

Excellent shouldering with 3-corner insert

RM3

KORLOY
TECH-NEWS



- Multi milling tool for best results in perpendicular shouldering
- High rake chipbreaker for high speed and high feed machining
- Strong clamping force for better stability

RM3 - Multifunctional Shouldering Milling Tool

RM3

Constant optimisation and quality improvements are required in machining. This means that tools in machining must fulfil both factors. As a leading manufacturer of cutting tools, we always strive to develop and offer advanced tool solutions.

RM3 is the result of our efforts and combines multifunctional application possibilities with the highest quality and performance. In addition, the tool concept leads to excellent process reliability due to its high rigidity and strong clamping.

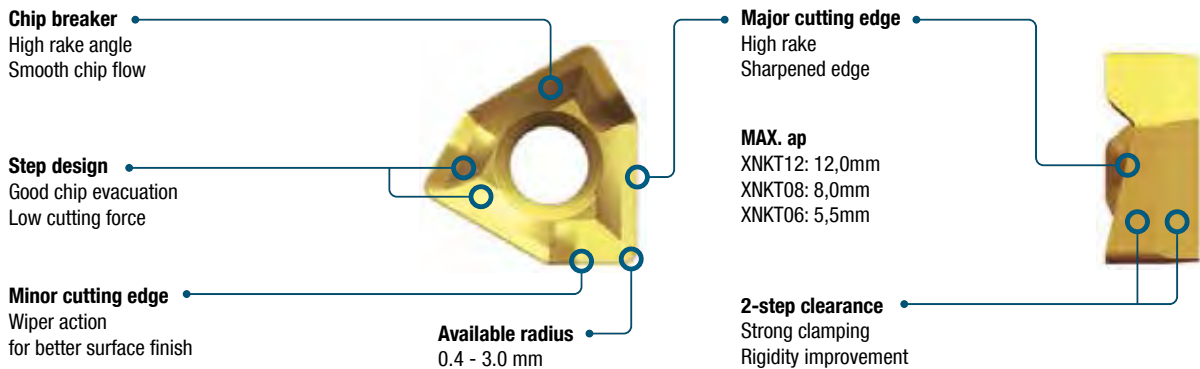
As a multifunctional tool, the **RM3** not only enables corner milling operations with excellent squareness, but also face milling, ramping, circular milling, plunging and the production of grooves.

The comprehensive concept of the **RM3** was the basis for the development of this milling cutter, which offers you a wide range of optimisation options in production.

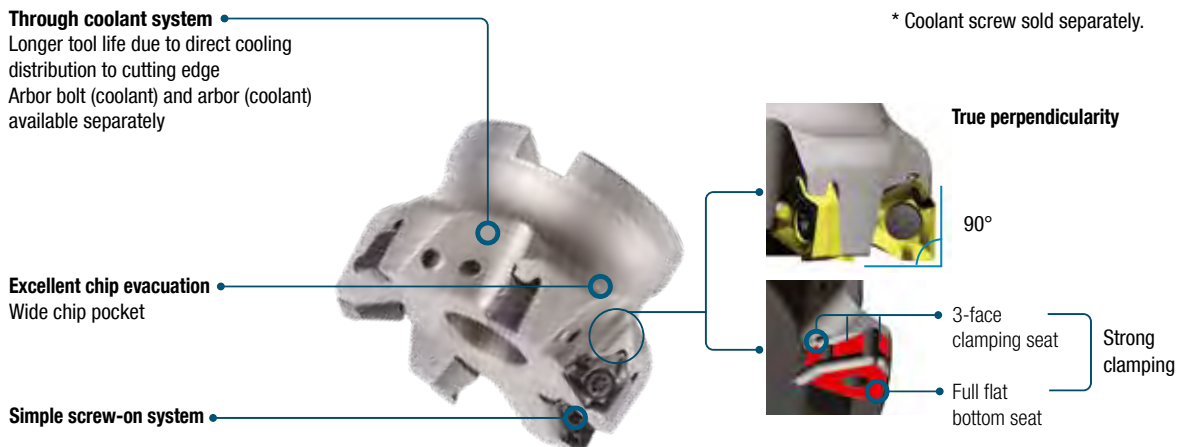
The wide range of applications reduces the number of tools required in production and thus the acquisition and stocking costs. The implementation of the latest findings in machining increases productivity and thus the actual production volume.

Complemented by the high process reliability thanks to the stable design and the strong clamping, the **RM3** is our solution for your challenges in a wide range of milling applications.

Features of insert



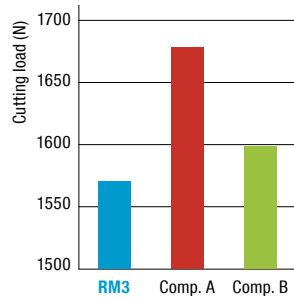
Features of cutter



Performance evaluation

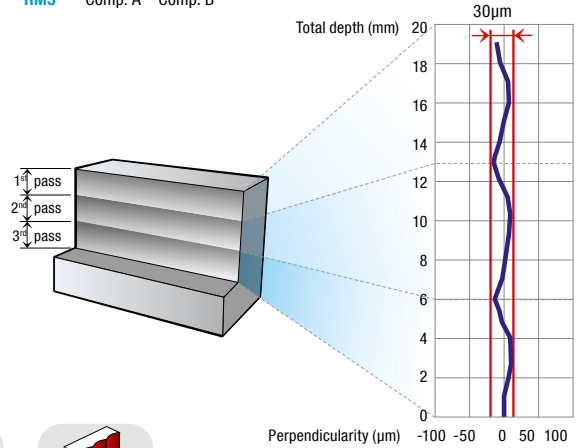
Performance evaluation

- Workpiece: 42CrMo4 (200HB)
- Cutting conditions:
 - vc: 250 m/min
 - fz: 0.1 mm/t
 - ap: 3.0 mm, dry
- Tools:
 - Insert: XNKT080508PNSR-MM PC5300
 - Cutter: RM3PCM4063HR-M
 - Machine: Vertical M/C

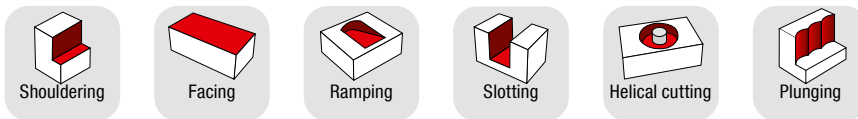


Cutting edge	Features
	True positive clearance due to high rake angle ► excellent machinability

- Workpiece: 42CrMo4 (200HB)
- Cutting conditions:
 - vc: 200 m/min
 - fz: 0.1 mm/t
 - ap: 7.0x3 mm pass
 - ae: 10.0 mm, dry
- Tools:
 - Insert: XNKT080508PNSR-MM PC5300
 - Cutter: RM3PCM4063HR-M
 - Machine: Vertical M/C



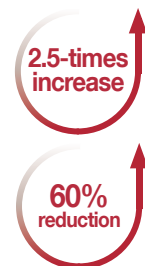
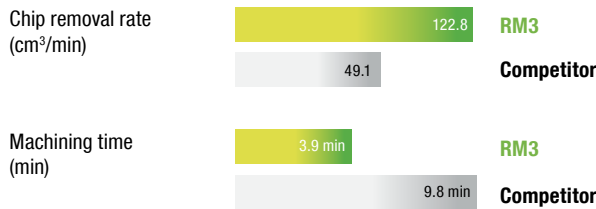
Application area



Cutting performance

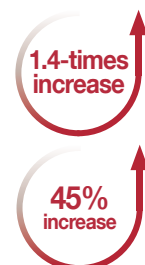
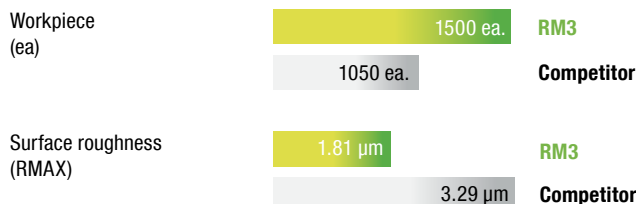
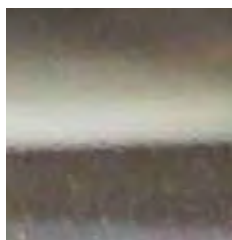
Carbon steel (C45, HB200)

- Cutting conditions: vc: 270 m/min · fz: 1.0 mm/t · ap: 3.0 x 8 pass mm · ae: 5.0 mm · Shouldering
- Tools: Insert: XNKT08508PNSR-MM PC5300 · Holder: RM3PCM4063HR-M









Alloy steel (42CrMo4, HB200)

- Cutting conditions: vc: 250 m/min · fz: 0.125 mm/t · ap (mm) = Finishing: 0.5 / Roughing: 7.0 · Facing
- Tools: Insert: XNKT080508PNSR-MM PC5300 / Holder: RM3PCM4063HR-M



Features of chip breakers

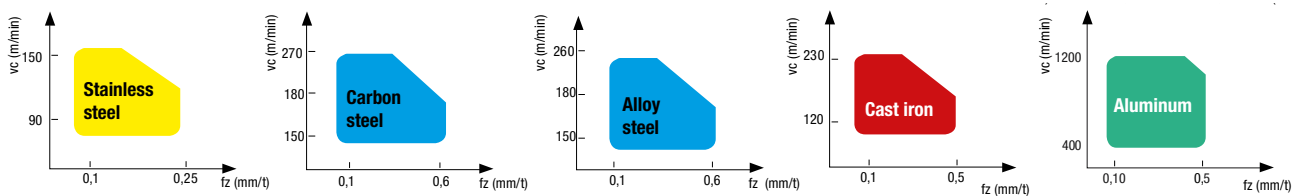
Chip breaker	Cutting edge	Features
For Aluminum MA 		Sharp cutting edge and buffed top face for an excellent chip flow and welding resistance in aluminum machining
Light cutting ML 		Finishing to medium cutting Sharp cutting edge for hard-to-cut material Low cutting force
General cutting MM 		Medium cutting to roughing General shouldering operation 1st recommendation

Application guideline for grade

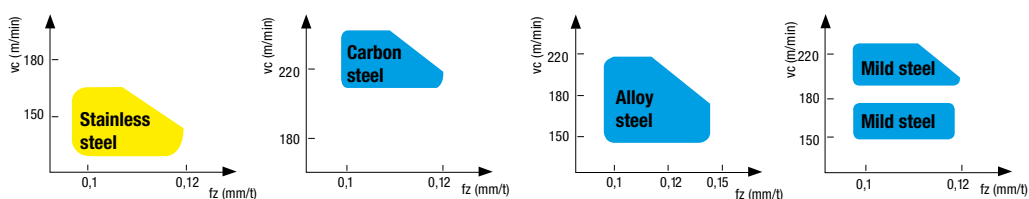
Workpiece		P			M	K	N
		Carbon steel	Alloy steel		Stainless steel	Cast iron	Non-ferrous
			< 40 HRC	< 60 HRC			
Chip breaker	First choice	MM	MM	MM	ML	ML	MA
	Second choice	ML	ML	ML	-	MM	-
Grade	High speed machining	PC3700	PC3700	-	PC9540	PC6510	H01
	General machining	PC5400	PC5300	PC2505 PC2510	PC9540	PC5300	
	Interrupted machining	PC5400	PC5400	-	PC9540	PC5400	

Cutting conditions for shouldering and grooving

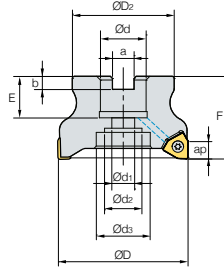
Grooving (ap 3mm step, Ø63)



Grooving (ap 3mm step, Ø63)



RM3PC(M)3000 new



AA
90°
• AR: -5°
• RR: -9° - -6°

(mm)

Designation	Stock		ØD	ØD2	Ød	Ød1	Ød2	Ød3	a	b	E	F	ap		
RM3PCM	3040HR	▲	5	40	35	16	9	14	-	8.4	5.6	16	40	5.5	0.2
	3040HR-M	▲	6	40	35	16	9	14	-	8.4	5.6	16	40	5.5	0.2
	3050HR	▲	6	50	42	22	11	18	-	10.4	6.3	20	40	5.5	0.3
	3050HR-M	▲	7	50	42	22	11	18	-	10.4	6.3	20	40	5.5	0.3
	3063HR	▲	7	63	49	22	11	18	-	10.4	6.3	20	40	5.5	0.49
	3063HR-M	▲	8	63	49	22	11	18	-	10.4	6.3	20	40	5.5	0.49
RM3PC (RM3PCM)	3080HR	▲	8	80	57	25.4 (27)	14	25	35	9.5 (12.4)	6 (7)	25 (23)	50	5.5	0.87
	3080HR-M	▲	10	80	57	25.4 (27)	14	25	35	9.5 (12.4)	6 (7)	25 (23)	50	5.5	0.88

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Available inserts



Designation	Cermet	Coated													Uncoated		
	CN30	NCM325	NCM335	NCM535	NCM545	PC2505	PC2510	PC3700	PC6510	PC3545	PC9540	PC5300	UNC840	PC5400	ST30A	G10	H01
XNCT 060405PNFR-MA																	▲
XNKT 060405PNER-ML				○	○	○	●	▲	▲	○	▲	▲	○	▲			
060405PNSR-MM				○	○	●	●	▲	▲	○	●	▲	○	▲			
060408PNER-ML				○	○	○	○	○	●	○	▲	●	○	●			
060408PNSR-MM				○	○	●	▲	▲	●	○	○	▲	○	●			

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

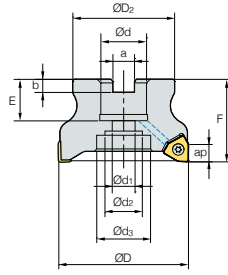
Available arbors

Designation	RM3PCM
RM3PC(M) 3040HR	BT□□-FMC16-□□
3040HR-M	
3050HR	BT□□-FMC22-□□
3050HR-M	
3063HR	
3063HR-M	
3080HR	BT□□-FMC27-□□
3080HR-M	

Parts

Specification	Screw	Wrench	
Ø40-Ø80	FTNA0306	TW09S	

RM3PC(M)4000 new



AA 90°
 • AR: -5°
 • RR: -8° - -6°

(mm)

Designation	Stock		ØD	ØD2	Ød	Ød1	Ød2	Ød3	a	b	E	F	ap		
RM3PCM	4040HR	▲	3	40	35	16	9	14	-	8.4	5.6	19	40	8.0	0.19
	4040HR-M	▲	4	40	35	16	9	14	-	8.4	5.6	19	40	8.0	0.19
	4050HR	▲	4	50	42	22	11	18	-	10.4	6.3	20	40	8.0	0.28
	4050HR-M	▲	5	50	42	22	11	18	-	10.4	6.3	20	40	8.0	0.29
	4063HR	▲	5	63	49	22	11	18	-	10.4	6.3	20	40	8.0	0.54
	4063HR-M	▲	6	63	49	22	11	18	-	10.4	6.3	20	40	8.0	0.53
RM3PC (RM3PCM)	4080HR	▲	5	80	57	25.4 (27)	14	20	35	9.5 (12.4)	6 (7)	25 (23)	50	8.0	1.08
	4080HR-M	▲	7	80	57	25.4 (27)	14	20	35	9.5 (12.4)	6 (7)	25 (23)	50	8.0	1.06
	4100HR	▲	7	100	67	31.75 (32)	18	26	42	12.7 (14.4)	8 (8)	33 (25)	63 (50)	8.0	1.68
	4100HR-M	▲	8	100	67	31.75 (32)	18	26	42	12.7 (14.4)	8 (8)	33 (25)	63 (50)	8.0	1.67
	4125HR	▲	8	125	90	38.1 (40)	22	32	52	15.9 (16.4)	9 (10)	38 (29)	63	8.0	3.45
	4125HR-M	▲	10	125	90	38.1 (40)	22	32	52	15.9 (16.4)	9 (10)	38 (29)	63	8.0	3.45

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Available inserts



Bezeichnung	Cermet	Coated												Uncoated				
	CN30	NCM325	NCM335	NCM335	NCM335	NCM335	PC2505	PC2510	PC3700	PC6510	PC3545	PC9540	PC5300	UNC840	PC5400	ST30A	G10	H01
XNCT	060405PNFR-MA																	▲
	080504PNFR-MA																	▲
	080508PNFR-MA																	▲
	080512PNFR-MA																	●
	080520PNFR-MA																	●
XNKT	080504PNSR-ML	○			○		○	○	○	○	○	▲	●	○	●			
	080504PNSR-MM	○			○		○	○	●	○	○	○	○	○	○			
	080508PNSR-ML	○			○		○	○	▲	▲	○	▲	▲	○	▲			
	080508PNSR-MM	○			●		●	●	▲	▲	○	●	▲	○	▲			
	080512PNSR-ML						○	○	○	○	○	○	○		●			
	080512PNSR-MM						●	●	●	○	○	○	▲		●			
	080516PNSR-ML	○			○		○	○	○	○	○	○	○	○	○			
	080516PNSR-MM						●	●	●	○	○	○	○	▲	○			
	080520PNSR-ML	○			○		○	○	○	○	○	○	○	○	○			
	080520PNSR-MM	○			○		●	●	○	○	○	○	○	○	○			

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

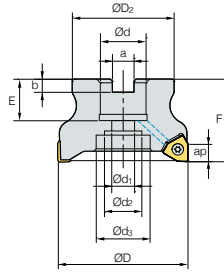
Available arbors

Designation	RM3PCM
RM3PC(M) 4040HR	BT <input type="checkbox"/> <input type="checkbox"/> - FMC16 - <input type="checkbox"/> <input type="checkbox"/>
4050HR	BT <input type="checkbox"/> <input type="checkbox"/> - FMC22 - <input type="checkbox"/> <input type="checkbox"/>
4063HR	
4080HR	BT <input type="checkbox"/> <input type="checkbox"/> - FMC27 - <input type="checkbox"/> <input type="checkbox"/>
4100HR	BT <input type="checkbox"/> <input type="checkbox"/> - FMC32 - <input type="checkbox"/> <input type="checkbox"/>
4125HR	BT <input type="checkbox"/> <input type="checkbox"/> - FMC40 - <input type="checkbox"/> <input type="checkbox"/>

Parts

Specification	Screw	Wrench
Ø40-0125	FTNA0408	TW15S

RM3PC(M)5000 new



AA 90°
 • AR: -5°
 • RR: -7°

(mm)

Designation	Stock		ØD	ØD2	Ød	Ød1	Ød2	Ød3	a	b	E	F	ap		
RM3PC (RM3PCM)	5080HR	▲	5	80	57	25.4 (27)	14	20	35	9.5 (12.4)	6 (7)	24 (23)	50	12.0	0.84
	5080HR-M	▲	7	80	57	25.4 (27)	14	20	35	9.5 (12.4)	6 (7)	24 (23)	50	12.0	0.84
	5100HR	▲	7	100	67	31.75 (32)	18	28	45	12.7 (14.4)	8 (8)	32 (25)	63	12.0	1.76
	5100HR-M	▲	8	100	67	31.75 (32)	18	28	45	12.7 (14.4)	8 (8)	32 (25)	63	12.0	1.76
	5125HR	●	8	125	90	38.1 (40)	22	32	52	15.9 (16.4)	9 (10)	38 (30)	63	12.0	2.70
	5125HR-M	●	10	125	90	38.1 (40)	22	32	52	15.9 (16.4)	9 (10)	38 (30)	63	12.0	2.70

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Available inserts



Bezeichnung	Cermet	Coated											Uncoated				
	CN30	NCM325	NCM335	NCM335	NCM335	NCM335	PC2505	PC2510	PC3700	PC6510	PC9540	PC3545	PC5300	PC5400	ST30A	G10	H01
XNCT 120608PNFR-MA																	●
XNKT 120604PNSR-MM			○				○	○	○	○	○	○	●	●			
120608PNER-ML			○				○	○	●	●	▲	○	▲	▲			
120608PNSR-MM			○				●	●	●	▲	●	○	▲	▲			
120612PNER-ML			○				○	○	○	○	○	○	●	●			
120612PNSR-MM							●	●	○	○	○	○	●	●			
120616PNER-ML							○	○	○	○	○	○	●	●			
120616PNSR-MM							●	●	○	○	○	○	●	●			
120620PNER-ML							○	○	○	○	○	○	●	●			
120620PNSR-MM							●	●	○	○	○	○	○	○			

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Available arbors

Designation	RM3PCM
RM3PC(M) 5080HR	BT □□ - FMC27 - □□
5100HR	BT □□ - FMC32 - □□
5125HR	BT □□ - FMC40 - □□

Parts

Specification	Screw	Wrench
Ø40-0125	FTNA0511	TW20-100

RM3PS3000 new

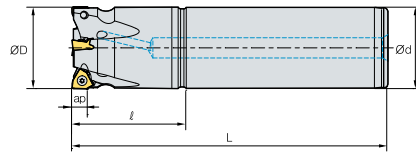


Fig. 1

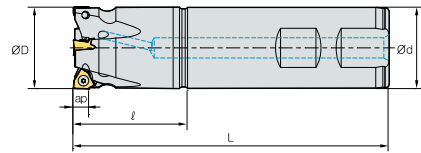


Fig. 2



AA
90°

• AR: -5°
• RR: -16°--9°

(mm)

Designation	Stock		ØD	Ød	ℓ	L	ap		Fig.
RM3PS 3020HR-2S20	▲	2	20	20	35	100	5.5	0.21	2
3020HR-2L20	▲	2	20	20	35	200	5.5	0.43	1
3021HR-2S20	▲	2	21	20	30	100	5.5	0.21	2
3021HR-2L20	▲	2	21	20	30	200	5.5	0.43	1
3025HR-3S20	▲	3	25	20	35	115	5.5	0.27	2
3025HR-3L20	▲	3	25	20	35	200	5.5	0.46	1
3025HR-3S25	▲	3	25	25	40	115	5.5	0.36	2
3025HR-3L25	▲	3	25	25	40	200	5.5	0.66	1
3026HR-2S20	●	2	26	20	35	115	5.5	0.29	2
3026HR-2L20	●	2	26	20	35	200	5.5	0.47	1
3026HR-3S20	▲	3	26	20	35	115	5.5	0.28	2
3026HR-3L20	▲	3	26	20	35	200	5.5	0.47	1
3026HR-2S25	▲	2	26	25	35	115	5.5	0.37	2
3026HR-2L25	○	2	26	25	35	200	5.5	0.68	1
3026HR-3S25	▲	3	26	25	35	115	5.5	0.37	2
3026HR-3L25	▲	3	26	25	35	200	5.5	0.68	1
3032HR-3S25	▲	3	32	25	42	125	5.5	0.48	2
3032HR-3L25	▲	3	32	25	42	200	5.5	0.74	1
3032HR-4S25	▲	4	32	25	42	125	5.5	0.48	2
3032HR-4L25	▲	4	32	25	42	200	5.5	0.74	1
3032HR-4S32	▲	4	32	32	42	125	5.5	0.68	2
3032HR-4L32	▲	4	32	32	42	200	5.5	1.13	1
3033HR-3S25	○	3	33	25	42	125	5.5	0.49	2
3033HR-3L25	○	3	33	25	42	200	5.5	0.75	1
3033HR-4S25	▲	4	33	25	42	125	5.5	0.49	2
3033HR-4L25	●	4	33	25	42	200	5.5	0.75	1
3033HR-4S32	●	4	33	32	42	125	5.5	0.70	2
3033HR-4L32	▲	4	33	32	42	200	5.5	1.14	1
3040HR-4S32	▲	4	40	32	45	130	5.5	0.83	2
3040HR-4L32	▲	4	40	32	45	200	5.5	1.24	1
3040HR-5S32	▲	5	40	32	45	130	5.5	0.83	2
3040HR-5L32	▲	5	40	32	45	200	5.5	1.24	1

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Available inserts



Designation	Cermet	Coated													Uncoated		
	CN30	NCM325	NCM335	NCM535	NCM545	PC2505	PC2510	PC3700	PC6510	PC3545	PC9540	PC5300	UNC840	PC5400	ST30A	G10	H01
XNCT 060405PNFR-MA																	▲
XNKT 060405PNER-ML				○	○	○	●	▲	▲	○	▲	▲	○	▲			
060405PNSR-MM				○	○	●	●	▲	▲	○	●	▲	○	▲			
060408PNER-ML				○	○	○	○	○	●	○	▲	●	○	●			
060408PNSR-MM				○	○	●	▲	▲	●	○	○	▲	○	●			

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Parts

Specification	Screw 	Wrench
Ø20-Ø40	FTNA0306	TW09S

RM3PS4000 new

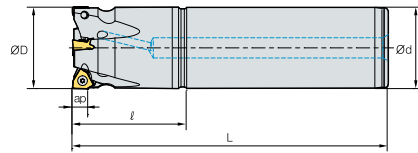


Fig. 1

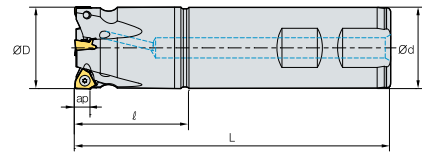


Fig. 2



AA
90°

• AR: -5°
• RR: -11°--7°

(mm)

Designation	Stock		ØD	Ød	ℓ	L	ap		Fig.
RM3PS 4032HR-3S32	▲	3	32	32	42	125	8	0.67	2
4032HR-3L32	○	3	32	32	42	200	8	1.11	1
4033HR-3S32	▲	3	33	32	42	125	8	0.68	2
4033HR-3L32	○	3	33	32	42	200	8	1.13	1
4040HR-3S32	▲	3	40	32	42	130	8	0.8	2
4040HR-3L32	○	3	40	32	42	200	8	1.21	1
4040HR-4S32	▲	4	40	32	42	130	8	0.81	2
4040HR-4L32	○	4	40	32	42	200	8	1.22	1
4050HR-4S32	▲	4	50	32	42	135	8	0.99	2
4050HR-4L32	○	4	50	32	42	200	8	1.38	1
4050HR-4S40	●	4	50	40	42	135	8	1.32	2
4050HR-4L40	○	4	50	40	42	200	8	1.94	1
4050HR-5S32	▲	5	50	32	42	135	8	1.02	2
4050HR-5L32	○	5	50	32	42	200	8	1.40	1
4050HR-5S40	▲	5	50	40	42	135	8	1.35	2
4050HR-5L40	○	5	50	40	42	200	8	1.96	1
4063HR-5S32	●	5	63	32	42	135	8	1.31	2
4063HR-5L32	○	5	63	32	42	200	8	1.70	1
4063HR-5S40	●	5	63	40	42	135	8	1.64	2
4063HR-5L40	○	5	63	40	42	200	8	2.25	1
4063HR-6S32	▲	6	63	32	42	135	8	1.31	2
4063HR-6L32	○	6	63	32	42	200	8	1.70	1
4063HR-6S40	●	6	63	40	42	135	8	1.64	2
4063HR-6L40	○	6	63	40	42	200	8	2.26	1

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Available inserts



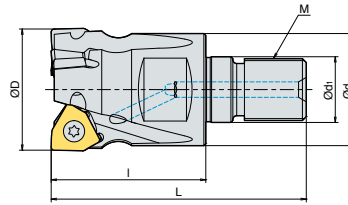
Designation	Cermet	Coated												Uncoated			
	CN30	NCM325	NCM335	NCM535	NCM545	PC2505	PC2510	PC3700	PC6510	PC3545	PC9540	PC5300	UNC840	PC5400	ST30A	G10	H01
XNCT 060405PNFR-MA																	▲
080504PNFR-MA																	▲
080508PNFR-MA																	▲
080512PNFR-MA																	●
080520PNFR-MA																	●
XNKT 080504PNER-ML		○		○		○	○	○	○	○	▲	●	○	●			
080504PNSR-MM		○		○		○	○	●	○	○	○	●	○	●			
080508PNER-ML		○		○		○	●	▲	▲	○	▲	▲	○	▲			
080508PNSR-MM		○		●		●	●	▲	▲	○	●	▲	○	▲			
080512PNER-ML						○	○	○	○	○	○	○		●			
080512PNSR-MM						●	●	●	○	○	○	▲		●			
080516PNER-ML		○		○		○	○	○	○	○	○	○	○	●			
080516PNSR-MM						○	○	●	○	○	○	▲		●			
080520PNER-ML		○		○		○	○	○	○	○	○	○	○	●			
080520PNSR-MM		○		○		●	●	○	○	○	○	▲	○	●			

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Parts

Specification	Screw 	Wrench
Ø32-Ø63	FTNA0408	TW15S

RM3PM3000/4000 new



• AR: -5°
• RR: -16°--7°

(mm)

Designation	Stock		ØD	Ød	Ød1	I	L	M	ap		
RM3PM	3020HR-2-M10	▲	2	20	18	10.5	30	50	M10	5.5	0.06
	3025HR-3-M12	▲	3	25	21	12.5	35	58	M12	5.5	0.10
	3032HR-4-M16	▲	4	32	29	17	40	66	M16	5.5	0.21
	3040HR-5-M16	▲	5	40	29	17	40	66	M16	5.5	0.26
RM3PM	4032HR-3-M16	▲	3	32	29	17	40	66	M16	8	0.21
	4040HR-4-M16	▲	4	40	29	17	50	76	M16	8	0.33
	4050HR-5-M16	▲	5	50	29	17	55	81	M16	8	0.49

Available inserts



Designation	Cermet		Coated											Uncoated					
	CN30	NCM325	NCM335	NCM335	NCM535	NCM545	PC2505	PC2510	PC3700	PC6510	PC3545	PC9540	PC5300	UNC840	PC5400	ST30A	G10	H01	
Type 3000	XNCT	060405PNFR-MA																▲	
	XNKT	060405PNER-ML				○	○	○	●	▲	▲	○	▲	▲	○	▲			
		060405PNSR-MM				○	○	●	●	▲	▲	○	●	▲	○	▲			
		060408PNER-ML				○	○	○	○	○	●	○	▲	●	○	●			
Type 4000	XNCT	060405PNFR-MA																▲	
		080504PNFR-MA																▲	
		080508PNFR-MA																	▲
		080512PNFR-MA																	●
		080520PNFR-MA																	●
	XNKT	080504PNER-ML		○		○		○	○	○	○	○	▲	●	○	●			
		080504PNSR-MM		○		○		○	○	○	○	○	○	○	○	○			
		080508PNER-ML		○		○		○	○	○	○	○	○	○	○	○			
		080508PNSR-MM		○		●		○	○	○	○	○	○	○	○	○			
		080512PNER-ML						○	○	○	○	○	○	○		○			
		080512PNSR-MM						○	○	○	○	○	○	○		○			
		080516PNER-ML		○		○		○	○	○	○	○	○	○	○	○			
		080516PNSR-MM						○	○	○	○	○	○	○	○	○			
		080520PNER-ML		○		○		○	○	○	○	○	○	○	○	○			
		080520PNSR-MM		○		○		○	○	○	○	○	○	○	○	○			

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Available adaptor

Designation	Available adaptor	
RM3PM	3020HR-2-M10	MAT-M10
	3025HR-3-M12	MAT-M12
	3032HR-4-M16	MAT-M16
	3040HR-5-M16	MAT-M16
RM3PM	4032HR-3-M16	MAT-M16
	4040HR-4-M16	MAT-M16
	4050HR-5-M16	MAT-M16

Designation:
RM3PM4032HR-M16
Modular head threading measure size (M16)

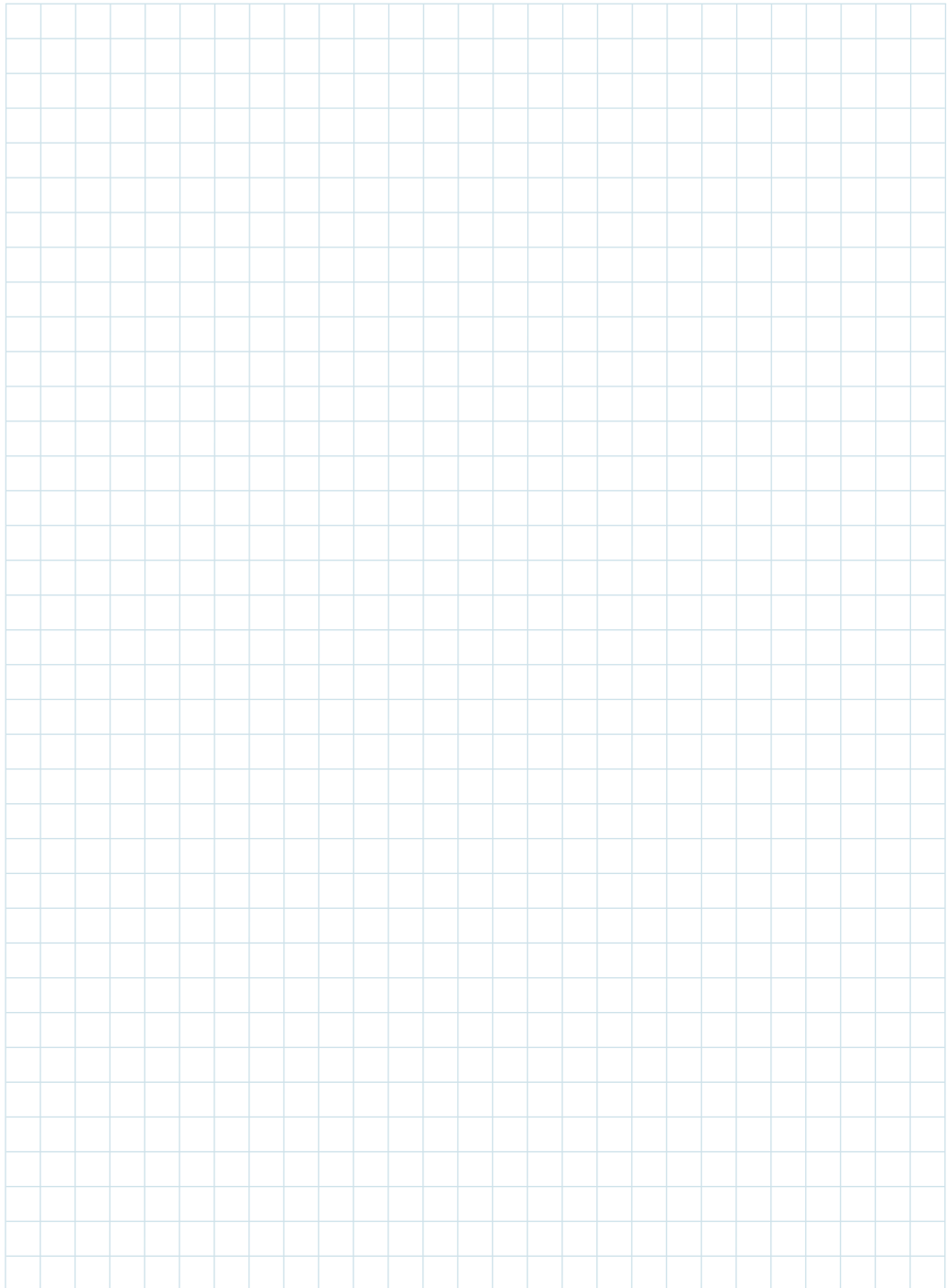
||

Adaptor spec.:
MAT-M16-035-S32S
Adaptor threading measure (M16)

Parts

Type	Specification	Screw	Wrench
3000	Ø20-Ø40	FTNA0306	TW09S
4000	Ø32-Ø50	FTNA0408	TW15S

Notes



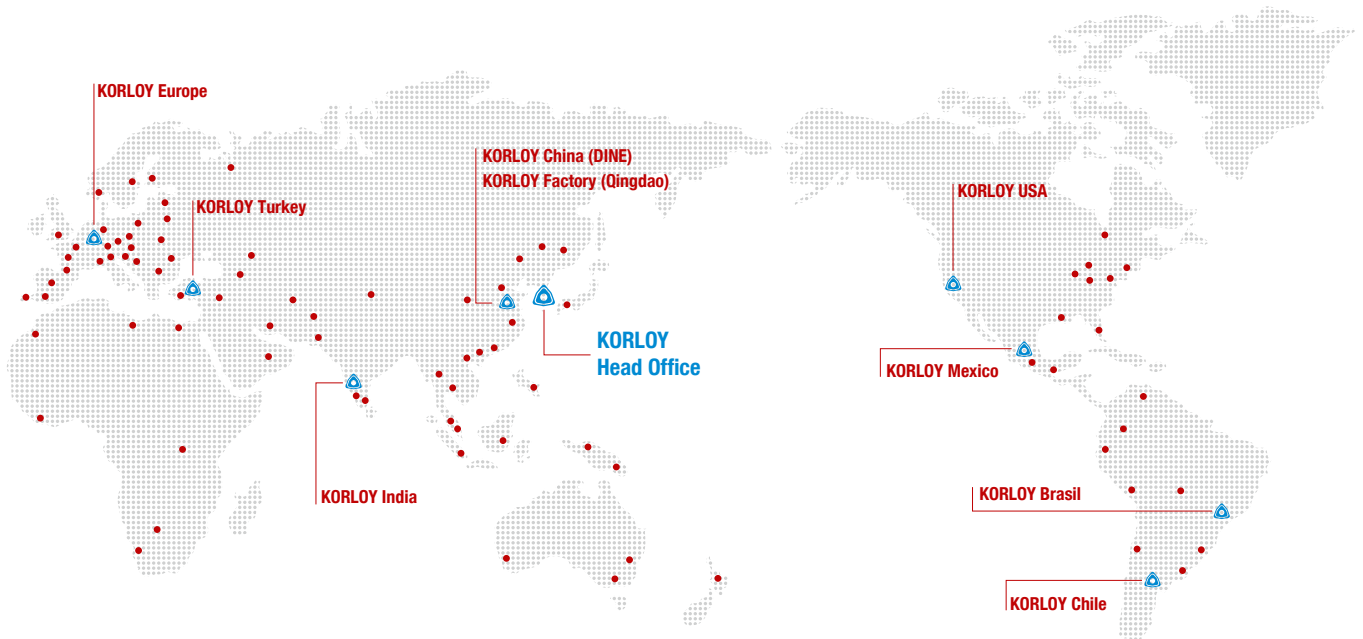
For the safe metalcutting

- Use safety supplies such as protective gloves to prevent possible injury while touching the edge of tools.
- Use safety glasses or safety cover to hedge possible dangers. Inappropriate usage or excessive cutting condition may lead tool's breakage or even the fragment's scattering.
- Clamp the workpiece tightly enough to prevent its movement while its machining.

Properly manage the tool change phase because the inordinately used tool can be easily broken under the excessive cutting load or severe wear, and it may threaten the operator's safety.

- Use safety cover because chips evacuated during cutting are hot and sharp and may cause burns and cuts. To remove chips safely, stop machining, put on protective gloves, and use a hook or other tools.

- Prepare for fire prevention measures as the use of the non-water soluble cutting oil may cause fire.
- Use safety cover and other safety supplies because the spare parts or the inserts can be pulled out due to centrifugal force while high speed machining.



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