



For more information

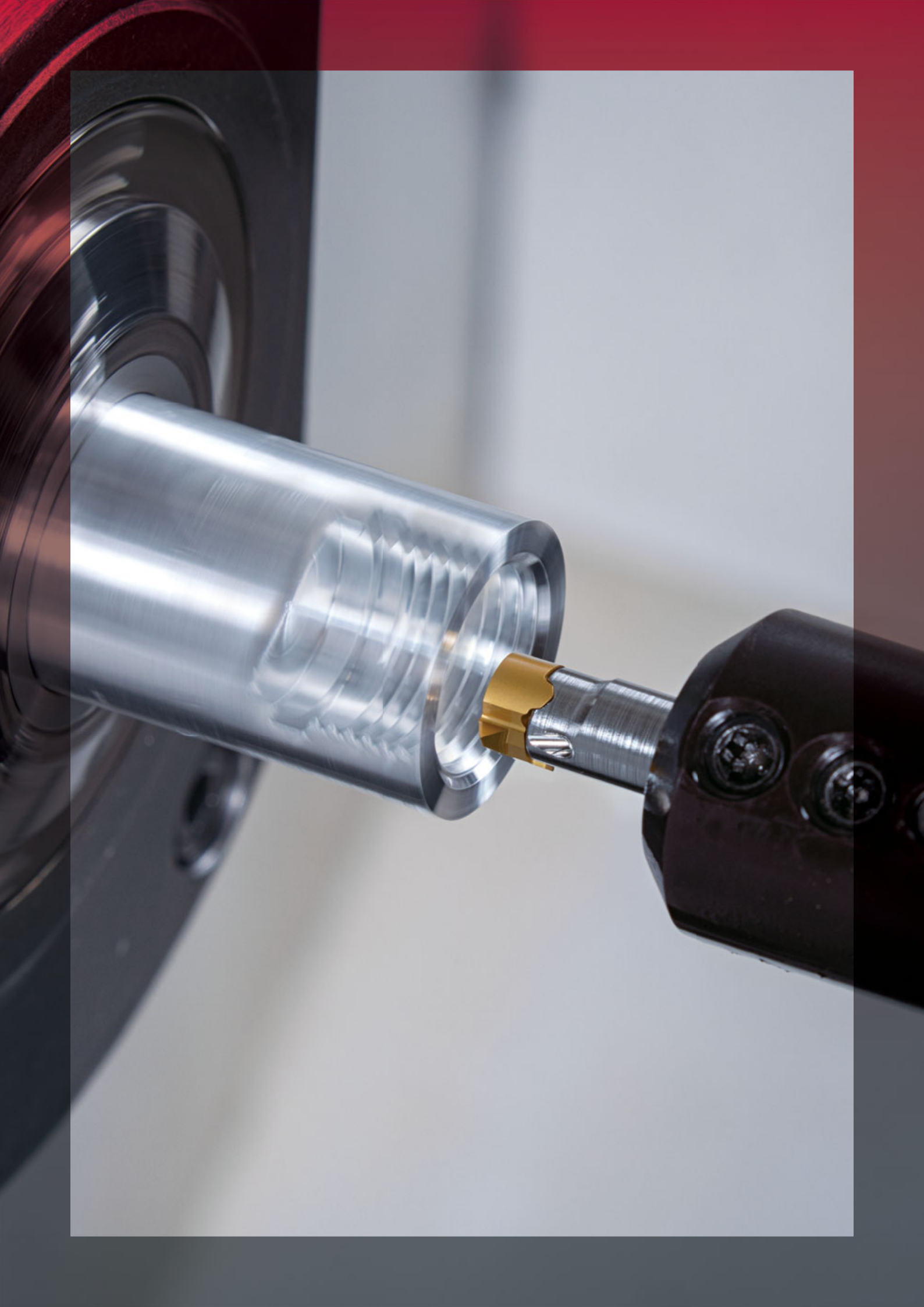
Small internal grooving and threading tool

TINY INTERNAL **CUT**

Tungaloy Report No. 564-G

Internal grooving and thread turning tool series for bores as small as $\varnothing 5$ mm







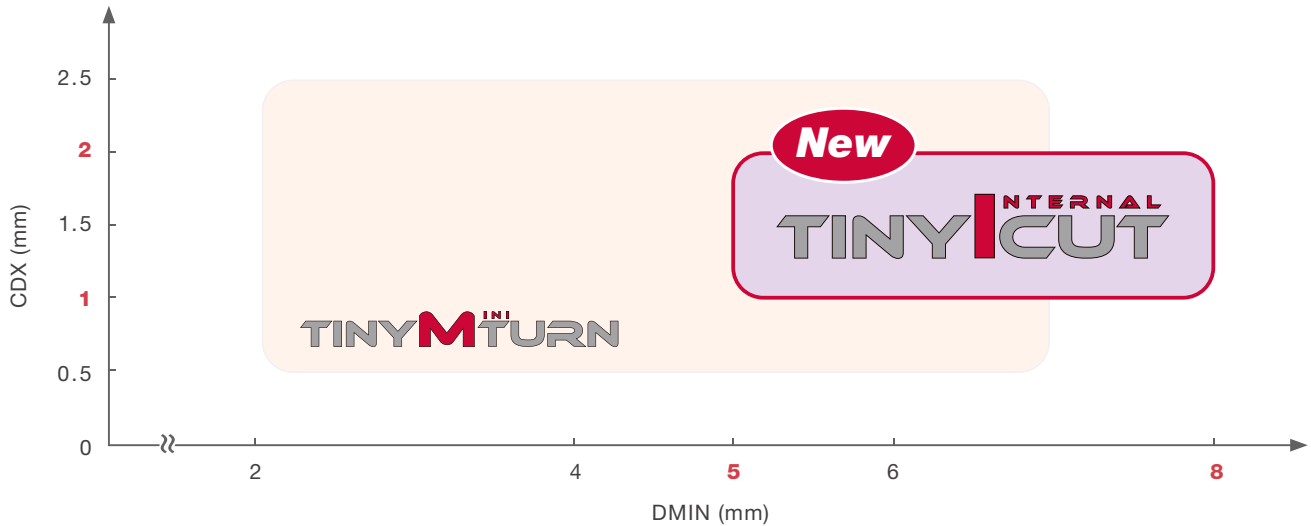
TINY ^{INTERNAL} CUT



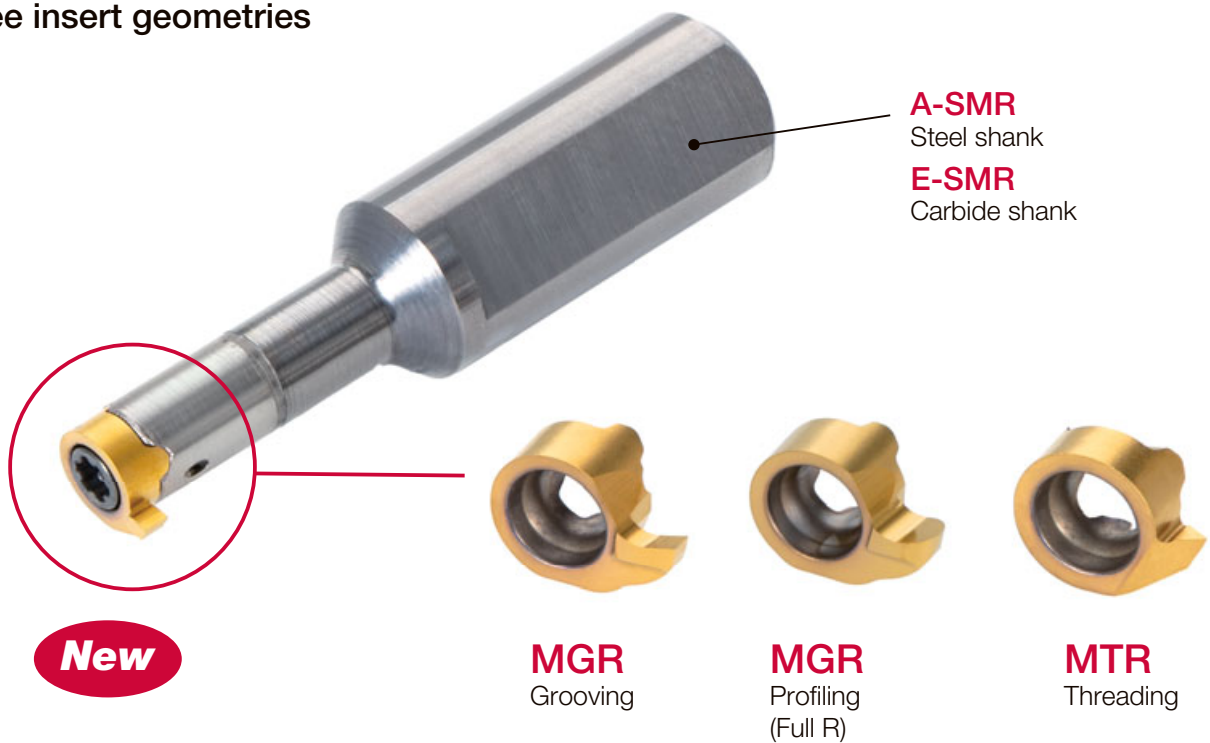
Indexable tooling solution for internal machining of
small diameter bores

Indexable solution for small holes!

Application ranges / Internal grooving holder



Three insert geometries



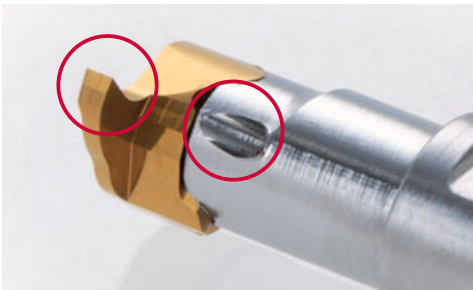
Unique clamping system for highly rigid clamping



Insert is secured at 3 points

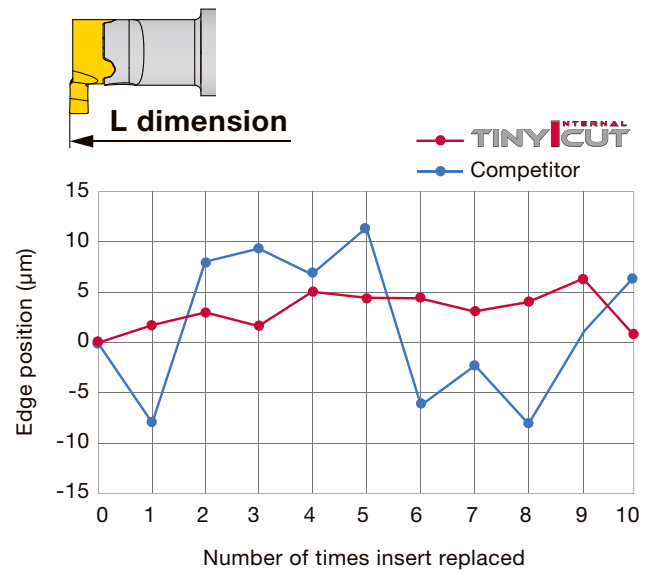
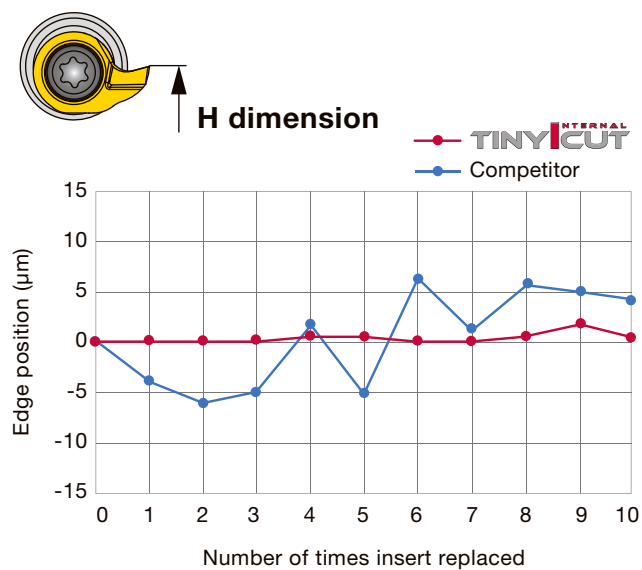
Tool body with through coolant

Make sure that, when assembling, the cutting edge is in line with the coolant outlet for effective chip evacuation.



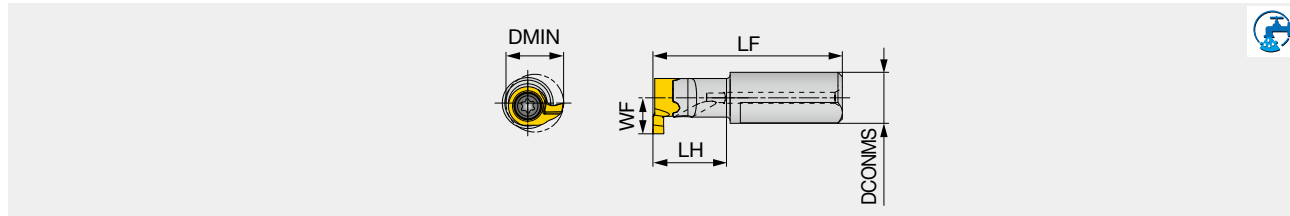
Extremely precise edge repeatability

Exchangeable head system with extremely high repeatability



A/E-SMR

Screw-on boring bar



Designation	Material	DCONMS	LH	LF	Insert	Torque*
A07080-SMR4	Steel	7	8	24	M*R4...	0.4
E07120-SMR4	Carbide	7	12	29	M*R4...	0.4
A07100-SMR5	Steel	7	10	26	M*R5...	1.1
E07180-SMR5	Carbide	7	18	34	M*R5...	1.1

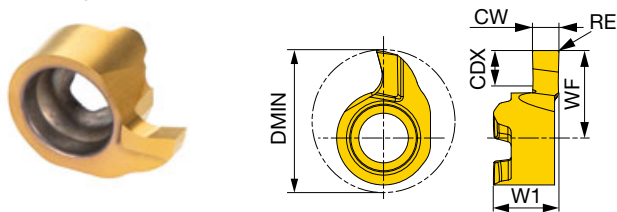
*Torque: Recommended clamping torque (N·m)
 For A/E-SMR4, the above LF and LH dimensions are true with MGR4100F000-D05 insert assembled.
 For A/E-SMR5, the above LF and LH dimensions are true with MGR5150F003-D07 insert assembled.
 The DMIN and WF sizes vary depending on the insert sizes used.

SPARE PARTS		
Designation	Clamping screw	Wrench
A/E07*-SMR4	CSPB-1.8L3.6	IP-6F
A/E07*-SMR5	CSTB-2.5L054DR	T-7F

INSERTS

MGR

Grooving



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

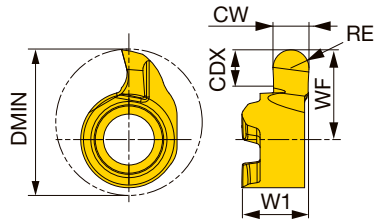
★ : First choice

Designation	CW	RE	Coated							CDX	DMIN	WF	W1
			SH7025										
MGR4100F000-D05	1	0	●							1	5	2.95	2.3
MGR5100F003-D07	1	0.03	●							1	7	3.95	3.7
MGR5150F003-D07	1.5	0.03	●							1	7	3.95	3.7
MGR5100F003-D08	1	0.03	●							2	8	4.95	3.7
MGR5150F010-D08	1.5	0.1	●							2	8	4.95	3.7
MGR5200F020-D08	2	0.2	●							2	8	4.95	3.7

● : New product

MGR

Profiling (Full R)



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

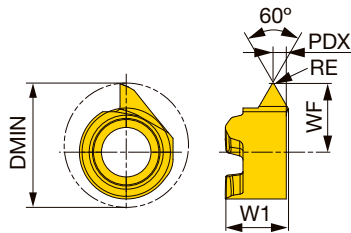
★ : First choice

Designation	CW	RE	Coated							CDX	DMIN	WF	W1
			SH7025										
MGR5100F050-D07	1	0.5	●							1	7	3.95	3.7
MGR5150F075-D07	1.5	0.75	●							1	7	3.95	3.7
MGR5200F100-D08	2	1	●							2	8	4.95	3.7

● : New product

MTR

Threading



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

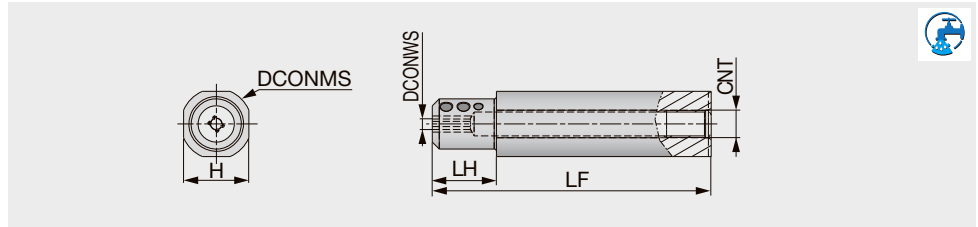
★ : First choice

Designation	RE	Coated							Pitch min	Pitch max	DMIN	PDX	WF	W1
		SH7025												
MTR460F003-D05	0.03	●							0.5	0.75	5	0.65	2.9	2.1
MTR560F007-D07	0.07	●							1	1.25	7	0.9	3.9	3.6

● : New product

JBBS-4N

Sleeve for internal coolant supply with 4 coolant holes



Designation	DCONMS	DCONWS	LF	LH	H	CNT
JBBS159-7-L100C-4N	15.875	7	100	10	14.58	Rc1/8
JBBS16-7-L100C-4N	16	7	100	10	15	Rc1/8
JBBS19-7-L100C-4N	19.05	7	100	20	17.2	Rc1/8
JBBS20-7-L100C-4N	20	7	100	20	18	Rc1/8
JBBS22-7-L100C-4N	22	7	100	20	20	Rc1/8
JBBS25-7-L100C-4N	25	7	100	23	23	Rc1/8
JBBS254-7-L100C-4N	25.4	7	100	23	23.4	Rc1/8

SPARE PARTS



Designation	Clamping screw	Wrench
JBBS**-7-L**C-4N	SSHM5-4PF-S	P-2.5

STANDARD CUTTING CONDITIONS

Internal grooving

ISO	Workpiece material	Grade	Cutting speed Vc (m/min)	Feed: f (mm/rev)			
				RE = 0 mm	RE = 0.03 mm	RE = 0.1 mm	RE = 0.2 mm
P	Low carbon steel S15C, etc., C15E4, etc.	SH7025	10 - 100	0.005 - 0.015	0.005 - 0.02	0.01 - 0.02	0.01 - 0.03
	Carbon steels, Alloy steel S55C, SCM440, etc., C55, 42CrMoS4, etc.	SH7025	10 - 60	0.005 - 0.01	0.005 - 0.015	0.005 - 0.015	0.01 - 0.03
	Prehardened steel NAK80, PX5, etc.	SH7025	10 - 40	0.005 - 0.008	0.005 - 0.01	0.005 - 0.01	0.01 - 0.025
M	Stainless steel SUS304, etc., X5CrNi18-9, etc.	SH7025	10 - 80	0.005 - 0.008	0.005 - 0.01	0.005 - 0.015	0.01 - 0.02

Profiling - full radius

ISO	Workpiece material	Grade	Cutting speed Vc (m/min)	Feed: f (mm/rev)		
				RE = 0 mm (Max.ap = 0.35 mm)	RE = 0.03 mm (Max.ap = 0.5 mm)	RE = 0.2 mm (Max.ap = 0.7 mm)
P	Low carbon steel S15C, etc., C15E4, etc.	SH7025	10 - 120	0.005 - 0.015	0.005 - 0.02	0.01 - 0.02
	Carbon steels, Alloy steel S55C, SCM440, etc., C55, 42CrMoS4, etc.	SH7025	10 - 100	0.005 - 0.01	0.005 - 0.018	0.01 - 0.015
	Prehardened steel NAK80, PX5, etc.	SH7025	10 - 80	0.005 - 0.008	0.005 - 0.015	0.005 - 0.013
M	Stainless steel SUS304, etc., X5CrNi18-9, etc.	SH7025	10 - 100	0.005 - 0.01	0.005 - 0.012	0.005 - 0.01

Threading

ISO	Workpiece material	Grade	Cutting speed Vc (m/min)	Feed: f (mm/rev)
P	Low carbon steel S15C, etc., C15E4, etc.	SH7025	10 - 100	30 - 60
	Carbon steels, Alloy steel S55C, SCM440, etc., C55, 42CrMoS4, etc.	SH7025	10 - 60	10
	Prehardened steel NAK80, PX5, etc.	SH7025	10 - 40	10 - 20
M	Stainless steel SUS304, etc., X5CrNi18-9, etc.	SH7025	10 - 80	10 - 80

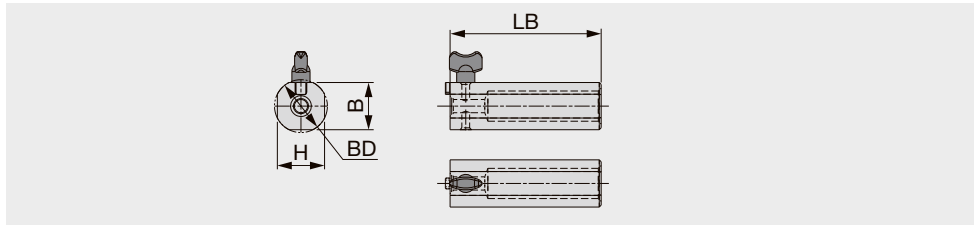
Recommended infeeding passes for thread pitches

Thread pitch (mm)	Insert designation	RE (mm)	Total depth of feed	Recommended number of passes	Depth of cut per pass (mm)								
					Pass 1	Pass 2	Pass 3	Pass 4	Pass 5	Pass 6	Pass 7	Pass 8	Pass 9
0.5	MTR460F003-D05	0.03	0.3	5	0.08	0.07	0.06	0.05	0.04				
0.75		0.03	0.47	6	0.12	0.1	0.08	0.07	0.06	0.04			
1	MTR560F007-D07	0.07	0.6	6	0.18	0.15	0.1	0.08	0.05	0.04			
1.25		0.07	0.76	7	0.18	0.15	0.12	0.1	0.1	0.07	0.04		

ACCESSORY

QC-12D28EXC

Holder for insert change



Designation	BD	LB	H	B
QC-12D28EXC	28	80	25	25

Note: This is a dedicated holder designed to facilitate insert changes. Do not use this holder for machining as it may cause damages to tool, workpiece, machine, and possible human injury.

SPARE PARTS


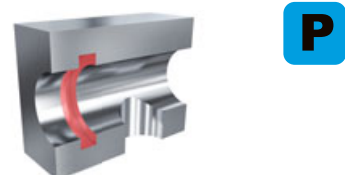
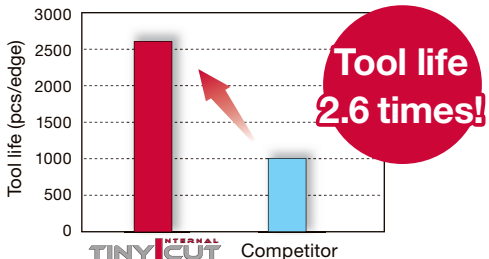
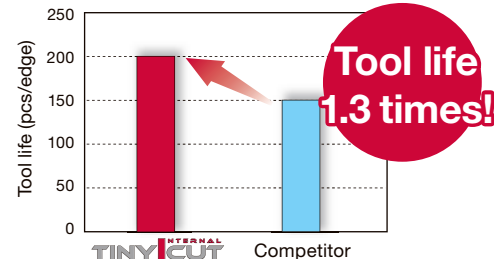


Designation	Fixing screw
QC-12D28EXC	KNOBM5X10



TinyInternalCut heads are small. When it is difficult to change inserts while holding the modular head with fingers, use the dedicated holder to facilitate insert changes.

PRACTICAL EXAMPLES

Workpiece type		Cover	Valve seat
Toolholder		A07080-SMR4	A07080-SMR4
Insert		MGR4100F000-D05	MGR4100F000-D05
Grade		SH7025	SH7025
Workpiece material		Alloy steel	Alloy steel
			
Cutting conditions	Cutting speed: V_c (m/min)	38	50
	Feed : f (mm/rev)	0.01	0.01
	Groove width : CW (mm)	1	1
	Groove depth : CDX (mm)	0.7	0.5
	Machining	Internal grooving	Internal grooving
	Coolant	Wet	Wet
Results		 <p>With rigid insert clamping and the use of JBBS-4N tool sleeve, TinyInternalCut eliminated chip bird-nesting and provided 2.6 times tool life increase.</p>	 <p>With excellent edge line security and sharpness, TinyInternalCut eliminated burr generation and extended tool life by 1.3 times.</p>

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.

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/Miguel 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
Wrocławskie, 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 Bulvarı 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-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/sg

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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