



DOUBLE OCTOMILL™
PRODUCT RANGE

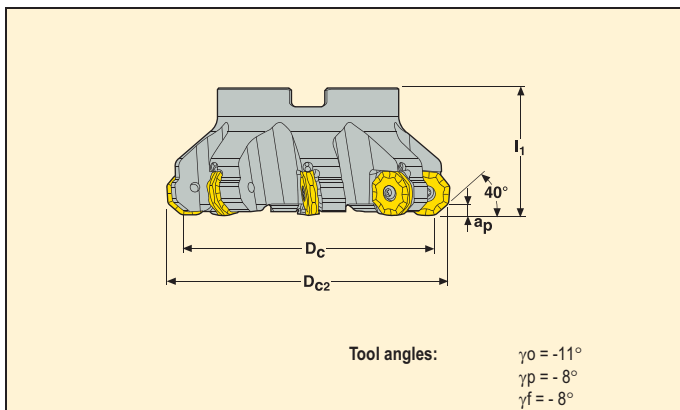
SECO 



SECO
R220.48-0123-01-8S



- For insert selection and cutting data recommendations, see page 6.
- For complete insert programme, see page 7.



Pitch	Part No.	Dimensions in mm							
		D _c	D _{c2}	l ₁	a _p				
Normal	R220.48 -0063-09-05S	63	78	40	6	5	0,6	4900	ONMU09
	-0080-09-06S	80	95	50	6	6	1,1	4400	ONMU09
	-0100-09-07S	100	115	50	6	7	1,8	3900	ONMU09
	-0125-09-08S	125	140	63	6	8	3,0	3500	ONMU09
	-8160-09-10S	160	175	63	6	10	4,4	3100	ONMU09
	-8200-09-12S	200	215	63	6	12	6,2	2700	ONMU09
	-8250-09-16S	250	265	63	6	16	13,5	2500	ONMU09
	-8315-09-20S	315	330	80	6	20	27,8	2200	ONMU09

Spare parts

	Locking screw	Key *
For cutter		
R220.48..	C05013-T20P	T20P-4

* Torque values 6,0 Nm.

Dimensions of mounting

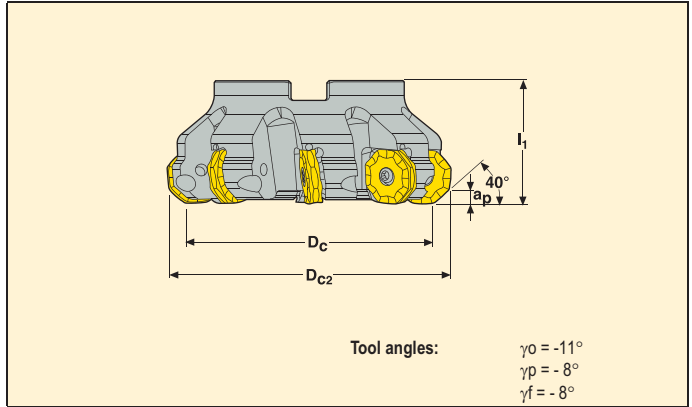
	Dimensions in mm						For arbor	For spindle-nose
	For cutter	dm _m	D _{5m}	B _{kw}	c	d _{hc1}		
R220.48-0063		22	47	10,4	7	-	-	22
R220.48-0080		27	62	12,4	7	-	-	27
R220.48-0100		32	77	14,4	8	-	-	32
R220.48-0125		40	90	16,4	9	-	-	40
R220.48-8160		40	90	16,4	9	66,7	-	40
R220.48-8200		60	130	25,7	14	101,6	-	ISO50
R220.48-8250		60	130	25,7	14	101,6	177,8	ISO50
R220.48-8315		60	225	25,7	14	101,6	177,8	ISO50,ISO60

Please check availability in current price and stock-list.

Double Octomill 220.48-09



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Pitch	Part No.	Dimensions in mm							
		D _c	D _{c2}	l ₁	a _p				
Normal +	R220.48 -0063-09-06S	63	78	40	6	6	0,6	4900	ONMU09
	-0080-09-07S	80	95	50	6	7	1,1	4400	ONMU09
	-0100-09-08S	100	115	50	6	8	1,9	3900	ONMU09
	-0125-09-10S	125	140	63	6	10	3,3	3500	ONMU09
	-8160-09-12S	160	175	63	6	12	4,7	3100	ONMU09
	-8200-09-16S	200	215	63	6	16	6,2	2700	ONMU09
	-8250-09-20S	250	265	63	6	20	13,9	2500	ONMU09
	-8315-09-24S	315	330	80	6	24	28,5	2200	ONMU09

Spare parts

	Locking screw	Key *
For cutter		
R220.48..	C05013-T20P	T20P-4

* Torque values 6,0 Nm.

Dimensions of mounting

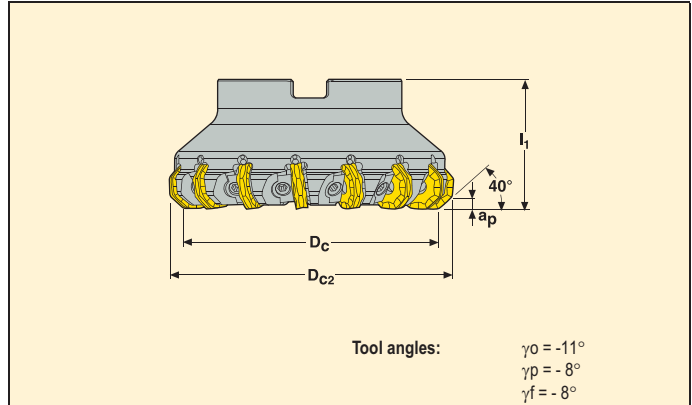
	Dimensions in mm						For arbor	For spindle-nose	
	For cutter	dm _m	D _{5m}	B _{kw}	c	d _{hc1}			d _{hc2}
	R220.48-0063	22	47	10,4	7	–	–	22	–
	R220.48-0080	27	62	12,4	7	–	–	27	–
	R220.48-0100	32	77	14,4	8	–	–	32	–
	R220.48-0125	40	90	16,4	9	–	–	40	–
	R220.48-8160	40	90	16,4	9	66,7	–	40	ISO40
	R220.48-8200	60	130	25,7	14	101,6	–	–	ISO50
	R220.48-8250	60	130	25,7	14	101,6	177,8	–	ISO50
	R220.48-8315	60	225	25,7	14	101,6	177,8	–	ISO50,ISO60

Please check availability in current price and stock-list.

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Pitch	Part No.	Dimensions in mm							
		D _c	D _{c2}	l ₁	a _p				
Close	R220.48 -0080-09-09M	80	95	50	6	9	1,4	4400	ONMU09
	-0100-09-12M	100	115	50	6	12	2,2	3900	ONMU09
	-0125-09-15M	125	140	63	6	15	3,8	3500	ONMU09
	-8160-09-20M	160	175	63	6	20	5,4	3100	ONMU09
	-8200-09-24M	200	215	63	6	24	7,0	2700	ONMU09
	-8250-09-30M	250	265	63	6	30	15,1	2500	ONMU09
	-8315-09-40M	315	330	80	6	40	30,1	2200	ONMU09

Spare parts

	Wedge	Wedge screw	Key *
For cutter			
R220.48..	CW0816	LD8025-T25P	T25P-4

* Torque values 6,0 - 8,0 Nm.

Dimensions of mounting

	Dimensions in mm						For arbor	For spindle-nose
	For cutter	d _m	D _{sm}	B _{kw}	c	d _{hc1}		
R220.48-0080		27	62	12,4	7	-	-	27
R220.48-0100		32	77	14,4	8	-	-	32
R220.48-0125		40	90	16,4	9	-	-	40
R220.48-8160		40	90	16,4	9	66,7	-	40
R220.48-8200		60	130	25,7	14	101,6	-	ISO50
R220.48-8250		60	130	25,7	14	101,6	177,8	ISO50
R220.48-8315		60	225	25,7	14	101,6	177,8	ISO50,ISO60

Please check availability in current price and stock-list.

Seco Material group No.	Recom. feed f_z mm/tooth	First choice	Difficult operations
1	0,15–0,35	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
2	0,15–0,35	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
3	0,15–0,35	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
4	0,15–0,35	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
5	0,10–0,30	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
6	0,10–0,20	ONMU 090520ANTN-M14 MP1500	ONMU 090520ANTN-MD16 MP1500
7	0,10–0,15	ONMU 090520ANTN-M14 MP1500	ONMU 090520ANTN-MD16 MP3000
8	0,15–0,30	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
9	0,15–0,30	ONMU 090520ANTN-M14 MP2500	ONMU 090520ANTN-M14 T350M
10	0,15–0,25	ONMU 090520ANTN-M14 T350M	ONMU 090520ANTN-MD16 T350M
11	0,15–0,20	ONMU 090520ANTN-MD16 T350M	ONMU 090520ANTN-MD16 T350M
12	0,15–0,35	ONMU 090520ANTN-M14 MK1500	ONMU 090520ANTN-M14 MK3000
13	0,15–0,35	ONMU 090520ANTN-M14 MK1500	ONMU 090520ANTN-M14 MK3000
14	0,10–0,30	ONMU 090520ANTN-MD16 MK1500	ONMU 090520ANTN-MD16 MK3000
15	0,10–0,25	ONMU 090520ANTN-MD16 MP1500	ONMU 090520ANTN-MD16 MK3000
16	0,10–0,25	ONMU 090520ANTN-M14 MP1500	ONMU 090520ANTN-M14 MP1500
17	0,10–0,25	ONMU 090520ANTN-M14 MP1500	ONMU 090520ANTN-M14 MP1500
20	–	–	–
21	–	–	–
22	–	–	–

Cutting data – Full engagement width ($a_e/D_c = 100\%$)

Seco Material Group No.	Grades																				
	MP1500			MP2500			MP3000/MK2000			T350M			F40M			MK1500			MK3000		
	Feed, f_z (mm/tooth)																				
	0,15	0,25	0,35	0,15	0,25	0,35	0,15	0,25	0,35	0,15	0,25	0,35	0,15	0,25	0,35	0,15	0,25	0,35	0,15	0,25	0,35
Cutting speed, v_c (m/min)																					
1	390	335	295	345	295	260	330	280	250	300	255	230	260	225	200	–	–	–	320	270	240
2	340	290	260	305	260	230	285	245	215	265	225	200	230	195	175	–	–	–	280	235	210
3	285	245	215	255	215	190	240	205	180	220	185	165	190	165	145	–	–	–	230	195	175
4	260	220	195	230	195	175	220	185	165	200	170	150	175	150	130	–	–	–	210	180	160
5	210	180	160	190	160	140	180	150	135	165	140	125	140	120	110	–	–	–	170	145	130
6	155	130	115	135	115	105	130	110	100	120	100	90	105	90	80	–	–	–	125	105	95
7	50	40	–	40	35	–	40	35	–	40	30	–	35	30	–	–	–	40	35	–	
8	255	215	190	200	170	150	195	170	150	185	160	140	170	145	130	–	–	–	195	170	150
9	220	185	165	175	150	130	170	145	130	160	140	125	150	125	110	–	–	–	170	145	130
10	185	160	140	150	125	110	145	125	110	140	120	105	125	105	95	–	–	–	145	125	110
11	145	125	–	115	100	–	115	95	–	110	90	–	100	85	–	–	–	115	95	–	
12	230	195	175	200	170	155	190	165	145	175	150	135	155	130	115	285	245	215	185	160	140
13	205	175	155	180	155	135	170	145	130	155	135	120	135	115	105	255	220	195	165	140	125
14	185	160	140	165	140	125	155	135	120	145	125	110	125	105	95	235	200	180	150	130	115
15	150	130	–	135	115	–	125	110	–	115	100	–	100	85	–	190	160	–	125	105	–
16	1060	900	800	940	800	710	890	755	675	815	695	620	710	605	540	–	–	–	860	735	650
17	855	730	650	760	645	575	720	610	545	660	560	500	575	490	435	–	–	–	695	590	525
20	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
21	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
22	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

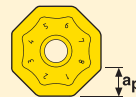
Surface finish

Type of insert geometry	Feed mm/rev \leq	R_a μ m
M14	0,45	1,0
M15	2,1	0,8
MD16	0,45	1,0
MD17	2,1	0,8

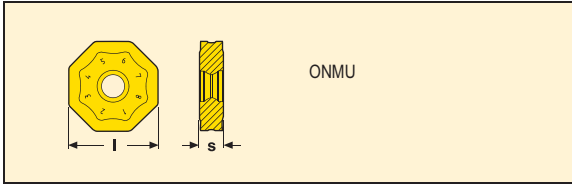
Finish of the milled surface is determined by feed/rev used.

Dimensions in mm

Insert geometry	Max D.O.C. a_p	Wiper flat width B
M14	6	0,45
M15	4	2,1
MD16	6	0,45
MD17	4	2,1



ON..09



Size	Dimensions in mm	
	l	s
ON..09	22	5,8

Inserts	Part No.	Cutting rake	Grades																
			Coated											Uncoated					
			MK1500	MK2000	MK3000	MP1500	MP2500	MP3000	MH1000	MS2500	T25M	T350M	F15M	F20M	F25M	F40M	S60M	HX	H15
M13 	ONMU 090520ANTN-M13*	20°	■	■	■	■	■	■											
	ONMU 090520ANTN-M14	15°	■	■	■	■	■	■								■			
	ONMU 090520ANTN-M15	15°	■	■	■	■	■	■								■			
M14/M15 	ONMU 090520ANTN-MD16	0°	■		■	■	■	■											
	ONMU 090520ANTN-MD17	0°	■		■	■	■	■											
MD16/MD17 																			

■ Stock standard
 Subject to change refer to current price and stock-list
 *M13 In stock beginning of 2010

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