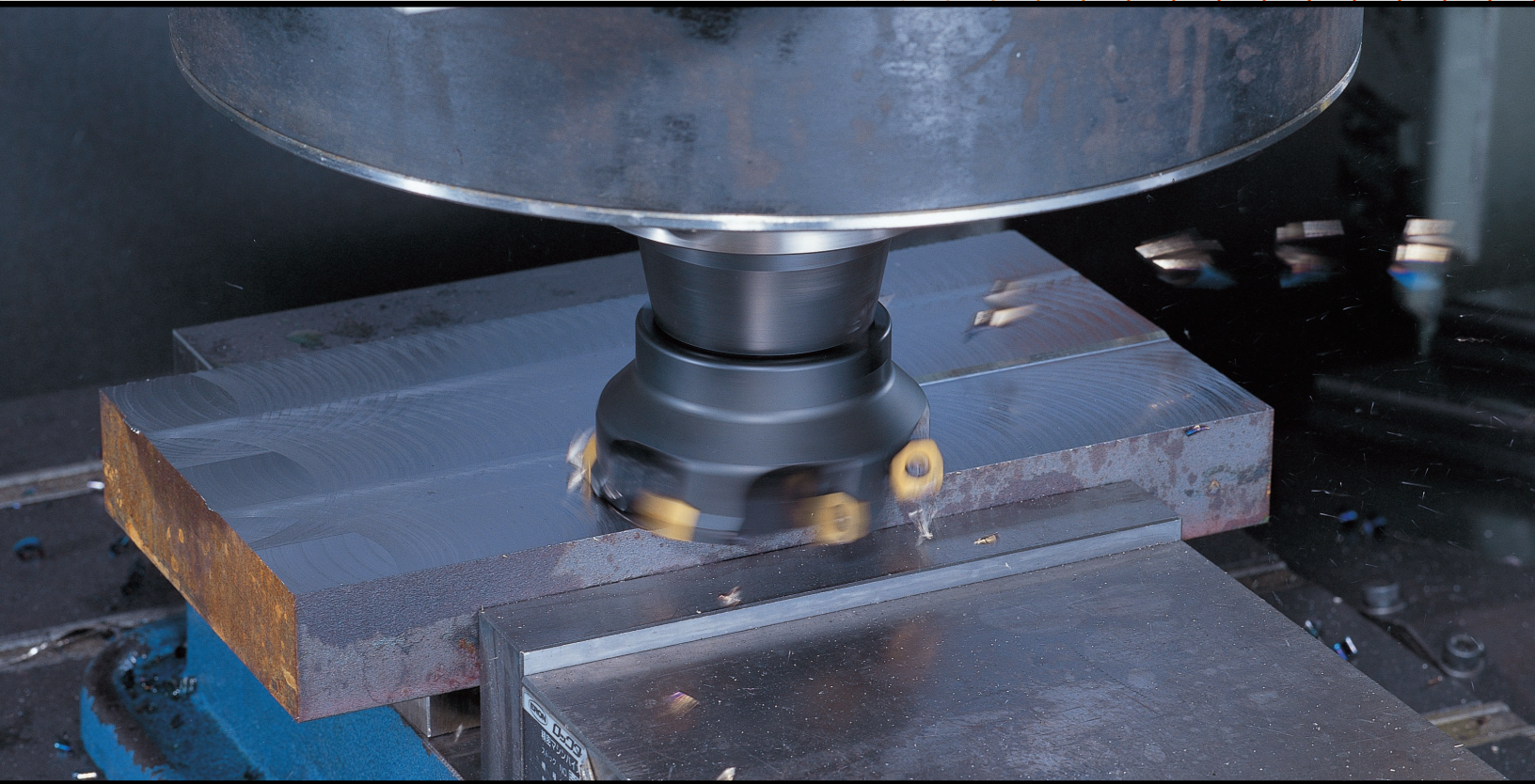


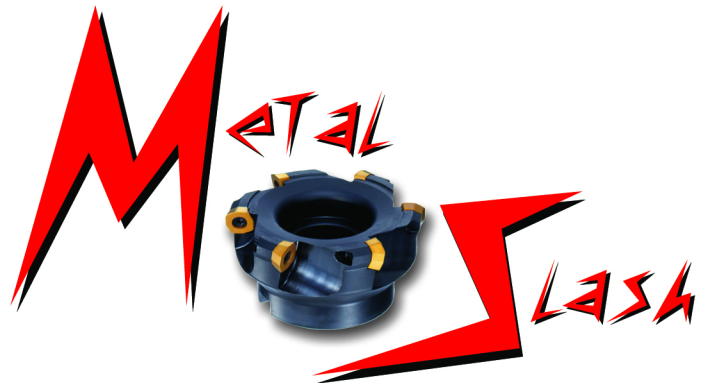
 SUMITOMO ELECTRIC

# ***Metal Slash Mill***

***High Feed Milling Cutter***



***Feed Rates Up to  
0.078" IPT !!!***



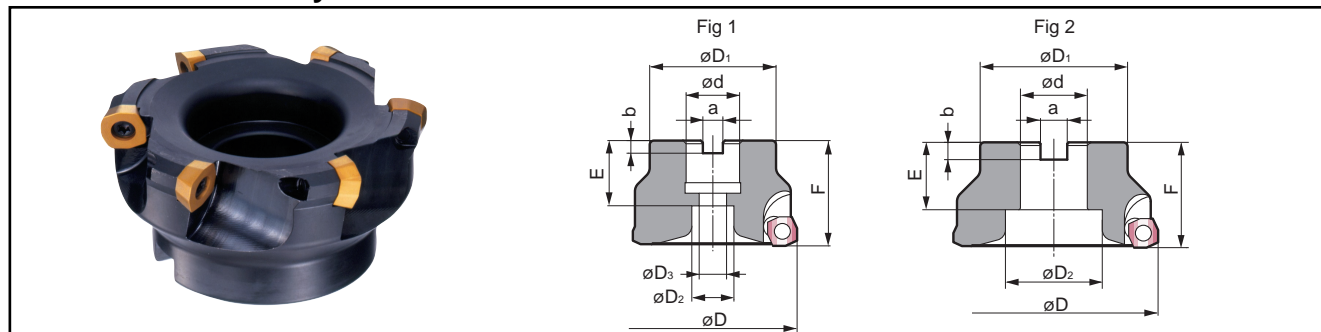
# Metal Slash Mill

## ■ Features & Benefits

- Screw-on insert assembly
- U.S. stock standard bodies available in 2.000" - 4.000" diameters  
Worldwide stock includes 63.0 mm - 125 mm
- High feed rates (Maximum feed rate = 0.078" IPT) result in high productivity milling
- Four corner insert design yields low tooling costs per part
- Unique design directs cutting forces into the machine spindle to facilitate high feed rates even in low rigidity conditions
- Insert grades available for carbon steel, stainless steel, cast iron, & die steel



## ■ MS Mill Availability



| Sumitomo Cat. No. | Status | Dimensions (Inch / mm) |       |       |       |       |       |       |       |       |   | No. of Teeth | Fig. |
|-------------------|--------|------------------------|-------|-------|-------|-------|-------|-------|-------|-------|---|--------------|------|
|                   |        | D                      | D1    | D2    | D3    | F     | d     | a     | b     | E     |   |              |      |
| MS14020SR         | ●      | 2.000                  | 1.500 | 0.609 | 0.406 | 1.750 | 0.750 | 0.319 | 0.190 | 1.020 | 4 | 1            |      |
| MS14025SR         | ●      | 2.500                  | 1.750 | 0.797 | 0.531 | 1.750 | 1.000 | 0.375 | 0.220 | 1.020 | 4 | 1            |      |
| MS14030R          | ●      | 3.000                  | 2.250 | 0.797 | 0.531 | 1.750 | 1.000 | 0.375 | 0.220 | 1.020 | 5 | 1            |      |
| MS14040R          | ●      | 4.000                  | 2.870 | 1.000 | 0.656 | 2.000 | 1.250 | 0.500 | 0.280 | 1.020 | 6 | 1            |      |
| MS14063RS         | ★      | 63.0                   | 59.0  | 18.0  | 11.0  | 40.0  | 22.0  | 10.4  | 6.3   | 26.0  | 4 | 1            |      |
| MS14080R          | ★      | 80.0                   | 60.0  | 20.0  | 13.0  | 50.0  | 25.4  | 9.5   | 6.0   | 31.0  | 5 | 1            |      |
| MS14100R          | ★      | 100.0                  | 70.0  | 46.0  | —     | 50.0  | 31.8  | 12.7  | 8.0   | 32.0  | 6 | 2            |      |
| MS14125R          | ★      | 125.0                  | 80.0  | 56.0  | —     | 63.0  | 38.1  | 15.9  | 10.0  | 38.0  | 7 | 2            |      |

● = USA stocked item  
★ = Worldwide Warehouse item

## ■ Inserts

| Sumitomo Cat. No. | CVD Coated |        | PVD Coated |       | Dimensions (Inch) |       |       |   | Fig. |
|-------------------|------------|--------|------------|-------|-------------------|-------|-------|---|------|
|                   | CS3000     | ACZ310 | ACZ330     | I.C.  | Thickness         | R2    | R5    |   |      |
| SDMW1406ZDTR      | ●          | ●      | ●          | 0.551 | 0.236             | 0.079 | 0.197 | 3 |      |
| SDEW1406ZDTR      | ★          | ★      | ★          | 0.551 | 0.236             | 0.079 | 0.197 | 4 |      |

SDEW = Ground tolerance inserts    ● = USA stocked item    ★ = Worldwide Warehouse item

## ■ Grade Application

| Grade  | Coating                              | Application  |
|--------|--------------------------------------|--|
| CS3000 | Al <sub>2</sub> O <sub>3</sub> (CVD) | High speed milling of carbon steels and stainless steels |
| ACZ310 | ZX - TiNAIN (PVD)                    | General purpose milling of die steels and cast irons     |
| ACZ330 | ZX - TiNAIN (PVD)                    | General purpose milling of steels and stainless steels   |

## ■ Recommended Running Conditions

| Material        | Cutting Speed (SFM) | Feed Rate (IPT) | Depth of Cut (Inch) | Recommended Grade |
|-----------------|---------------------|-----------------|---------------------|-------------------|
| Carbon Steel    | 500 ~ 820           | < 0.078"        | < 0.059"            | ACZ330, CS3000    |
| Die Steel       | 325 ~ 650           | < 0.059"        | < 0.059"            | ACZ330, ACZ310    |
| Stainless Steel | 525 ~ 650           | < 0.039"        | < 0.059"            | ACZ330, CS3000    |
| Cast Iron       | 325 ~ 650           | < 0.059"        | < 0.078"            | ACZ330, ACZ310    |

## ■ Hardware

| Applicable Cutter | Insert Screw | Wrench |
|-------------------|--------------|--------|
| MS 1400 series    | BFTX0513N    | TTX20  |

Torque specifications for BFTX0513N is 45-49 in/lbs.