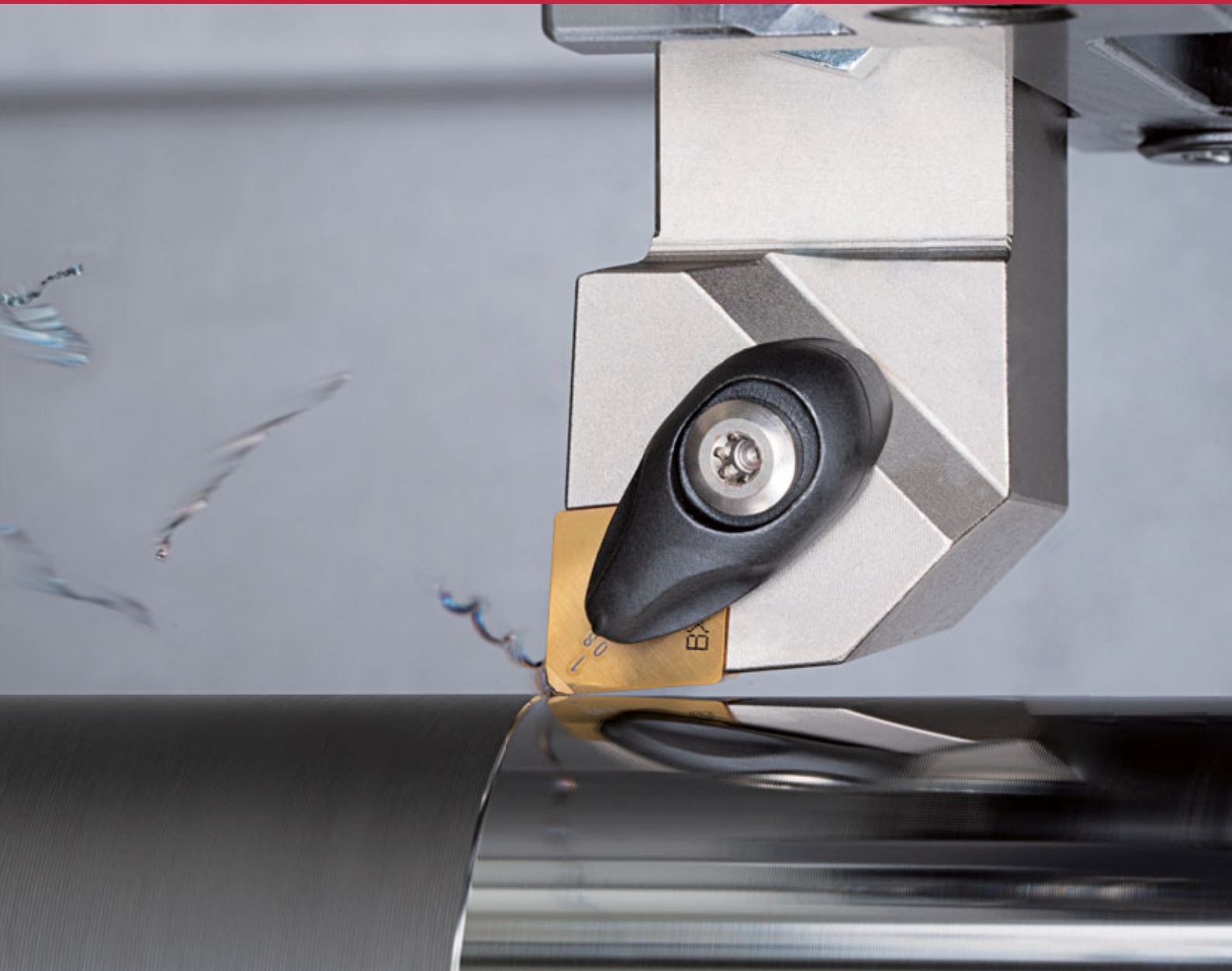


T-CBN HARDBREAKER HP

www.tungaloy.com

Tungaloy Report No. 518S1-G

Now available in BXA10 for effective chipbreaking in hard turning



INDUSTRY 4.0
FEED the SPEED!

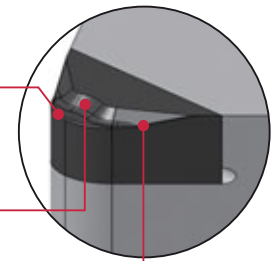
Available in new BXA10 allowing a wider application coverage

- 1 By separating the chipbreaker from the cutting edge, the cutting force imposed on the cutting edge during machining is significantly reduced, thus providing long tool life.
- 2 The cutting edge preparation is designed to ensure easy cutting at low cutting forces, while maintaining close tolerances with no deviations.
- 3 The **HP** style chipbreaker, combined with built-in wipers, yields excellent surface quality and good chip control.



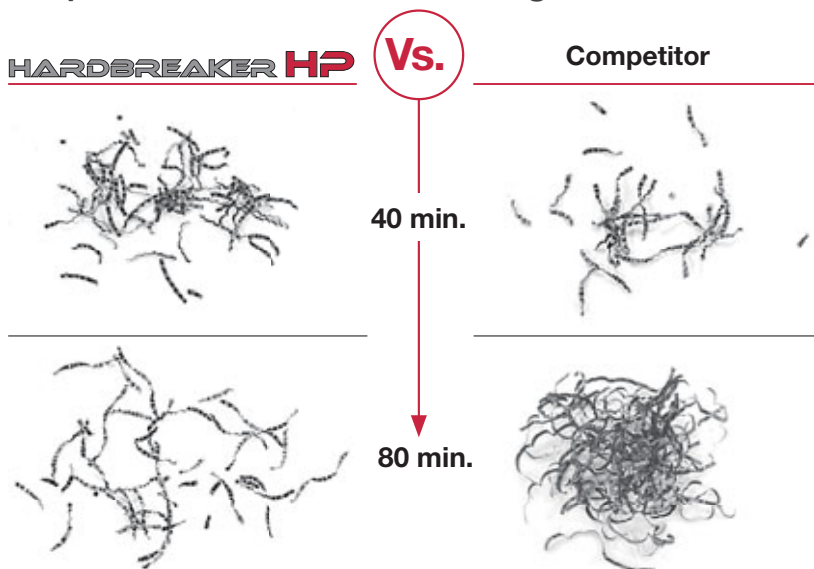
Optimized edge preparation for low cutting force

HP chipbreaker
Wiper



CUTTING PERFORMANCE

Chip control is stable for a long time



Insert : 2QP-CNGM120408-HP
 Workpiece material : JIS SCM420 58HRC
 Cutting speed : $V_c = 180$ m/min
 Feed : $f = 0.15$ mm/rev
 Depth of cut : $a_p = 0.15$ mm
 Holder : ACLNR2525M12-A
 Coolant : Wet
 Machining : External continuous cutting

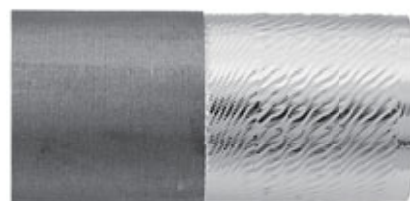
Chatter stability

HARDBREAKER HP



Due to low cutting force, chatter stability is greatly improved

Competitor (without breaker)



INSERT

NEGATIVE TYPE

- : Continuous cutting
- ◐ : Light interrupted cutting
- ✱ : Heavy interrupted cutting

		Material				Dimension (mm)					Edge prep.						
Shape	Designation	BXA10	BXA20	BXM10	No. of corners	LE	RE	IC	S	D1	Standard	Sharp edge	L	LFLC	H	Wiper	Chipbreaker
		P															
		M															
		K															
		N															
		S															
		H	●	●	●												
	2QP-CNGM**-H*	●	●	●													
	2QP-CNGM120404-HP	●	●	●	2	2.3	0.4	12.7	4.76	5.16							○
	2QP-CNGM120408-HP	●	●	●	2	2.2	0.8	12.7	4.76	5.16							○
	2QP-CNGM120412-HP	●	●	●	2	2.4	1.2	12.7	4.76	5.16							○
	2QP-CNGM120408WL-HP	●	●	●	2	2.2	0.8	12.7	4.76	5.16							○
	2QP-DNGM**-H*	●	●	●													
	2QP-DNGM150404-HP	●	●	●	2	2.5	0.4	12.7	4.76	5.16							○
	2QP-DNGM150408-HP	●	●	●	2	2.1	0.8	12.7	4.76	5.16							○
	2QP-DNGM150412-HP	●	●	●	2	2	1.2	12.7	4.76	5.16							○
	2QP-DNGM150608-HP	●	●	●	2	2.1	0.8	12.7	6.35	5.16							○
	2QP-GNGG**-HP	●	●	●													
	2QP-GNGG120404-HP	●	●	●	2	2.1	0.4	12.7	4.76	5.16							○
1)	2QP-GNGG120408-HP	●	●	●	2	2.1	0.8	12.7	4.76	5.16							○
	2QP-GNGG120412-HP	●	●	●	2	2.2	1.2	12.7	4.76	5.16							○
	3QP-TNGM**-H*	●	●	●													
	3QP-TNGM160404-HP	●	●	●	3	2.2	0.4	9.525	4.76	3.81							○
	3QP-TNGM160408-HP	●	●	●	3	1.9	0.8	9.525	4.76	3.81							○
	3QP-TNGM160412-HP	●	●	●	3	2.4	1.2	9.525	4.76	3.81							○
	2QP-VNGM**-H*	●	●	●													
	2QP-VNGM160404-HP	●	●	●	2	3.1	0.4	9.525	4.76	3.81							○
	2QP-VNGM160408-HP	●	●	●	2	2.2	0.8	9.525	4.76	3.81							○

1) Tungaloy's standard

POSITIVE TYPE

		Material				Dimension (mm)					Edge prep.						
Shape	Designation	BXA10	BXA20	BXM10	No. of corners	LE	RE	IC	S	D1	Standard	Sharp edge	L	LFLC	H	Wiper	Chipbreaker
		P															
		M															
		K															
		N															
		S															
		H	●	●	●												
	2QP-CCGT**-HP	●	●	●													
	2QP-CCGT060204-HP	●	●	●	2	2.3	0.4	6.35	2.38	2.8							○
	2QP-CCGT09T304-HP	●	●	●	2	2.3	0.4	9.525	3.97	4.4							○
	2QP-CCGT09T308-HP	●	●	●	2	2.2	0.8	9.525	3.97	4.4							○
	2QP-CCGT09T304WL-HP	●	●	●	2	2.3	0.4	9.525	3.97	4.4							○
	2QP-CCGT09T308WL-HP	●	●	●	2	2.2	0.8	9.525	3.97	4.4							○
	2QP-DCGT**-HP	●	●	●													
	2QP-DCGT070204-HP	●	●	●	2	2.5	0.4	6.35	2.38	2.8							○
	2QP-DCGT11T304-HP	●	●	●	2	2.5	0.4	9.525	3.97	4.4							○
	2QP-DCGT11T308-HP	●	●	●	2	2.1	0.8	9.525	3.97	4.4							○
	3QP-TPGT**-HP	●	●	●													
	3QP-TPGT110304-HP	●	●	●	3	2.2	0.4	6.35	3.18	3.4							○
	3QP-TPGT110308-HP	●	●	●	3	1.9	0.8	6.35	3.18	3.4							○
	2QP-VBGT**-HP	●	●	●													
	2QP-VBGT110304-HP	●	●	●	2	3	0.4	6.35	3.18	2.8							○
	2QP-VBGT110308-HP	●	●	●	2	2.2	0.8	6.35	3.18	2.8							○
	2QP-VBGT160404-HP	●	●	●	2	3	0.4	9.525	4.76	4.4							○
	2QP-VBGT160408-HP	●	●	●	2	2.2	0.8	9.525	4.76	4.4							○

- : New product
- : Line up

Tungaloy Corporation (Head office)

11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima 970-1144 Japan
Phone: +81-246-36-8501
Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy America, Inc.

3726 N Ventura Drive
Arlington Heights, IL 60004, U.S.A.
Phone: +1-888-554-8394
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada

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

Tungaloy de Mexico S.A.

C Los Arellano 113,
Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410
Fax: +52-449-929-5411
www.tungaloy.com/mx

Tungaloy do Brasil Ltda.

Avd. Independencia N4158 Residencial Flora
13280-000 Vinhedo, São Paulo, Brasil
Phone: +55-19-38262757
Fax: +55-19-38262757
www.tungaloy.com/br

Tungaloy Germany GmbH

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

Tungaloy France S.A.S.

ZA Courtaboef - Le Rio
1 rue de la Terre de feu
F-91952 Courtaboef Cedex, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.com/fr

Tungaloy Italia S.r.l.

Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1
Fax: +39-02-252012-65
www.tungaloy.com/it

Tungaloy Czech s.r.o.

Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391
Fax: +420-532 123 392
www.tungaloy.com/cz

Tungaloy Ibérica S.L.

C/Miquel Servet, 43B, Nau 7
Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360
Fax: +34 93 876 2798
www.tungaloy.com/es

Tungaloy Scandinavia AB

Bultgatan 38
442 40 Kungälv, Sweden
Phone: +46-462119200
Fax: +46-462119207
www.tungaloy.com/se

Tungaloy Rus, LLC

Andropova avenue, h.18/7,
11 floor, office 3, 115432,
Moscow, Russia
Phone: +7-499-683-01-80
Fax: +7-499-683-01-81
www.tungaloy.com/ru

Tungaloy Polska Sp. z o.o.

Ul. Irysowa 1, 55-040 Bielany
Wroclawskie, Poland
Phone: +48 607 907 237
www.tungaloy.com/pl

Tungaloy U.K. Ltd

Gallan Park, Watling Street,
Cannock, WS110XG, UK
Phone: +44 121 4000 231
Fax: +44 121 270 9694
www.tungaloy.com/uk

Tungaloy Hungary Kft

Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846
Fax: +36 1 781-6866
www.tungaloy.com/hu

Tungaloy Turkey

Serifali Mah.bayraktar Bulvari Kule Sk. No:26
34775 Umraniye / Istanbul / Turkey
Phone: +90 216 540 04 67
Fax: +90 216 540 04 87
www.tungaloy.com/tr

Tungaloy Benelux b.v.

Tjalk 70
NL-2411 NZ Bodegraven, Netherlands
Phone: +31 172 630 420
Fax: +31 172 630 429
www.tungaloy.com/nl

Tungaloy Croatia

Ulica bana Josipa Jelačića 87,
10430, Samobor, Croatia
Phone: +385 1 3326 604
Fax: +385 1 3327 683
www.tungaloy.com/hr

Tungaloy Cutting Tool (Shanghai) Co.,Ltd.

Rm No 401 No.88 Zhabei
Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880
Fax: +86-21-3621-1918
www.tungaloy.com/cn

Tungaloy Cutting Tools (Taiwan) Co.,Ltd.

9F, No.293, Zhongyang Rd,
Xinzhuang Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy Cutting Tools (Thailand) Co.,Ltd.

Interlink tower 4th Fl.
1858/5-7 Bangna-Trad Road
km.5 Bangna, Bangna, Bangkok 10260
Thailand
Phone: +66-2-751-5711
Fax: +66-2-751-5715
www.tungaloy.com/th

Tungaloy Singapore (Pte.), Ltd.

62 Ubi Road 1, #06-11 Oxley BizHub 2
Singapore 408734
Phone: +65-6391-1833
Fax: +65-6299-4557
www.tungaloy.com/sg

Tungaloy Vietnam

LE04.38, Lexington Residence
67 Mai Chi Tho St., Dist. 2,
Ho Chi Minh City, Vietnam
Phone: +84-2837406660
www.tungaloy.com/sg

Tungaloy India Pvt. Ltd.

Indiabulls Finance Centre,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai-400013, India
Phone: +91-22-6124-8804
Fax: +91-22-6124-8899
www.tungaloy.com/in

Tungaloy Korea Co., Ltd

#1312, Byucksan Digital Valley 5-cha
Beotkkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161
Fax: +82-2-6393-8952
www.tungaloy.com/kr

Tungaloy Malaysia Sdn Bhd

50 K-2, Kelana Mall, Jalan SS6/14
Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan
Malaysia
Phone: +603-7805-3222
Fax: +603-7804-8563
www.tungaloy.com/my

Tungaloy Australia Pty Ltd

Unit 68 1470 Ferntree Gully Road
Knoxfield 3180 Victoria, Australia
Phone: +61-3-9755-8147
Fax: +61-3-9755-6070
www.tungaloy.com/au

PT. Tungaloy Indonesia

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



www.tungaloy.com

follow us at:

facebook.com/tungaloyjapan
twitter.com/tungaloyjapan
www.youtube.com/tungaloycorporation



AS9100 Certified
78006
2015.11.04
ISO14001 Certified
EC97J1123
1997.11.26

Distributed by:



FIND US ON THE CLOUD!
machiningcloud.com

