

MILL TO THE MAX WITH SECO HIGH FEED SP

YOUR CHALLENGE

Milling challenging materials like tough steels, stainless steels, superalloys and titanium cause built-up or notched edges and broken inserts that increase tooling costs and cause unexpected downtime.

OUR SOLUTION

The High Feed SP easily cuts ISO P, M and S materials to increase material removal rates and extend tool life.

YOUR CHALLENGE

Inexperienced operators index inserts incorrectly, which leads to unexpected machine downtime and scrapped parts.

OUR SOLUTION

The High Feed SP is robust and easy to index.

YOUR CHALLENGE

Optimized milling performance requires switching among numerous tools to implement various machining strategies and part materials.

OUR SOLUTION

One High Feed SP tool handles a complete range of high feed milling operations and materials.



CUSTOMER BENEFITS

- Lower cost per part
- Increased production
- Maximum machine usage
- Less unexpected downtime
- Tooling versatility reduces production costs and saves time
- High Feed strategy provides maximized machine performance

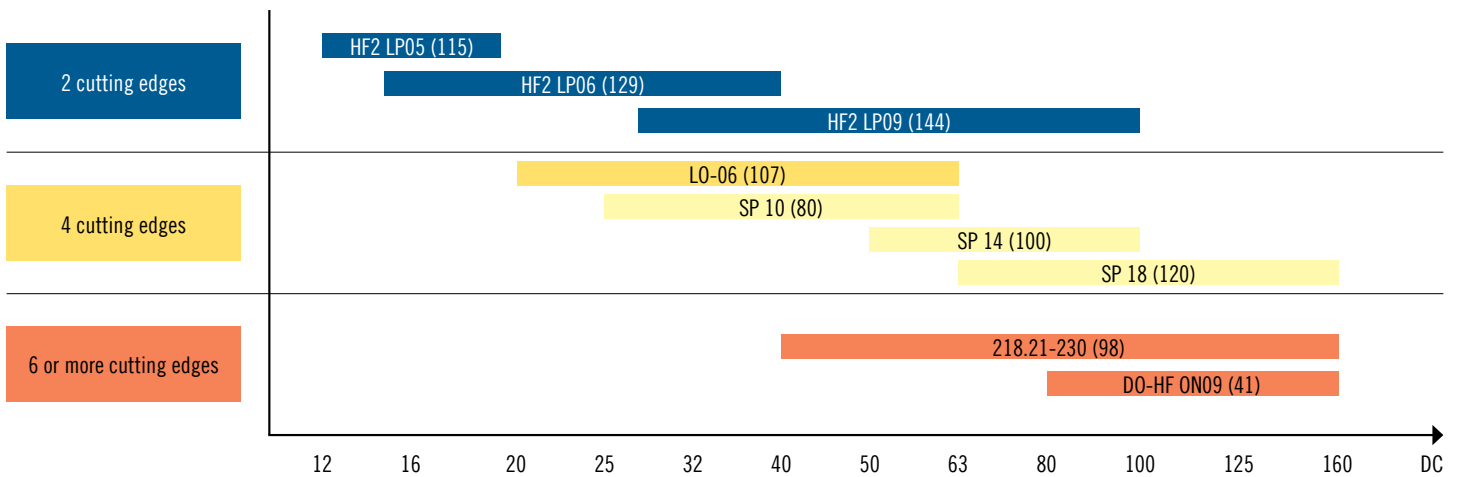


SECO HIGH FEED SP

GET THE TOOL THAT MILLS IT ALL

For challenging ISO P, M and S materials, the Seco High Feed SP features a combination of dedicated cutting geometries and insert grades, as well as optimized lead angles, that combine to boost material removal rates, maximize chip evacuation and extend tool life. Packed with versatility, one High Feed SP tool optimizes copy milling, ramping, pocketing, face milling and plunging operations to reduce tooling inventory further. Designed for ease of use, the milling tools provide simple foolproof insert indexing that prevents operator mistakes, unexpected machine downtime and scrapped parts.

POSITIONING HIGH FEED CUTTERS



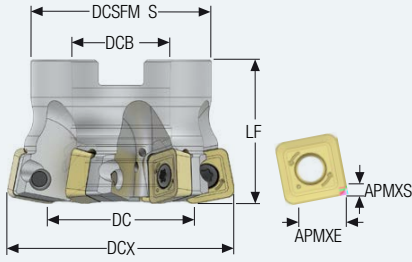
Cost per edge index (xx) based on SP14, F40M Price list 2022

INSERT RANGE OVERVIEW

DESIGNATION	IC IN MM	AN IN MM	RE IN MM	S IN MM	CUTTING RAKE IN °	GRADES															
						COATED													UNCOATED		
						MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MW2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M
SPKT10T317TN-M10	10,0	11,0	1,7	3,97	13,0 °	■	■	■			■	■	■	■		■					■
SPKT10T317TN-MD12	10,0	11,0	1,7	3,97	5,0 °	■		■	■						■						■
SPKT140523TN-M14	14,0	11,0	2,3	5,56	13,0 °		■	■			■	■	■		■						■
SPKT140523TN-MD16	14,0	11,0	2,3	5,56	5,0 °	■	■	■	■						■						■
SPKT180630TN-M14	18,0	11,0	3,0	6,35	12,0 °	■	■	■							■						■
SPKT180630TN-MD16	18,0	11,0	3,0	6,35	5,0 °	■		■	■						■						■

Please note, that the shown data are just an extract. More products available.
For more information please visit www.secotools.com.





SECO HIGH FEED SP

METRIC/INCH CUTTERS RANGE – HIGH FEED SP SIZE 10

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC IN MM	DCX IN MM	ZFP	APMXS IN MM	APMXE IN MM	DCB IN MM	DCSFMS IN MM	LF IN MM	RP IN MM	RMPX°	CMIN IN MM	CMAX IN MM	RPMX	CUTINT_MASTER
R220.21-0050-SP10.5A	10097563	Arbor	33.7	50.0	5	1.1	7.0	22.0	41.0	40.0	2.8	1.9	83.7	98.0	17300	SPKT10T317
R220.21-0050-SP10.6A	10097564	Arbor	33.7	50.0	6	1.1	7.0	22.0	41.0	40.0	2.8	1.9	83.7	98.0	17300	SPKT10T317
R220.21-0052-SP10.5A	10097565	Arbor	35.7	52.0	5	1.1	7.0	22.0	49.0	40.0	2.8	1.8	87.7	102.0	17000	SPKT10T317
R220.21-0052-SP10.6A	10097566	Arbor	35.7	52.0	6	1.1	7.0	22.0	49.0	40.0	2.8	1.8	87.7	102.0	17000	SPKT10T317
R220.21-0063-SP10.6A	10097567	Arbor	46.7	63.0	6	1.1	7.0	22.0	49.0	40.0	2.8	1.3	109.7	124.0	15800	SPKT10T317
R220.21-0063-SP10.7A	10097568	Arbor	46.7	63.0	7	1.1	7.0	22.0	49.0	40.0	2.8	1.3	109.7	124.0	15800	SPKT10T317

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC IN MM	DCX IN MM	ZFP	APMXS IN MM	APMXE IN MM	DCB IN MM	DCSFMS IN MM	LF IN MM	RP IN MM	RMPX°	CMIN IN MM	CMAX IN MM	RPMX	CUTINT_MASTER
R220.21-02.00-SP10.5A	10128666	Arbor	34.5	50.8	5	1.1	7.0	19.05	45.45	38.1	2.8	1.9	85.3	99.6	17300	SPKT10T317
R220.21-02.00-SP10.6A	10097573	Arbor	34.5	50.8	6	1.1	7.0	19.05	45.45	38.1	2.8	1.9	85.3	99.6	17300	SPKT10T317
R220.21-02.50-SP10.6A	10128667	Arbor	47.2	63.5	6	1.1	7.0	19.05	45.45	38.1	2.8	1.3	110.7	125.0	15800	SPKT10T317
R220.21-02.50-SP10.7A	10097574	Arbor	47.2	63.5	7	1.1	7.0	19.05	45.45	38.1	2.8	1.3	110.7	125.0	15800	SPKT10T317

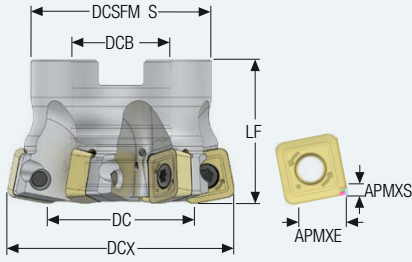
HIGH FEED SP SIZE 14

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC IN MM	DCX IN MM	ZFP	APMXS IN MM	APMXE IN MM	DCB IN MM	DCSFMS IN MM	LF IN MM	RP IN MM	RMPX°	CMIN IN MM	CMAX IN MM	RPMX	CUTINT_MASTER
R220.21-0050-SP14.4A	10068147	Arbor	27.1	50.0	4	1.8	10.0	22.0	41.0	40.0	4.02	3.5	77.1	98.0	10700	SPKT140523
R220.21-0050-SP14.5A	10068148	Arbor	27.1	50.0	5	1.8	10.0	22.0	41.0	40.0	4.04	1.8	77.1	98.0	10700	SPKT140523
R220.21-0052-SP14.4A	10068149	Arbor	29.1	52.0	4	1.8	10.0	22.0	49.0	40.0	4.02	3.2	81.1	102.0	10500	SPKT140523
R220.21-0052-SP14.5A	10101535	Arbor	29.1	52.0	5	1.8	10.0	22.0	49.0	40.0	4.02	3.2	81.1	102.0	10500	SPKT140523
R220.21-0063-SP14.5A	10068150	Arbor	40.1	63.0	5	1.8	10.0	27.0	49.0	50.0	4.01	2.3	103.1	124.0	9600	SPKT140523
R220.21-0063-SP14.6A	10068151	Arbor	40.1	63.0	6	1.8	10.0	27.0	49.0	50.0	4.01	2.3	103.1	124.0	9600	SPKT140523
R220.21-0066-SP14.5A	10068152	Arbor	43.0	66.0	5	1.8	10.0	27.0	61.0	50.0	4.02	2.1	109.0	130.0	9400	SPKT140523
R220.21-0066-SP14.6A	10101540	Arbor	43.0	66.0	6	1.8	10.0	27.0	61.0	50.0	4.02	2.1	109.0	130.0	9400	SPKT140523
R220.21-0080-SP14.6A	10068154	Arbor	57.0	80.0	6	1.8	10.0	27.0	61.0	50.0	4.01	1.6	137.0	158.0	8500	SPKT140523
R220.21-0080-SP14.7A	10068155	Arbor	57.0	80.0	7	1.8	10.0	27.0	61.0	50.0	4.01	1.6	137.0	158.0	8500	SPKT140523
R220.21-0084-SP14.6A	10068156	Arbor	61.0	84.0	6	1.8	10.0	32.0	79.0	50.0	4.01	1.5	145.0	166.0	8300	SPKT140523
R220.21-0100-SP14.8A	10068157	Arbor	77.0	100.0	8	1.8	10.0	32.0	79.0	50.0	4.01	1.2	177.0	198.0	7600	SPKT140523
R220.21-0125-SP14.9A	10132522	Arbor	102.0	125.0	9	1.8	10.0	40.0	90.0	63.0	4.0	0.9	227.0	248.0	6800	SPKT140523

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC IN MM	DCX IN MM	ZFP	APMXS IN MM	APMXE IN MM	DCB IN MM	DCSFMS IN MM	LF IN MM	RP IN MM	RMPX°	CMIN IN MM	CMAX IN MM	RPMX	CUTINT_MASTER
R220.21-02.00-SP14.4A	10068158	Arbor	27.9	50.8	4	1.8	10.0	19.05	45.45	38.1	4.01	3.3	78.7	99.6	10700	SPKT140523
R220.21-02.00-SP14.5A	10068159	Arbor	27.9	50.8	5	1.8	10.0	19.05	45.45	38.1	4.01	3.3	78.7	99.6	10700	SPKT140523
R220.21-02.50-SP14.5A	10068160	Arbor	40.5	63.5	5	1.8	10.0	19.05	45.45	38.1	4.02	2.2	104.0	125.0	9600	SPKT140523
R220.21-02.50-SP14.6A	10068161	Arbor	40.5	63.5	6	1.8	10.0	19.05	45.45	38.1	4.02	2.2	104.0	125.0	9600	SPKT140523
R220.21-03.00-SP14.6A	10068162	Arbor	53.2	76.2	6	1.8	10.0	25.4	58.15	50.8	4.02	1.7	116.4	150.4	8500	SPKT140523
R220.21-03.00-SP14.7A	10068163	Arbor	53.2	76.2	7	1.8	10.0	25.4	58.15	50.8	4.02	1.7	116.4	150.4	8500	SPKT140523
R220.21-04.00-SP14.8A	10068164	Arbor	78.6	101.6	8	1.8	10.0	38.1	89.9	50.8	4.01	1.2	180.2	201.2	7600	SPKT140523

Please note, that the shown data are just an extract. More products available.
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SECO HIGH FEED SP

HIGH FEED SP SIZE 18

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC IN MM	DCX IN MM	ZEFP	APMXS IN MM	APMXE IN MM	DCB IN MM	DCSFMS IN MM	LF IN MM	RP IN MM	RMPX°	CMIN IN MM	CMAX IN MM	RPMX	CUTINT_MASTER
R220.21-0063-SP18.5A	10097579	Arbor	33.7	63.0	5	2.5	14.0	22.0	49.0	50.0	5.41	2.4	96.7	124.0	5800	SPKT180630
R220.21-0066-SP18.5A	10097580	Arbor	36.7	66.0	5	2.5	14.0	27.0	61.0	55.0	5.4	3.4	102.7	130.0	5700	SPKT180630
R220.21-0080-SP18.5A	10097581	Arbor	50.7	80.0	5	2.5	14.0	27.0	61.0	50.0	5.4	2.4	130.7	158.0	5100	SPKT180630
R220.21-0080-SP18.6A	10097582	Arbor	50.7	80.0	6	2.5	14.0	27.0	61.0	50.0	5.4	2.4	130.7	158.0	5100	SPKT180630
R220.21-0100-SP18.7A	10097583	Arbor	70.7	100.0	7	2.5	14.0	32.0	79.0	50.0	5.39	1.7	170.7	198.0	4500	SPKT180630
R220.21-0125-SP18.8A	10097584	Arbor	95.6	125.0	8	2.5	14.0	40.0	90.0	63.0	5.39	1.2	220.6	248.0	4000	SPKT180630
R220.21-8160-SP18.10A	10097585	Arbor	130.6	160.0	10	2.5	14.0	40.0	90.0	63.0	5.39	0.9	290.6	318.0	3600	SPKT180630

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC IN MM	DCX IN MM	ZEFP	APMXS IN MM	APMXE IN MM	DCB IN MM	DCSFMS IN MM	LF IN MM	RP IN MM	RMPX°	CMIN IN MM	CMAX IN MM	RPMX	CUTINT_MASTER
R220.21-02.50-SP18.5A	10097586	Arbor	34.2	63.5	5	2.5	14.0	19.05	45.45	50.8	5.41	3.7	97.7	125.0	5800	SPKT180630
R220.21-03.00-SP18.5A	10128670	Arbor	46.9	76.2	5	2.5	14.0	25.4	58.15	50.8	5.4	2.6	123.1	150.4	5100	SPKT180630
R220.21-03.00-SP18.6A	10097587	Arbor	46.9	76.2	6	2.5	14.0	25.4	58.15	50.8	5.4	2.6	123.1	150.4	5100	SPKT180630
R220.21-04.00-SP18.7A	10097588	Arbor	72.3	101.6	7	2.5	14.0	38.1	89.9	50.8	5.39	1.7	173.9	201.2	4500	SPKT180630
R220.21-05.00-SP18.8A	10097589	Arbor	97.6	127.0	8	2.5	14.0	38.1	89.9	63.5	5.39	1.2	224.6	252.0	4000	SPKT180630
R220.21-06.00-SP18.10A	10097590	Arbor	123.0	152.4	10	2.5	14.0	50.8	124.7	63.5	5.39	1.0	275.4	302.8	3700	SPKT180630

METRIC/INCH CUTTERS RANGE – HIGH FEED SP SIZE 10/14

DESIGNATION	ITEM NUMBER	SHANKTYPE	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX	CMIN	CMAX	RPMX	CUTINT_MASTER
R217.21-01.25.16RE-SP10.3A	10097569	Combimaster	15.4	31.75	3	1.1	7.0	M16	30.0	35.0	2.83	5.6	47.15	61.5	21600	SPKT10T317
R217.21-01.50.20RE-SP10.4A	10097571	Combimaster	21.8	38.1	4	1.1	7.0	M20	36.5	40.0	2.79	3.0	59.9	74.2	19300	SPKT10T317
R217.21-1632.RE-SP10.3A	10097555	Combimaster	15.7	32.0	3	1.1	7.0	M16	30.0	35.0	2.83	4.3	47.7	62.0	21600	SPKT10T317
R217.21-1635.RE-SP10.3A	10097557	Combimaster	18.7	35.0	3	1.1	7.0	M16	30.0	35.0	2.8	3.5	53.7	68.0	20700	SPKT10T317
R217.21-1635.RE-SP10.4A	10097558	Combimaster	18.7	35.0	4	1.1	7.0	M16	30.0	35.0	2.8	3.5	53.7	68.0	20700	SPKT10T317
R217.21-2040.RE-SP10.4A	10097559	Combimaster	23.7	40.0	4	1.1	7.0	M20	36.5	40.0	2.79	2.7	63.7	78.0	19300	SPKT10T317
R217.21-2040.RE-SP10.5A	10097560	Combimaster	23.7	40.0	5	1.1	7.0	M20	36.5	40.0	2.79	2.7	63.7	78.0	19300	SPKT10T317
R217.21-2042.RE-SP10.4A	10097561	Combimaster	25.7	42.0	4	1.1	7.0	M20	36.5	40.0	2.8	2.5	67.7	82.0	18800	SPKT10T317
R217.21-2042.RE-SP10.5A	10097562	Combimaster	25.7	42.0	5	1.1	7.0	M20	36.5	40.0	2.8	2.5	67.7	82.0	18800	SPKT10T317
R217.21-2040.RE-SP14.3A	10135958	Combimaster	17.0	40.0	3	1.8	10.0	M20	36.5	45.0	4.06	2.9	57.0	78.0	11900	SPKT140523