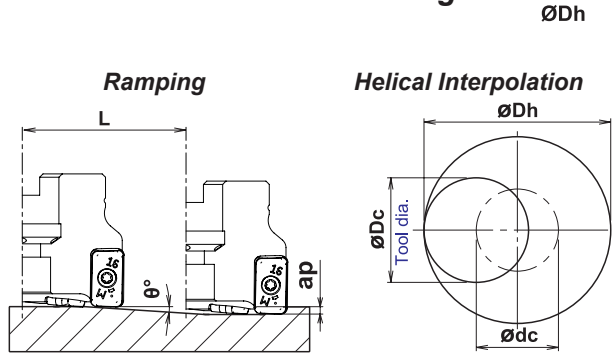



**INCH**
**METRIC**

# Extreme SAP Cutters

## Recommended Data for Profile Milling



- Calculation of tool pass dia.

$$\text{Ødc} = \text{ØDh} - \text{ØDc}$$

Tool pass dia.    Bore dia.    Tool Dia.

- Depth of cut per one circuit should not exceed max. depth of cut ap.
- Down cutting is recommended. Tool pass rotation should be counterclockwise.

- In case of ramping and helical interpolation, apply 80% or less feed (F) from standard cutting condition table.
- In case of helical interpolation, recommend wet cutting by coolant through the tool.

	CATALOG NUMBER	Tool Diameter (Dc)	Effective Cutting Diameter	Max. Depth of Cut: AP	Ramping		Helical Interpolation	
					Max. Ramp Angle	Total Cutting Length at Max. AP: L	Min. Bore Diameter: Dh min	Max. Bore Diameter: Dh max
<b>INCH</b>	MSX-2100-M12	1.00"	.85"	.059"	0.7°	4.83"	1.48"	1.85"
	EXSAP-2100-**	1.00"	.85"	.059"	0.7°	4.83"	1.48"	1.85"
	MSX-*125-M16	1.25"	1.10"	.059"	0.5°	6.77"	1.98"	2.35"
	EXSAP-3125-**	1.25"	1.10"	.059"	0.5°	6.77"	1.98"	2.35"
	MSX-4150-M16	1.50"	1.35"	.059"	0.4°	8.46"	2.48"	2.85"
	EXSAP-4150-**	1.50"	1.35"	.059"	0.4°	8.46"	2.48"	2.85"
	EXSAP-*200R-075	2.00"	1.85"	.059"	0.3°	11.28"	3.48"	3.85"
	EXSAP-5250R-100	2.50"	2.35"	.059"	0.2°	16.92"	4.48"	4.85"
	EXSAP-7300R-100	3.00"	2.85"	.059"	0.18°	18.80"	5.48"	5.85"
	EXSAP-*400R-150	4.00"	3.85"	.059"	0.12°	28.20"	7.48"	7.85"
EXSAP-*600R-150	6.00"	5.85"	.059"	0.08°	42.30"	11.48"	11.85"	
<b>METRIC</b>	MSX-2025-M12	25	21.5	1.5	0.7°	123	37	46
	MSX-*032-M16	32	28.5	1.5	0.5°	172	48	60
	MSX-4040-M16	40	36.5	1.5	0.4°	215	64	76
	EXSAP-*050R-22	50	46.5	1.5	0.3°	286	84	96
	EXSAP-5063R-22	63	59.5	1.5	0.2°	430	110	122
	EXSAP-7080R-27	80	76.5	1.5	0.15°	573	144	156