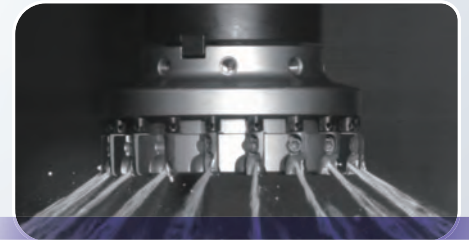


High-Efficiency Milling Cutter for Aluminum Alloy

ALNEX ANX Series

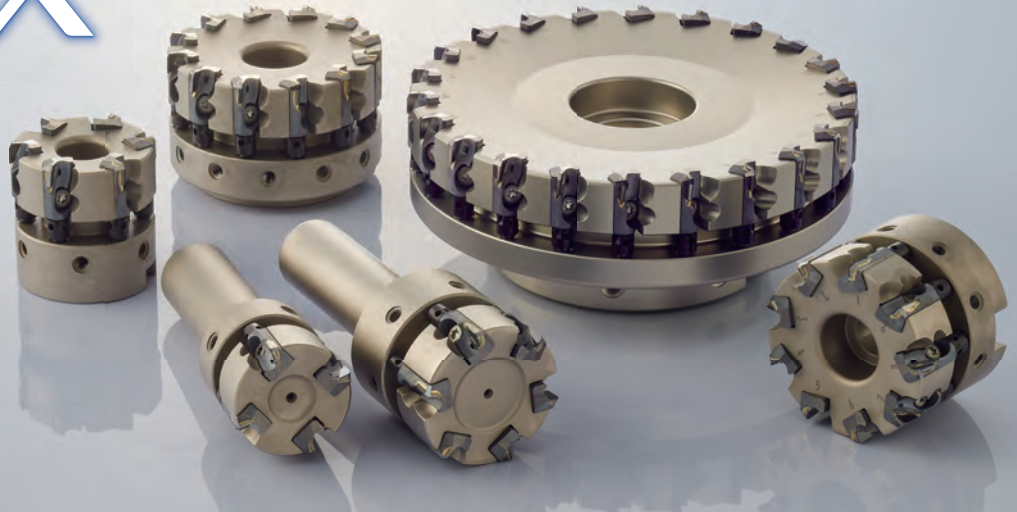
Ultra-High Efficiency Machining Excellent Chip Control



Blade Through Coolant



ALNEX



Features

Drastically Reduced Runout Adjustment Time

Simple screw-fastening structure enables fine adjustments to be made easily

Blade Through Coolant

Secures a supply of coolant to the cutting edge and breaks chips thoroughly

Lightweight Aluminum Alloy Body

Utilising aluminum alloy to achieve a total weight of less than 1.3kg for a $\phi 125$ mm cutter with 22 teeth.

Series

Number in ● is the number of teeth Inch Inch Bore

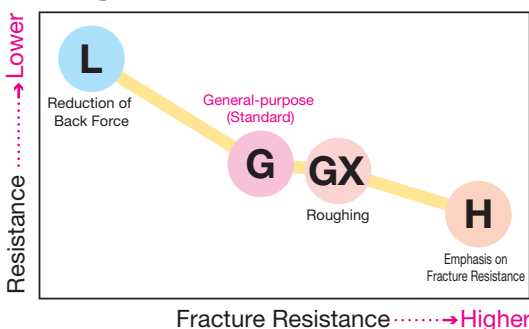
| Type | Cat. No. | Body Material | Diameter Range (mm) | | | | | | | |
|------------|--|----------------|---------------------|-----------|-----------|-----------|-----------|------------|------------|------------|
| | | | $\phi 32$ | $\phi 40$ | $\phi 50$ | $\phi 63$ | $\phi 80$ | $\phi 100$ | $\phi 125$ | $\phi 160$ |
| Shell type | ANXA 16000RS | Aluminum Alloy | | | | | ●10 ●14 | ●12 ●18 | ●14 ●22 | ●20 ●28 |
| | ANXA 16000R Inch | Aluminum Alloy | | | | | ●10 ●14 | ●12 ●18 | ●14 ●22 | ●20 ●28 |
| | ANXS 16000RS | Steel | | ●6 | ●6 ●9 | ●8 ●12 | ●10 ●14 | ●12 ●18 | ●14 ●22 | |
| | ANXS 16000R Inch | Steel | | | | ●8 ●12 | ●10 ●14 | ●12 ●18 | ●14 ●22 | |
| Shank type | ANXS 16000E | Steel | ●4 | ●6 | | | | | | |

Blade Selection Guide

| Work Materials | N | | | | | |
|--------------------|-------------------------|-----------------|-----------|---------------|-----------------------|-------|
| Type | L | G | GX | H | — | W |
| Cutting Edge Shape | | | | | | |
| Features | Low Resistance | Standard | Long Edge | High Strength | | |
| Applications | Finishing/Light Cutting | General-purpose | Roughing | | Corner Radius Milling | Wiper |
| Edge Length η | 6.0mm | 6.0mm | 9.0mm | 6.0mm | | |

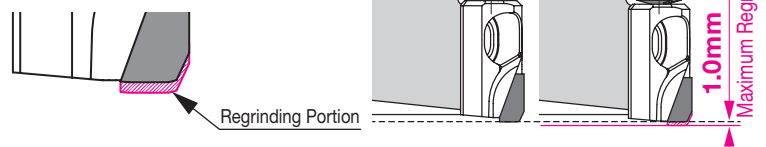
*Edge Length
GX Type only 9.0mm

Edge Selection Guide



- Reduces running costs by drastically increasing insert regrinding allowance (to 1.0mm)

Assuming 0.2mm of regrinding each time, an edge can be used up to 6 times.
(*Peripheral edge cannot be reground.)



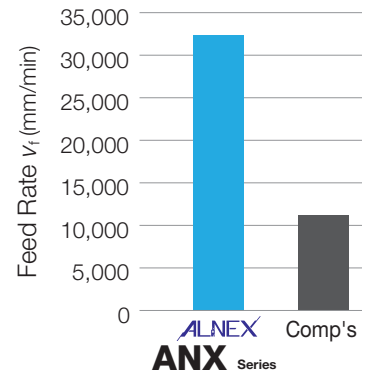
High-speed/High-efficiency Cutting

Realizes ultra-high efficiency machining with $v_f = 30,000\text{mm/min}$



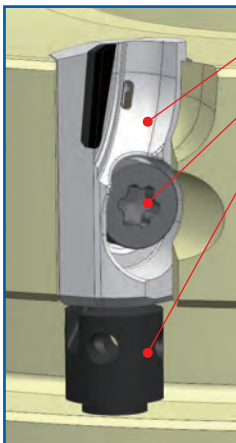
Cutter diameter $\phi 100\text{mm}$ comparison

| | Spindle Speed min^{-1} | Number of Teeth | Feed Rate $v_f(\text{mm/min})$ |
|------------------|---------------------------------|-----------------|--------------------------------|
| ALNEX ANX Series | 18,000 | 18 | 32,400 |
| Comp's | 9,500 | 12 | 11,400 |

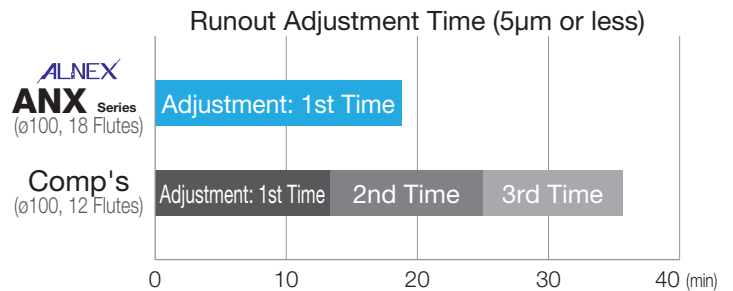


Drastically Reduced Runout Adjustment Time

- Simple screw-fastening structure
- Enables fine adjustments to be made easily
- High-rigidity body



Blade
Clamp Screw
Adjustment Screw



1st Time Completed, Adjustment Time Reduced

Chip Control



Blade-Through Coolant Chip Breaking



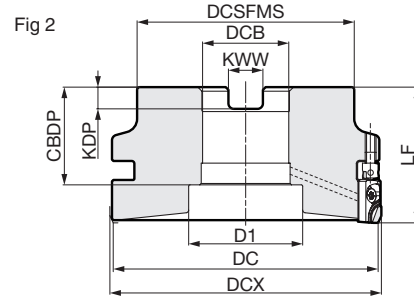
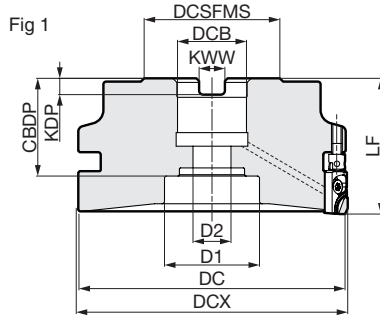
ALNEX ANX Series



Competitor's

Work material: ADC12
Cutting conditions: $v_c = 2,500\text{m/min}$, $f_z = 0.05\text{mm/t}$, $a_p = 0.5\text{mm Wet}$

| | | |
|------------|--------|-----|
| Rake Angle | Radial | +5° |
| | Axial | +5° |



Body (Steel)

| | | | | | | | | | | | | | | Dimensions (mm) | |
|-----------------------|-------|---------|---------------|------------------|-------------------|---------------|------------------|------------------|----------------------|---------|---------|-----------------|-------------|-----------------|--|
| Cat. No. | Stock | Dia. DC | Max. Dia. DCX | Boss Dia. DCSFMS | Overall Length LF | Bore Dia. DCB | Keyway Width KWW | Keyway Depth KDP | Mounting Depth CBDBP | Bolt D1 | Bolt D2 | Number of Teeth | Weight (kg) | Fig | |
| ANXS 16040RS06 | ● | 38 | 40 | 38.5 | 40 | 16 | 8.4 | 5.6 | 26 | 14 | 9 | 6 | 0.3 | 1 | |
| 16050RS06 | ● | 48 | 50 | 48.5 | 40 | 22 | 10.4 | 6.3 | 26 | 18 | 11 | 6 | 0.4 | 1 | |
| 16050RS09 | ● | 48 | 50 | 48.5 | 40 | 22 | 10.4 | 6.3 | 26 | 18 | 11 | 9 | 0.5 | 1 | |
| 16063RS08 | ● | 61 | 63 | 50 | 40 | 22 | 10.4 | 6.3 | 26 | 18 | 11 | 8 | 0.7 | 1 | |
| 16063RS12 | ● | 61 | 63 | 50 | 40 | 22 | 10.4 | 6.3 | 26 | 18 | 11 | 12 | 0.7 | 1 | |
| 16080RS10 | ● | 78 | 80 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 10 | 1.2 | 1 | |
| 16080RS14 | ● | 78 | 80 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 14 | 1.2 | 1 | |
| 16100RS12 | ● | 98 | 100 | 80 | 50 | 32 | 14.4 | 8 | 32 | 46 | — | 12 | 2.0 | 2 | |
| 16100RS18 | ● | 98 | 100 | 80 | 50 | 32 | 14.4 | 8 | 32 | 46 | — | 18 | 2.0 | 2 | |
| 16125RS14 | ● | 123 | 125 | 80 | 63 | 40 | 16.4 | 9 | 35 | 52 | — | 14 | 3.9 | 2 | |
| 16125RS22 | ● | 123 | 125 | 80 | 63 | 40 | 16.4 | 9 | 35 | 52 | — | 22 | 3.9 | 2 | |
| ANXS 16063R08 | ● | 61 | 63 | 50 | 50 | 25.4 | 9.5 | 6 | 31 | 20 | 14 | 8 | 0.9 | 1 | |
| 16063R12 | ● | 61 | 63 | 50 | 50 | 25.4 | 9.5 | 6 | 31 | 20 | 14 | 12 | 0.9 | 1 | |
| 16080R10 | ● | 78 | 80 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 10 | 1.2 | 1 | |
| 16080R14 | ● | 78 | 80 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 14 | 1.2 | 1 | |
| 16100R12 | ● | 98 | 100 | 80 | 50 | 31.75 | 12.7 | 8 | 36 | 42 | — | 12 | 2.0 | 2 | |
| 16100R18 | ● | 98 | 100 | 80 | 50 | 31.75 | 12.7 | 8 | 36 | 42 | — | 18 | 2.0 | 2 | |
| 16125R14 | ● | 123 | 125 | 80 | 63 | 38.1 | 15.9 | 10 | 42.5 | 52 | — | 14 | 3.9 | 2 | |
| 16125R22 | ● | 123 | 125 | 80 | 63 | 38.1 | 15.9 | 10 | 42.5 | 52 | — | 22 | 3.9 | 2 | |

Blades are sold separately.

If using a blade for corner radius machining (ANB1604R), DC = DCX.

Identification Code

ANX S 16 100 R S 18

Cutter Series Steel Body Blade Size Cutter Dia. Feed Direction Metric Bore Number of Teeth

Maximum Allowable Spindle Speed

| Cat. No. | n max(min ⁻¹) |
|----------------|---------------------------|
| ANXS 16040RS06 | 25,000 |
| ANXS 16050RS06 | 25,000 |
| ANXS 16050RS09 | 25,000 |
| ANXS 16063RS08 | 22,000 |
| ANXS 16063RS12 | 22,000 |
| ANXS 16080RS10 | 20,000 |
| ANXS 16080RS14 | 20,000 |
| ANXS 16100RS12 | 18,000 |
| ANXS 16100RS18 | 18,000 |
| ANXS 16125RS14 | 16,000 |
| ANXS 16125RS22 | 16,000 |
| ANXS 16063R08 | 22,000 |
| ANXS 16063R12 | 22,000 |
| ANXS 16080R10 | 20,000 |
| ANXS 16080R14 | 20,000 |
| ANXS 16100R12 | 18,000 |
| ANXS 16100R18 | 18,000 |
| ANXS 16125R14 | 16,000 |
| ANXS 16125R22 | 16,000 |

Parts

| Applicable Cutter | Clamp Screw | Adjustment Screw | Wrench | Adjustment Wrench | Centre Bolt | Assembly Wrench |
|-------------------|--|--------------------------|---------|-------------------|-------------|---|
| | ANXS 16040RS06 ANXS 16050RS00 ANXS 16063RS00 ANXS 16080RS00 ANXS 16100RS00 ANXS 16125RS00 ANXS 16063R00 ANXS 16080R00 ANXS 16100R00 ANXS 16125R00 | BXA0310IP 2.0 | HFJ | TRXW10IP | ANT | BXH0825-D13 BXH1030-D16 BXH1235-D33 BXH1635-D40 BXH2036-D50 BXH1235-D18 BXH1235-D33 BXH1635-D40 BXH2036-D50 |

(Sold Separately)

Recommended Tightening Torque (N·m)

● mark: Standard stocked item

Blade

Dimensions (mm)

| Grade | | SUMIDIA | | | | |
|---------------------|------------------|----------|---------------------|------------------|-----------------|-----|
| Process | High-speed/Light | N | | | | |
| | General-purpose | N | | | | |
| | Roughing | N | | | | |
| Cat. No. | | DA1000 | Cutting Edge Length | Wiper Edge Shape | Applications | Fig |
| ANB 1600R-L | | ● | 6.0 | Linear | Low Resistance | 1 |
| ANB 1600R-G | | ● | 6.0 | Arc-Shaped | General-purpose | 1 |
| ANB 1600R-H | | ● | 6.0 | Arc-Shaped | Strong Edge | 1 |
| ANB 1600R-GX | | ● | 9.0 | Arc-Shaped | Long Edge | 2 |
| ANB 1604R | | ● | 6.0 | Linear | Corner Radius | 3 |
| ANB 1600R-W | | ● | — | Arc-Shaped | Wiper | 4 |

Fig 1

Fig 2

Fig 3

Fig 4

Wiper Blade

Recommended Cutting Conditions

Si content of 12.6% or less

| ISO | Work Material | Hardness | Cutting Speed v_c (m/min) Min. - Optimum - Max. | Feed Rate f_z (mm/t) Min. - Optimum - Max. | Blade Grade |
|----------|----------------|----------|---|--|-------------|
| N | Aluminum Alloy | — | 2,000 - 2,500 - 3,000 | 0.05 - 0.13 - 0.20 | DA1000 |

Si content of over 12.6%

| ISO | Work Material | Hardness | Cutting Speed v_c (m/min) Min. - Optimum - Max. | Feed Rate f_z (mm/t) Min. - Optimum - Max. | Blade Grade |
|----------|----------------|----------|---|--|-------------|
| N | Aluminum Alloy | — | 400 - 600 - 800 | 0.05 - 0.13 - 0.20 | DA1000 |

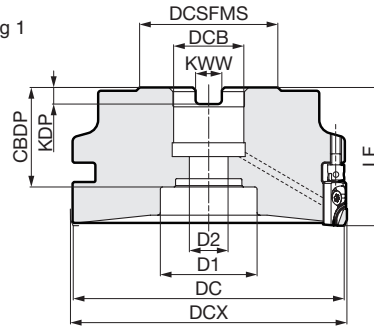
Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, depth of cut and other factors.

| | | |
|------------|--------|-----|
| Rake Angle | Radial | +5° |
| | Axial | +5° |

| | |
|-----|-----|
| 3mm | 90° |
|-----|-----|



Fig 1



Body (Aluminum Alloy)

Dimensions (mm)

| Cat. No. | Stock | Dia. DC | Max. Dia. DCX | Boss Dia. DCSFMS | Overall Length LF | Bore Dia. DCB | Keyway Width KWW | Keyway Depth KDP | Mounting Depth CBDP | Bolt D1 | Bolt D2 | Number of Teeth | Weight (kg) |
|-----------------------|-------|---------|---------------|------------------|-------------------|---------------|------------------|------------------|---------------------|---------|---------|-----------------|-------------|
| ANXA 16080RS10 | ● | 78 | 80 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 10 | 0.5 |
| ANXA 16080RS14 | ● | 78 | 80 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 14 | 0.5 |
| ANXA 16100RS12 | ● | 98 | 100 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 12 | 0.8 |
| ANXA 16100RS18 | ● | 98 | 100 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 18 | 0.9 |
| ANXA 16125RS14 | ● | 123 | 125 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 14 | 1.2 |
| ANXA 16125RS22 | ● | 123 | 125 | 50 | 50 | 27 | 12.4 | 7 | 34 | 35 | 14 | 22 | 1.3 |
| ANXA 16160RS20 | ● | 158 | 160 | 80 | 63 | 40 | 16.4 | 9 | 35 | 52 | 29 | 20 | 2.6 |
| ANXA 16160RS28 | ● | 158 | 160 | 80 | 63 | 40 | 16.4 | 9 | 35 | 52 | 29 | 28 | 2.6 |
| ANXA 16080R10 | ● | 78 | 80 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 10 | 0.5 |
| ANXA 16080R14 | ● | 78 | 80 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 14 | 0.5 |
| ANXA 16100R12 | ● | 98 | 100 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 12 | 0.9 |
| ANXA 16100R18 | ● | 98 | 100 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 18 | 0.9 |
| ANXA 16125R14 | ● | 123 | 125 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 14 | 1.2 |
| ANXA 16125R22 | ● | 123 | 125 | 50 | 50 | 25.4 | 9.5 | 6 | 34 | 35 | 14 | 22 | 1.3 |
| ANXA 16160R20 | ● | 158 | 160 | 80 | 63 | 38.1 | 15.9 | 10 | 42.5 | 55 | 30 | 20 | 2.4 |
| ANXA 16160R28 | ● | 158 | 160 | 80 | 63 | 38.1 | 15.9 | 10 | 42.5 | 55 | 30 | 28 | 2.6 |

Blades are sold separately.

If using a blade for corner radius machining (ANB1604R), DC = DCX.

Identification Code

ANX A 16 100 R S 18

Cutter Series Aluminum Alloy Body Blade Size Cutter Dia. Feed Direction Metric Bore Number of Teeth

Parts

(Sold Separately)

| Applicable Cutter | Clamp Screw | Adjustment Screw | Wrench | Adjustment Wrench | Centre Bolt | Assembly Wrench |
|-------------------|---------------|------------------|----------|-------------------|-------------|-----------------|
| ANXA 16080RS○○ | BXA0310IP 2.0 | HFJ | TRXW10IP | ANT | BXH1235-D33 | HFVT |
| ANXA 16100RS○○ | | | | | BXH2036-D50 | |
| ANXA 16125RS○○ | | | | | BXH1235-D33 | |
| ANXA 16160RS○○ | | | | | BXH2036-D50 | |
| ANXA 16080R○○ | | | | | | |
| ANXA 16100R○○ | | | | | | |
| ANXA 16125R○○ | | | | | | |
| ANXA 16160R○○ | | | | | | |

Recommended Tightening Torque (N·m)

Maximum Allowable Spindle Speed

| Cat. No. | $n \max(\text{min}^{-1})$ |
|----------------|---------------------------|
| ANXA 16080RS10 | 20,000 |
| ANXA 16080RS14 | 20,000 |
| ANXA 16100RS12 | 18,000 |
| ANXA 16100RS18 | 18,000 |
| ANXA 16125RS14 | 16,000 |
| ANXA 16125RS22 | 16,000 |
| ANXA 16160RS20 | 14,000 |
| ANXA 16160RS28 | 14,000 |
| ANXA 16080R10 | 20,000 |
| ANXA 16080R14 | 20,000 |
| ANXA 16100R12 | 18,000 |
| ANXA 16100R18 | 18,000 |
| ANXA 16125R14 | 16,000 |
| ANXA 16125R22 | 16,000 |
| ANXA 16160R20 | 14,000 |
| ANXA 16160R28 | 14,000 |

Blade

Dimensions (mm)

| Grade | | SUMIDIA | | | | |
|---------------------|------------------|----------|---------------------|------------------|-----------------|-----|
| Process | High-speed/Light | N | | | | |
| | General-purpose | N | | | | |
| | Roughing | N | | | | |
| Cat. No. | | DA1000 | Cutting Edge Length | Wiper Edge Shape | Applications | Fig |
| ANB 1600R-L | | ● | 6.0 | Linear | Low Resistance | 1 |
| ANB 1600R-G | | ● | 6.0 | Arc-Shaped | General-purpose | 1 |
| ANB 1600R-H | | ● | 6.0 | Arc-Shaped | Strong Edge | 1 |
| ANB 1600R-GX | | ● | 9.0 | Arc-Shaped | Long Edge | 2 |
| ANB 1604R | | ● | 6.0 | Linear | Corner Radius | 3 |
| ANB 1600R-W | | ● | — | Arc-Shaped | Wiper | 4 |

Fig 1

Fig 2

Fig 3

Fig 4

Wiper Blade

Recommended Cutting Conditions

Si content of 12.6% or less

| ISO | Work Material | Hardness | Cutting Speed v_c (m/min) Min. - Optimum - Max. | Feed Rate f_z (mm/t) Min. - Optimum - Max. | Blade Grade |
|----------|----------------|----------|---|--|-------------|
| N | Aluminum Alloy | — | 2,000 - 2,500 - 3,000 | 0.05 - 0.13 - 0.20 | DA1000 |

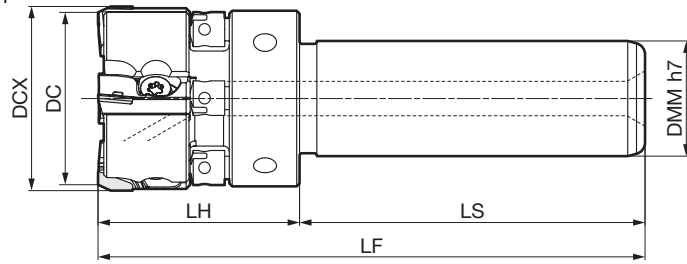
Si content of over 12.6%

| ISO | Work Material | Hardness | Cutting Speed v_c (m/min) Min. - Optimum - Max. | Feed Rate f_z (mm/t) Min. - Optimum - Max. | Blade Grade |
|----------|----------------|----------|---|--|-------------|
| N | Aluminum Alloy | — | 400 - 600 - 800 | 0.05 - 0.13 - 0.20 | DA1000 |

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



Fig 1



Body (Steel)

Dimensions (mm)

| Cat. No. | Stock | Dia. DC | Max. Dia. DCX | Shank Dia. DMM | Head LH | Shank Length LS | Overall Length LF | Number of Teeth | Weight (kg) |
|----------------------|-------|---------|---------------|----------------|---------|-----------------|-------------------|-----------------|-------------|
| ANXS 16032E04 | ● | 30 | 32 | 20 | 35 | 60 | 95 | 4 | 0.3 |
| 16040E06 | ● | 38 | 40 | 20 | 40 | 60 | 100 | 6 | 0.5 |

Blades are sold separately.

If using a blade for corner radius machining (ANB1604R), DC = DCX.

Identification Code

ANX S 16 032 E 04

| | | | | | |
|---------------|------------|------------|-------------|------------|-----------------|
| Cutter Series | Steel Body | Blade Size | Cutter Dia. | With Shank | Number of Teeth |
|---------------|------------|------------|-------------|------------|-----------------|

Maximum Allowable Spindle Speed

| Cat. No. | $n \max(\text{min}^{-1})$ |
|---------------|---------------------------|
| ANXS 16032E04 | 10,000 |
| ANXS 16040E06 | 10,000 |

Parts

(Sold Separately)

| Applicable Cutter | Clamp Screw | Adjustment Screw | Wrench | Adjustment Wrench | Assembly Wrench |
|-------------------|----------------------|------------------|----------|-------------------|-----------------|
| ANXS 16032E04 | | | | | |
| ANXS 16040E06 | BXA0310IP 2.0 | HFJ | TRXW10IP | ANT | HFVT |

Recommended Tightening Torque (N·m)

Blade

Dimensions (mm)

| Grade | | SUMIDIA | | | | |
|---------------------|------------------|----------|---------------------|------------------|-----------------|-----|
| Process | High-speed/Light | N | | | | |
| | General-purpose | N | | | | |
| | Roughing | N | | | | |
| Cat. No. | | DA1000 | Cutting Edge Length | Wiper Edge Shape | Applications | Fig |
| ANB 1600R-L | | ● | 6.0 | Linear | Low Resistance | 1 |
| ANB 1600R-G | | ● | 6.0 | Arc-Shaped | General-purpose | 1 |
| ANB 1600R-H | | ● | 6.0 | Arc-Shaped | Strong Edge | 1 |
| ANB 1600R-GX | | ● | 9.0 | Arc-Shaped | Long Edge | 2 |
| ANB 1604R | | ● | 6.0 | Linear | Corner Radius | 3 |
| ANB 1600R-W | | ● | — | Arc-Shaped | Wiper | 4 |

Fig 1

Fig 2

Fig 3

Fig 4

Wiper Blade

Recommended Cutting Conditions

Si content of 12.6% or less

| ISO | Work Material | Hardness | Cutting Speed v_c (m/min) Min. - Optimum - Max. | Feed Rate f_z (mm/t) Min. - Optimum - Max. | Blade Grade |
|----------|----------------|----------|---|--|-------------|
| N | Aluminum Alloy | — | 2,000 - 2,500 - 3,000 | 0.05 - 0.13 - 0.20 | DA1000 |

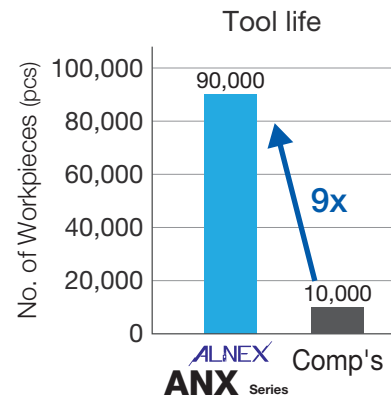
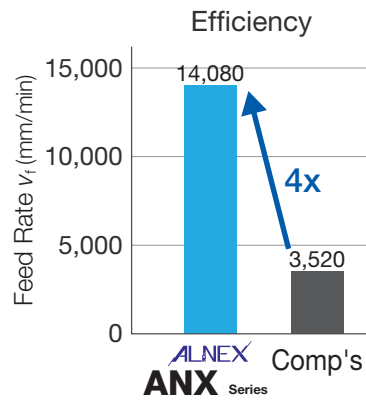
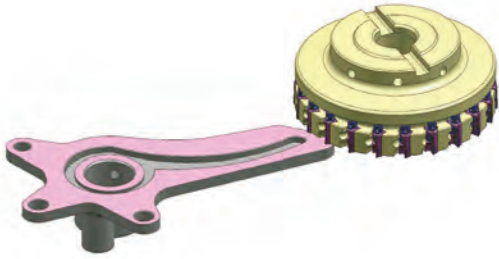
Si content of over 12.6%

| ISO | Work Material | Hardness | Cutting Speed v_c (m/min) Min. - Optimum - Max. | Feed Rate f_z (mm/t) Min. - Optimum - Max. | Blade Grade |
|----------|----------------|----------|---|--|-------------|
| N | Aluminum Alloy | — | 400 - 600 - 800 | 0.05 - 0.13 - 0.20 | DA1000 |

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

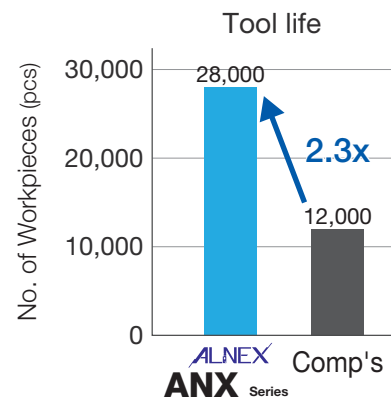
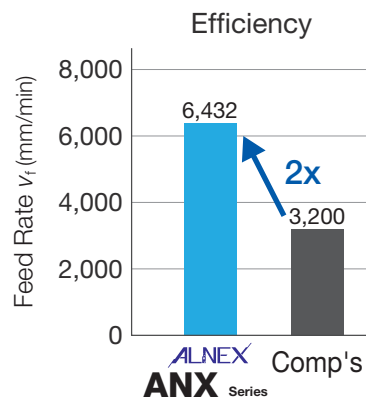
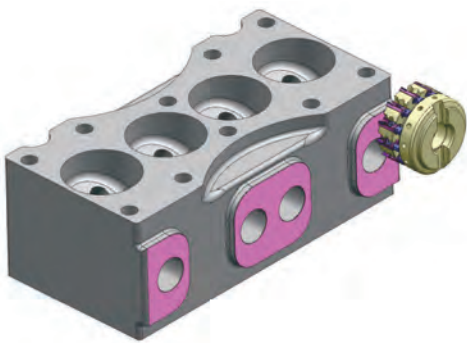
Application Examples

Achieves 4 times the efficiency and 9 times the tool life



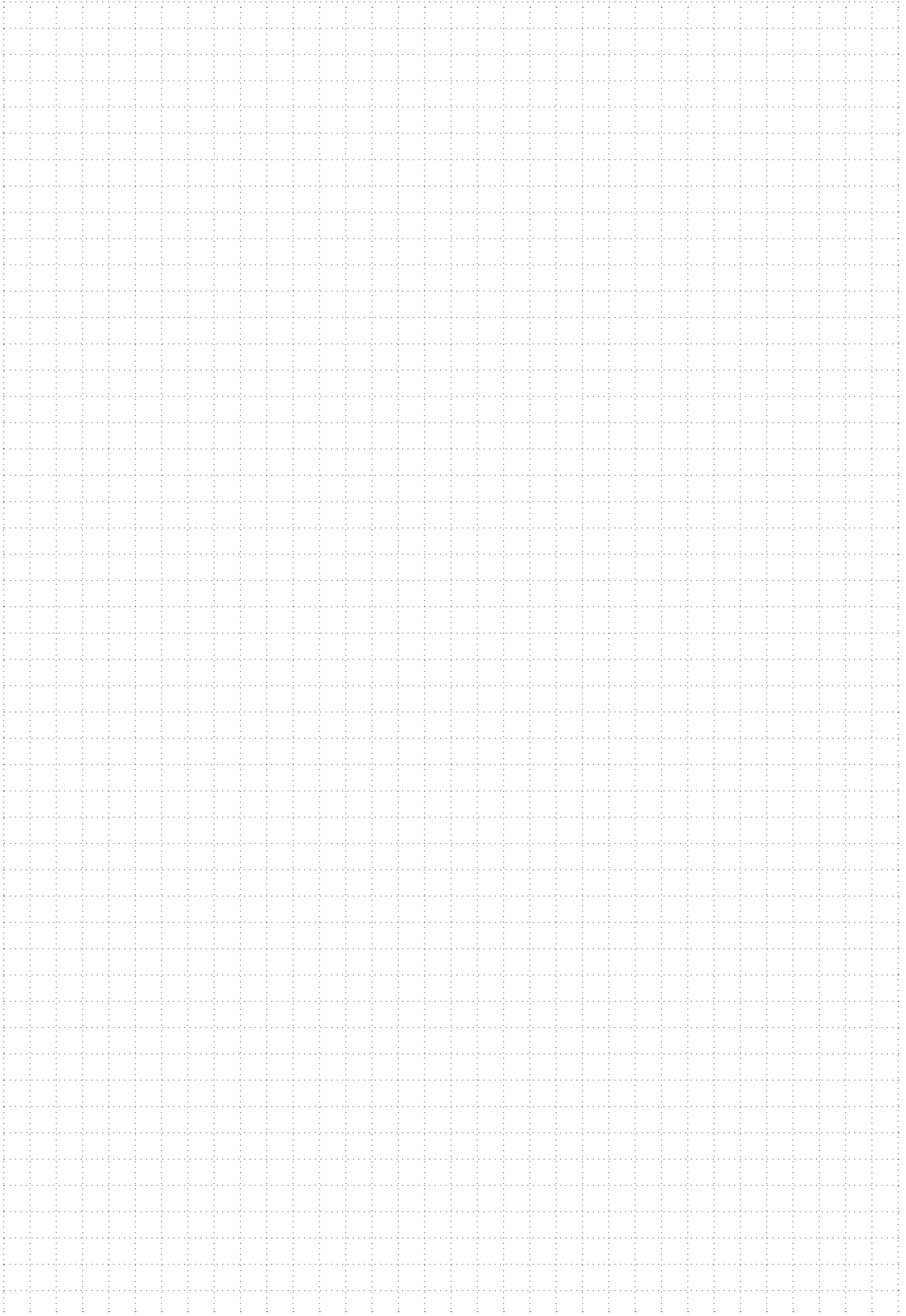
Machine: Vertical Machining Centre BT30 Work material: ADC12 Automotive Component Tool: ANXA 16125R22 ($\phi 125$, 22-flute, aluminum alloy body *Total weight with arbor 1.75kg)
 Blade: ANB 1600R-G (DA1000) Cutting conditions: $v_c = 3,142\text{m/min}$, $v_f = 14,080\text{mm/min}$, $a_p = 0.8\text{mm}$ Wet

Achieves 2 times the efficiency and 2.3 times the tool life



Machine: Vertical Machining Centre HSK63 Work material: ADC12 Cylinder Head Tool: ANXS 16063RS12 ($\phi 63$, 12-flute, steel body)
 Blade: ANB 1600R-G (DA1000) Cutting conditions: $v_c = 1,583\text{m/min}$, $v_f = 6,432\text{mm/min}$, $a_p = 0.5\text{mm}$ Wet

MEMO





- Very hot or lengthy chips may be discharged while the machine is in operation. Therefore, machine guards, safety goggles or other protective covers must be used. Fire safety precautions must also be considered.

< SAFETY NOTES >

- Please handle with care as this product has sharp edges.
- Improper cutting conditions or mis-handling of the tool may result in breakages or projectiles. Therefore, please use the tool within its recommended conditions.

- When using non-water soluble cutting oil, precautions against fire must be taken and please ensure that a fire extinguisher is placed near the machine.

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