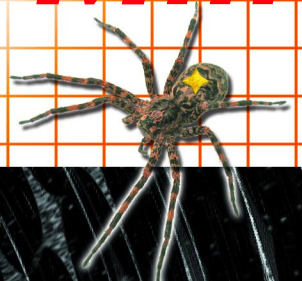
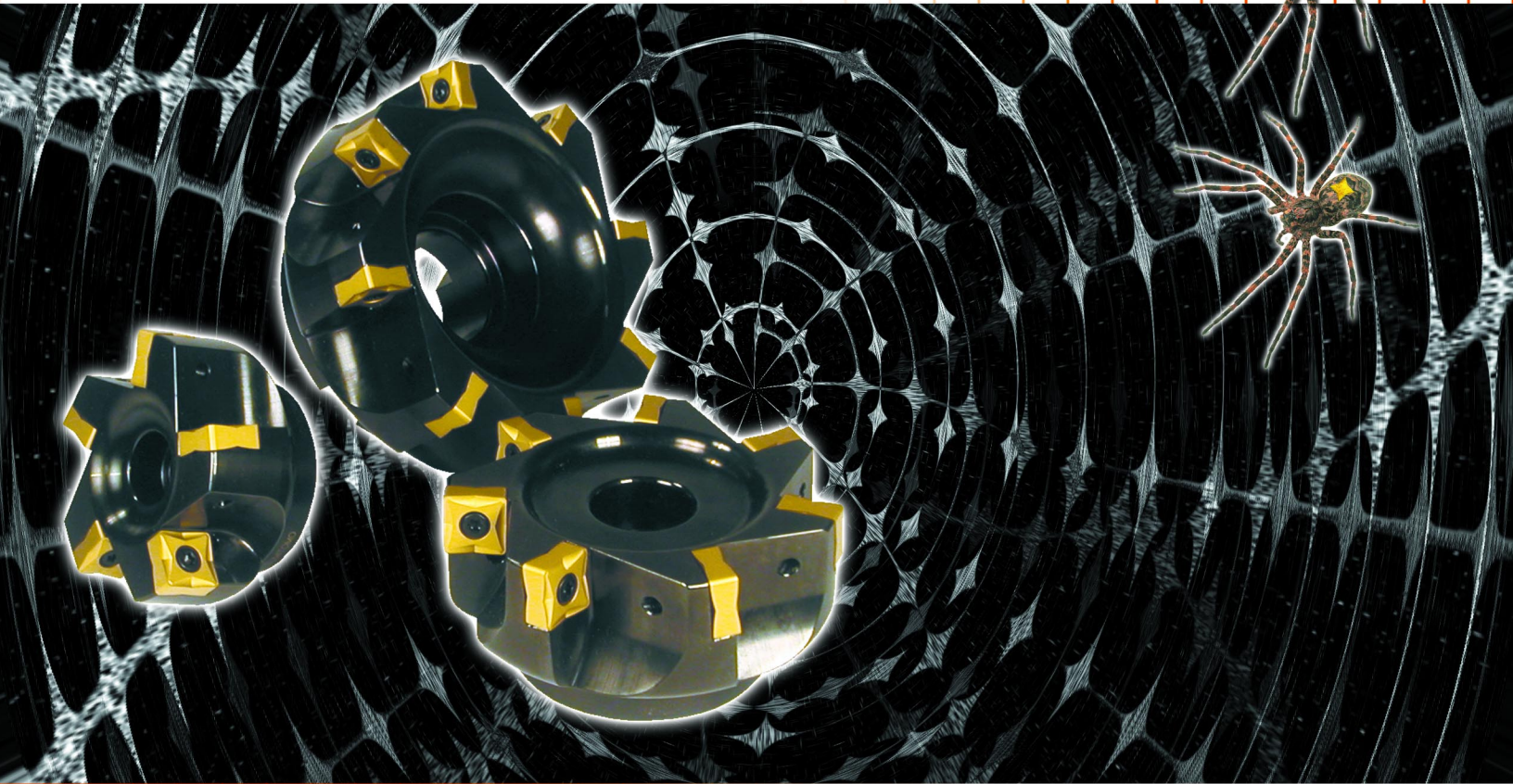




SUMITOMO

CARBIDE - CBN - DIAMOND

# *SumiMill Spider Mill*



*High productivity  
cast iron milling cutter  
with eight cutting edges*



# SumiMill Spider Mill

High productivity cast iron milling cutter with eight cutting edges

## Features & Benefits

- 90° double negative milling cutter with positive cutting insert geometry
- High productivity shell mill for gray cast iron and ductile iron face milling
- Eight (8) cutting edges per insert
- Available in the new grades ACK100 and ACK200
- Unique positive chipbreaker insert provides less cutting force, more productivity and longer tool life



## Spider Mill Availability

Sumitomo Cat. No.	Status	Dimensions (Inch)										
		øD	ød	F	ød1	ød2	ød3	E	a	I.C.	Pitch	Fig.
SDP53000R	●	3.000"	2.250"	1.750"	1.000"	0.531"	0.797"	1.020"	0.385"	0.625"	5	1
SDP54000R	●	4.000"	2.756"	2.000"	1.250"	0.656"	1.030"	1.090"	0.515"	0.625"	7	1
SDP55000R	●	5.000"	3.750"	2.500"	1.500"	NA	2.000"	1.060"	0.635"	0.625"	8	2
SDP56000R	●	6.000"	4.380"	2.500"	1.500"	NA	2.000"	1.060"	0.635"	0.625"	10	2

● = USA stocked item

## Inserts

Sumitomo Cat. No.	CVD Coated		Dimensions (Inch)		
	ACK100	ACK200	I.C.	Thickness	R
SNEX156612DP	●	●	0.625	0.266	0.047

● = USA stocked item

## Grade Application

Grade	Coating	Application
ACK100	CVD Coated	High speed grade for milling of gray and ductile cast irons
ACK200	CVD Coated	General purpose grade for milling of gray and ductile cast irons

## Recommended Running Conditions

Material	Recommended Speed and Feed				Recommended Grade
	Speed (SFM)	Feed Rate (IPT)	Feed Rate (IPT)	Feed Rate (IPT)	
Gray Cast Iron	550	0.006	0.008	0.010	ACK100 ACK200
	725	0.006	0.008	0.010	ACK100 ACK200
Ductile Iron	450	0.005	0.0065	0.009	ACK100 ACK200
	600	0.005	0.0065	0.009	ACK100 ACK200

█ Ideal conditions

## Hardware

Applicable Cutter	Insert Screw	Wrench
SDP5□000R	BFTX0513N	TTX20

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