SUMITOMO
CARBIDE - CBN - DIAMOND
Global Support, Global Solutions.

New Product Report No.077

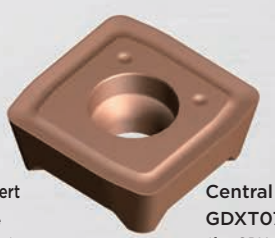
General-purpose High-precision Multi-function Shoulder Milling Cutter

SEC-WAVEMILL WEZM series

WEZ series now offers a multi-function type capable of drilling

Combining WEZ series and GDX series inserts to achieve multi-functionality

Peripheral Insert
AO□T11 size
(for WEZ11 type)



Central Insert
GDXT07 size
(for GDX series)

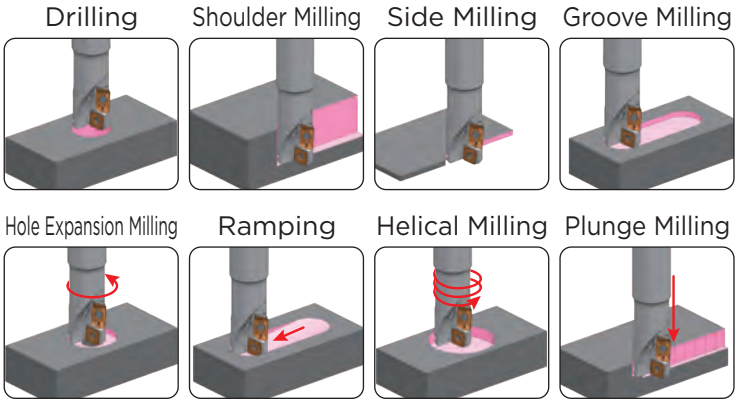
P M K N S H

SUMITOMO ELECTRIC GROUP

WEZM series

■ Features

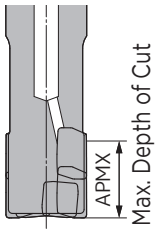
- ● Multi-function type added to WEZ series
- ● Insert for WEZ series used as peripheral insert
  Achieves excellent cutting edge sharpness and wall accuracy
- ● Insert for GDX series used as central insert
  Enables 1D drilling



■ Product Range (Multi-function)

Type	Cat. No.	Dia. (mm)			
		ø20	ø21	ø25	ø26
Shank type	**WEZM 11000E**	19	19	27	27
	WEZM 11000EL	19	19	27	27
Modular type	**WEZM 11000M**	19	19	27	27

(Max. Depth of Cut: mm)



■ Product Range (Insert)

●: Standard stocked item

Size	Process	Series	Tolerance	Cat. No.	Corner Radius (mm)								
					R0.2	R0.4	R0.5	R0.8	R1.0	R1.2	R1.6	R2.0	R2.4
11 type	Peripheral Insert	WEZ series	M Class	**AOMT11T3○○PEER-G**	●	●	●	●	●	●	●	●	●
				AOMT11T3○○PEER-H		●		●		●	●		
			E Class	**AOET11T3○○PEER-F**	●	●	●	●	●	●	●	●	●
				AOET11T3○○PEER-P20	●	●	●	●	●	●			
				AOET11T3○○PEER-P25	●	●	●	●	●	●			
				AOET11T3○○PEFR-S	●	●	●	●	●	●	●	●	●
	Central Insert	GDX series	M Class	**GDXT070308C-L**				●					
				GDXT070308C-G				●					

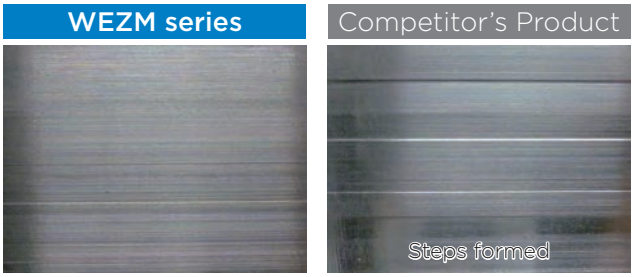
*R3.0 and R3.2 cannot be used
*P type chipbreaker Cat. No. is specific to the cutter diameter. Check “P type Chipbreaker Selection Guide” below.

■ P type Chipbreaker Selection Guide

Cat. No.	Dia. (mm)			
	ø20	ø21	ø25	ø26
AOM11T3○○PEER-P●●	-P20		-P25	

■ Insert for GDX Series Used for Central Insert

■ Wall Surface Comparison

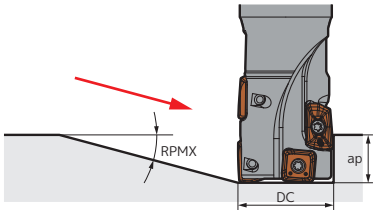


Machine: Vertical Machining Center BT50 Work Material: S50C
Overhang Amount: 80mm
Tool: WEZM 11025E2725-07 (ø25)
Peripheral Insert: AOMT11T308PEER-G (ACU2500)
Central Insert: GDXT070308C-G
Cutting Conditions: vc = 150 m/min fz = 0.15 mm/rev ap = 27 mm ae = 5 mm Dry

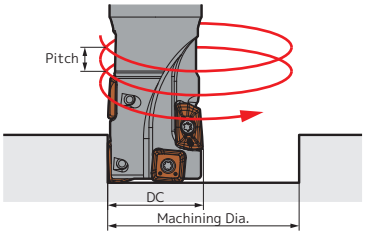
*Note that the flat head screw sizes for the peripheral and central inserts are different.

■ Ramping/Helical Milling Upper Limit

Ramping



Helical Milling



Dia. DC (mm)	Max. Ramping Angle RMPX (°)	Helical Milling	
		Max. Machining Dia. (mm)	Min. Machining Dia. (mm)
20	90	37.3	20.0
21	90	39.3	21.0
25	90	47.3	25.0
26	90	49.3	26.0

WEZM 11000E(L) type

P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metal | S Exotic Alloy

Rake Angle		
	Radial	9° to 10°
	Axial	-14° to -15°

19-27mm 90°

Shoulder Milling | Groove Milling | Ramping | Drilling | Profiling | Side Milling | Plunge Milling | Helical Milling

Fig 1

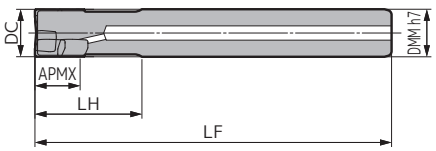
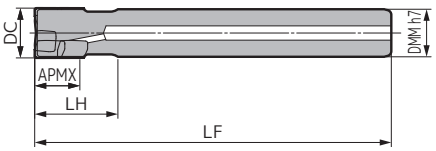


Fig 2



■ Body (Shank type)

Dimensions (mm)

Cat. No.	Stock	Dia. DC	Max. Depth of Cut APMX	Shank DMM	Head LH	Overall Length LF	Total No. of Teeth	No. of Steps	Effective No. of Teeth	Weight (kg)	Fig
WEZM 11020E1920-07	○	**20**	19	20	45	150	3	2	1	0.29	1
WEZM 11021E1920-07	○	**21**	19	20	35	150	3	2	1	0.30	2
WEZM 11025E2725-07	○	**25**	27	25	55	150	4	3	1	0.46	1
WEZM 11026E2725-07	○	**26**	27	25	45	150	4	3	1	0.47	2

Inserts are sold separately.

■ Body (Long Shank type)

Dimensions (mm)

Cat. No.	Stock	Dia. DC	Max. Depth of Cut APMX	Shank DMM	Head LH	Overall Length LF	Total No. of Teeth	No. of Steps	Effective No. of Teeth	Weight (kg)	Fig
WEZM 11020EL1920-07	○	**20**	19	20	60	185	3	2	1	0.36	1
WEZM 11021EL1920-07	○	**21**	19	20	35	185	3	2	1	0.38	2
WEZM 11025EL2725-07	○	**25**	27	25	75	220	4	3	1	0.70	1
WEZM 11026EL2725-07	○	**26**	27	25	45	220	4	3	1	0.72	2

Inserts are sold separately.

■ Identification Code

WEZM 11 020 E L 19 20 - 07

- WEZM: Series Code
- 11: Insert Size
- 020: Dia.
- E: Shank type
- L: Long Shank
- 19: Max. Depth of Cut
- 20: Shank Dia.
- 07: Central Insert Size

■ Parts

	Flat Insert Screw		Wrench	Anti-seizure Cream
		N·m		
Peripheral Insert	BFTX0306IP	**1.5**	TRDR08IP*	SUMI-P*
Central Insert	BFTX02506IP			

*Wrenches and anti-seizure cream are sold separately.

■ Recommended Cutting Conditions (Shoulder Milling)

ISO	Work Material	Hardness	Chipbreaker	Cutting Speed vc (m/min) Min. - **Optimum** - Max.	Feed Rate fz (mm/rev) Min. - **Optimum** - Max.	Insert Grade
P	Carbon Steel	≤ 280HB	G	80 - **150** - 200	0.08 - **0.15** - 0.20	ACU2500
		> 280HB	G	80 - **100** - 120	0.08 - **0.15** - 0.20	ACP2000
	Alloy Steel	≤ 280HB	G	80 - **150** - 180	0.08 - **0.15** - 0.20	ACP3000
M	Stainless Steel	≤ 280HB	G	80 - **120** - 160	0.08 - **0.15** - 0.20	ACU2500 ACS1000 ACS2500 ACS3000
K	Cast Iron / Ductile Cast Iron	—	G	80 - **150** - 200	0.08 - **0.15** - 0.20	ACU2500 ACK2000 ACK3000
S	Exotic Alloy	—	G	40 - **50** - 60	0.08 - **0.15** - 0.20	ACU2500 ACS1000 ACS2500 ACS3000
N	Aluminum Alloy	Si ≤ 12.6%	S	300 - **500** - 800	0.05 - **0.10** - 0.15	DL2000 H20
		Si > 12.6%	S	100 - **200** - 250	0.05 - **0.10** - 0.15	

Note
- The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, workpiece rigidity, depth of cut and other factors.
- There may be cases where machining cannot be performed under recommended cutting conditions, depending on the machine rigidity and workpiece rigidity.
- For groove milling, adjust the feed rate to around 70% of the above values.

■ Recommended Cutting Conditions (Drilling)

ISO	Work Material	Hardness	Chipbreaker	Cutting Speed vc (m/min) Min. - **Optimum** - Max.	Feed Rate fz (mm/rev) Min. - **Optimum** - Max. ø20 to ø21	ø25 to ø26	Insert Grade
P	Carbon Steel	≤ 280HB	G	100 - **160** - 220	0.06 - **0.13** - 0.20	0.06 - **0.14** - 0.22	ACU2500
		> 280HB	G	90 - **120** - 150	0.05 - **0.10** - 0.14	0.05 - **0.10** - 0.14	ACP2000
	Alloy Steel	≤ 280HB	G	110 - **140** - 170	0.05 - **0.10** - 0.14	0.05 - **0.10** - 0.14	ACP3000
M	Stainless Steel	≤ 280HB	G	120 - **180** - 210	0.05 - **0.10** - 0.15	0.05 - **0.10** - 0.15	ACU2500 ACS1000 ACS2500 ACS3000
K	Cast Iron / Ductile Cast Iron	—	G	100 - **125** - 150	0.09 - **0.15** - 0.19	0.09 - **0.16** - 0.22	ACU2500 ACK2000 ACK3000
S	Exotic Alloy	—	G	15 - **20** - 25	0.06 - **0.08** - 0.10	0.06 - **0.08** - 0.10	ACU2500 ACS1000 ACS2500 ACS3000
N	Aluminum Alloy	Si ≤ 12.6%	S	200 - **260** - 320	0.06 - **0.11** - 0.17	0.06 - **0.11** - 0.17	DL2000 H20
		Si > 12.6%	S	70 - **100** - 120	0.06 - **0.11** - 0.17	0.06 - **0.11** - 0.17	

Note
- The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, workpiece rigidity, depth of cut and other factors.
- There may be cases where machining cannot be performed under recommended cutting conditions, depending on the machine rigidity and workpiece rigidity.

*For holes over 3mm deep, 0.3 to 1mm step machining is recommended for chip breaking.

N·m Recommended Tightening Torque (N·m) ○ mark: Stock or planned stock (to be released as of November 2025)

WEZM 11000E(L) type

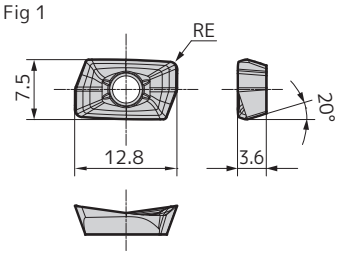
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy

■ Insert (Peripheral Insert)

Dimensions (mm)

Grade Classification		Coated Carbide									Carbide	DLC	Cermet		
Process	High-speed/Light Cutting		P		K		M S	M S		M S		N	P		
	Medium Cutting	K M S		P		K		M S	M S	M S	M S	N	N		
	Roughing	K M S		P		K			M S		M S				
Cat. No.		ACU2500	ACP2000	ACP3000	ACK2000	ACK3000	ACS1000 (New)	ACS2500	ACS3000	ACM200	ACM300	H20	DL2000	T2500A	Corner Radius RE	Fig
AOMT 11T302PEER-G		●		●		●	●	●	●	▲	▲	—	—	●	0.2	1
11T304PEER-G		●	●	●	●	●	●	●	●	▲	▲	—	—	●	0.4	1
11T305PEER-G		●							●	▲	▲	—	—		0.5	1
11T308PEER-G		●	●	●	●	●	●	●	●	▲	▲	—	—	●	0.8	1
11T310PEER-G		●							●	▲	▲	—	—		1.0	1
11T312PEER-G		●		●		●	●	●	●	▲	▲	—	—		1.2	1
11T316PEER-G		●		●		●	●	●	●	▲	▲	—	—		1.6	1
11T320PEER-G		●		●		●	●	●	●	▲	▲	—	—		2.0	1
11T324PEER-G		●							●	▲	▲	—	—		2.4	1
AOMT 11T304PEER-H		●	●	●	●	●	●	●	●	▲	▲	—	—	—	0.4	1
11T308PEER-H		●	●	●	●	●	●	●	●	▲	▲	—	—	—	0.8	1
11T312PEER-H		●							●	▲	▲	—	—	—	1.2	1
11T316PEER-H		●							●	▲	▲	—	—	—	1.6	1
AOET 11T302PEER-F		●	—		—				●	—		—	—	—	0.2	1
11T304PEER-F		●	—		—				●	—		—	—	—	0.4	1
11T305PEER-F		●	—		—					—		—	—	—	0.5	1
11T308PEER-F		●	—		—				●	—		—	—	—	0.8	1
11T310PEER-F		●	—		—					—		—	—	—	1.0	1
11T312PEER-F		●	—		—				●	—		—	—	—	1.2	1
11T316PEER-F		●	—		—					—		—	—	—	1.6	1
11T320PEER-F		●	—		—				●	—		—	—	—	2.0	1
11T324PEER-F		●	—		—					—		—	—	—	2.4	1
AOET 11T302PEER-P20		●	—		—					—		—	—	—	0.2	1
11T304PEER-P20		●	—		—					—		—	—	—	0.4	1
11T305PEER-P20		●	—		—					—		—	—	—	0.5	1
11T308PEER-P20		●	—		—					—		—	—	—	0.8	1
11T310PEER-P20		●	—		—					—		—	—	—	1.0	1
11T312PEER-P20		●	—		—					—		—	—	—	1.2	1
AOET 11T302PEER-P25		●	—		—					—		—	—	—	0.2	1
11T304PEER-P25		●	—		—					—		—	—	—	0.4	1
11T305PEER-P25		●	—		—					—		—	—	—	0.5	1
11T308PEER-P25		●	—		—					—		—	—	—	0.8	1
11T310PEER-P25		●	—		—					—		—	—	—	1.0	1
11T312PEER-P25		●	—		—					—		—	—	—	1.2	1
AOET 11T302PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.2	1
11T304PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.4	1
11T305PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.5	1
11T308PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.8	1
11T310PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	1.0	1
11T312PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	1.2	1
11T316PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	1.6	1
11T320PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	2.0	1
11T324PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	2.4	1

Fig 1



Peripheral Insert: -G: General-purpose, -H: Strong Edge, -F: Medium Finishing, -P20/-P25: High-precision Machining, -S: Non-Ferrous Metals.
*For the 2nd step on, use R0.8 or below.
*-P20 is applicable to cutter diameters ø20 and ø21. -P25 is applicable to cutter diameters ø25 and ø26.

■ Insert (Central Insert)

Dimensions (mm)

Grade Classification		Coated Carbide				
Process	High-speed/Light Cutting	K P M S				
	Medium Cutting	K P M S				
	Roughing	K P M S				
Cat. No.		ACU2500	Width W1	Thickness S	Corner Radius RE	Fig
GDXT 070308C-L		●	8.6	3.18	0.8	2
070308C-G		●	8.6	3.31	0.8	3

Fig 2 Central insert L type

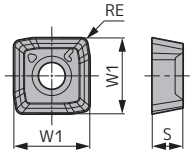
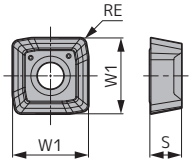


Fig 3 Central insert G type



N·m Recommended Tightening Torque (N·m) ● mark: Standard stocked item ▲ mark: To be replaced by a new product, made to order, or discontinued Blank: Made-to-order item — mark: Not available

WEZM 11000M type

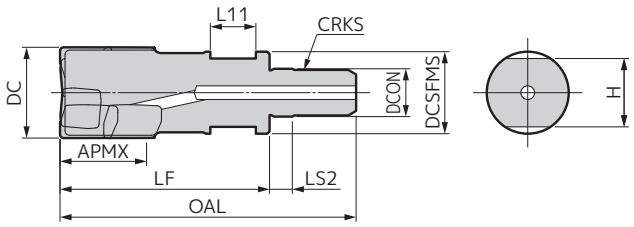
P Steel | M Stainless Steel | K Cast Iron | N Non-Ferrous Metal | S Exotic Alloy

Rake Angle		
	Radial	9° to 10°
	Axial	-14° to -15°

19-27mm 90°

Shoulder Milling | Groove Milling | Ramping | Drilling | Profiling | Side Milling | Plunge Milling | Helical Milling

Fig 1



■ Body (Modular type)

Dimensions (mm)

Cat. No.	Stock	Dia. DC	Max. Depth of Cut APMX	Boss DCSFMS	Mounting Dia. DCON	Screw CRKS	Overall Length OAL	Effective Length LF	Length LS2	Flat L11	Width H	Total No. of Teeth	No. of Steps	Effective No. of Teeth	Weight (kg)	Fig
WEZM 11020M1019Z1-07	○	**20**	19	18	10.5	**M10**	65	46	5	10	15	3	2	1	0.07	1
WEZM 11021M1019Z1-07	○	**21**	19	18	10.5	**M10**	65	46	5	10	15	3	2	1	0.07	1
WEZM 11025M1227Z1-07	○	**25**	27	22	12.5	**M12**	73	52	5	11	19	4	3	1	0.11	1
WEZM 11026M1227Z1-07	○	**26**	27	22	12.5	**M12**	73	52	5	11	19	4	3	1	0.12	1

Inserts are sold separately.

■ Identification Code

WEZM 11 020 M10 19 Z1 - 07

WEZM	11	020	M10	19	Z1	-	07
Series Code	Insert Size	Dia.	Mounting Screw Size	Max. Depth of Cut	Number of Flutes		Central Insert Size

■ Parts

	Flat Insert Screw		Wrench	Anti-seizure Cream
		N·m		
Peripheral Insert	BFTX0306IP	**1.5**	TRDR08IP*	SUMI-P*
Central Insert	BFTX02506IP			

*Wrenches and anti-seizure cream are sold separately.

■ Recommended Cutting Conditions (Shoulder Milling)

ISO	Work Material	Hardness	Chipbreaker	Cutting Speed vc (m/min) Min. - **Optimum** - Max.	Feed Rate fz (mm/rev) Min. - **Optimum** - Max.	Insert Grade
P	Carbon Steel	≤ 280HB	G	80 - **150** - 200	0.08 - **0.15** - 0.20	ACU2500
		> 280HB	G	80 - **100** - 120	0.08 - **0.15** - 0.20	ACP2000
	Alloy Steel	≤ 280HB	G	80 - **150** - 180	0.08 - **0.15** - 0.20	ACP3000
M	Stainless Steel	≤ 280HB	G	80 - **120** - 160	0.08 - **0.15** - 0.20	ACU2500 ACS1000 ACS2500 ACS3000
K	Cast Iron / Ductile Cast Iron	—	G	80 - **150** - 200	0.08 - **0.15** - 0.20	ACU2500 ACK2000 ACK3000
S	Exotic Alloy	—	G	40 - **50** - 60	0.08 - **0.15** - 0.20	ACU2500 ACS1000 ACS2500 ACS3000
N	Aluminum Alloy	Si ≤ 12.6%	S	300 - **500** - 800	0.05 - **0.10** - 0.15	DL2000 H20
		Si > 12.6%	S	100 - **200** - 250	0.05 - **0.10** - 0.15	

Note
- The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, workpiece rigidity, depth of cut and other factors.
- There may be cases where machining cannot be performed under recommended cutting conditions, depending on the machine rigidity and workpiece rigidity.
- For groove milling, adjust the feed rate to around 70% of the above values.

■ Recommended Cutting Conditions (Drilling)

ISO	Work Material	Hardness	Chipbreaker	Cutting Speed vc (m/min) Min. - **Optimum** - Max.	Feed Rate fz (mm/rev) Min. - **Optimum** - Max. ø20 to ø21	ø25 to ø26	Insert Grade
P	Carbon Steel	≤ 280HB	G	100 - **160** - 220	0.06 - **0.13** - 0.20	0.06 - **0.14** - 0.22	ACU2500
		> 280HB	G	90 - **120** - 150	0.05 - **0.10** - 0.14	0.05 - **0.10** - 0.14	ACP2000
	Alloy Steel	≤ 280HB	G	110 - **140** - 170	0.05 - **0.10** - 0.14	0.05 - **0.10** - 0.14	ACP3000
M	Stainless Steel	≤ 280HB	G	120 - **180** - 210	0.05 - **0.10** - 0.15	0.05 - **0.10** - 0.15	ACU2500 ACS1000 ACS2500 ACS3000
K	Cast Iron / Ductile Cast Iron	—	G	100 - **125** - 150	0.09 - **0.15** - 0.19	0.09 - **0.16** - 0.22	ACU2500 ACK2000 ACK3000
S	Exotic Alloy	—	G	15 - **20** - 25	0.06 - **0.08** - 0.10	0.06 - **0.08** - 0.10	ACU2500 ACS1000 ACS2500 ACS3000
N	Aluminum Alloy	Si ≤ 12.6%	S	200 - **260** - 320	0.06 - **0.11** - 0.17	0.06 - **0.11** - 0.17	DL2000 H20
		Si > 12.6%	S	70 - **100** - 120	0.06 - **0.11** - 0.17	0.06 - **0.11** - 0.17	

Note
- The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, workpiece rigidity, depth of cut and other factors.
- There may be cases where machining cannot be performed under recommended cutting conditions, depending on the machine rigidity and workpiece rigidity.

*For holes over 3mm deep, 0.3 to 1mm step machining is recommended for chip breaking.

N·m Recommended Tightening Torque (N·m) ○ mark: Stock or planned stock (to be released as of November 2025)

WEZM 11000M type

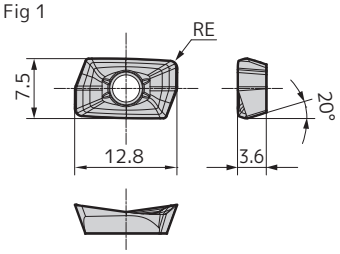
P Steel M Stainless Steel K Cast Iron N Non-Ferrous Metal S Exotic Alloy

■ Insert (Peripheral Insert)

Dimensions (mm)

Grade Classification		Coated Carbide									Carbide	DLC	Cermet		
Process	High-speed/Light Cutting		P		K		M S	M S		M S		N	P		
	Medium Cutting	K M S		P		K		M S	M S	M S	M S	N	N		
	Roughing	K M S		P		K			M S		M S				
Cat. No.		ACU2500	ACP2000	ACP3000	ACK2000	ACK3000	ACS1000 (New)	ACS2500	ACS3000	ACM200	ACM300	H20	DL2000	T2500A	Corner Radius RE	Fig
AOMT 11T302PEER-G		●		●		●	●	●	●	▲	▲	—	—	●	0.2	1
11T304PEER-G		●	●	●	●	●	●	●	●	▲	▲	—	—	●	0.4	1
11T305PEER-G		●							●	▲	▲	—	—		0.5	1
11T308PEER-G		●	●	●	●	●	●	●	●	▲	▲	—	—	●	0.8	1
11T310PEER-G		●							●	▲	▲	—	—		1.0	1
11T312PEER-G		●		●		●	●	●	●	▲	▲	—	—		1.2	1
11T316PEER-G		●		●		●	●	●	●	▲	▲	—	—		1.6	1
11T320PEER-G		●		●		●	●	●	●	▲	▲	—	—		2.0	1
11T324PEER-G		●							●	▲	▲	—	—		2.4	1
AOMT 11T304PEER-H		●	●	●	●	●	●	●	●	▲	▲	—	—	—	0.4	1
11T308PEER-H		●	●	●	●	●	●	●	●	▲	▲	—	—	—	0.8	1
11T312PEER-H		●							●	▲	▲	—	—	—	1.2	1
11T316PEER-H		●							●	▲	▲	—	—	—	1.6	1
AOET 11T302PEER-F		●	—		—				●	—		—	—	—	0.2	1
11T304PEER-F		●	—		—				●	—		—	—	—	0.4	1
11T305PEER-F		●	—		—					—		—	—	—	0.5	1
11T308PEER-F		●	—		—				●	—		—	—	—	0.8	1
11T310PEER-F		●	—		—					—		—	—	—	1.0	1
11T312PEER-F		●	—		—				●	—		—	—	—	1.2	1
11T316PEER-F		●	—		—					—		—	—	—	1.6	1
11T320PEER-F		●	—		—				●	—		—	—	—	2.0	1
11T324PEER-F		●	—		—					—		—	—	—	2.4	1
AOET 11T302PEER-P20		●	—		—					—		—	—	—	0.2	1
11T304PEER-P20		●	—		—					—		—	—	—	0.4	1
11T305PEER-P20		●	—		—					—		—	—	—	0.5	1
11T308PEER-P20		●	—		—					—		—	—	—	0.8	1
11T310PEER-P20		●	—		—					—		—	—	—	1.0	1
11T312PEER-P20		●	—		—					—		—	—	—	1.2	1
AOET 11T302PEER-P25		●	—		—					—		—	—	—	0.2	1
11T304PEER-P25		●	—		—					—		—	—	—	0.4	1
11T305PEER-P25		●	—		—					—		—	—	—	0.5	1
11T308PEER-P25		●	—		—					—		—	—	—	0.8	1
11T310PEER-P25		●	—		—					—		—	—	—	1.0	1
11T312PEER-P25		●	—		—					—		—	—	—	1.2	1
AOET 11T302PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.2	1
11T304PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.4	1
11T305PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.5	1
11T308PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	0.8	1
11T310PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	1.0	1
11T312PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	1.2	1
11T316PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	1.6	1
11T320PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	2.0	1
11T324PEFR-S		—	—	—	—	—	—	—	—	—	—	●	●	—	2.4	1

Fig 1



Peripheral Insert: -G: General-purpose, -H: Strong Edge, -F: Medium Finishing, -P20/-P25: High-precision Machining, -S: Non-Ferrous Metals.
*For the 2nd step on, use R0.8 or below.
*-P20 is applicable to cutter diameters ø20 and ø21. -P25 is applicable to cutter diameters ø25 and ø26.

■ Insert (Central Insert)

Dimensions (mm)

Grade Classification		Coated Carbide				
Process	High-speed/Light Cutting	K M S				
	Medium Cutting	K M S				
	Roughing	K M S				
Cat. No.		ACU2500	Width W1	Thickness S	Corner Radius RE	Fig
GDXT 070308C-L		●	8.6	3.18	0.8	2
070308C-G		●	8.6	3.31	0.8	3

Fig 2 Central insert L type

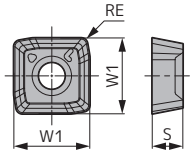
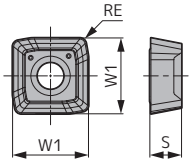


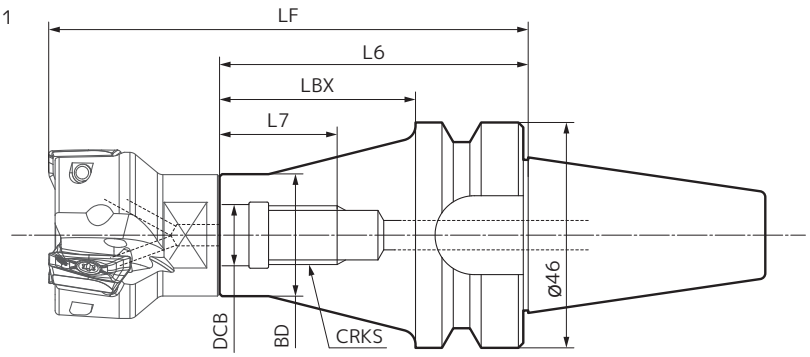
Fig 3 Central insert G type



N·m Recommended Tightening Torque (N·m) ● mark: Standard stocked item ▲ mark: To be replaced by a new product, made to order, or discontinued Blank: Made-to-order item — mark: Not available

■ BBT Integrated type - SEC-Modular Tools Special Arbors

Fig 1



■ BBT Integrated Arbor

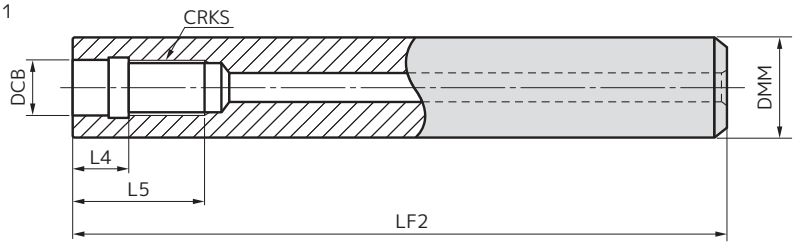
Dimensions (mm)

Cat. No.	Stock	Screw CRKS	Hole Dia. DCB	External Dia. BD	Body Overhang L6	Length LBX	Thread Depth L7	Overhang LF*1	Coolant Hole	Fig
BBT30-M10-45	●	**M10**	10.5	19.9	67	45	20	113	Yes	1
M12-40	●	**M12**	12.5	24.9	62	40	22	114	Yes	1

*1: Overhang length for LF is with head mounted.
Can also be used with BT30 spindle machines.

■ SEC-Modular Tools - Special Arbors (Carbide Arbor/Steel Arbor)

Fig 1



■ Carbide Arbor

Dimensions (mm)

Cat. No.	Stock	Screw CRKS	Hole Dia. DCB	Shank DMM	Overall Length LF2	Depth L4	Thread Depth L5	Overhang LF*2	Fig
MA18M10L150C	●	**M10**	10.5	18	150	10	20	196	1
18M10L200C	●	**M10**	10.5	18	200	10	20	246	1
20M10L150C	●	**M10**	10.5	20	150	10	20	196	1
20M10L200C	●	**M10**	10.5	20	200	10	20	246	1
MA23M12L200C	●	**M12**	12.5	23	200	10	22	252	1
23M12L250C	●	**M12**	12.5	23	250	10	22	302	1
25M12L200C	●	**M12**	12.5	25	200	10	22	252	1
25M12L250C	●	**M12**	12.5	25	250	10	22	302	1

● Set Dimensions (*2)

■ Steel Arbor

Dimensions (mm)

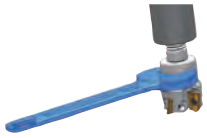
Cat. No.	Stock	Screw CRKS	Hole Dia. DCB	Shank DMM	Overall Length LF2	Depth L4	Thread Depth L5	Overhang LF*2	Fig
MA20M10L150S	●	**M10**	10.5	20	150	10	20	196	1
25M12L200S	●	**M12**	12.5	25	200	10	22	252	1

■ Recommended Tightening Torque (N·m)

***Take care when tightening the head.**

· When mounting the head to an arbor, follow the regulated tightening torque in the table below.
· Check the mounting screw size for the head and arbor beforehand.

Screw Size	Regulated Tightening Torque (N·m)
M10	**46**
M12	**60**



■ Identification Code

MA	**20**	**M10**	**L150**	**C**
Series Code	Shank Dia.	Mounting Screw Size	Arbor Overall Length	Arbor Material (C: Carbide S: Steel)

● mark: Standard stocked item

< SAFETY NOTES >

- 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.
- 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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(2025.10) I TP/AK