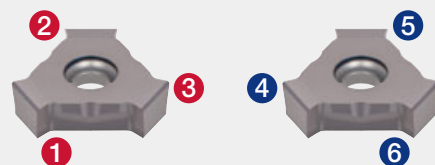
ASV type

6 corners available

$W = 4, 5, 6, 8 \text{ mm}$

R edge

L edge

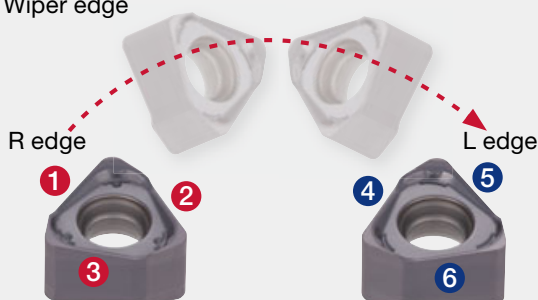


TUNG U^{NIVERSAL} SLO

ASW / TSW type

6 corners available
With Wiper edge

$W = 10, 12, 14, 16 \text{ mm}$



TEC T^{ANGENTIAL} SLO

ASN / TSN type

4 corners available
With Wiper edge

$W = 16, 19, 25 \text{ mm}$

R edge

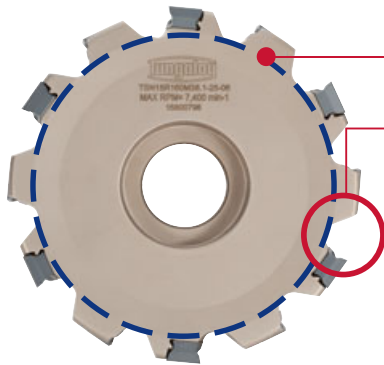
L edge



High productivity due to a large number of edge lines

- High density insert cutters for TungThinSlit, TungUniversalSlot, TecTangentialSlot!
- 1.3 - 1.7 times higher productivity than conventional tools

Sample: **TEC T SLOTT**



Highly rigid cutter body with tangential insert

Excellent chip evacuation with an optimized chip gullet

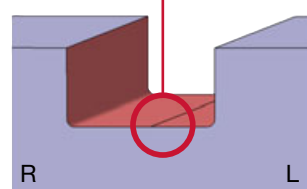
Comparison of no. of edge lines (Edge width: $W = 16$ mm)

Tool dia. ϕD_c (mm)	TEC T SLOTT	Competitor A	Competitor B
$\phi 100$	5	-	3
$\phi 125$	6	5	4
$\phi 160$	7	6	5
$\phi 200$	8	7	6

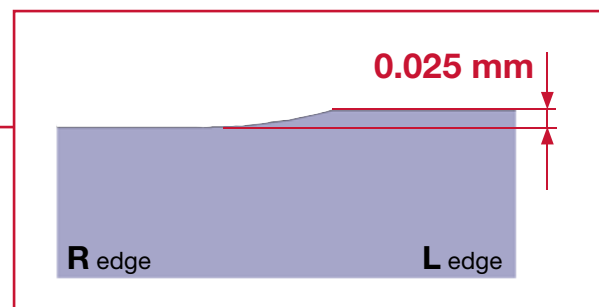
Small gap between R edge and L edge

Precise runout due to the ground inserts

Machining example: **TEC T SLOTT**



Workpiece



Tool diameter : $\phi D_c = \phi 125$ mm
 Workpiece : S55C / C55 (200HB)
 Cutting speed : $V_c = 150$ m/min
 Chip thickness : $t = 0.13$ mm
 Edge width : $W = 16$ mm
 Depth of slot : $a_e = 6$ mm
 Machine : Vertical M/C, BT50

*Dimension shown is under ideal condition.

CUTTING PERFORMANCE

Comparison of chip control

Smooth chip evacuation!
Better than conventional tools!

Tool diameter : $\phi D_c = \phi 125$ mm Feed per : $f_z = 0.19$ mm/t ($a_e = 10$ mm)
Cutting speed : $V_c = 150$ m/min edge line $f_z = 0.14$ mm/t ($a_e = 20$ mm)
Chip thickness : $t = 0.1$ mm $f_z = 0.125$ mm/t ($a_e = 25$ mm)
No. of edge lines: 1 edge line $f_z = 0.12$ mm/t ($a_e = 30$ mm)
Machine : Vertical M/C, BT50

TUNG^{THIN}SPLIT ASV type

○ : Good

✕ : Bad, chip packing

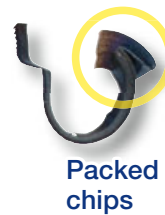
P **Steel** S55C / C55 (200HB)
Edge width: $W = 4$ mm, Dry (with air)
Corner radius: $r_\epsilon = 0.4$ mm

Cutter	Depth of slot: a_e (mm)		
	10	20	25
TUNG ^{THIN} SPLIT	○	○	○
Competitor A	○	○	✕
Competitor B	○	✕	✕

Chips at $a_e = 25$ mm depth



Competitor A



Packed chips

Competitor B



No chip control

M **Stainless** SUS304 / X5CrNi18-9 (180HB)
Edge width: $W = 6$ mm, Wet
Corner radius: $r_\epsilon = 0.8$ mm

Cutter	Depth of slot: a_e (mm)		
	10	20	30
TUNG ^{THIN} SPLIT	○	○	○
Competitor A	○	✕	✕

Chips at $a_e = 30$ mm depth



Competitor A



Packed chips

TUNG^{UNIVERSAL}SLOT ASW / TSW type

P **Steel** S55C / C55 (200HB)
Edge width: $W = 10$ mm, Dry
Corner radius: $r_\epsilon = 0.8$ mm

Cutter	Depth of slot: a_e (mm)		
	10	20	30
TUNG ^{UNIVERSAL} SLOT	○	○	○
Competitor A	○	○	✕

Chips at $a_e = 30$ mm depth



Competitor A



Packed chips



Chips are packed because of bad chip control and flow.

Comparison of tool life

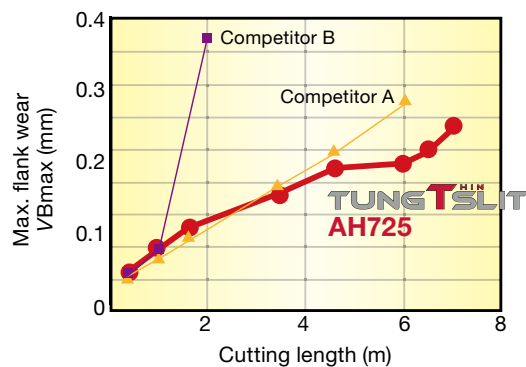
Longer tool life than competitors tools!

Tool diameter : $\phi D_c = \phi 125 \text{ mm}$
 Cutting speed : $V_c = 150 \text{ m/min}$
 Chip thickness : $t = 0.1 \text{ mm}$

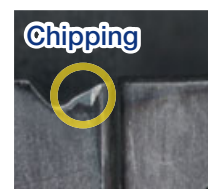
Feed per edge line : $f_z = 0.19 \text{ mm/t}$
 Depth of slot : $a_e = 10 \text{ mm}$
 No. of edge lines : 1 edge line
 Machine : Vertical M/C, BT50

TUNG^{THIN}SLIT ASV type**P****Steel** S55C / C55 (200HB)

Edge width: $W = 4 \text{ mm}$, Dry
 Corner radius: $r_\epsilon = 0.4 \text{ mm}$

TUNG^{THIN}SLIT

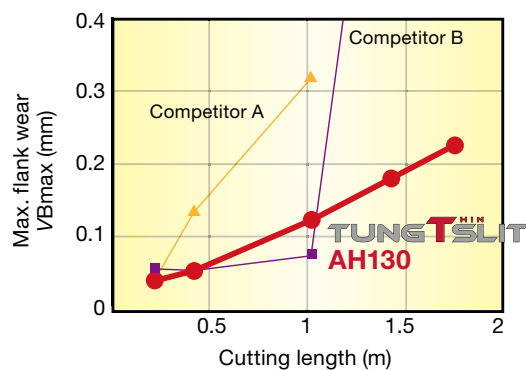
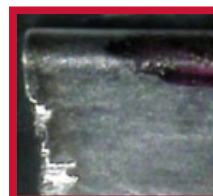
Competitor A



Competitor B

**M****Stainless** SUS304 / X5CrNi18-9 (180HB)

Edge width: $W = 6 \text{ mm}$, Wet
 Corner radius: $r_\epsilon = 0.8 \text{ mm}$

TUNG^{THIN}SLIT

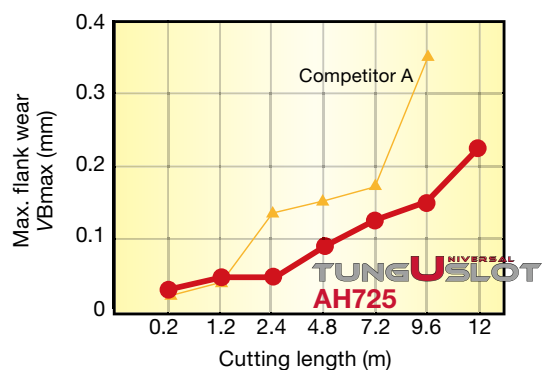
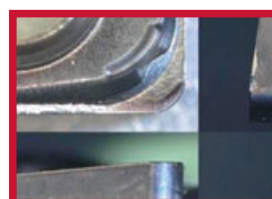
Competitor A



Competitor B

TUNG^{UNIVERSAL}SLIT ASW / TSW type**P****Steel** S55C / C55 (200HB)

Edge width: $W = 10 \text{ mm}$, Dry
 Corner radius: $r_\epsilon = 0.8 \text{ mm}$

TUNG^{UNIVERSAL}SLIT

Competitor A



Comparison of tool life

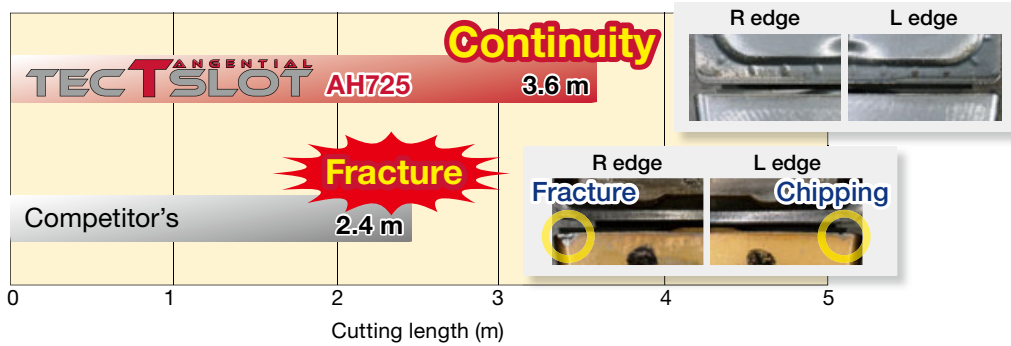
Reliable insert with tough cutting edge!

TEC^{TANGENTIAL}SLOT ASN / TSN type

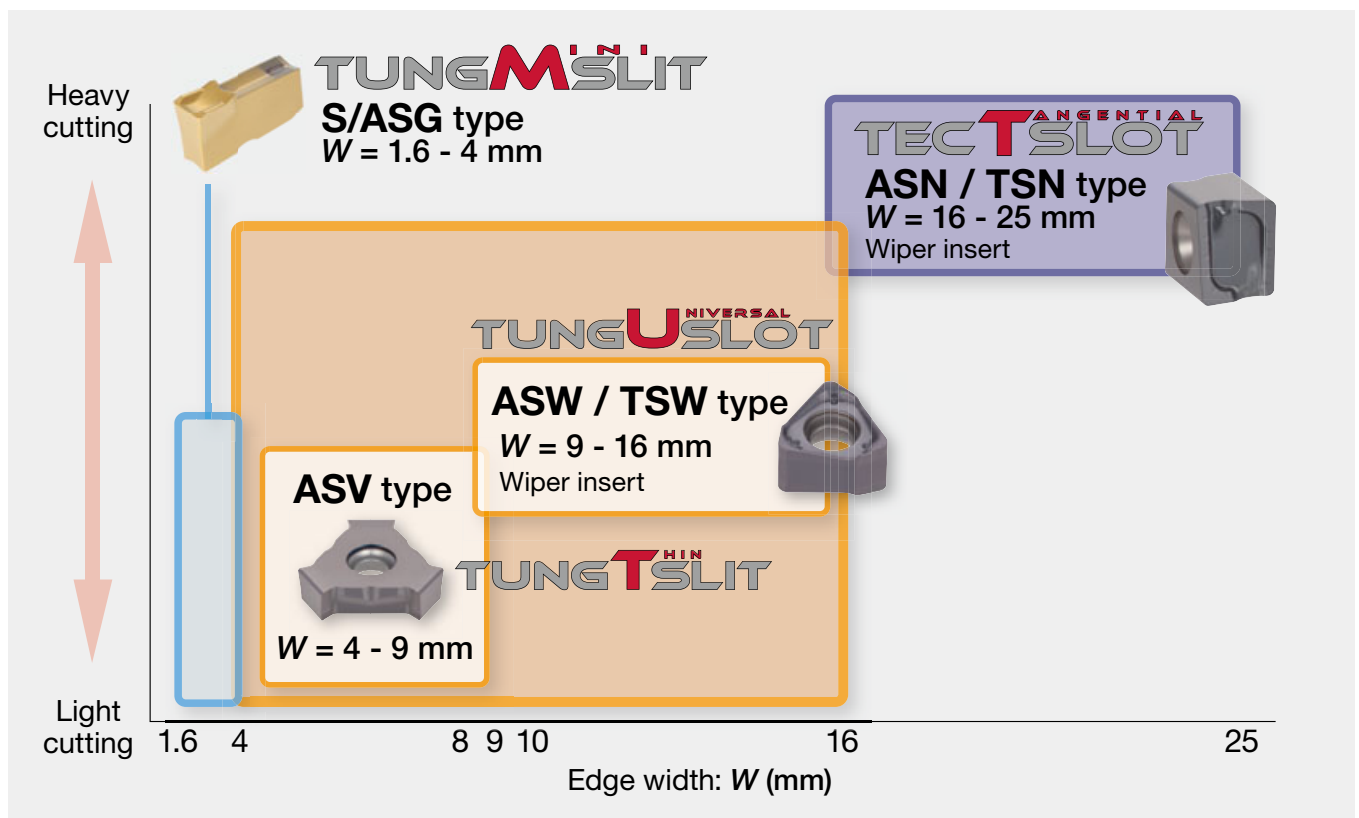
P Steel S55C / C55 (200HB)
Edge width: $W = 16$ mm, Dry
Corner radius: $r_\epsilon = 0.8$ mm

Tool diameter : $\phi D_c = \phi 125$ mm
Cutting speed : $V_c = 150$ m/min
Chip thickness : $t = 0.2$ mm
Feed per edge line : $f_z = 0.3$ mm/t

Edge width : $W = 16$ mm
Depth of slot : $a_e = 16$ mm
No. of edge lines : 1 edge line
Machine : Vertical M/C, BT50



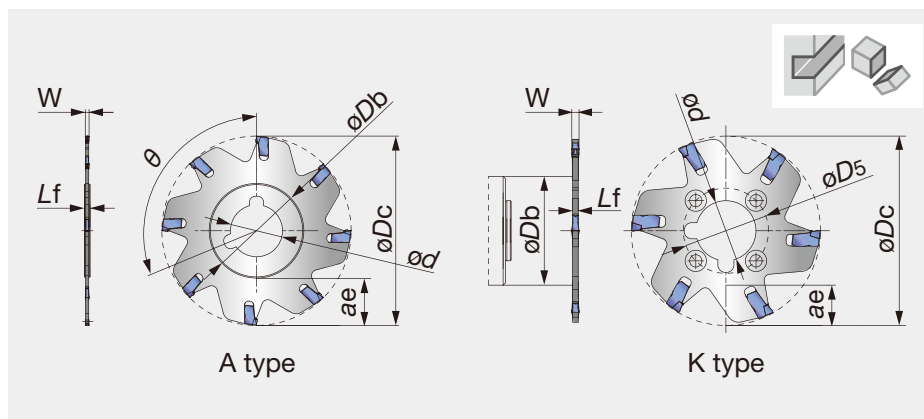
APPLICATION RANGE



Side cutter for thin slitting and cutting off

CUTTER - AXIAL DRIVE

TungMiniSlit S/ASG



Designation	W min	W max	oDc	z	oDb	oD	oD5	Lf	Max. ae	θ°	SS	SS	Drive flange	type	Insert
SSG01R063-E1.6	1.6	1.6	63	6	32	10	22	2.4	14	0	SW25-32	SW1.00-32	-	K	SSS16N
ASG01N076-1.6	1.6	1.6	76.2	8	39	25.4	-	2.4	14	112.5	-	-	-	A	SSS16N
ASG01N080-E1.6	1.6	1.6	80	8	39	22	-	2.4	16	112.5	-	-	-	A	SSS16N
ASG01N100-1.6	1.6	1.6	100	10	39	25.4	-	2.4	30	90	-	-	-	A	SSS16N
ASG01N100-E1.6	1.6	1.6	100	10	39	22	-	2.4	30	90	-	-	-	A	SSS16N
ASG01N125-1.6	1.6	1.6	125	12	64	31.75	-	2.4	30	75	-	-	-	A	SSS16N
ASG01N125-E1.6	1.6	1.6	125	12	64	27	-	2.4	30	75	-	-	-	A	SSS16N
SSG02R063-E2	1.85	2.5	63	6	32	10	22	2.4	15	0	SW25-32	SW1.00-32	-	K	SSM/S22N
ASG02N076-2	1.85	2.5	76.2	8	39	25.4	-	2.4	17	112.5	-	-	-	A	SSM/S22N
ASG02N080-E2	1.85	2.5	80	8	39	22	-	2.4	20	112.5	-	-	-	A	SSM/S22N
ASG02N100-2	1.85	2.5	100	10	39	25.4	-	2.4	30	90	-	-	-	A	SSM/S22N
ASG02N100-E2	1.85	2.5	100	10	39	22	-	2.4	30	90	-	-	-	A	SSM/S22N
ASG02N125-2	1.85	2.5	125	12	60	31.75	-	2.4	32	75	-	-	-	A	SSM/S22N
ASG02N125-E2	1.85	2.5	125	12	60	27	-	2.4	32	75	-	-	-	A	SSM/S22N
SSG03R063-E3	2.65	3.5	63	5	32	10	22	2.4	15	0	SW25-32	SW1.00-32	-	K	SSM/S31N
SSG03R080-3	2.65	3.5	80	6	46	25.4	36	2.4	16	0	SW32-25.4-46-J	SW1.25-46	R1.00-46	K	SSM/S31N
SSG03R080-E3	2.65	3.5	80	6	40 ⁽¹⁾	22	32	2.4	19 ⁽²⁾	0	SW32-40	-	R22-46	K	SSM/S31N
SSG03R100-3	2.65	3.5	100	6	46	25.4	36	2.4	26	0	SW32-25.4-46-J	SW1.25-46	R1.00-46	K	SSM/S31N
SSG03R100-E3	2.65	3.5	100	6	40 ⁽¹⁾	22	32	2.4	29 ⁽³⁾	0	SW32-40	-	R22-46	K	SSM/S31N
SSG03R125-3	2.65	3.5	125	8	55	31.75	45	2.4	34	0	-	-	R1.25-55	K	SSM/S31N
SSG03R125-E3	2.65	3.5	125	8	55	32	45	2.4	34	0	S32-55	-	R32-55	K	SSM/S31N
SSG04R063-E4	4	4.5	63	5	32	10	22	3.2	15	0	SW25-32	SW1.00-32	-	K	SSM/S41N
SSG04R080-4	4	4.5	80	6	46	25.4	36	3.2	16	0	SW32-25.4-46-J	SW1.25-46	R1.00-46	K	SSM/S41N
SSG04R080-E4	4	4.5	80	6	40 ⁽¹⁾	22	32	3.2	19 ⁽²⁾	0	SW32-40	-	R22-46	K	SSM/S41N
SSG04R100-4	4	4.5	100	6	46	25.4	36	3.2	26	0	SW32-25.4-46-J	SW1.25-46	R1.00-46	K	SSM/S41N
SSG04R100-E4	4	4.5	100	6	40 ⁽¹⁾	22	32	3.2	29 ⁽³⁾	0	SW32-40	-	R22-46	K	SSM/S41N
SSG04R125-4	4	4.5	125	8	55	31.75	45	3.2	34	0	-	-	R1.25-55	K	SSM/S41N

(1) When using a drive flange, oDb = 46 mm

(2) When using a drive flange, Max. ae = 16 mm

(3) When using a drive flange, Max. ae = 26 mm

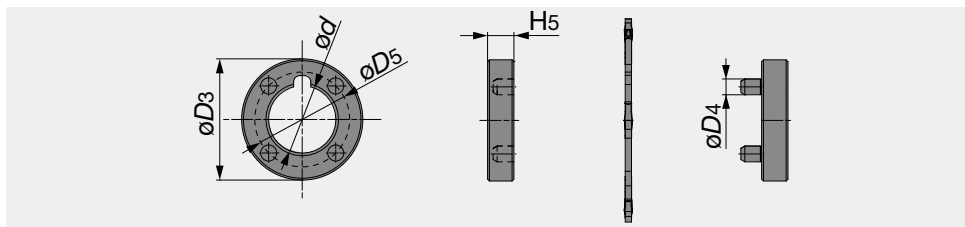
SPARE PARTS

Designation	Grip	Extractor
SSG01/02...	ESG0.5	-
ASG01/02...	ESG0.5	-
SSG03/04...	-	ESG1

TUNGSLIT

R (drive flange set)

Drive flange set for side cutters

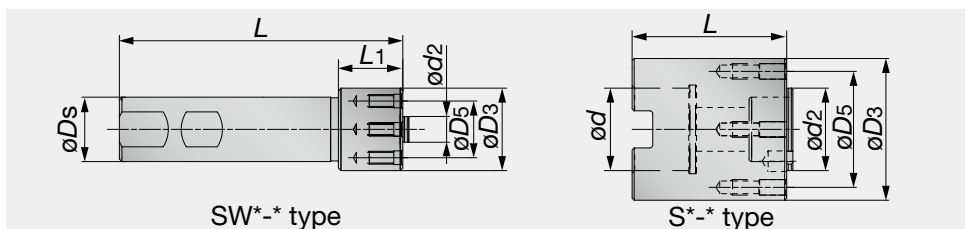


Designation	ϕd	$\phi D3$	$\phi D4$	$\phi D5$	H5
R1.00-46	25.4	46	5	36	10
R 22-46	22	46	6	32	10
R1.25-55	31.75	55	6	45	10
R 32-55	32	55	6	45	10

TUNGSLIT

SW/S

Drive shanks for side cutters



Designation	ϕDs	ϕd	$\phi d2$	$\phi D3$	$\phi D5$	L1	L
SW25-32	25	-	10	32	22	25	110
SW32-40	32	-	22	40	32	30	120
SW32-25.4-46-J	32	-	25.4	46	36	30	120
SW1.00-32	25.4	-	10	32	22	25.4	110
SW1.25-46	31.75	-	25.4	46	36	30	120
S 32-55	-	32	32	55	45	-	60

SPARE PARTS

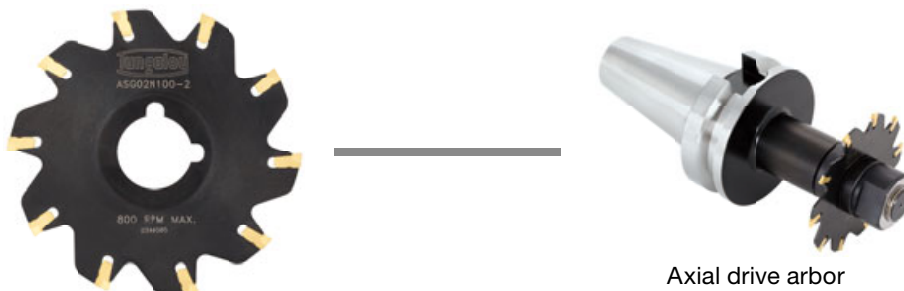


Designation	Screw	Wrench		
		Mono block type	Torx bit	Handle
SW25-32	SR76-961	SETT-15/5	-	-
SW32-40	SR76-963	SETT-15/5	-	-
SW32-25.4-46-J	SR76-963	SETT-15/5	-	-
SW1.00-32	SR76-961	SETT-15/5	-	-
SW1.25-46	SR76-963	SETT-15/5	-	-
S32-55	SR76-943	-	BT20M	H-TB

COMBINATION OF ARBORS / ATTACHMENTS

Cutter bodies : “A” type

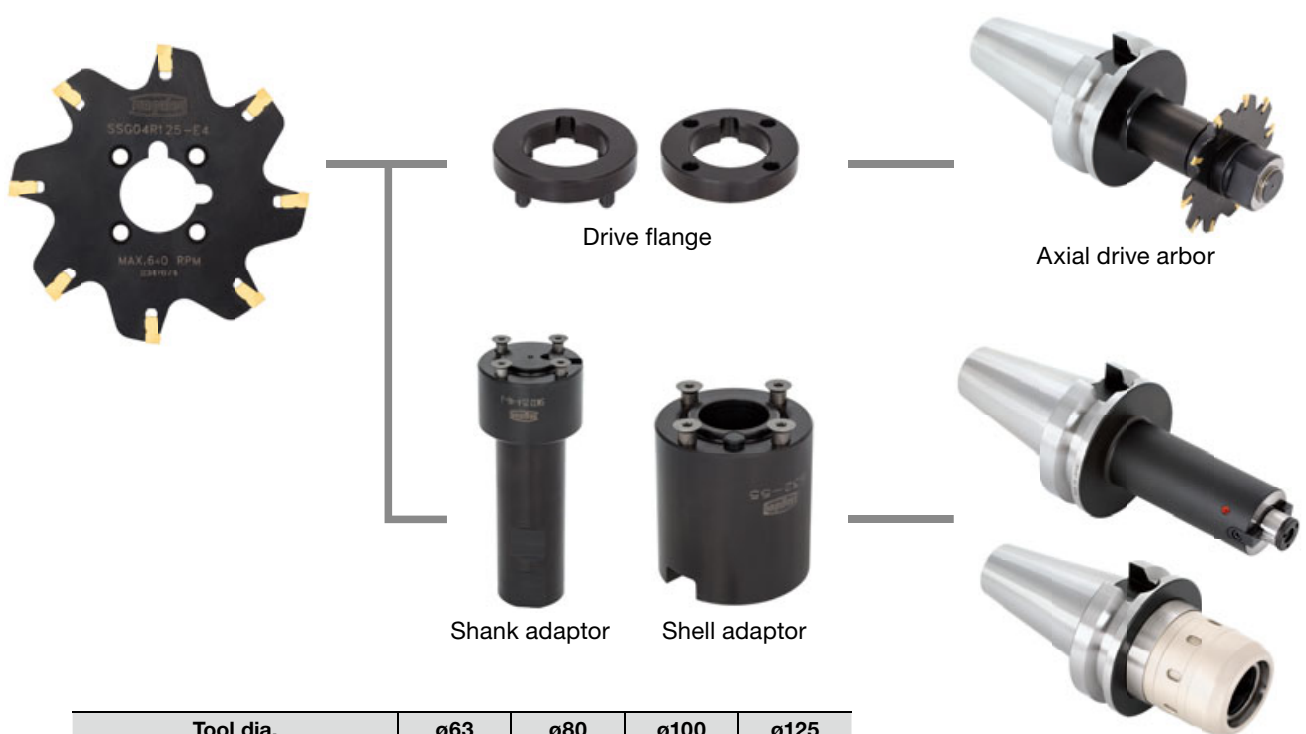
A-type disk cutters are without clamping holes on the hub and can be mounted only by using axial drive arbors.



Axial drive arbor

Cutter bodies : “K” type

K-type disk cutters are with clamping holes on the hub and can be mounted by using intermediate shanks or shell adaptors, making it possible to use endmills / shell mill arbors.



Drive flange

Axial drive arbor

Shank adaptor

Shell adaptor

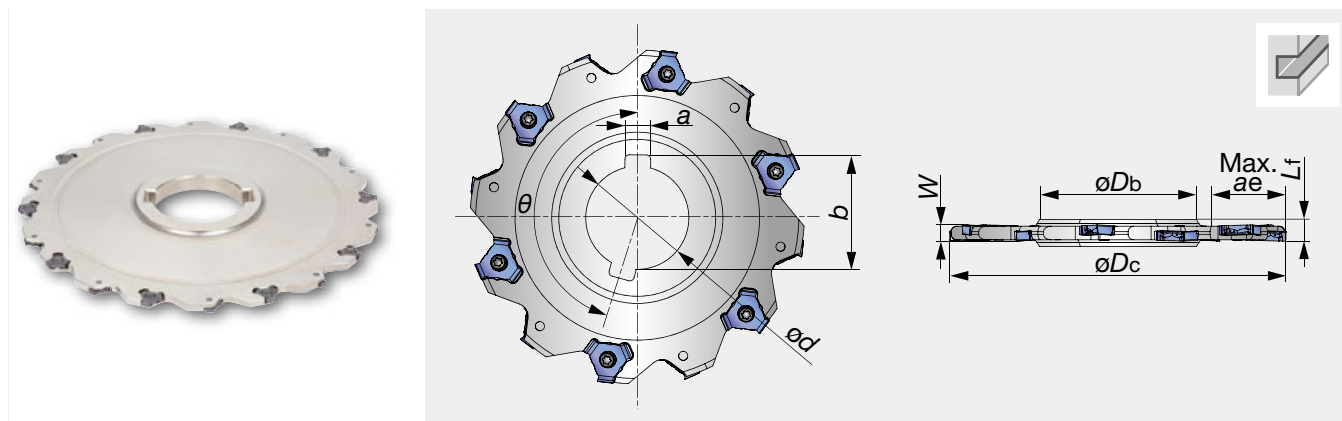
Shell mill / Endmill arbor

Tool dia.	ø63	ø80	ø100	ø125
Drive flange	-	✓	✓	✓
Shank / Shell adaptor	✓	✓	✓	✓

Axial drive type slot milling cutter with face mounted inserts

CUTTER - AXIAL DRIVE

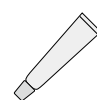
TungThinSlit ASV + TVKX



Designation	W	øDc	Z eff	øDb	ød	Lf	b	a	Max. ae	θ	z	Insert
ASV02N080-4	4	80	5	41	25.4	6	28	6.35	15	162°	10	TVKX0202...
ASV02N080-E4	4	80	5	41	27	6	29.8	7	15	162°	10	TVKX0202...
ASV02N100-4	4	100	6	48	31.75	6	35.2	7.92	20	165°	12	TVKX0202...
ASV02N100-E4	4	100	6	47	32	6	34.8	8	20	165°	12	TVKX0202...
ASV02N125-4	4	125	8	58	38.1	6	42.3	9.52	30	168.75°	16	TVKX0202...
ASV02N125-E4	4	125	8	55	40	6	43.5	10	30	168.75°	16	TVKX0202...
ASV02N160-4	4	160	10	58	38.1	6	42.3	9.52	45	171°	20	TVKX0202...
ASV02N160-E4	4	160	10	55	40	6	43.5	10	45	171°	20	TVKX0202...
ASV03N080-5	5	80	5	41	25.4	6.5	28	6.35	15	162°	10	TVKX03X3...
ASV03N080-E5	5	80	5	41	27	6.5	29.8	7	15	162°	10	TVKX03X3...
ASV03N100-5	5	100	6	48	31.75	6.5	35.2	7.92	20	165°	12	TVKX03X3...
ASV03N100-E5	5	100	6	47	32	6.5	34.8	8	20	165°	12	TVKX03X3...
ASV03N125-5	5	125	8	58	38.1	6.5	42.3	9.52	30	168.75°	16	TVKX03X3...
ASV03N125-E5	5	125	8	55	40	6.5	43.5	10	30	168.75°	16	TVKX03X3...
ASV03N160-5	5	160	10	58	38.1	6.5	42.3	9.52	45	171°	20	TVKX03X3...
ASV03N160-E5	5	160	10	55	40	6.5	43.5	10	45	171°	20	TVKX03X3...
ASV04N080-6	6	80	4	41	25.4	8	28	6.35	17	157.5°	8	TVKX04H3...
ASV04N080-E6	6	80	4	41	27	8	29.8	7	17	157.5°	8	TVKX04H3...
ASV04N100-6	6	100	5	48	31.75	8	35.2	7.92	23.5	162°	10	TVKX04H3...
ASV04N100-E6	6	100	5	47	32	8	34.8	8	23.5	162°	10	TVKX04H3...
ASV04N125-6	6	125	6	58	38.1	8	42.3	9.52	31	165°	12	TVKX04H3...
ASV04N125-E6	6	125	6	55	40	8	43.5	10	32.5	165°	12	TVKX04H3...
ASV04N160-6	6	160	8	58	38.1	8	42.3	9.52	48.5	168.75°	16	TVKX04H3...
ASV04N160-E6	6	160	8	55	40	8	43.5	10	50	168.75°	16	TVKX04H3...
ASV04N200-6	6	200	10	69	50.8	8	55.8	12.7	63	171°	20	TVKX04H3...
ASV04N200-E6	6	200	10	69	50	8	53.5	12	63	171°	20	TVKX04H3...
ASV05N080-8	8	80	4	41	25.4	10	28	6.35	17	157.5°	8	TVKX0504...
ASV05N080-E8	8	80	4	41	27	10	29.8	7	17	157.5°	8	TVKX0504...

Designation	W	ϕD_c	Z eff	ϕD_b	ϕd	Lf	b	a	Max. ae	θ	z	Insert
ASV05N100-8	8	100	5	48	31.75	10	35.2	7.92	23.5	162°	10	TVKX0504...
ASV05N100-E8	8	100	5	47	32	10	34.8	8	23.5	162°	10	TVKX0504...
ASV05N125-8	8	125	6	58	38.1	10	42.3	9.52	31	165°	12	TVKX0504...
ASV05N125-E8	8	125	6	55	40	10	43.5	10	32.5	165°	12	TVKX0504...
ASV05N160-8	8	160	8	58	38.1	10	42.3	9.52	48.5	168.75°	16	TVKX0504...
ASV05N160-E8	8	160	8	55	40	10	43.5	10	50	168.75°	16	TVKX0504...
ASV05N200-8	8	200	10	69	50.8	10	55.8	12.7	63	171°	20	TVKX0504...
ASV05N200-E8	8	200	10	69	50	10	53.5	12	63	171°	20	TVKX0504...

SPARE PARTS

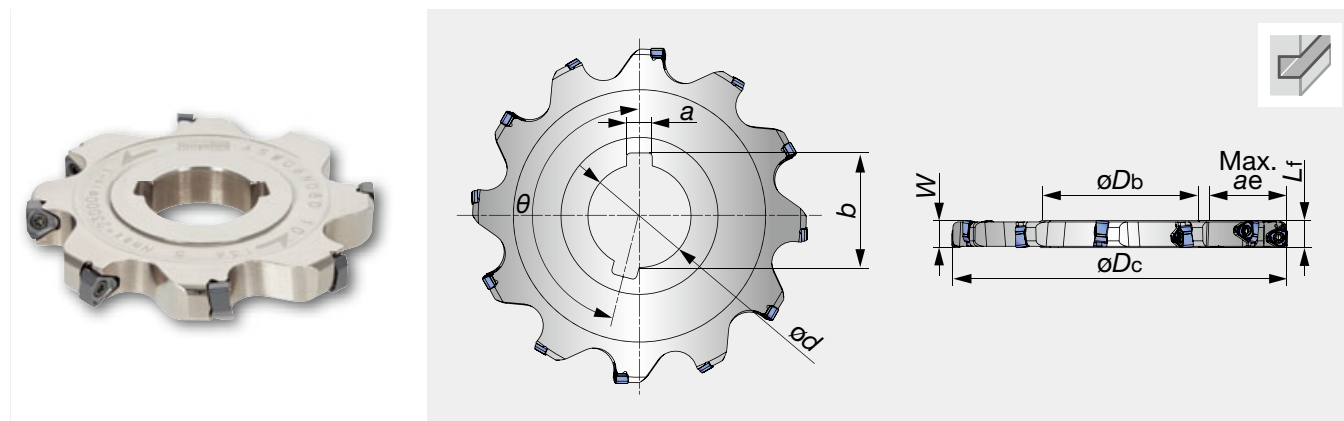


Designation	Clamping screw	Wrench			Lubricant
		Mono block type	Bit	Grip	
ASV02N...	SR114-018-L3.40	T-6D	-	-	M-1000
ASV03N...	SR114-018-L3.40	T-6D	-	-	M-1000
ASV04N...	SR14-500-L5.1	-	BT15S	H-TB2W	M-1000
ASV05N...	SR14-500-L7.0	-	BT15S	H-TB2W	M-1000

Axial drive type slot milling cutter

CUTTER - AXIAL DRIVE

TungUniversalSlot ASW + WNGU



Designation	W	øDc	Z eff	øDb	ød	Lf	b	a	Max. ae	θ	z	Insert
ASW06N080-10	10	80	4	41	25.4	10	28	6.35	18.5	157.5°	8	WNGU0603...
ASW06N080-E10	10	80	4	41	27	10	29.8	7	18.5	157.5°	8	WNGU0603...
ASW06N100-10	10	100	5	48	31.75	10	35.2	7.92	25	162°	10	WNGU0603...
ASW06N100-E10	10	100	5	47	32	10	34.8	8	25.5	162°	10	WNGU0603...
ASW06N125-10	10	125	6	58	38.1	10	42.3	9.52	32.5	165°	12	WNGU0603...
ASW06N125-E10	10	125	6	55	40	10	43.5	10	34	165°	12	WNGU0603...
ASW06N160-10	10	160	7	58	38.1	10	42.3	9.52	50	167.14°	14	WNGU0603...
ASW06N160-E10	10	160	7	55	40	10	43.5	10	51.5	167.14°	14	WNGU0603...
ASW07N100-12	12	100	5	48	31.75	12	35.2	7.92	25	162°	10	WNGU07T3...
ASW07N100-E12	12	100	5	47	32	12	34.8	8	25.5	162°	10	WNGU07T3...
ASW07N125-12	12	125	6	58	38.1	12	42.3	9.52	32.5	165°	12	WNGU07T3...
ASW07N125-E12	12	125	6	55	40	12	43.5	10	34	165°	12	WNGU07T3...
ASW07N160-12	12	160	7	58	38.1	12	42.3	9.52	50	167.14°	14	WNGU07T3...
ASW07N160-E12	12	160	7	55	40	12	43.5	10	51.5	167.14°	14	WNGU07T3...
ASW09N100-14	14	100	5	48	31.75	14	35.2	7.92	25	162°	10	WNGU0904...
ASW09N100-E14	14	100	5	47	32	14	34.8	8	25.5	162°	10	WNGU0904...
ASW09N160-14	14	160	7	58	38.1	14	42.3	9.52	50	167.14°	14	WNGU0904...
ASW09N160-E14	14	160	7	55	40	14	43.5	10	51.5	167.14°	14	WNGU0904...
ASW09N160-16	16	160	7	58	38.1	16	42.3	9.52	50	167.14°	14	WNGU0904...
ASW09N160-E16	16	160	7	55	40	16	43.5	10	51.5	167.14°	14	WNGU0904...

SPARE PARTS

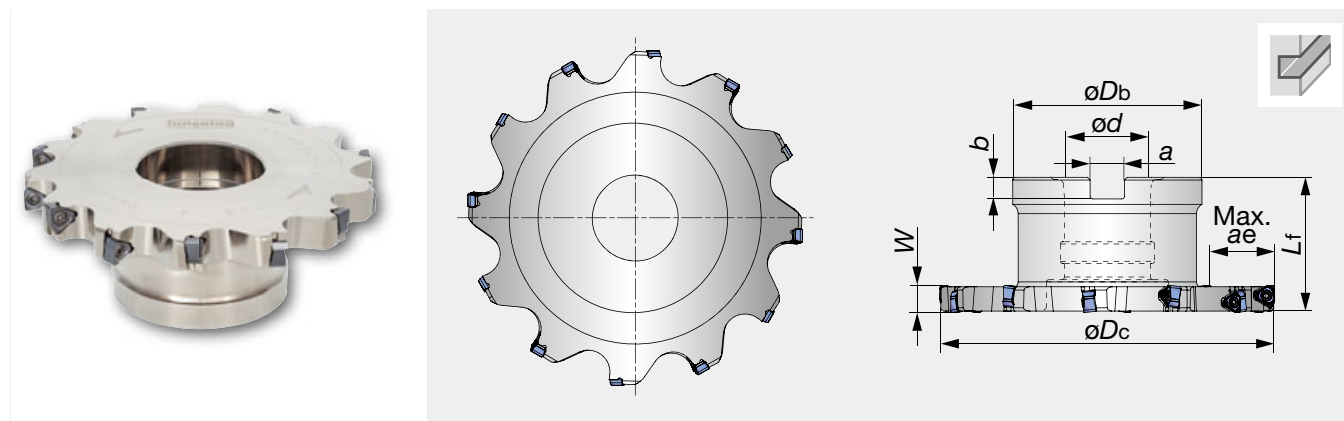


Designation	Clamping screw	Wrench				Grip	Lubricant
		Mono block type	Bit				
ASW06N...	CSPB-2.5	-	IP-8D	-	-	-	M-1000
ASW07N100...	CSPD-3	-	BLD IP10/S7	SW6-SD	-	-	M-1000
ASW07N125...	CSPD-3	-	BLD IP10/S7	SW6-SD	-	-	M-1000
ASW07N160...	CSPD-3	-	IP-10D	-	-	-	M-1000
ASW09N100...	-	CSPB-3.5	-	BLD IP15/S7	-	H-TB2W	M-1000
ASW09N160...	-	CSPB-3.5	IP-15D	-	-	-	M-1000

Radial drive type slot milling cutter

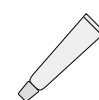
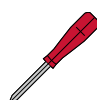
CUTTER - RADIAL DRIVE

TungUniversalSlot TSW + WNGU



Designation	W	øDc	Z eff	øDb	ød	Lf	b	a	Max. ae	z	Insert
TSW06R100-10	10	100	5	50	25.4	50	6	9.5	24	10	WNGU0603...
TSW06R100-E10	10	100	5	58	27	50	7	12.4	20	10	WNGU0603...
TSW06R125-10	10	125	6	70	31.75	50	8	12.7	26.5	12	WNGU0603...
TSW06R125-E10	10	125	6	66	32	50	8	14.4	28.5	12	WNGU0603...
TSW06R160-10	10	160	7	100	38.1	63	10	15.9	29	14	WNGU0603...
TSW06R160-E10	10	160	7	82	40	63	9	16.4	38	14	WNGU0603...
TSW07R100-12	12	100	5	50	25.4	50	6	9.5	24	10	WNGU07T3...
TSW07R100-E12	12	100	5	58	27	50	7	12.4	20	10	WNGU07T3...
TSW07R125-12	12	125	6	70	31.75	50	8	12.7	26.5	12	WNGU07T3...
TSW07R125-E12	12	125	6	66	32	50	8	14.4	28.5	12	WNGU07T3...
TSW07R160-12	12	160	7	100	38.1	63	10	15.9	29	14	WNGU07T3...
TSW07R160-E12	12	160	7	82	40	63	9	16.4	38	14	WNGU07T3...
TSW09R160-16	16	160	7	100	38.1	63	10	15.9	29	14	WNGU0904...
TSW09R160-E16	16	160	7	82	40	63	9	16.4	38	14	WNGU0904...

SPARE PARTS

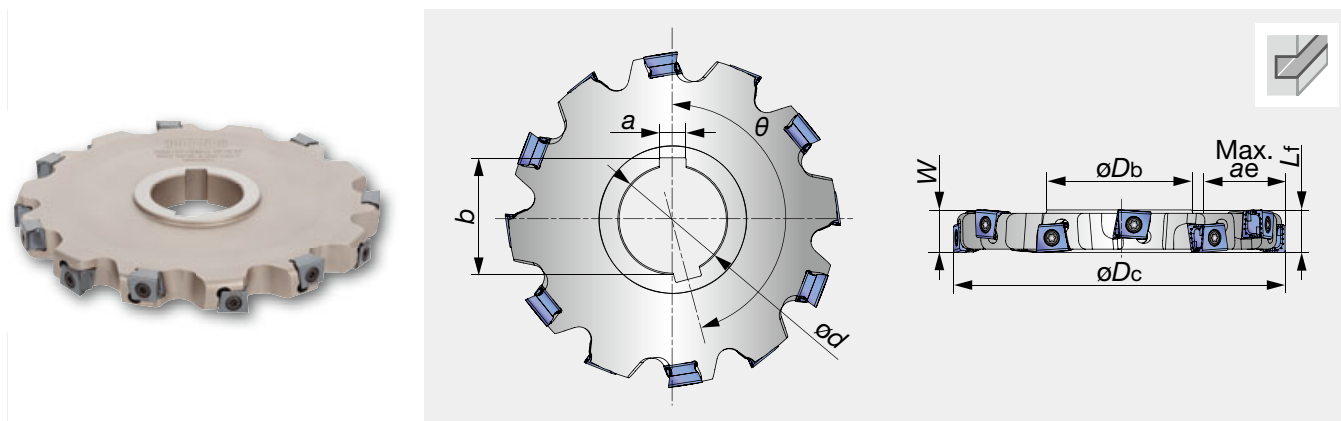


Designation	Clamping screw		Wrench			Lubricant
			Mono block type	Bit	Grip	
TSW06R...	CSPB-2.5	-	IP-8D	-	-	M-1000
TSW07R100...	CSPD-3	-	-	BLD IP10/S7	SW6-SD	M-1000
TSW07R125...	CSPD-3	-	-	BLD IP10/S7	SW6-SD	M-1000
TSW07R160...	CSPD-3	-	IP-10D	-	-	M-1000
TSW09R...	-	CSPB-3.5	IP-15D	-	-	M-1000

Axial drive type slot milling cutter with tangentially mounted inserts

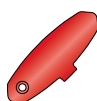
CUTTER - AXIAL DRIVE

TecTangentialSlot ASN + LMEU



Designation	W	ϕD_c	Z eff	ϕD_b	ϕd	Lf	b	a	Max. ae	θ	z	Insert
ASN10R100M31.7-16-05	16	100	5	48	31.75	16	35.2	7.92	25	162°	10	LMEU1008...
ASN10R100M32.0E16-05	16	100	5	47	32	16	34.8	8	25.5	162°	10	LMEU1008...
ASN10R125M38.1-16-06	16	125	6	58	38.1	16	42.3	9.52	32.5	165°	12	LMEU1008...
ASN10R125M40.0E16-06	16	125	6	55	40	16	43.5	10	34	165°	12	LMEU1008...
ASN10R160M38.1-16-07	16	160	7	58	38.1	16	42.3	9.52	50	167.14°	14	LMEU1008...
ASN10R160M40.0E16-07	16	160	7	55	40	16	43.5	10	51.5	167.14°	14	LMEU1008...
ASN10R200M50.0E16-08	16	200	8	69	50	16	53.6	12	64.5	168.75°	16	LMEU1008...
ASN12R100M31.7-19-05	19	100	5	48	31.75	19	35.2	7.92	25	162°	10	LMEU1208...
ASN12R100M32.0E19-05	19	100	5	47	32	19	34.8	8	25.5	162°	10	LMEU1208...
ASN12R125M38.1-19-06	19	125	6	58	38.1	19	42.3	9.52	32.5	165°	12	LMEU1208...
ASN12R125M40.0E19-06	19	125	6	55	40	19	43.5	10	34	165°	12	LMEU1208...
ASN12R160M38.1-19-07	19	160	7	58	38.1	19	42.3	9.52	50	167.14°	14	LMEU1208...
ASN12R160M40.0E19-07	19	160	7	55	40	19	43.5	10	51.5	167.14°	14	LMEU1208...
ASN12R200M50.0E19-08	19	200	8	69	50	19	53.6	12	64.5	168.75°	16	LMEU1208...
ASN12R250M50.0E19-09	19	250	9	84	50	19	53.6	12	82	170°	18	LMEU1208...
ASN15R125M38.1-25-05	25	125	5	58	38.1	25	42.3	9.52	32.5	162°	10	LMEU1509...
ASN15R125M40.0E25-05	25	125	5	55	40	25	43.5	10	34	162°	10	LMEU1509...
ASN15R160M38.1-25-06	25	160	6	58	38.1	25	42.3	9.52	50	165°	12	LMEU1509...
ASN15R160M40.0E25-06	25	160	6	55	40	25	43.5	10	51.5	167.14°	12	LMEU1509...
ASN15R200M50.0E25-07	25	200	7	69	50	25	53.6	12	64.5	168.75°	14	LMEU1509...
ASN15R250M50.0E25-08	25	250	8	84	50	25	53.6	12	82	170°	16	LMEU1509...

SPARE PARTS

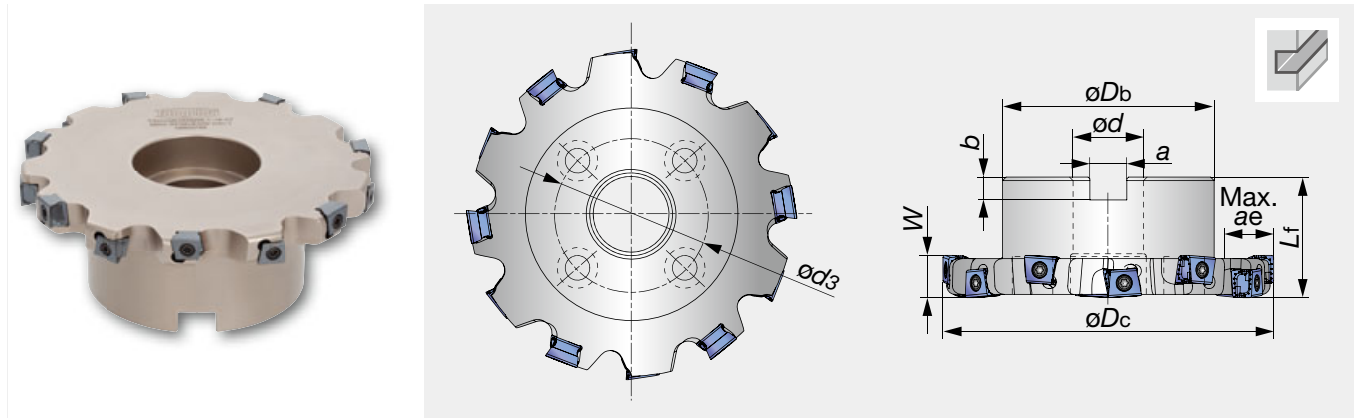


Designation	Clamping screw	Wrench	
		Bit	Grip
ASN10R...	SM40-143-H0	BT15S	H-TB
ASN12R...	SM40-143-H0	BT15S	H-TB
ASN15R...	CSTB-5L159	BT20S	H-TB

Radial drive type slot milling cutter with tangentially mounted inserts

CUTTER - RADIAL DRIVE

TecTangentialSlot TSN + LMEU



Designation	W	ϕD_c	Z eff	ϕD_b	ϕd	Lf	b	a	Max. ae	ϕd_3	z	Insert
TSN10R100M25.4-16-05	16	100	5	50	25.4	50	6	9.5	24	-	10	LMEU1008...
TSN10R100M27.0E16-05	16	100	5	58	27	50	7	12.4	20	-	10	LMEU1008...
TSN10R125M31.7-16-06	16	125	6	70	31.75	50	8	12.7	26.5	-	12	LMEU1008...
TSN10R125M32.0E16-06	16	125	6	66	32	50	8	14.4	28.5	-	12	LMEU1008...
TSN10R160M38.1-16-07	16	160	7	100	38.1	63	10	15.9	29	-	14	LMEU1008...
TSN10R160M40.0E16-07	16	160	7	82	40	63	9	16.4	38	-	14	LMEU1008...
TSN10R200M47.6-16-08	16	200	8	135	47.625	63	14	25.4	31.5	101.6	16	LMEU1008...
TSN10R200M40.0E16-08	16	200	8	88	40	63	9	16.4	55	66.7	16	LMEU1008...
TSN12R100M25.4-19-05	19	100	5	50	25.4	50	6	9.5	24	-	10	LMEU1208...
TSN12R100M27.0E19-05	19	100	5	58	27	50	7	12.4	20	-	10	LMEU1208...
TSN12R125M31.7-19-06	19	125	6	70	31.75	50	8	12.7	26.5	-	12	LMEU1208...
TSN12R125M32.0E19-06	19	125	6	66	32	50	8	14.4	28.5	-	12	LMEU1208...
TSN12R160M38.1-19-07	19	160	7	100	38.1	63	10	15.9	29	-	14	LMEU1208...
TSN12R160M40.0E19-07	19	160	7	82	40	63	9	16.4	38	-	14	LMEU1208...
TSN12R200M40.0E19-08	19	200	8	88	40	63	9	16.4	55	66.7	16	LMEU1208...
TSN12R200M47.6-19-08	19	200	8	135	47.625	63	14	25.4	31.5	101.6	16	LMEU1208...
TSN12R250M47.6-19-09	19	250	9	140	47.625	63	14	25.4	54	101.6	18	LMEU1208...
TSN12R250M60.0E19-09	19	250	9	135	60	63	14	25.7	56.5	101.6	18	LMEU1208...
TSN15R125M31.7-25-05	25	125	5	70	31.75	50	8	12.7	26.5	-	10	LMEU1509...
TSN15R125M32.0E25-05	25	125	5	66	32	50	8	14.4	28.5	-	10	LMEU1509...
TSN15R160M38.1-25-06	25	160	6	100	38.1	63	10	15.9	29	-	12	LMEU1509...
TSN15R160M40.0E25-06	25	160	6	82	40	63	9	16.4	38	-	12	LMEU1509...
TSN15R200M40.0E25-07	25	200	7	95	40	63	9	16.4	51.5	66.7	14	LMEU1509...
TSN15R200M47.6-25-07	25	200	7	135	47.625	63	14	25.4	31.5	101.6	14	LMEU1509...
TSN15R250M47.6-25-08	25	250	8	140	47.625	63	14	25.4	54	101.6	16	LMEU1509...
TSN15R250M60.0E25-08	25	250	8	135	60	63	14	25.7	56.5	101.6	16	LMEU1509...

SPARE PARTS

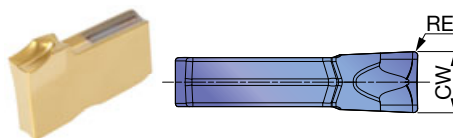


Designation	Clamping screw	Wrench	
		Bit	Grip
TSN10R...	SM40-143-H0	BT15S	H-TB
TSN12R...	SM40-143-H0	BT15S	H-TB
TSN15R...	CSTB-5L159	BT20S	H-TB

SSM



SSS



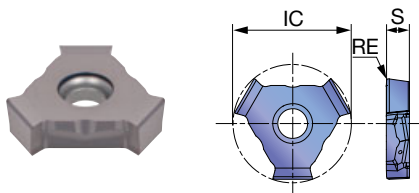
P	Steel	★		
M	Stainless	★		
K	Cast iron	★		
N	Non-ferrous			
S	Superalloys			
H	Hard materials			

★ : First choice
☆ : Second choice

Designation	RE	Coated							CW±0.04
		GH130							
SSM22N	0.2	●							2.2
SSM31N	0.2	●							3.1
SSM41N	0.25	●							4.1
SSS16N	0.16	●							1.6
SSS22N	0.2	●							2.2
SSS31N	0.2	●							3.1
SSS41N	0.25	●							4.1

● : Line up

TVKX-MJ



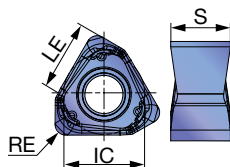
P	Steel	☆		★	★	
M	Stainless		★	☆	☆	
K	Cast iron	★		☆	☆	
N	Non-ferrous					
S	Superalloys	★	☆	★	★	
H	Hard materials					

★ : First choice
☆ : Second choice

[illegible]

● : Line up

WNGU-MJ



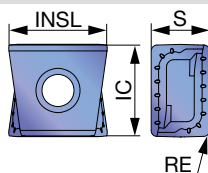
P	Steel	☆	★	★	★
M	Stainless		★	☆	★
K	Cast iron	★		☆	
N	Non-ferrous				
S	Superalloys	★	☆	★	
H	Hard materials				

★ : First choice
☆ : Second choice

Designation	RE	Coated				LE	IC	S
		AH120	AH130	AH725	AH3135			
WNGU060304TN-MJ	0.4	●			●	5.6	6.1	4.4
WNGU060308TN-MJ	0.8	●	●	●	●	5.6	6.1	4.4
WNGU060310TN-MJ	1	●			●	5.6	6.1	4.4
WNGU060316TN-MJ	1.6	●	●	●		5.6	6.1	4.4
WNGU060320TN-MJ	2	●			●	5.6	6.1	4.4
WNGU07T304TN-MJ	0.4	●			●	6.8	7.4	5.5
WNGU07T308TN-MJ	0.8	●	●	●		6.8	7.4	5.5
WNGU07T310TN-MJ	1	●			●	6.8	7.4	5.5
WNGU07T316TN-MJ	1.6	●	●	●		6.8	7.4	5.5
WNGU07T320TN-MJ	2	●			●	6.8	7.4	5.5
WNGU090404TN-MJ	0.4	●			●	8.5	8.6	6.5
WNGU090408TN-MJ	0.8	●	●	●		8.5	8.6	6.5
WNGU090410TN-MJ	1	●			●	8.5	8.6	6.5
WNGU090416TN-MJ	1.6	●	●	●		8.5	8.6	6.5
WNGU090420TN-MJ	2	●			●	8.5	8.6	6.5

● : Line up

LMEU-MJ



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

★ : First choice
☆ : Second choice

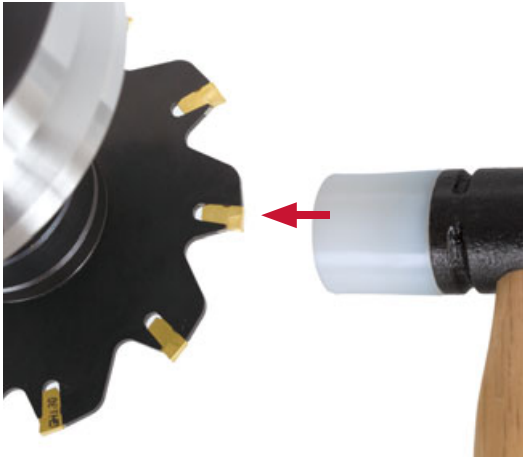
Designation	RE	Coated				INSL	IC	S
		AH120	AH140	AH725	AH3135			
LMEU100808ZNEN-MJ	0.8	●	●	●	●	12.7	10.5	8
LMEU100810ZNEN-MJ	1	●			●	12.7	10.5	8
LMEU100816ZNEN-MJ	1.6	●	●	●	●	12.5	10.5	8
LMEU100820ZNEN-MJ	2	●			●	12.4	10.5	8
LMEU100824ZNEN-MJ	2.4	●	●	●	●	12.4	10.5	8
LMEU100830ZNEN-MJ	3	●			●	12.2	10.5	8
LMEU100832ZNEN-MJ	3.2	●	●	●	●	12.2	10.5	8
LMEU120808ZNEN-MJ	0.8	●	●	●	●	13.6	12.7	8
LMEU120816ZNEN-MJ	1.6	●	●	●	●	13.4	12.7	8
LMEU120820ZNEN-MJ	2	●			●	13.3	12.7	8
LMEU120824ZNEN-MJ	2.4	●	●	●	●	13.2	12.7	8
LMEU120830ZNEN-MJ	3	●			●	13.1	12.7	8
LMEU120832ZNEN-MJ	3.2	●	●	●	●	13.1	12.7	8
LMEU150908ZNEN-MJ	0.8	●	●	●	●	15.6	15	9.5
LMEU150916ZNEN-MJ	1.6	●	●	●	●	15.4	15	9.5
LMEU150920ZNEN-MJ	2	●			●	15.4	15	9.5
LMEU150924ZNEN-MJ	2.4	●	●	●	●	15.3	15	9.5
LMEU150930ZNEN-MJ	3	●			●	15.2	15	9.5
LMEU150932ZNEN-MJ	3.2	●	●	●	●	15.1	15	9.5
LMEU150940ZNEN-MJ*	4	●			●	14.9	15	9.5
LMEU150950ZNEN-MJ*	5	●			●	14.7	15	9.5

* Please note that LMEU150940 and LMEU150950 inserts are for special cutter bodies only and do not fit standard versions.

● : Line up

INSERT INSTALLATION AND REMOVAL

Installation



Before installing inserts, clear chips and dust from the insert seats by air blast or waste rag.

Lightly press the insert into the insert seat by hand, then use a plastic hammer to fix the insert in firmly into the position.

Make sure that there is no gap between the insert and the insert seat.



OK



X

Removal

SSG01/02 type



Insert the wrench (included in the package) in the hole and tilt the wrench in the arrowed direction.

SSG03/04 type



Insert the wrench in the hole and turn the wrench to the arrowed direction.

STANDARD CUTTING CONDITIONS

S/ASG type

ISO	Work piece materials	Hardness (HB)	Insert	Cutting speed V _c (m/min)	Chip thickness t (mm)
P	Low carbon steel (SS400, S15C, etc.)	- 200	SSM...	150 - 230	0.05 - 0.15
	High carbon steel (S45C, S55C, etc.)	200 - 300	SSM...	100 - 170	0.04 - 0.13
	Alloy steels (SCM440, SCr415, etc.)	150 - 300	SSM...	90 - 160	0.04 - 0.13
	Tool steel (SKD11, SKD61, etc.)	- 300	SSM...	70 - 120	0.04 - 0.13
M	Stainless steel (SUS304, SUS316, etc.)	-	SSS...	90 - 200	0.04 - 0.13
K	Grey cast iron (FC250, FC300, etc.)	150 - 250	SSM...	100 - 200	0.05 - 0.15
	Ductile cast iron (FCD400, etc.)	150 - 250	SSM...	80 - 130	0.05 - 0.15



STANDARD CUTTING CONDITIONS

ASV, ASW / TSW, ASN / TSN type

ISO	Workpiece materials	Hardness	Priority	Grades	Cutting speed	Feed per edge line: fz (mm/t)	
						ASV	
						ae / øDc (mm)	
		(HB)			Vc (m/min)	10%	20%
P	Low carbon steel (SS400 / E275A, etc.)	- 200	First choice	AH725	90 - 180	0.08 - 0.25	0.06 - 0.19
		- 200	For impact resistance	AH130, AH140	90 - 180	0.08 - 0.25	0.06 - 0.19
	High carbon steel (S45C / C45, etc.)	200 - 300	First choice	AH725	90 - 180	0.07 - 0.22	0.05 - 0.16
		200 - 300	For impact resistance	AH130, AH140	90 - 180	0.07 - 0.22	0.05 - 0.16
	Alloy steel (SCM440 / 42CrMo4, etc.)	150 - 300	First choice	AH725	90 - 180	0.07 - 0.22	0.05 - 0.16
		150 - 300	For impact resistance	AH130, AH140	90 - 180	0.07 - 0.22	0.05 - 0.16
	Tool steel (SKD61 / X40CrMoV5-1, etc.)	- 300	First choice	AH725	90 - 180	0.07 - 0.22	0.05 - 0.16
		- 300	For impact resistance	AH130, AH140	90 - 180	0.07 - 0.22	0.05 - 0.16
M	Stainless steel (SUS304 / X5CrNi18-9, etc.)	-	-	AH130, AH140	90 - 200	0.07 - 0.22	0.05 - 0.16
K	Grey cast iron (FC250 / 250, etc.)	150 - 250	-	AH120	120 - 230	0.08 - 0.25	0.06 - 0.19
	Ductile cast iron (FCD400, etc.)	150 - 250	-	AH120	90 - 150	0.08 - 0.25	0.06 - 0.19
S	Titanium alloys (Ti-6Al-4V, etc.)	-	First choice	AH725	30 - 40	0.07 - 0.12	0.05 - 0.09
		-	For impact resistance	AH130	30 - 40	0.07 - 0.12	0.05 - 0.09
	Nickel-based alloys (Inconel 718, etc.)	-	First choice	AH725	20 - 35	0.07 - 0.12	0.05 - 0.09
		-	For impact resistance	AH130	20 - 35	0.07 - 0.12	0.05 - 0.09

■ Chip thickness “t”

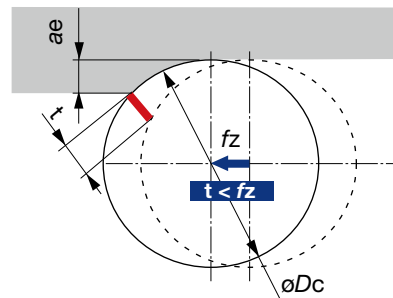
- Chip thickness “t” is one of the most important factors for chip evacuation in slot milling.
- Therefore, setup feed per edge line (fz) should be calculated according to chip thickness (t).

Slotting with a slot milling cutter

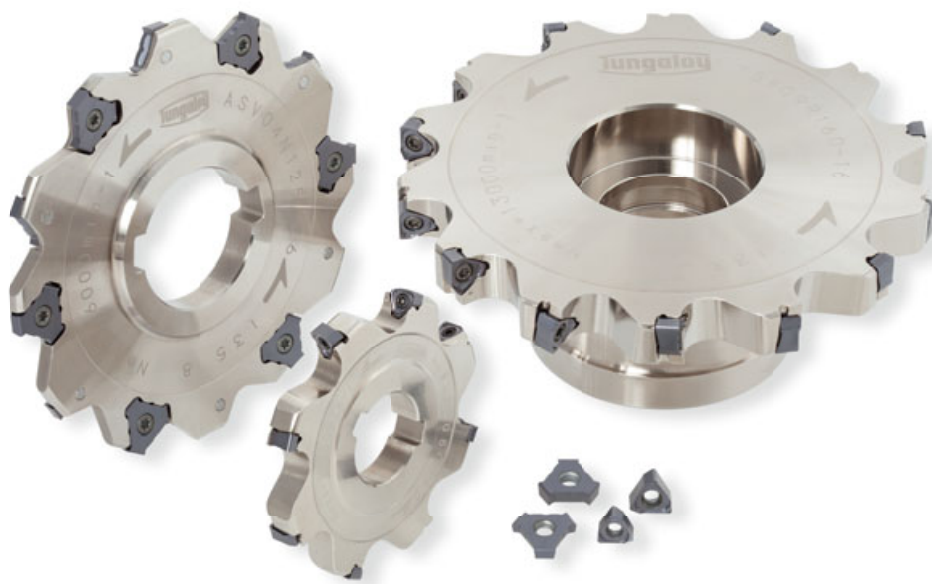
$$t \cong 2 \times fz \times \sqrt{(ae / \phi Dc) \times (1 - (ae / \phi Dc))}$$

$$fz \cong t / 2 / \sqrt{(ae / \phi Dc) \times (1 - (ae / \phi Dc))}$$

ϕDc : Tool diameter (mm)
 fz : Feed per edge line (mm/t)
 ae : Depth of slot (mm)



Feed per edge line: fz (mm/t)									
ASV		ASW / TSW				ASN / TSN			
ae / øDc (mm)		ae / øDc (mm)				ae / øDc (mm)			
30%	≤ 50%	10%	20%	30%	≤ 50%	10%	20%	30%	≤ 50%
0.05 - 0.16	0.05 - 0.15	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.05 - 0.16	0.05 - 0.15	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.04 - 0.14	0.04 - 0.13	0.12 - 0.33	0.09 - 0.25	0.07 - 0.21	0.07 - 0.2	0.22 - 0.42	0.16 - 0.31	0.14 - 0.27	0.13 - 0.25
0.05 - 0.16	0.05 - 0.15	0.12 - 0.42	0.09 - 0.31	0.07 - 0.27	0.07 - 0.25	0.22 - 0.5	0.16 - 0.38	0.14 - 0.32	0.13 - 0.3
0.05 - 0.16	0.05 - 0.15	0.12 - 0.42	0.09 - 0.31	0.07 - 0.27	0.07 - 0.25	0.22 - 0.33	0.16 - 0.25	0.14 - 0.21	0.13 - 0.2
0.04 - 0.07	0.04 - 0.07	0.1 - 0.17	0.08 - 0.13	0.06 - 0.11	0.06 - 0.1	0.12 - 0.22	0.09 - 0.16	0.07 - 0.14	0.07 - 0.13
0.04 - 0.07	0.04 - 0.07	0.1 - 0.17	0.08 - 0.13	0.06 - 0.11	0.06 - 0.1	0.12 - 0.22	0.09 - 0.16	0.07 - 0.14	0.07 - 0.13
0.04 - 0.07	0.04 - 0.07	0.1 - 0.17	0.08 - 0.13	0.06 - 0.11	0.06 - 0.1	0.12 - 0.22	0.09 - 0.16	0.07 - 0.14	0.07 - 0.13
0.04 - 0.07	0.04 - 0.07	0.1 - 0.17	0.08 - 0.13	0.06 - 0.11	0.06 - 0.1	0.12 - 0.22	0.09 - 0.16	0.07 - 0.14	0.07 - 0.13



GUIDELINE FOR ORDERING SPECIAL TOOL

Tailor made cutters and inserts are available upon request. Please verify if your desired specification is possible from the table below. When requesting the quotation, please fill in the information sheet on the next page and send it to us.

Cutter

(A) Edge width: Depending on the edge width, insert type should be selected. (Please see Table #1 for detail.)

(B) Tool diameter: Depending on the insert type selected, tool diameter may be limited.

(C) Mount specification, bore diameter: For mount specification, axial drive or radial drive can be selected. If other specification is required, please provide the specification on the information sheet.

Tool designation can be determined with information A, B and C

Table #1: Available range of edge width and tool diameter

Edge width W (mm)	Insert Designation	Tool Designation (tool shape)	Tool diameter range ⁽²⁾ øDc (mm)
4.0 - 4.5	TVKX02***	ASV02...	ø50 -
4.5 - 6.0	TVKX03***	ASV03...	ø50 -
6.0 - 7.4	TVKX04**** ⁽¹⁾	T/ASV04...	ø80 -
7.4 - 9.0	TVKX05**** ⁽¹⁾	T/ASV05...	ø80 -
8.7 - 11.0	WNGU0603**	T/ASW06...	ø50 -
10.6 - 13.2	WNGU07T3**	T/ASW07...	ø50 -
12.6 - 16.7	WNGU0904**	T/ASW09...	ø50 -
15.1 - 18.6	LMEU1008**	T/ASN10...	ø80 -
17.5 - 23.1	LMEU1208**	T/ASN12...	ø80 -
19.8 - 27.6	LMEU1509**	T/ASN15...	ø80 -

(1) Special inserts may be required depending on the edge width.

(2) Max tool diameter should be confirmed when requesting quotation.

Example of tool designation

T		SW06		R	110.5 - 9.8		M	25.4		
1		2		3	4		5	6	7	
1 Mount specification				4 Tool diameter øDc (mm)				6 Bore specification		
T		Radial drive		100		ø100		M		JIS
A		Axial drive		110.5		ø110.5		E		ISO
2 Tool shape				5 Edge width W (mm)				7 Bore diameter ød (mm)		
Please see table #1				9.8		9.8		25.4		ø25.4
3 Hand of tool				11		11		27.0		ø27.0
R		Right								
L		Left								

Insert

Special corner radius is available.

Available range

Insert Designation	Edge width W (mm)	Corner radius r _ε (mm)	Grades
SSM...	1.70 - 2.52	0.2 - 1.0	GH130
	2.53 - 3.52	0.2 - 1.5	
	3.53 - 4.52	0.2 - 2.0	
TVKX02,03	-	0 - 1.0	AH725, AH130, AH120
TVKX04,05	-	0 - 2.0	

Insert Designation	Corner radius r _ε (mm)	Grades
WNGU06	0 - 2.0	AH725, AH130, AH120
WNGU07	0 - 2.4	
WNGU09	0 - 2.8	
LMEU...	0.4 - 4.0	AH725, AH140, AH120

Example of insert designation

WNGU07T3		08	-	12345	AH725
1		2		3	4
1 Insert shape		2 Corner radius r_{ϵ} (mm)		3 Identification #	
Please see table #1		08	0.8	Decided by Tungaloy	
		13	1.3		
4 Grade					

■ Information sheet for quotation & order

When requesting a quotation,
please make a COPY of this page and send to us.

Company:

Name:

Phone:

Tool information

Tool diameter: $\varnothing D_c$	$\varnothing D_c =$ mm	Sketch of tool:
Edge width: W	$W =$ mm	
Tool type	☐ Axial drive ☐ Radial drive ☐ Other	
Bore diameter: $\varnothing d$	$\varnothing d =$ mm	
Corner radius: r_ϵ	$r_\epsilon =$ mm	

Tool Designation:

Insert Designation:

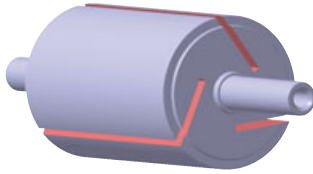
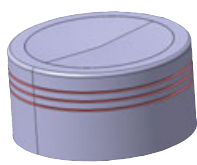
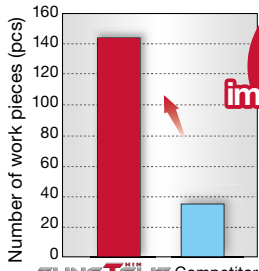
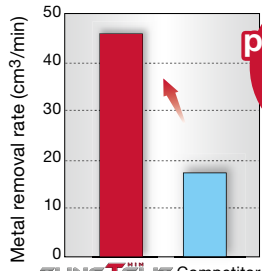
Workpiece information

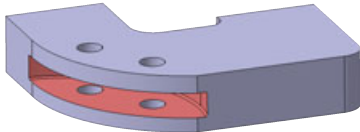
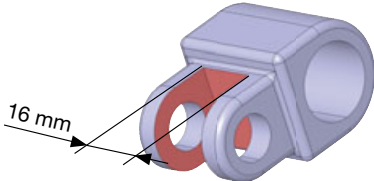
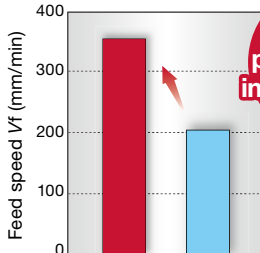
Tolerance of slot width required		Sketch of component:
Slot depth	mm	
Name of component		
Material, hardness		

Machine information

Machine type	☐ Horizontal ☐ Vertical ☐ Other	Note: e.g. Angled head attachment is used.
Spindle motor power		
Spindle adaptation		

PRACTICAL EXAMPLES

Workpiece type		Rotor	Piston head
Cutter		ASV02N160-E4 (ø100, 5 edge lines)	ASV05N100-8 (ø100, 5 edge lines)
Insert		TVKX020204-TN MJ	TVKX050404TN-MJ
Grade		AH130	AH725
Workpiece material		AVP- Alloyed Steel P40	Alloy steel
		 P	 P
Cutting conditions	Cutting speed: V_c (m/min)	161	120
	Chip thickness: t (mm)	0.01	0.12
	Feed per edge line: f_z (mm/t)	0.07	0.15
	Feed speed : V_f (mm/min)	200	286
	Edge width : W (mm)	4	8
	Depth of slot: a_e (mm)	41	20
	Coolant	Air blast	Dry
	Machine	ISO50, 20Kw, 3Axis VMC	HSK100
Results		 4 times tool life improvement! TungThinSlit could machine the complete slot in one pass without finish as the surface quality was good.	 productivity 3 times! Due to the incredible rigidity, 3 times higher productivity and improved surface finish are achieved without chattering.

Workpiece type		Machine parts	Machine parts												
Cutter		ASW06N100-10 (ø100, 5 edge lines)	TSN10R125M31.7-16-06 (ø125, 6 edge lines)												
Insert		WNGU060308TN-MJ	LMEU100808ZNEN-MJ												
Grade		AH725	AH120												
Workpiece material		SKD11 / X153CrMoV12	FCD450 / 450-10S												
															
Cutting conditions	Cutting speed: V_c (m/min)	110	150												
	Chip thickness: t (mm)	0.08	0.12												
	Feed per edge line: f_z (mm/t)	0.1	0.16												
	Feed speed : V_f (mm/min)	175	358												
	Edge width : W (mm)	10	16												
	Depth of slot: a_e (mm)	23	22												
	Coolant	Dry	Dry												
Machine	Vertical M/C, BT40	Vertical M/C, BT50													
Results	<table><tr><td></td><td>TUNG UNIVERSAL SLOT</td><td>Competitor</td></tr><tr><td>Number of passes</td><td>1</td><td>2</td></tr><tr><td>Chip evacuation</td><td>Good</td><td>Bad</td></tr><tr><td>Chattering</td><td>No</td><td>With</td></tr></table>			TUNG UNIVERSAL SLOT	Competitor	Number of passes	1	2	Chip evacuation	Good	Bad	Chattering	No	With	 70% productivity improvement! Higher feed per cutting edge can be applied, as the TecTangentialSlot is tougher than conventional inserts.
		TUNG UNIVERSAL SLOT	Competitor												
	Number of passes	1	2												
	Chip evacuation	Good	Bad												
Chattering	No	With													
TungUniversalSlot creates fine surface finish due to the excellent chip evacuation. Metal saw has chattering because of the number of effective edges. TungUniversalSlot machines without any vibration because of the optimum number of edges.															

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-NTK 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-NTK 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-NTK 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-NTK Germany GmbH.

Katzbergstr. 3a
D-40764 Langenfeld, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.com/de

Tungaloy France s.a.s

Les Fjords
19 avenue de Norvège
91140 Villebon Sur Yvette, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.com/fr

Tungaloy Italia S.r.l.

Viale Sarca 336/Edificio 13
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
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-NTK UK Ltd.

Suite 3, Pioneer House, Mill Street,
Cannock, WS11 0EF, 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,
Xinzhuan Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy-NTK Cutting Tool (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/singapore

Tungaloy-NTK Vietnam LLC

3rd Floor, Licogi 13 Tower, 164 Khuat Duy
Tien, Nhan Chinh, Thanh Xuan District,
Hanoi, Vietnam
Phone: +84 24 63282086
www.tungaloy.com/vn

Tungaloy India Pvt. Ltd.

One International Center,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai 400013, India
Phone: +91-22-6124-8803
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

Ruko Blok AA.10 No3&5, Grand Wisata,
Lembangjaya, Tambun Selatan, Bekasi,
17510 Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
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