

Rake Angle	Radial	-6° 45'
	Axial	-5° 45'

3mm 75°

P	M	K	N	N	S	H
Steel	Cast Iron	Cast Iron	Aluminum	Aluminum	Cast Alloy	Cast Alloy
X	X	X	X	X	X	X

SUMIBORON High-Speed Mill for Cast Iron RM Type

High Speed and High Efficiency Milling for Cast Iron



- **High speed, high efficiency milling of Grey Cast Iron**
 - Utilising solid SumiBoron BNS800 for high speed milling of $v_c = 1,500\text{m/min}$.
 - High speed roughing of up to $a_p = 3.0\text{mm}$.
 - Wiper insert for high speed finishing.
- **Low cost**
 - Cost effective 8 cornered inserts.
 - Insert regrinding possible.
- **Simple construction for insert run-out**
 - Simple design for direct insert mounting.
 - Insert run-out can be easily adjusted.

■ Cutter Bodies Inch

Fig 1

Fig 2

Dimensions (mm)

Cat. No.	Stock	Diameter	Diameter	Boss	Bolt	Height	Diameter	Groove width	Groove depth	Attaching depth	No. of teeth	Maximum Spindle Speed (min ⁻¹)	Weight (kg)	Fig
		DC	BD	DCSFMS	D1	LF	DCB	KWW	KDP	CBDP				
RM 3080R		80	90	60	—	50	25.40	9.5	6	25	6	9,000	1.6	1
3100R		100	110	70	46	50	31.75	12.7	8	32	8	8,000	2.1	2
3125R		125	135	80	59	63	38.10	15.9	10	38	10	7,000	3.9	2
3160R		160	170	100	80	63	50.80	19.1	11	38	12	6,000	5.9	2

Inserts are not included.

■ Inserts

Fig 3

Fig 4

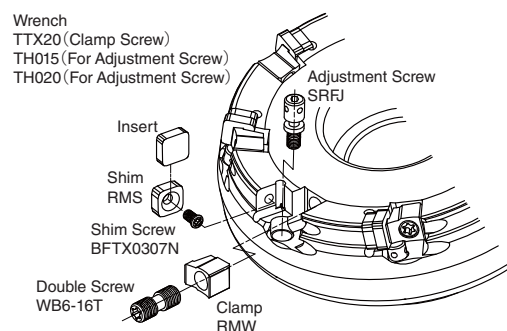
Wiper Inserts

Cat. No.	Stock	SUMIBORON	Fig
SNGN 090308	●	BNS800	3
090312	●	BNS800	3
SNEN 090308W	●	BNS800	4

⚠ CAUTION

- Do not use a mix of standard and wiper inserts on a single cutter setting.
- Do not mix new and reground inserts on a single cutter setting.
- Inserts can only be reground once (inscribed circle dimension must be at least 9.125mm)

For hardened steel machining use the SEC ACE Mill DNF Type.
Cutter Body... H54 Insert... L96



■ Parts

Clamp	Double Screw	Shim	Shim Screw
RMW	WB6-16T	RMS	BFTX0307N ≤ 2.0
Adjustment Screw	Wrench (Clamp Screw)	Wrench (For Adjustment Screw)	Wrench (For Adjustment Screw)
SRF J	TTX20	TH015	TH020

$\text{N}\cdot\text{m}$ Recommended Tightening Torque (N·m)

■ Recommended Cutting Conditions

ISO	Work	Hardness	Cutting Speed v_c (m/min) Min. - Optimum - Max.	Feed Rate f_z (mm/t) Min. - Optimum - Max.	Grade
K	Gray Cast Iron	250HB	800-1150-1500	0.05-0.13-0.20	BNS800 (Dry)

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.

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