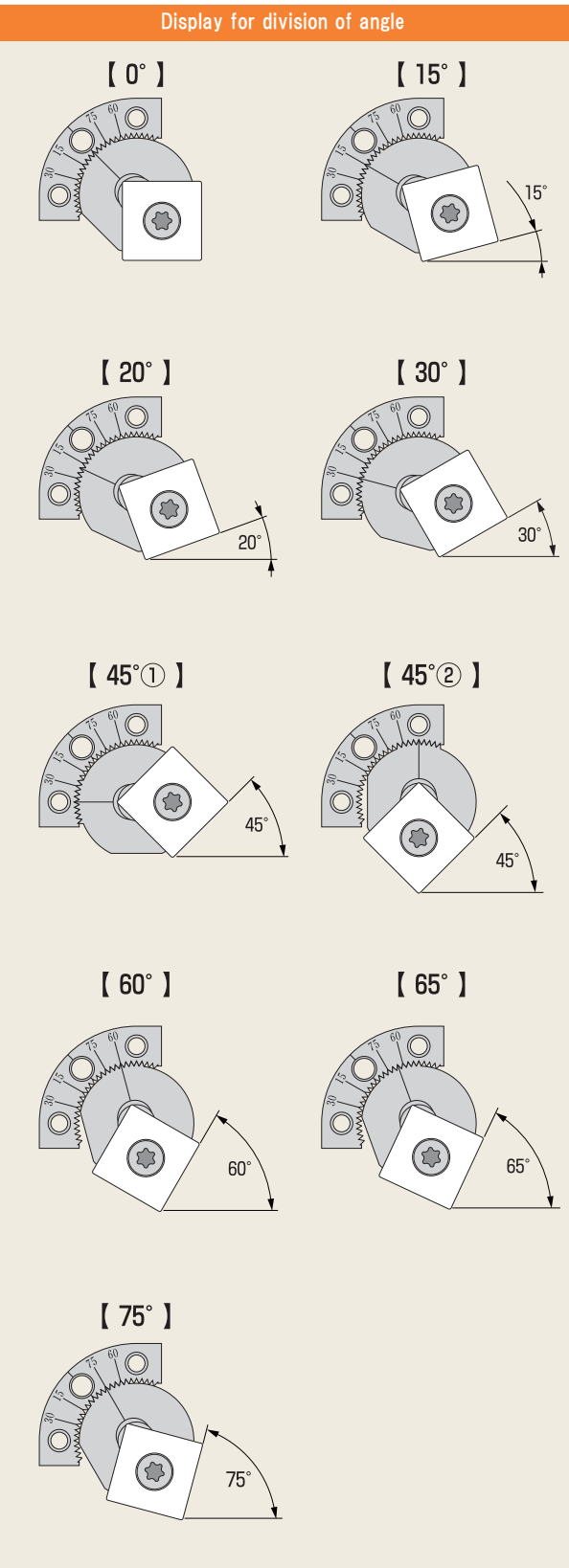
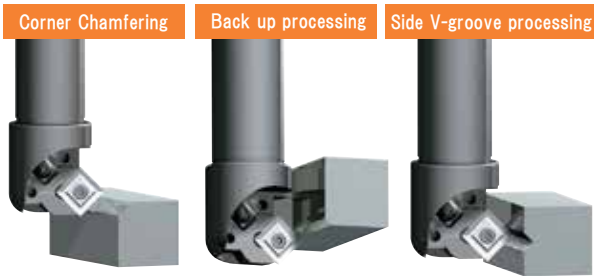
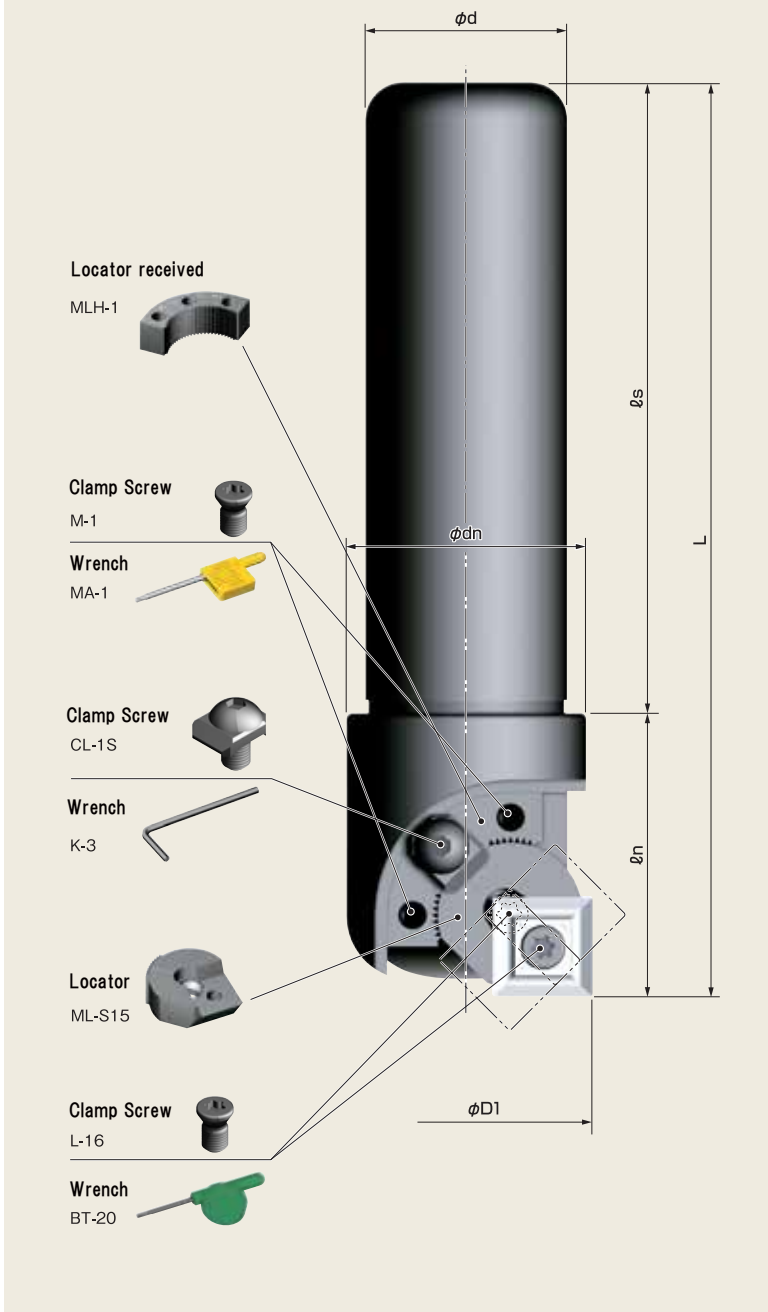


Variable Angle Processing!

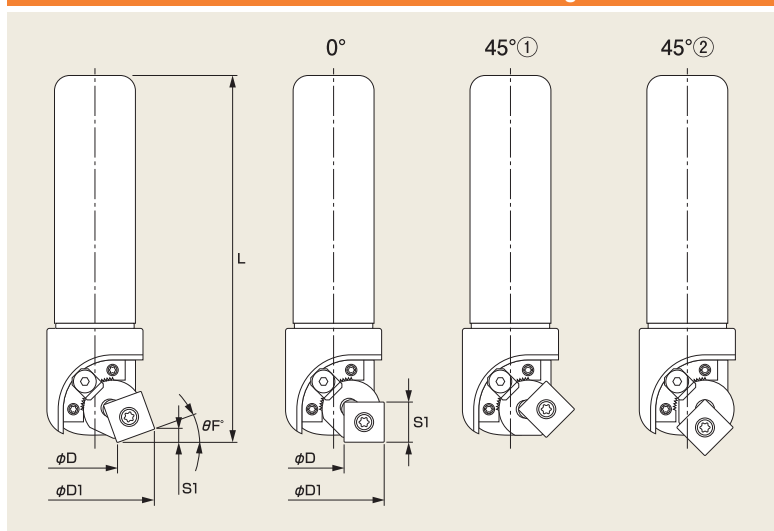
- By the serration mechanism and our original double clamp system, holding parts is superior to prevent insert movement. 0°~90° Angle adjustment can be easily and securely made



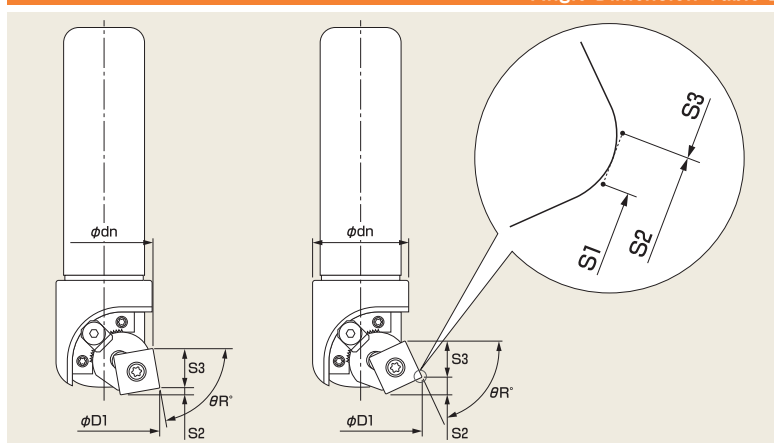
Body

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

※ 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-36)

〈 θF° 〉 Angle Dimension Table 1 (MAM32-50S)

θF°	ϕD	$\phi D1$	S1	L
0°	$\phi 8.3$	$\phi 40$	15.9	145
5°	$\phi 11.3$	$\phi 42.1$	1.3	145.2
10°	$\phi 13.6$	$\phi 44$	2.7	145.2
15°	$\phi 15.9$	$\phi 45.7$	4.0	145.2
20°	$\phi 18.1$	$\phi 47.1$	5.3	145.1
25°	$\phi 20.4$	$\phi 48.3$	6.5	144.8
30°	$\phi 22.6$	$\phi 49.3$	7.7	144.5
35°	$\phi 24.7$	$\phi 49.9$	8.8	144.1
40°	$\phi 26.7$	$\phi 50.3$	9.9	143.6
45°①	$\phi 28.7$	$\phi 50.5$	10.9	143
45°②	$\phi 14.3$	$\phi 36$	10.9	150.2
50°	$\phi 17.4$	$\phi 37.2$	11.8	150.2
55°	$\phi 20.5$	$\phi 38.2$	12.6	150
60°	$\phi 23.6$	$\phi 39.1$	13.4	149.6
65°	$\phi 26.7$	$\phi 39.7$	14	149.2
70°	$\phi 29.6$	$\phi 40.1$	14.5	148.6
75°	$\phi 32.4$	$\phi 40.4$	14.9	147.8
80°	$\phi 35.1$	$\phi 40.5$	15.2	147
85°	$\phi 37.6$	$\phi 40.3$	15.4	146.1

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

θR°	$\phi D1$	ϕdn	S2	S3
85°	$\phi 42.1$	$\phi 39.4$	1.7	15.4
80°	$\phi 44$	$\phi 38.6$	3.1	15.2
75°	$\phi 45.7$	$\phi 38.0$	4.4	14.3
70°	$\phi 47.1$	$\phi 38.0$	5.6	12.5
65°	$\phi 48.3$	$\phi 38.0$	6.9	11.1
60°	$\phi 49.3$	$\phi 38.0$	8	9.7
55°	$\phi 49.9$	$\phi 38.0$	9.2	8.5
50°	$\phi 50.3$	$\phi 38.0$	10.2	7.4
45°	$\phi 50.5$	$\phi 38.0$	11.2	6.2

Cutting Conditions

		SDET150404	SDMT150404	
Material	Material Model	ZA10N	ZA20N	AC15N
	Feed per blade (fz)	Cutting speed (m/min)		
General Steel	0.05~0.15		100~150	100~150
Alloy Steel	0.05~0.15		100~150	100~150
Stainless Steel	0.05~0.15		80~120	80~120
Aluminum, Resin, Brass	0.08~0.2	150~400		
Castings	0.05~0.15		100~150	

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

Processing Example

[Perimetry C5 Chamfering]

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



Dry cutting

Result

Good!
No secondary burrs and, No chattering after processing

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
	SDET150404 ZA10N	Carbide K10	Sharp edge	None	2	3
	SDMT150404 ZA20N	Carbide M20	Honing edge	None	4	3
	SDMT150404 AC15N	Fine particles Carbide	Honing edge	AlCrN	4	3