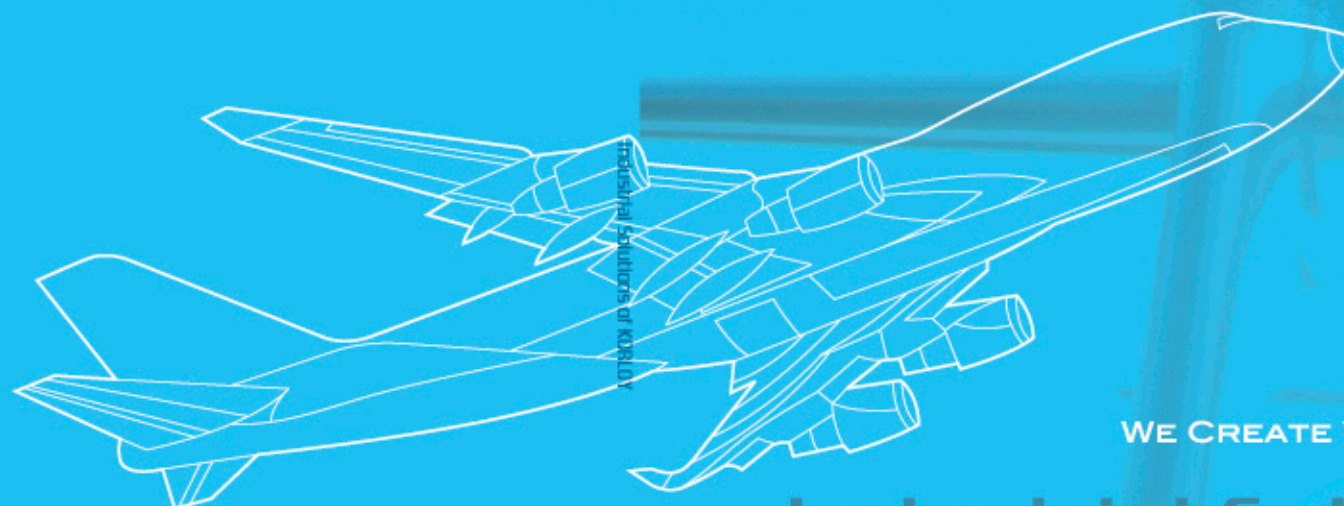


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IS-M



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Industrial Solutions of KORLOY

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 **KORLOY Inc.**



Industrial Solutions of KORLOY

◉ GEAR MACHINING 4

The gear is primary parts in the machine industry. KORLOY provides wide range of module(M8~M50) of external and internal gear for finishing, medium and roughing. KORLOY's special cutters for gear machining have got good reputation from our customers.

◉ ROLL MACHINING 8

KORLOY has various roll machining tools for different materials such as ductile cast iron, alumina, chilled steel, high chromium steel. The perfect combination of high hardness coating grade and unique chip breaker provides high productivity for our customers.

◉ BAR PEELING 10

Bar peeling is basic machining of automotive, ship and aerospace industries. KORLOY's various bar peeling cutting tools are satisfying our customers' needs.

◉ POWER GENERATION 12

Developing green energy (wind, nuclear, solar power generation) has been hot issues due to global warming and environmental issue. KORLOY supplies flanges, shafts and gear machining tools for wind power generation and various parts of gas and nuclear power generation as well.

◉ SHIP BUILDING 14

Korea is No.1 ship building country in the world and KORLOY has variety of ship building machining tools applied for cylinder blocks, crank shafts, pistons, cylinder liners and propeller housing in high efficiency machining.

◉ RAILROAD AND RAIL WHEEL 18

KORLOY provides the best solutions in rail separators, manganese crossing rail, hook-up rail and rail wheel machining. Railroad industry is continuously growing by switching other transportation.

◉ PIPE INDUSTRY 24

Steel pipes for laying, pressing, constructing, oil and gas are found in various industries and everywhere. KORLOY supplies high quality tools to comply with customers needs such as edge miller, bead removal and end-facing cutting tools for pipe machining.

◉ AEROSPACE 28

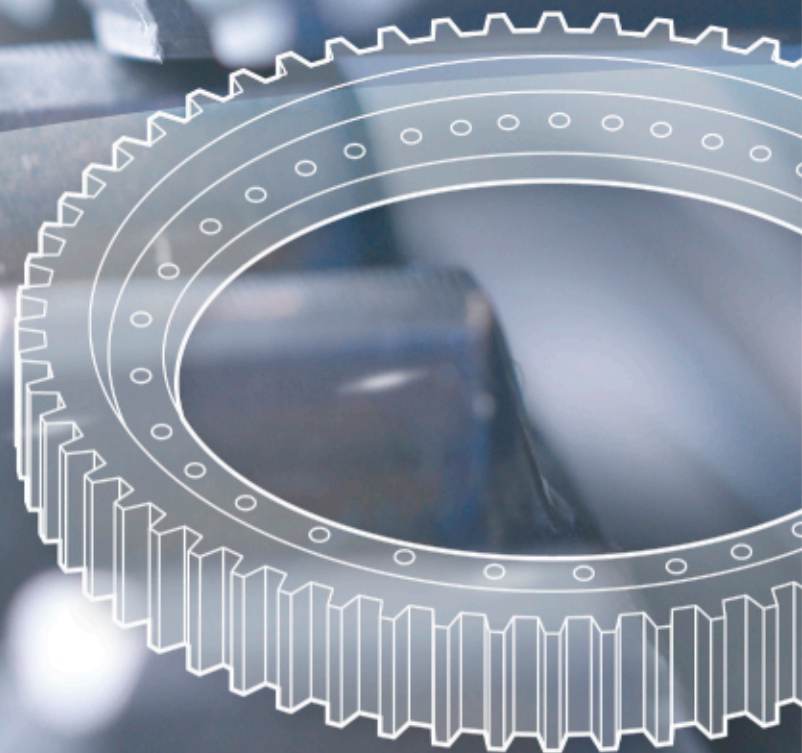
The scale of global aerospace industry in 2006 was 34 billion\$ and expected scale in 2011 is more than 10 times that of 2006's (525 billion\$). No.1 aerospace country is U.S.A and followed by UK, France, Germany, Canada. Nowadays, many countries such as China, Japan, Russia invest a lot in the aerospace industry. KORLOY, as a technology oriented precision machining tools supplier, ensures the high quality machining in engines, turbines, wings, frames, and landing gears.

GEAR MACHINING

- Recommended grades
- Roughing, Medium : PC3500
 - Finishing : PC9530, PC3500

1 Finishing cutter : M20

- Cutter diameter : $\varnothing 400$
- Number of tooth : 20
- External gear for 4 grade precision (KS or JIS)
- Additional chamfering is not necessary
chamfer formed at main process



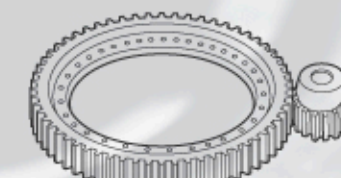
2 Medium machining cutter

- Cutter diameter : $\varnothing 280$
- Number of tooth : 48
- Designed to make involute profile on external gear.
- KORLOY exclusive insert ensures long tool life and high productivity.
- Optimum radius of insert forms ideal radius on the root of gear.



3 Roughing cutter

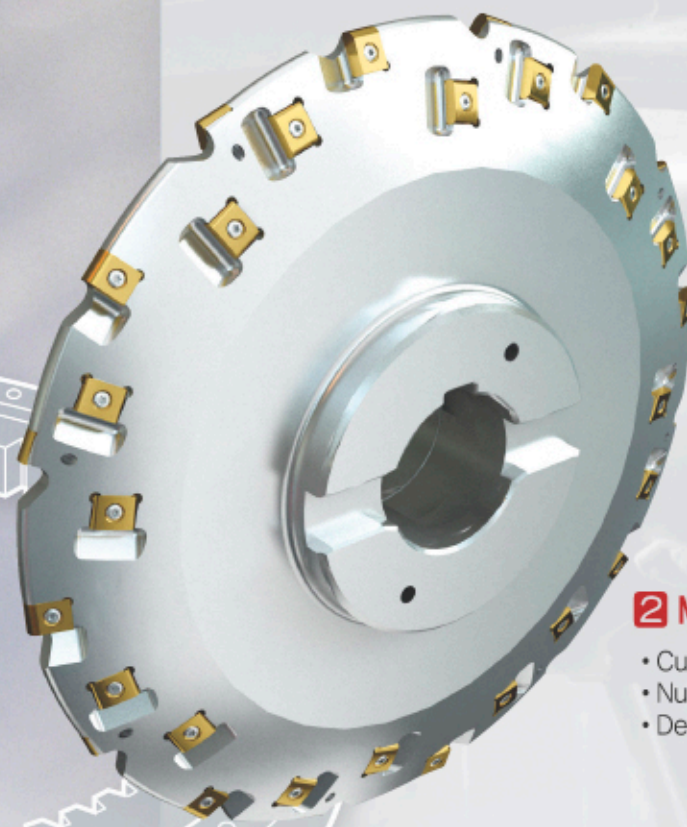
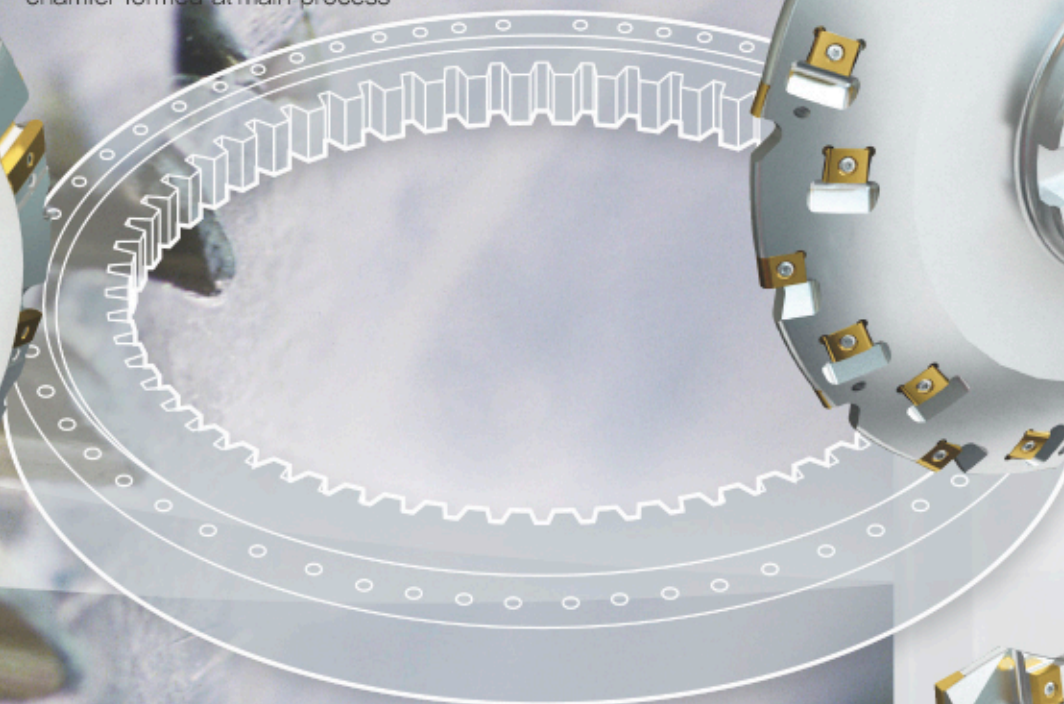
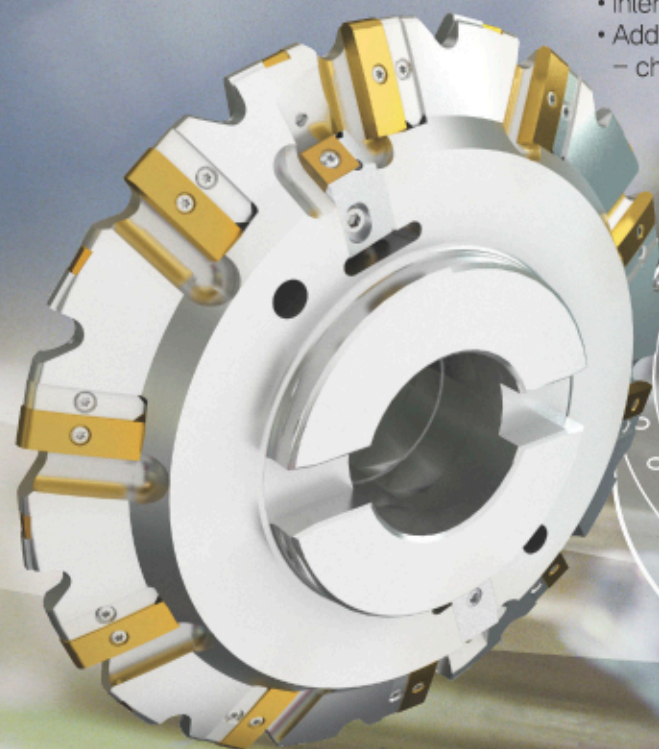
- Cutter diameter : $\varnothing 300$
- Number of tooth : 60
- High feed machining is accomplished due to the lower cutting load brought from "V" line array of inserts.



Application case External gear

1 Finishing cutter : M16

- Cutter diameter : $\varnothing 400$
- Number of tooth : 20
- Internal gear for 4 grade precision (KS or JIS)
- Additional chamfering is not necessary
– chamfer formed at main process



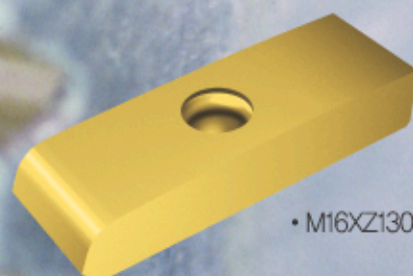
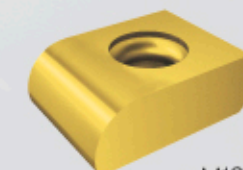
2 Medium machining cutter

- Cutter diameter : $\varnothing 400$
- Number of tooth : 48
- Designed to make involute profile on internal gear.

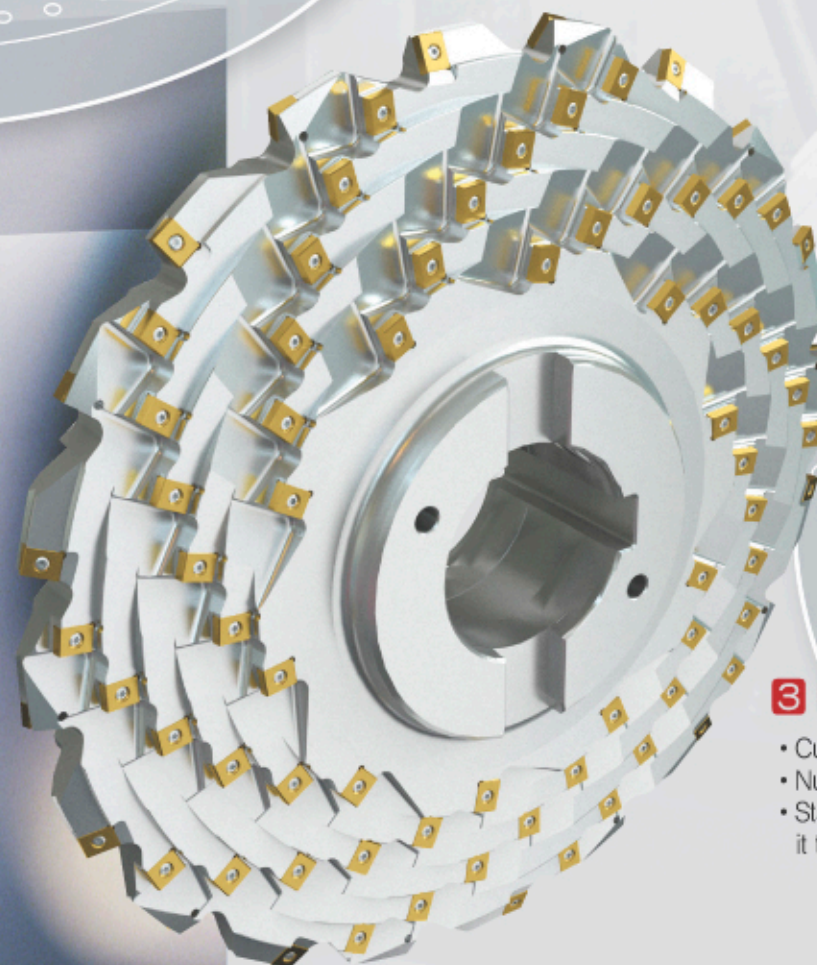
Application case Internal gear

• M16-M18-ROU

• LNE433-R80



• M16XZ130

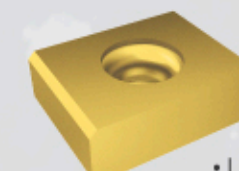
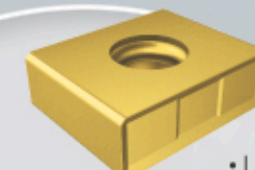


3 Roughing cutter

- Cutter diameter : $\varnothing 560$
- Number of tooth : 140
- "Stair" type insert array allow it to make variety of modul of gear.

• LNE434-02-1

• LNEX1906-C0.6-MF



ROLL MACHINING

→ Recommended grades

K05	NC6110	U10E
K10		
K15		
K20		
K25		
K30		

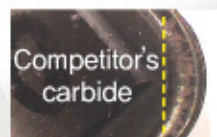
1 Parting-off of Roll

- Unique insert geometry for better chip control even in deep grooving.
- High hardness coating grade provides excellent wear resistance.

For parting-off

Application case

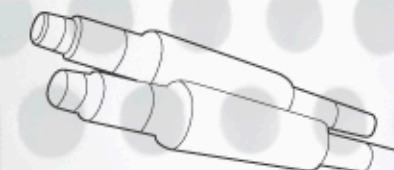
Closer chip breaker to the cutting edge provides better chip control even in deep grooving.



- Good chip evacuation even in deep grooving
- High hardness coating grade that has excellent wear resistance prevents big damage from cutting load.
(Photo shows cutting edge damage after machining same time under same conditions)

2 External turning of Roll

- Match of high hardness coating grade (NC6110) with chip breaker provides longer tool life with smooth chip control.
- Various cutting edge designs are applicable according to work-piece materials and cutting conditions.



Application case Turning/Forming/Parting-off

Application case

The combination of high hardness coating grade (NC6110) and chip breaker shows better performance.

KORLOY NC6110
LNJ6577C-CH20

Competitor's
carbide

For roughing and
medium of external
turning

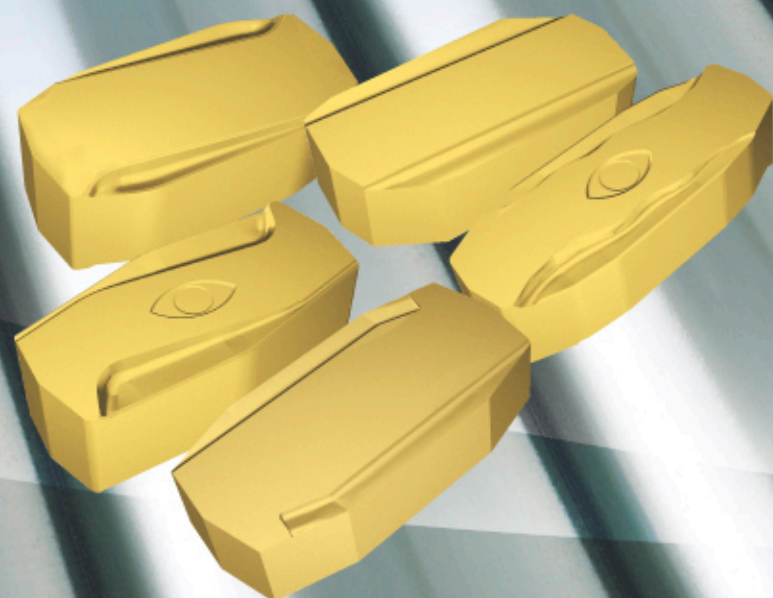
- Equipped with wide chip breaker enough to prevent crater wear
- Better chip control from the beginning of the machining, together with high hardness coating grade provides 3 times longer tool life than conventional tool. (especially at finishing)

For forming
and machining
of joint

3 Forming and Grooving of Roll

- Special chip breaker focus on suitable chip forming (engineered chip breaker width and depth)
- Cutting edge strengthening treatment prevents un-expected fracture of insert.

BAR PEELING



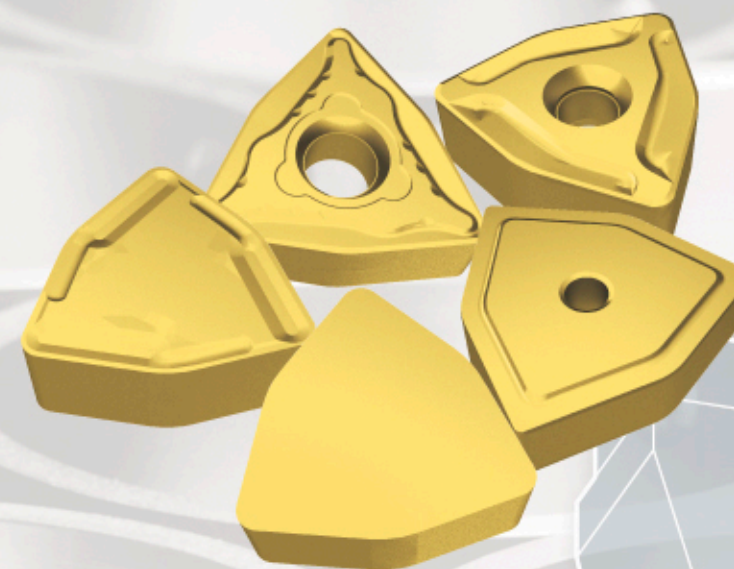
1 L type insert

- For small and medium size($\varnothing 20 \sim 60\text{mm}$) bar peeling of steels and stainless steels.
- Excellent surface finish accomplished.
- Various chip breakers can be applied for various cutting conditions.



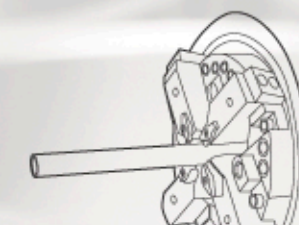
Recommended grades

P05	NC3010	CX269
P10		
P15		
P20		
P25		
P30		
M05	PC8110	NC9025
M10		
M15		
M20		
M25		
M30		

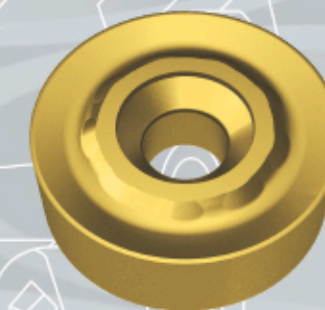


2 W type insert

- For medium and big size($\varnothing 40 \sim 200\text{mm}$) bar peeling of steels and stainless steels
- Proper surface finish at roughing
- Various chip breakers can be applied for various cutting conditions.



Application case Bar peeling



3 R type insert

- Single sided insert for big size(Over $\varnothing 150\text{mm}$) bar peeling
- Proper surface finish at roughing in steel and stainless steel machining.



4 T type insert

- Simple shape insert for intermediate size($\varnothing 40 \sim 200\text{mm}$) bar peeling
- Excellent surface finish can be achieved by using another type of insert together.

POWER GENERATION

Application case Shaft of wind power generation/Tower flange

Recommended grades

P05	NC3010	CX269	NC9025	NC500H
P10				
P15				
P20				
P25	NC3010	CX269	NC9025	NC500H
P30				
P35				
P40				
P45	NC3010	CX269	NC9025	NC500H
P50				
P55				
P60				

1 VT chip breaker

- Strong cutting edge for high feed and deep cutting depth
- Tough design of chip breaker provides excellent impact resistance
- SNMM type : 5 designations
- CNMM type : 5 designations

2 TM (Thread Milling)

- Thread milling indexable tools
- Various type of holder (standard, long, taper) and inserts
- Screw diameter : $\varnothing 9 \sim \varnothing 46\text{mm}$

3 VH chip breaker

- Good chip control in heavy machining
- Excellent performance for flange machining
- Suitable for continuous cutting conditions
- SNMM type : 5 designations
- CNMM type : 5 designations

4 LPD, SPD, NPD

Economical drilling tools with excellent performance

- High rigidity holder
- Reduced tool cost by using 4corner insert
- Good chip control and long tool life get high productivity.
- Grade : PC9530, H01

5 VZD (Vulcan drills)

- Rigid body for high feed and high precision machining
- Better chip evacuation from improved chip breaker
- Applicable for the drilling under poor cutting conditions.

6 RCMX type

- High quality machining
- Rigid insert ensures good surface finish and long tool life
- RCMX type : 6 designations

SHIP BUILDING

Recommended grades

- For Steel : PC3500
- For Cast iron : PC6510

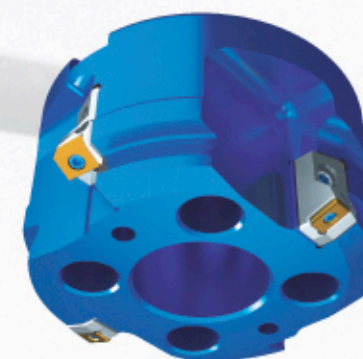


1 Roughing cutter for cylinder block

- Cutter diameter : $\varnothing 200$
- Applicable insert: SNCF1507ANN-MF
- Economical concepts : 8 edge available insert, high feed available tool
- KORLOY exclusive latch clamping system provides quick change of insert.

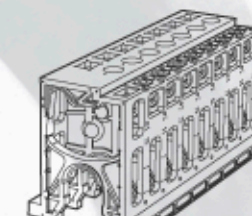
2 Multi purpose cutter (medium, roughing) for cylinder block

- Cutter diameter : $\varnothing 200$
- Applicable insert : SNCF1507ANN-MF
- Economical concepts : 8 edge available insert, high feed available tool
- KORLOY exclusive latch clamping system provides quick change of insert.



3 Cylinder block cam shaft boring cutter (Aluminum body cutter)

- Cutter diameter : $\varnothing 270$
- Applicable insert : LNE434 / SDKX1506
- Light aluminum cutter body, easy to handle, makes high precision boring.



Application case Engine Block

4 Cylinder block bearing cap seat machining cutter

- Cutter diameter : $\varnothing 250$
- Applicable insert : RDKT2006M0
- Several sizes of inserts are prepared to meet the radius requirement of work-piece.
- Rigid inserts for high efficiency machining



• YCE434-01



• YCE434-R3



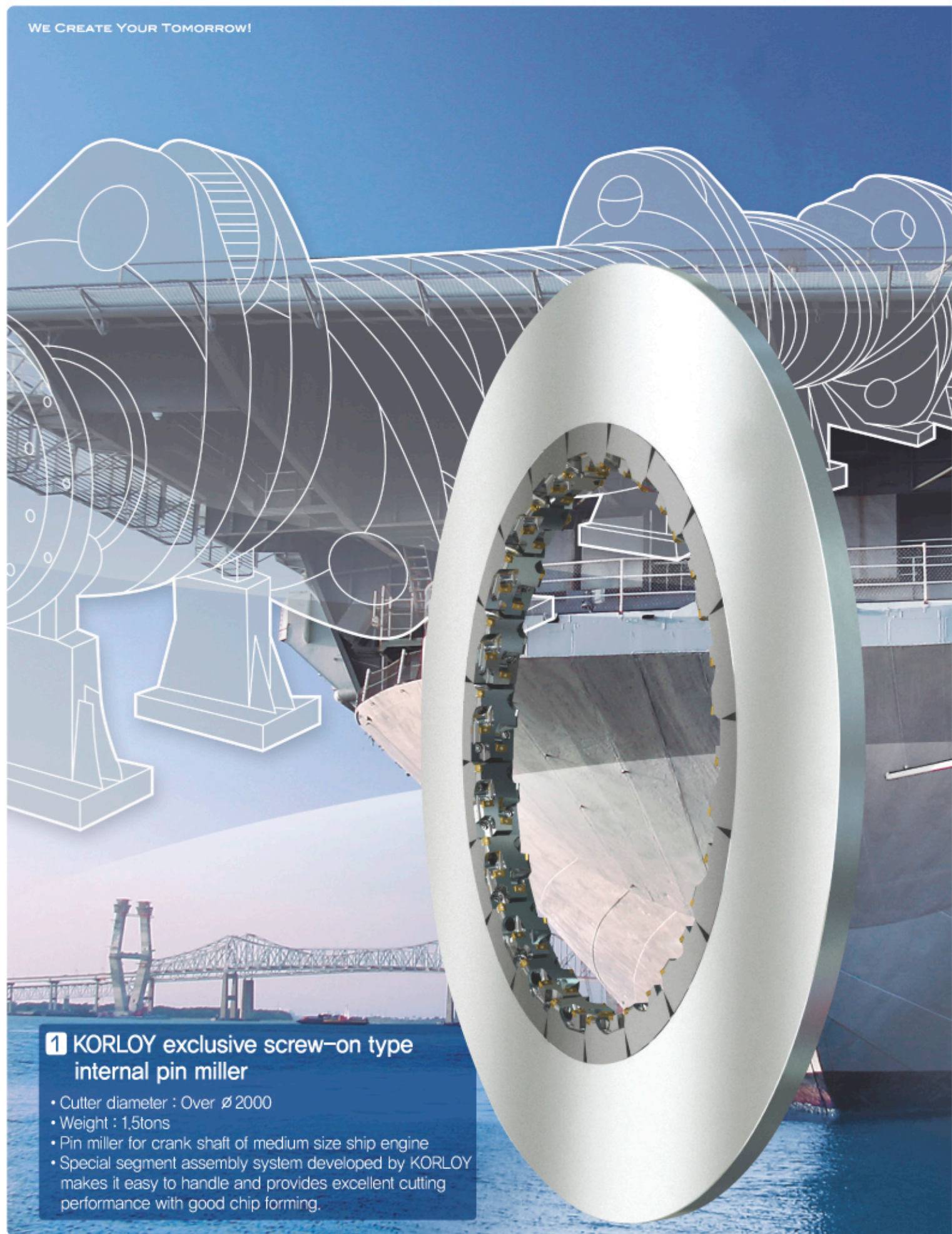
5 Adjustable medium machining cutter

- Cutter diameter : $\varnothing 250$
- Applicable insert : YCE434-01
- Cutting edge height adjustable device provides excellent surface finish.



6 High rake-angle applied cylinder block roughing cutter

- Cutter diameter : $\varnothing 250$
- Applicable insert : SECN2606AFN
- High rake angle cutter suitable for the machining has tendency to make chatter from variety of causes.



1 KORLOY exclusive screw-on type internal pin mill

- Cutter diameter : Over $\varnothing 2000$
- Weight : 1.5tons
- Pin miller for crank shaft of medium size ship engine
- Special segment assembly system developed by KORLOY makes it easy to handle and provides excellent cutting performance with good chip forming.



Application case **Crank shaft/Propeller**

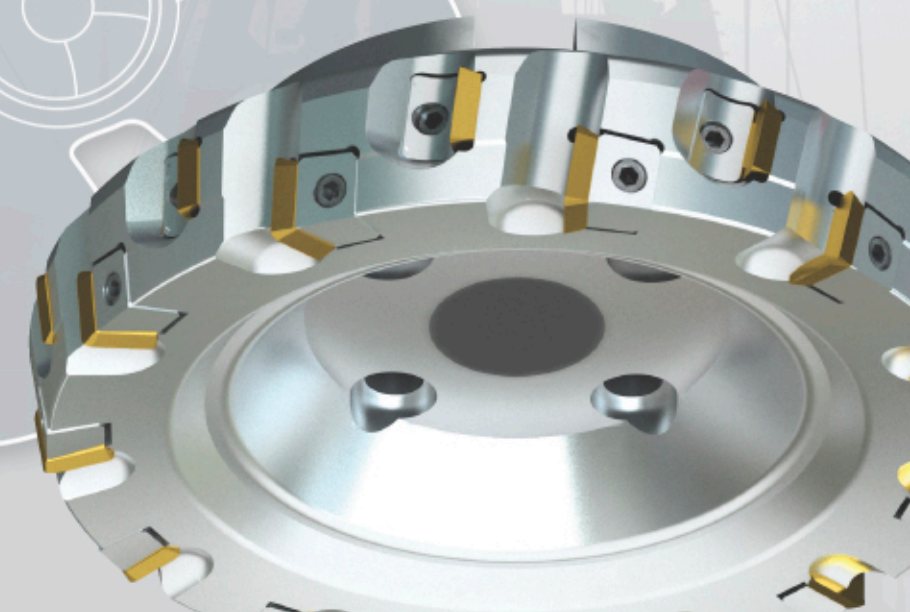
2 Periphery side of propeller machining tool

- Cutter diameter : $\varnothing 150$
- Applicable insert : CDEW170708R
- Positive relief angle applied to get smooth cutting without chatter.



3 Top face of propeller machining tool

- Cutter diameter : $\varnothing 250$
- Applicable insert : SECN1904EER
- Double layer insert array provides big depth of cut.

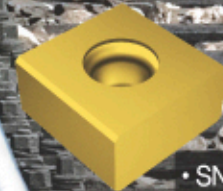


RAILROAD & RAIL WHEEL

- Recommended grades
• For Steel : NCM335, PC3500, PC3535



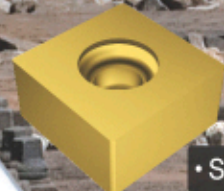
• SNC55-60-R19-1



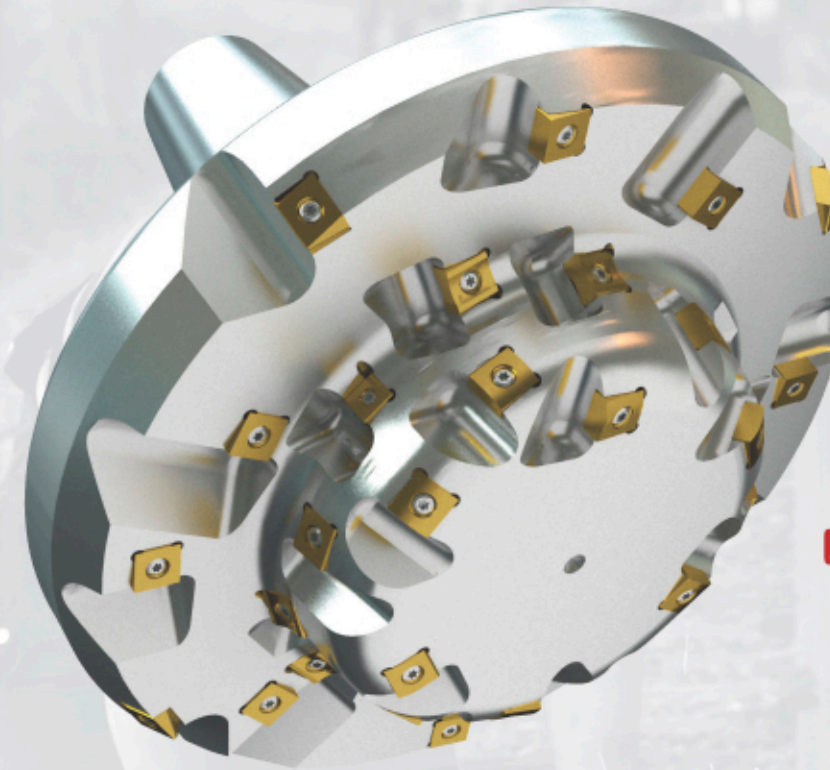
• SNC44-50-CF04

1 Rail separator joint face milling cutter

- Cutter diameter : $\varnothing 160$
- Number of tooth : 54
- Special customizing is available upon customer's requests.



• SNC55-KH04-S031



Application case Separator / Crossing

2 Forming cutter for the top side of rail way

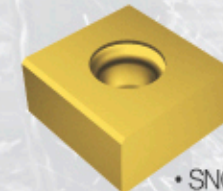
- Cutter diameter : $\varnothing 300$
- Number of tooth : 33
- One body design of cutter and arbor provides high rigidity.



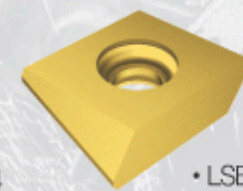
• SNC55-173-S031



• SNC55-RK13



• SNC44-50-CF04



• LSE434-R01



• SNC55-KH04-S031



• SNC55-173-S031



1 Forming cutter for the top side of rail way

- Cutter diameter : $\varnothing 160$
- Number of tooth : 16
- Precise forming of rail way is possible.



• SNC55-172-S031

• SNC55-KH04-S031



Application case Rail way

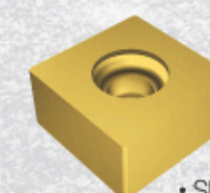
2 Taper milling for the top side of rail way

- Cutter diameter : $\varnothing 200$
- Number of tooth : 24
- Economical 8 edge available insert
- Special customizing is available upon customer's requests.



3 Periphery face milling for the top side of rail way

- Cutter diameter : $\varnothing 240$
- Number of tooth : 25



• SNC55-KH04-S031



1 RCMX insert for rail way wheel

Material : SSW2, \varnothing 840

Cutting conditions

- $vc=55\sim 100\text{m/min}$
- $fn=1.0\sim 1.5\text{mm/rev}$
- $ap=1.0\sim 6.0\text{mm}$

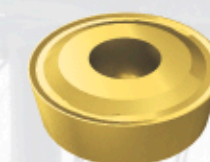
Application case Rail way wheel

2 LNUX insert for rail way wheel

Material : SSW2, \varnothing 920~1000

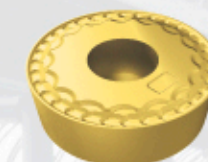
Cutting conditions

- $vc=78\text{m/min}$
- $fn=1.0\text{mm/rev}$
- $ap=3\sim 4\text{mm}$



B chip breaker

- Comprehensive roughing design having strong edge strength with long tool life.



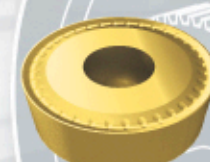
SB chip breaker

- Better chip control at low depth of cut machining



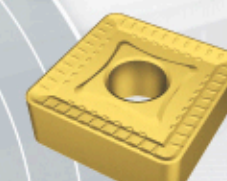
SL chip breaker

- Comprehensive chip breaker covers wide application range
- Proper chip control with long tool life



TM chip breaker

- Medium-finishing chip breaker, proper surface finish, superior wear resistance



VT chip breaker

- Strong cutting edge for high feed and deep cutting depth
- Tough design of chip breaker provides excellent impact resistance
- SNMM type : 5 designations



LNUX301940-TM

- Comprehensive design for general use, strong cutting edge with good chip forming. (First recommendation)



LNUX301940-TF

- For light cutting, it generates low cutting load, good chip forming.

Recommended grades

P05	NC3010	CX269	NC9025	NC500H
P10				
P15				
P20				
P25				
P30				
P35				
P40				
P45				

PIPE INDUSTRY

- Recommended grades
- For Steel : NCM325, PC3500



1 "X" shape machining()

- A machining to make "X" shape on the both side-end of steel plate, to do bevel-end welding.
- Locator wedge type clamping system applied for the cutter provides long durability of cutter as well as strong clamping power.

2 "Y" shape machining()

- A machining to make "Y" shape on the both side-end of steel plate, to do bevel-end welding.
- Wide chip pocket on cutter provides long durability of it by reducing contact of chip with cutter body.

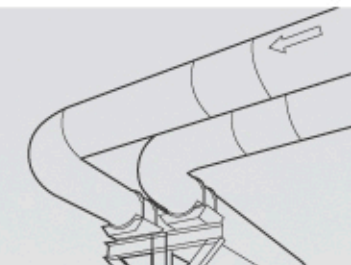
3 "I" shape machining()

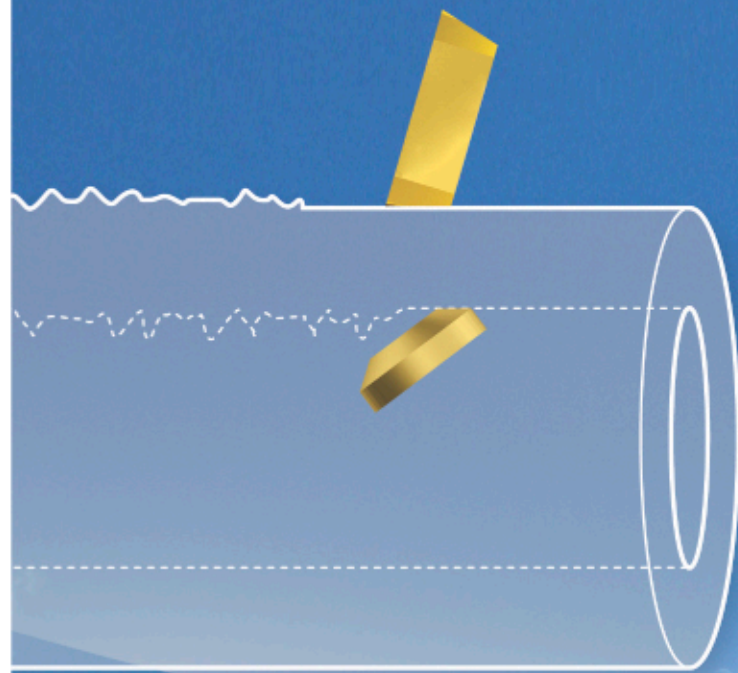
- A machining to make "I" shape on the both side-end of steel plate, to do bevel-end or plane-end welding.
- Several kinds of inserts (with chip breaker or without chip breaker) are available according to the cutting conditions.

4 Special machining

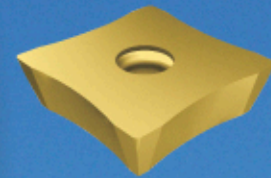
- Special design of cutter as per side-end shape of steel plant upon customer's request is available

Application case Edge milling



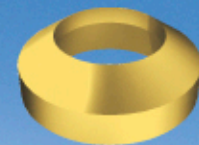


1 Bead removal insert : External



- Tool removing protruded part of melted welding material at out-side of pipe.
- Economical tool by using square insert to use 4 cutting edges.
- Grade : NC3030 (P30)

2 Bead removal insert : Internal



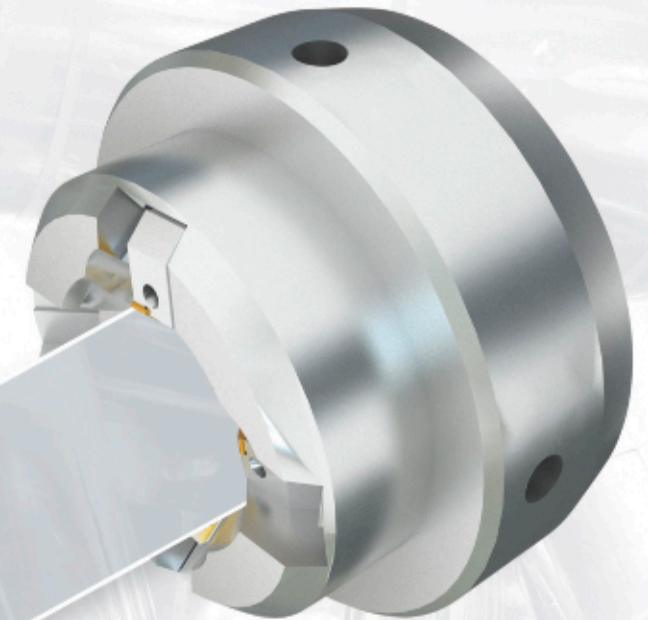
- Tool removing protruded part of melted welding material at inside of pipe.
- Grade : CX1222 (P40)

3 Slitting cutter

- Tool to cut-off the pipe after welding
- Economical tool by using square insert to use 4 cutting edges.
- Special chip breaker equipped on cutting edge provides smooth cutting.
- Grade : NCM325

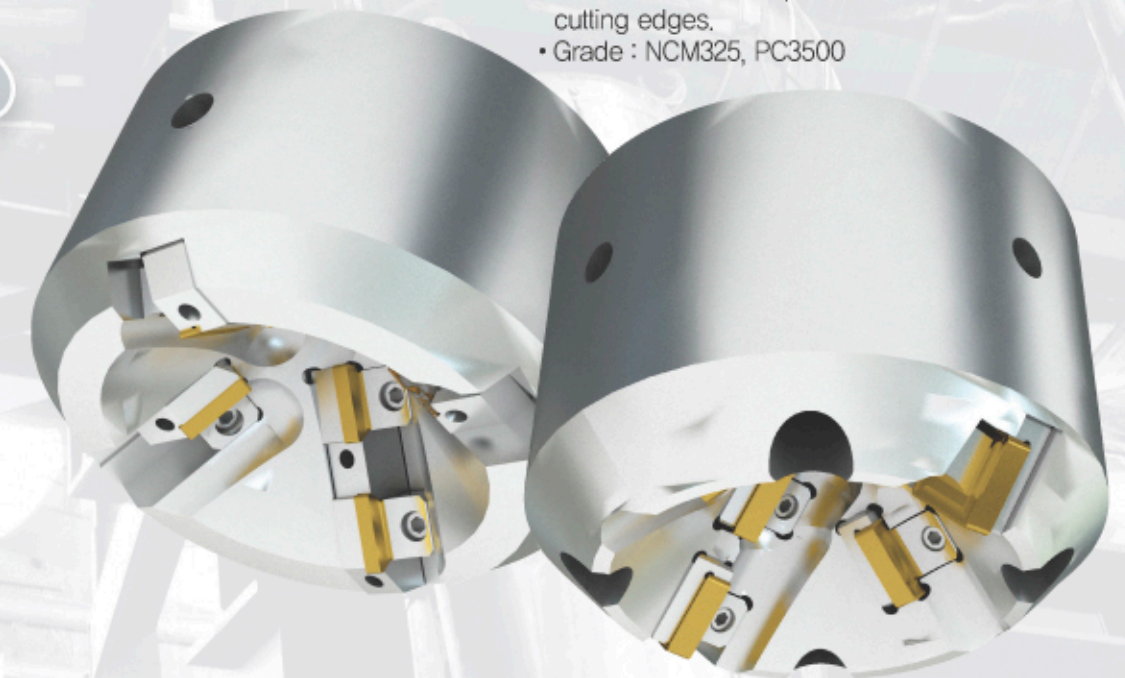


Application case Bead removal / Parting-off / Chamfering



4 Chamfer Tool

- Chamfering tool machining cut-off face of pipe.
- Special chamfering angle design is possible upon customer's request.
- Cost effective concept : Triangle and Square double-sided insert provides 6~8 effective cutting edges.
- Grade : NCM325, PC3500



AEROSPACE

Recommended grades (ISO Turning)

S05	PC8110	
S10		
S15		
S20		
S25		
S30		NC9025
M10	NC9025	PC9530
M20		
M30		
N10		H01
N20		

1 HRMDouble

High efficient and cost effective tool by double sided insert

- Cost effective tool by using double sided insert having 6 cutting edges.
- Smooth cutting has made by using high rake angle sharp cutting edge insert.

2 LPD, SPD, NPD

Drilling tool having superior quality with economical benefit

- Rigid drill body, economical 4 cutting edge using insert.
- High productivity delivered by using special chip breaker with optimum grade.
- Grade : PC9530, H01

3 Laser Mill

Multi-functional indexable end-mill

- Extremely hard grade provides long tool life.
- Easy and simply clamping of insert by using single screw.
- Excellent quality for fine finishing due to its inherent precise tolerance.

4 H-MAX

Solid end-mill for hard material

- Sub-micron carbide provides strength on sharp cutting edge preventing small chipping on it.
- Advanced PVD coating having high hardness with strong anti-oxidation property coated on it provides excellent tool life at the machining of hard to cut material having high hardness.

5 iMAX

Solid end-mill for hard to cut material (IFSE3000)

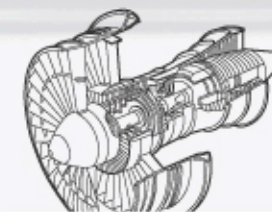
- High rake angle with helical flute provides excellent chip evacuation.
- Specially designed cutting edge applied to overcome work-hardening property of work-piece.
- Best quality at the machining of hard to cut material.

6 Alpha Mill

Multi functional milling tool

- Vast coverage of milling operation due to its variety of cutters and inserts.
- 3 dimensional chip breaker design provides smooth cutting.

Application case Engine 1



Application case **Engine 2**

1 TPD

Advanced high-performance precise indexable drill

- High-performance drill effective for high-speed, high-feed application.
- Advanced indexable drill offers precise drilled hole-size with excellent drilled surface.

2 MGT

For Grooving, Turning, Profiling, Cut-off

- Multi functional grooving tool can cover variety of machining with advanced chip-breaker.

4 SSEA

Solid carbide endmill for Aluminum machining

- Advanced geometry of endmill refrains build-up-edge from the cutting edge
- Superior surface machined surface
- DLC coated endmill available

3 Pro-X Mill

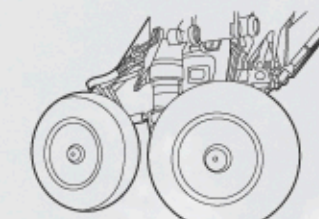
High-speed Aluminum Milling tool

- Unique mounting system of insert provides tight clamping of insert.
- Mirror surface and high rake angle of insert bring excellent machined surface by reduced cutting load and build-up-edge.
- Grade : H01

5 LPD, SPD, NPD

Economical high-performance indexable drill

- Economical high-performance indexable drill having rigid body and 4 cutting edge available insert.
- Combination of variety of grades and chip-breakers bring high productivity.
- Grade : PC9530, H01



Application case Landing gear / Accessory

1 LPD, SPD, NPD

Economical high-performance indexable drill

- Economical high-performance indexable drill having rigid body and 4 cutting edge available insert.
- Combination of variety of grades and chip-breakers bring high productivity.
- Grade : PC9530, H01

2 Boring Bar

Internal Turning

- ISO standard boring bar for internal machining

3 Alpha Mill

Multi functional milling tool

- Vast coverage of milling operation due to its variety of cutters and inserts.
- 3 dimensional chip breaker design provides smooth cutting.
- Grade : PC3500

4 TPD

Advanced high-performance precise indexable drill

- High-performance drill effective for high-speed, high-feed application.
- Advanced indexable drill offers precise drilled hole-size with excellent drilled surface.

5 MLD

- Direct drilling without separate operation (step drilling) over 20 x D.
- Wider flute space along with drill provides effective chip evacuation.
- Special design for rigid body provides smooth drilling without bending of drill.

6 Turning Holder

- To cope with variety of turning operation, customized complicated holder is available as well as standard ISO turning holder.

7 iMAX

Solid carbide coated Endmill for General use (IFE, IBE, IRE, FE, BE, RE)

- PVD coated endmill using sub-micro carbide rod.
- Comprehensive coated carbide endmill covers wide range from roughing to finishing.
- Multi purpose operation available (Periphery side, Grooving, Ramping)

Industrial Solutions

Index as per Industries



GEAR MACHINING

Finishing cutter : M20	04
Medium machining cutter	05
Roughing cutter	05
Finishing cutter : M16	06
Medium machining cutter	07
Roughing cutter	07



BAR PEELING

L type insert	10
W type insert	11
R type insert	11
T type insert	11



SHIP BUILDING

Roughing cutter for cylinder block	14
Multi purpose cutter for cylinder block	14
Cylinder block cam shaft boring cutter	15
Cylinder block bearing cap seat machining cutter	15
Adjustable medium machining cutter	15
High rake-angle applied cylinder block roughing cutter	15
KORLOY exclusive screw-on type internal pin miller	16
Periphery side of propeller machining tool	17
Top face of propeller machining tool	17



PIPE INDUSTRY

"X" shape machining	24
"Y" shape machining	25
"T" shape machining	25
Special machining	25
Bead removal insert : External	26
Bead removal insert : Internal	26
Slitting cutter	26
Chamfer Tool	27



ROLL MACHINING

Parting-off of Roll	08
External turning of Roll	09
Forming and Grooving of Roll	09



POWER GENERATION

VT chip breaker	12
TM (Thread Milling)	12
VH chip breaker	13
LPD, SPD, NPD	13
VZD (Vulcan drills)	13
RCMX type	13



RAILROAD AND RAIL WHEEL

Rail separator joint face milling cutter	18
Forming cutter for the top side of rail way	19
Forming cutter for the top side of rail way	20
Taper milling for the top side of rail way	21
Periphery face milling for the top side of rail way	21
RCMX insert for rail way wheel	22
LNIX insert for rail way wheel	23



AEROSPACE

HRMDouble	28
LPD, SPD, NPD	28 31 32
Laser Mill	29
H-MAX	29
I-Max	29 33
Alpha Mill	29 32
TPD	30 33
MGT	30
Pro-X Mill	31
SSEA	31
Boring Bar	32
MLD	33
Turning Holder	33

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