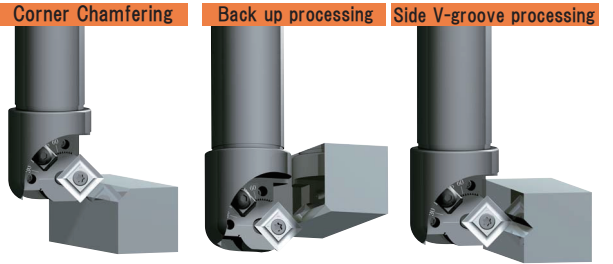
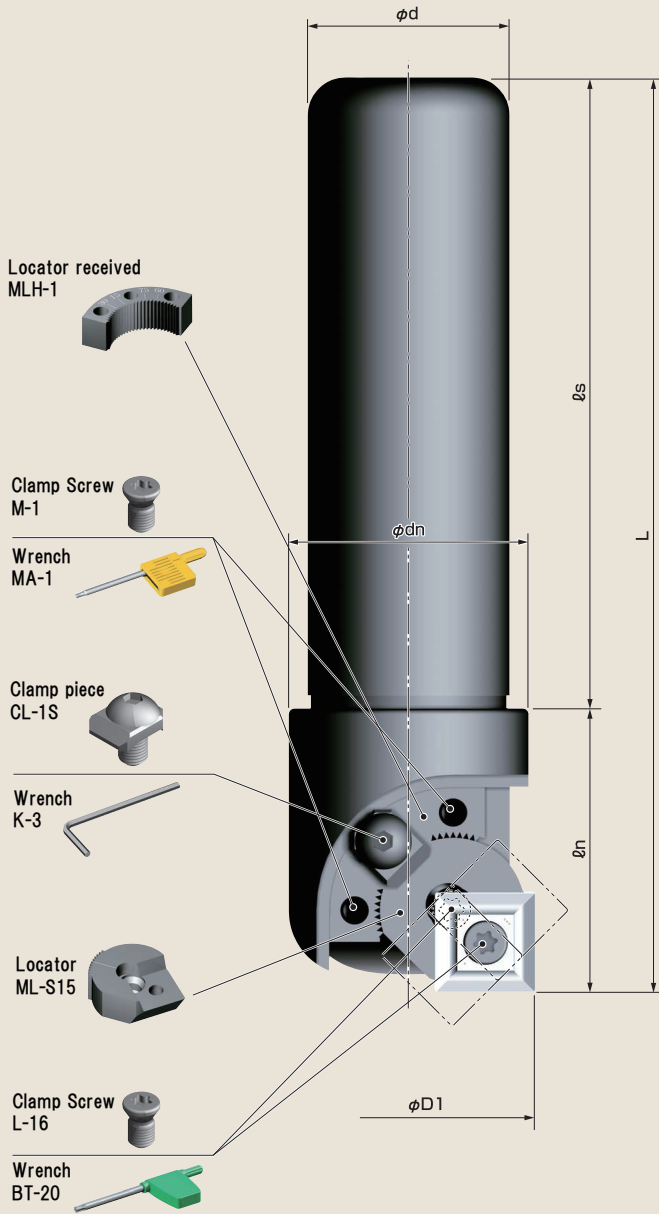
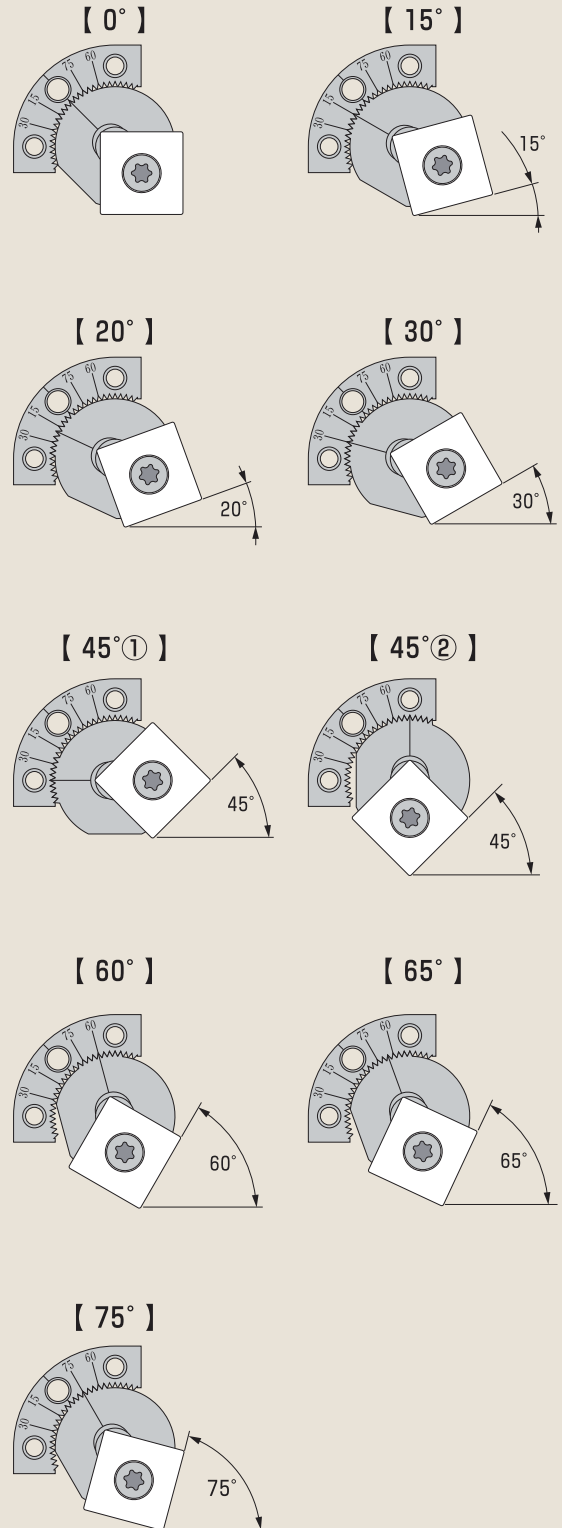


Variable Angle Processing!

- By the serration mechanism and our original double clamp system, holding parts is superior to prevent insert movement. 0°~90° Angle adjustment can be easily and securely made



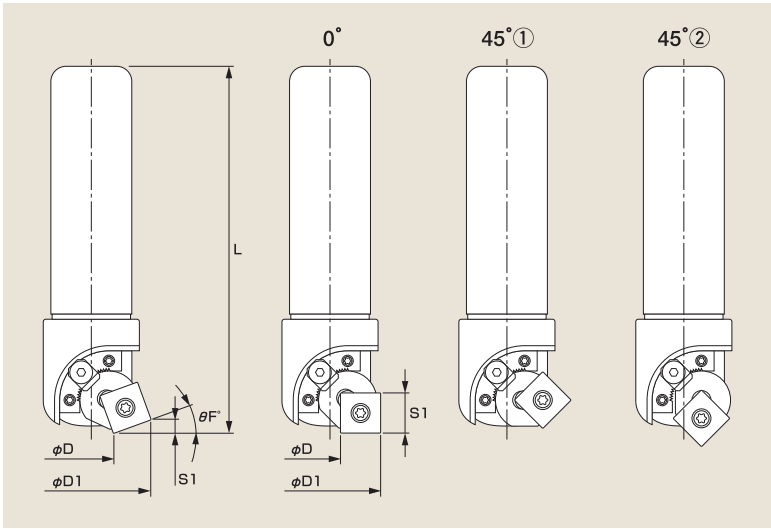
Display for division of angle



Model No.	blades	Dimensions (mm)					Inserts	
		$\phi D1$	ϕd	ϕdn	L	ℓs		ℓn
MAM32-50S	1	※1	32	38	145	100	45	SDMT150404 SDET150404
MAM32-50SL	1	※1	32	38	200	155	45	SDMT150404 SDET150404

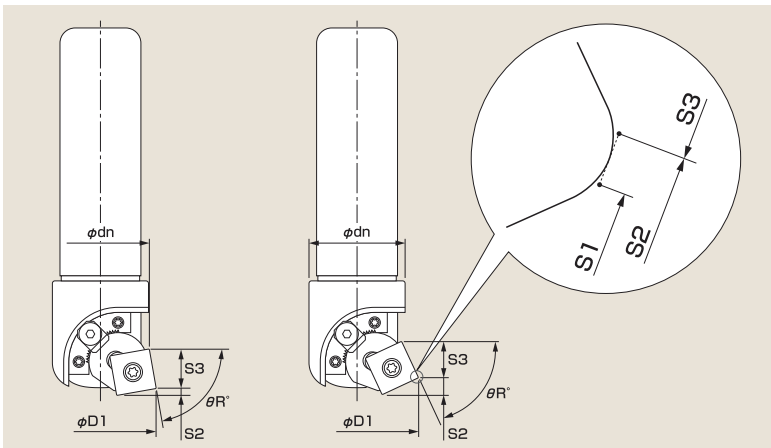
※ Insert is not equipped as standard accessory. Please purchase it separately
 ※ Clamp screw, wrench and locator are supplied as standard accessories
 ※ Please refer to angle dimension table (P-28)

< θF° > Angle Dimension Table 1 (MAM32-50S)



θF°	ϕD	$\phi D1$	S1	L
0°	φ8.3	φ40	15.9	145
5°	φ11.3	φ42.1	1.3	145.2
10°	φ13.6	φ44	2.7	145.2
15°	φ15.9	φ45.7	4.0	145.2
20°	φ18.1	φ47.1	5.3	145.1
25°	φ20.4	φ48.3	6.5	144.8
30°	φ22.6	φ49.3	7.7	144.5
35°	φ24.7	φ49.9	8.8	144.1
40°	φ26.7	φ50.3	9.9	143.6
45°①	φ28.7	φ50.5	10.9	143
45°②	φ14.3	φ36	10.9	150.2
50°	φ17.4	φ37.2	11.8	150.2
55°	φ20.5	φ38.2	12.6	150
60°	φ23.6	φ39.1	13.4	149.6
65°	φ26.7	φ39.7	14	149.2
70°	φ29.6	φ40.1	14.5	148.6
75°	φ32.4	φ40.4	14.9	147.8
80°	φ35.1	φ40.5	15.2	147
85°	φ37.6	φ40.3	15.4	146.1

< θR° > Angle Dimension Table 2 ($\theta R^\circ = 90^\circ - \theta F^\circ$)



θR°	$\phi D1$	ϕdn	S2	S3
85°	φ42.1	φ39.4	1.7	15.4
80°	φ44	φ38.6	3.1	15.2
75°	φ45.7	φ38.0	4.4	14.3
70°	φ47.1	φ38.0	5.6	12.5
65°	φ48.3	φ38.0	6.9	11.1
60°	φ49.3	φ38.0	8	9.7
55°	φ49.9	φ38.0	9.2	8.5
50°	φ50.3	φ38.0	10.2	7.4
45°	φ50.5	φ38.0	11.2	6.2

Cutting Conditions

	Material Model	SDMT150404			
		ZA10N	ZA20N	DA20N	AC15N
General Steel	0.05~0.15		100~150	100~150	100~150
Alloy Steel	0.05~0.15		100~150	100~150	100~150
Stainless Steel	0.05~0.15		80~120	80~120	80~120
Aluminum, Resin, Brass	0.08~0.2	150~400			
Castings	0.05~0.15		100~150	100~150	

● In case of Stainless steel processing, please take down cut

Processing Example

- Processing Example
- Body : MAM32-50S
- Body : SDMT150404 ZA20N
- Material : S45C
- Rotation Speed : 630.p.m.
- Table feed : 63mm/min
- Depth of Cut : C5
- Cutting Oil : None



Result
 Good!
 No secondary burrs and, No chattering after processing

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
<p>(SDMT150404)</p>	SDMT150404 ZA10N	Carbide K10	Sharp edge	None	2	3
<p>(SDMT150404)</p>	SDMT150404 ZA20N	Carbide M20	Honing edge	None	4	3
	SDMT150404 DA20N	Carbide M20	Honing edge	TiAlN	4	3
	SDMT150404 AC15N	Fine particles Carbide	Honing edge	AlCrN	4	3