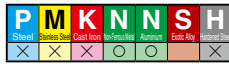


Rake Angle	Radial	0° to 2°
	Axial	+10°

5.7mm 90°



SUMIDIA Cutter

SAM-E Type



SUMIDIA Cutter Range Expansion

- **Special Design Edge**
 - Strong cutting edge improves performance.
- **High Precision**
 - Thin pitch screw allows fine adjustment.
- **High Speed Machining**
 - Strong clamp improves rigidity and enhances precision.

Body (SAM-E Type)

Cat. No.	Stock		Dimensions (mm)		No. of Teeth	Axial Rake	Radial Rake
	R	L	ϕD_c	ϕD_s			
SAM050E R/L	●		50	32	3	10°	0°
063E R/L	●		63	32	3	10°	1°
080E R/L	●		80	32	4	10°	2°

Inserts are not included.

Blades

Cat. No.	DA150		DA2200		Fig	Applicable Cutter
	R	L	R	L		
FAB R/L	●		●		1	FAM
SAB R/L	●		●		2	SAM

Spare Parts

Blade Clamp	Blade Side Clamp	Adjuster Wedge	Double Screw	Double Screw	Spanner	Applicable Cutter Cat. No.
FADR	FAWR	FAAR*	WB7-15T	WB7F-15T	TT25	FAM Type SAM Type

* Adjuster Wedge for SAM050E R/L and SAM063E R/L is SAAR.

Recommended Cutting Conditions

ISO	Work Material	Process	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
N	Aluminium Alloy (AC)	Rough	400-1700-3000	0.05-0.13-0.20	DA150 DA2200
	Aluminium Alloy (ADC)	Finishing	400-1700-3000	0.04-0.10-0.15	DA150 DA2200
	Aluminium Alloy (A390)	Finishing	300-450-600	0.04-0.10-0.15	DA150 DA2200

Comparison Test

● Finishing Surface Roughness	● Finishing Surface Roughness
Work Material: AC2C $v_c=1,500\text{m/min}$ $a_p=0.5\text{mm}$ $f_z=0.04$ to 0.15mm/t Dry Surface Milling	Work Material: AC2C $v_c=1,000\text{m/min}$ $a_p=5.0\text{mm}$ $a_e=0.1\text{mm}$ $f_z=0.06\text{mm/t}$ Dry Surface Milling

M

SUMIDIA

SUMIDIA

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Binderless

SUMICRYSTAL