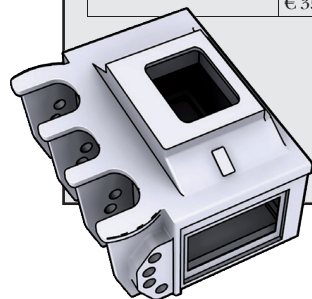


APPLICATION CASE

ROUGH FACING

Objective		Performance	
Material		GS400 (Seco Material Group 13)	
Component		Air Cooler Housing	
Machine		HB130T	
Holder		DIN 69871 ISO 50	
		Reference	Seco
Cutter		45° lead face mill	R220.48-0125-09-15M
No. of teeth		9	15
No cutting edges		4	16
Insert		Square insert	ONMU090520TN-M15 MK3000
Cutting data	v_c	200 m/min	300 m/min
	n	400 rpm	750 rpm
	f_z	0,36 mm/tooth	0,22 mm/tooth
	v_f	1300 mm/min	2500 mm/min
	a_p	4 mm	4 mm
	a_e	120 mm	120 mm
Coolant		Emulsion	Emulsion
Tool life		100 min	18 min
Power req.		65%	55%
Wear		0,3mm flank (average value)	0,1 mm flank wear
Result		Machining cost: € 350	Machining cost: € 240



CONTACT & INFORMATION

SECO MACHINING NAVIGATOR:

Update catalogue 2010

ONLINE INFORMATION:

Complete Double Octomill information:

<http://www.secotools.com/doubleoctomill>

Seco Tools international website:

<http://www.secotools.com>

TOOLS

MILLING

DOUBLE OCTOMILL™



**PERFORMANCE FACE MILLING CUTTER
WITH ECONOMICAL 16-EDGED INSERTS**

SECO

Seco Tools AB, 737 82 Fagersta, Sweden. Tel +46 223 400 00.
www.secotools.com

02739943 ST20106237 GB SECO TOOLS AB, PA Group Karlstad 2010

SECO

SAVING TIME AND MONEY

The new generation Double Octomill R220.48 face milling cutter is a highly versatile, economic and productive tool that can be used for both roughing and finishing.

EASY AND SECURE INDEXING

A unique feature that sets Double octomill apart from ordinary face mills is its precision insert seating technology. A set of hardened pins in each insert pocket locate the insert securely and accurately making it easy to index them and eliminating the need for any axial adjustment.

16 CUTTING EDGES

The easy-to-handle Double Octomill, with 16 cutting edges and positive insert geometry, can make a unique contribution to your milling performance. Choose Double Octomill, whatever your industry or applications are.

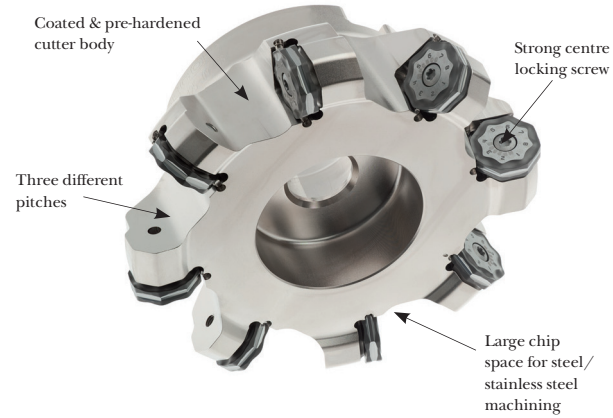
MAIN BENEFITS

- Same tool for roughing and finishing
- Excellent surface finish
- Long tool life
- Light cutting action
- Fewer spare parts, easy handling

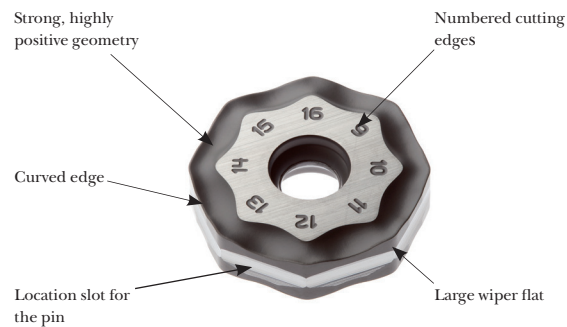
RANGE

Cutter:	Diameter = 63 - 315mm (-500mm)
Pitch configuration:	Normal, Normal+, Close
Insert type and size:	ONMU 09... (16 edges /insert)
Insert geometries	M13, M14, M15, MD16, MD17
Depth of cut:	Max ap = 4,5 - 6mm

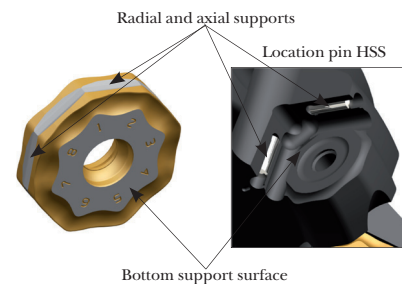
CUTTER FEATURES



HIGH PERFORMANCE INSERT



EXCELLENT PRECISION RADIAL AND AXIAL RUNOUT

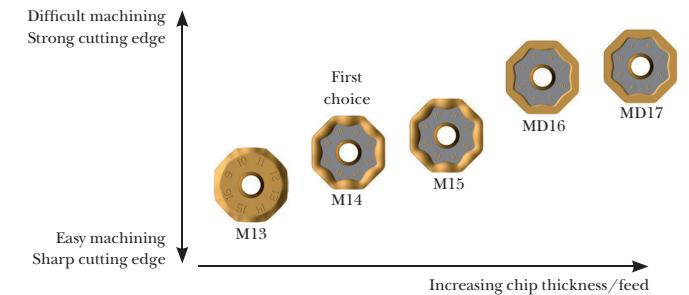


CENTRE LOCK & WEDGE

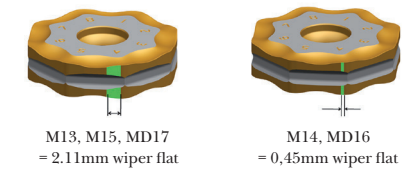


With Double Octomill the fixed pockets mean fewer spare parts and, in turn, reduced tool cost and simplicity. Insert edges are numbered for easy handling and best possible tool life is achieved by using the same cutting edge number in all pockets. No axial adjustment is needed, therefore handling is easy, just place the insert in the pocket.

FIVE DIFFERENT GEOMETRIES



TWO DIFFERENT WIPERS



GRADES

MP1500	Grade for medium rough milling under stable conditions.
MP2500	First choice grade for milling steel.
MP3000	Highly wear resistant optimised grade for milling in steel.
T350M	Basic choice for difficult stainless steel.
F40M	Suitable for fine to medium rough milling. First choice for milling with small feeds and/or low cutting speeds.
MK1500	First choice grade for milling cast iron.
MK2000	Complementary grade for difficult operations
MK3000	Optimisation grade in soft to medium hard steel under stable conditions.

* More detailed information in Machining Navigator 2009