



## **DOUBLE OCTOMILL™**

**16 CUTTING EDGES, ONE IN USE AND 15 WAITING!**

**SECO** 



SECO

R220,48-C125-11-8S

# UNIQUE!



## POCKETS WITH HIGH SPEED STEEL (HSS) LOCATION PINS

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. It's also unique!

Why? Because on the innovative Double Octomill the inserts are positioned in the pockets by HSS pins. This makes indexing easy and secure. You simply can't go wrong because the insert is correctly located by the HSS pins. What's more, the HSS pins ensure an extremely long life for the pocket (65 HRC).

Whatever your industry or application, the easy-to-handle Double Octomill, with its 16 cutting edges and positive insert geometry, can make a unique contribution to milling performance. Choose Double Octomill.

**BOOST YOUR PRODUCTIVITY AND CUT YOUR OPERATING COSTS.**

# SAVING YOU TIME AND MONEY

## **SAME TOOL FOR ROUGHING AND FINISHING**

A new insert design with a large wiper flat (2 mm) combined with best accuracy which results in best axial run-out makes Double Octomill an efficient cutter for both roughing and finishing. Cutting production time and saving you money.

## **CUTTER BODY GIVES LONG TOOL LIFE**

The Double Octomill's coated, pre-hardened body ensures long tool life. The hard coating (HV 700) does more than just reflect the high quality of the tool!

It also protects the tool from wear and prevents chips from welding on to the cutter body.

## **HIGH PERFORMANCE INSERT**

With Double Octomill, direct-pressed inserts with ground location grooves for best tolerances are available in high performance grades to suit every material.

This contributes to long tool life and high productivity since high cutting speeds can be used. The thickness of the inserts ensures high strength and process security with low risk of edge breakage.

All 16 cutting edges are numbered to make the indexing of cutting edges as easy as possible for you.

## **FIVE DIFFERENT GEOMETRIES**

M15, M13, MD17 = 2,11 mm wiper flat  
M14, MD16 = 0,45 mm wiper flat

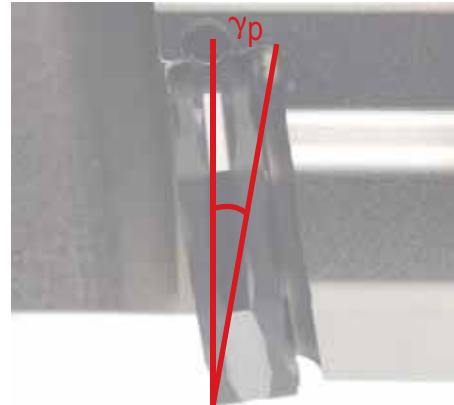


### LESS POWER CONSUMPTION

Although the cutting rake geometry is negative in the cutter, the effective cutting rake is positive due to a positive cutting rake on the inserts, including the M14, M15 and the new M13 for steel and other materials. The new M13 geometry is only intended for centre lock cutters in normal and normal+.

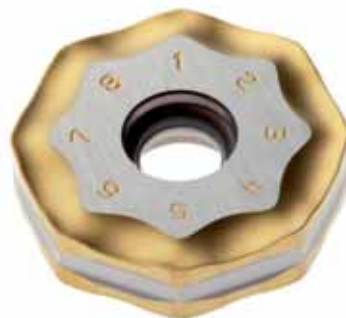
The positive cutting rake on the inserts is another factor allowing high cutting speeds to be used, thus increasing productivity.

For long term use, the depth of cut is 6 mm but for shorter periods, such as when machining components with irregular surfaces, a larger depth of cut can be chosen ( $a_p = 15$  mm).



### FEWER SPARE PARTS, EASY HANDLING

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



### THREE DIFFERENT PITCHES

Tools in the Double Octomill range are divided into three different pitches:

Normal, normal+, and close pitch, providing optimum productivity for different machines and materials. For example, if the machine has high power capability, choose the close pitch cutter. If the machine has limited power capability, choose normal or normal+.

On the normal and normal+ versions, the insert is locked in place by a centre lock mounting, with a strong screw. The close pitch version has wedge mounting using a new, stronger and self-orientating wedge. Both insert locking solutions gives you easy handling and maximum security during the cutting process.



### DURATOMIC™ FOR MAXIMUM PRODUCTIVITY

Duratomic is our latest insert coating technology and allows us to design grades for optimal performance in all areas of metal cutting.

Duratomic offers a new level of toughness and wear resistance in the same grade, with more versatile grades and a greater flexibility in cutting data. This gives you higher speeds, longer and more predictable tool life, a wider machining window and dramatically increased productivity.



### **UNBEATABLY LOW COST PER EDGE**

The new generation Double Octomill face milling cutter is an excellent choice for general applications in cast iron, steel and stainless steel in a wide range of industries, such as General Engineering, Automotive, Trucks and others. With 16 cutting edges it offers unmatched economy in terms of edge cost per insert.

This, in turn, gives lower component cost.



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