

Increasing productivity in unstable setups is achieved through light cutting and well-balanced forces

Superior surface finish is secured by high run out accuracy and precise wiper alignment thanks to the self centering inserts

Higher process security with easy, fast and secure handling of the single-sided inserts

Specially designed pockets can handle 3 different insert types

## Octomill™ 06 face milling cutter

From roughing to finishing in every material

# More than just a face mill.

## One pocket. Three insert types.

The Octomill™06 multi-insert pocket design can handle three different insert types to meet different application demands: face milling, moderate high feed milling and round inserts for profiling.

## Outperforming existing octagonal systems

Octomill™06 keeps the strength of common facemill systems with eight cutting edges but also adds edge strength and robustness while overcoming the weaknesses of single-sided solutions.

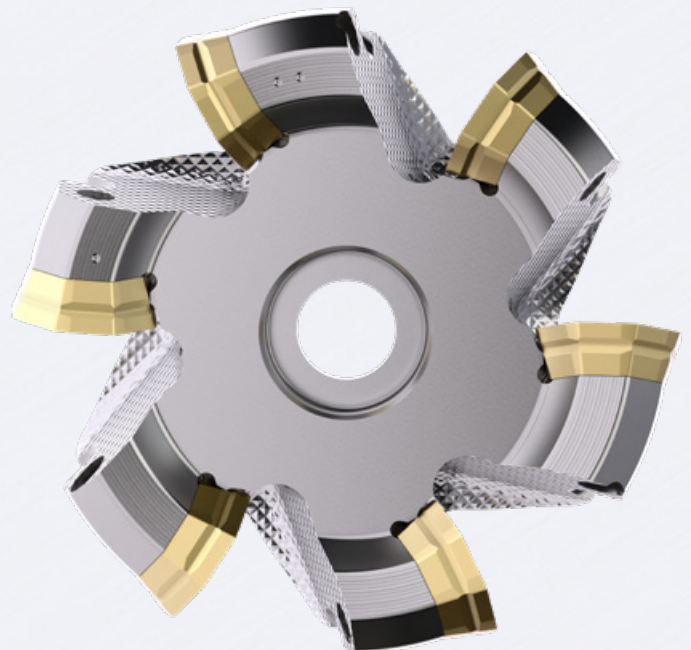
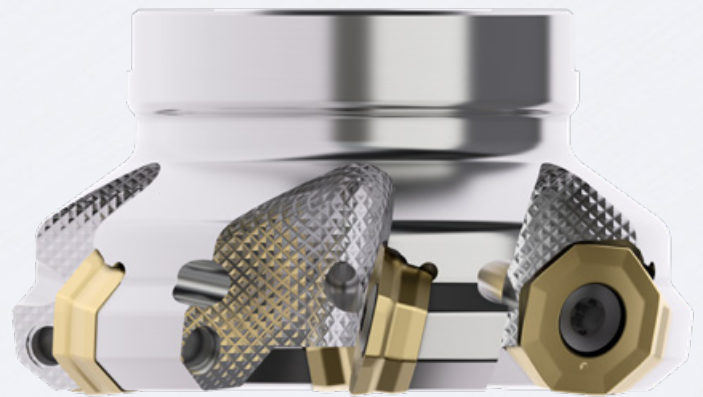
The chip formation is comparable to Quattromill™. The spiral chip shape is beneficial for close pitch cutters especially in long-chipping materials, such as stainless steel, superalloys, non-ferrous materials or low-alloyed steel.

## Easy and secure handling

The interface design mimics the characteristic of a double-sided insert. This leads to improved self-centering and secure positioning of the insert for enhanced run-out accuracy as well as edge-to-edge repeatability. Plus, you can index the insert directly in the pocket seat without having to remove the screw.

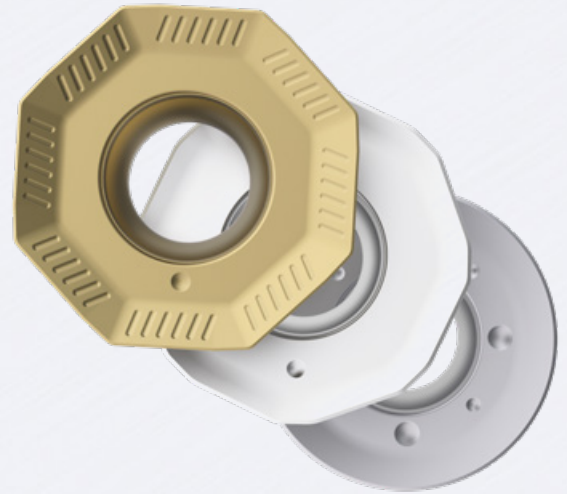
## Utilization of more cutting edges

The groove interface works as a defined limitation or breakage point when over-running the insert and avoids damaging the pocket seat.



# Technical specifications

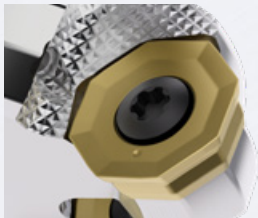
- Cutter range:** 40-250 mm (2.00 - 8.00 inch)
- Multi-insert range:** OO.T0605 face milling inserts  
OOMT0605-MHF moderate high feed  
ROMT1605 round 16 insert
- Wiper inserts:** 2 wiper inserts for higher demands in surface finish or finishing performance OOET0605ZZER-W8-M10 and OOET0605ZZSR-W4-M15.
- Insert grades for:** P M K S N H
- Mounting type:** Weldon & Arbor.



## Octomill™ 06: Working areas

The multi-insert pocket design of Seco Octomill™06 enables one cutter body to achieve excellent results in a variety of applications, including face milling, ramping, helical interpolation and profiling.

### Face Milling Inserts



OO.T0605ZZ.R (integrated wiper)  
OO.T060510TN (pure radii)  
KAPR = 40°  
APMX = 4,0 mm  
Wiper = 1,5 / 0 mm

### Moderate High Feed Insert

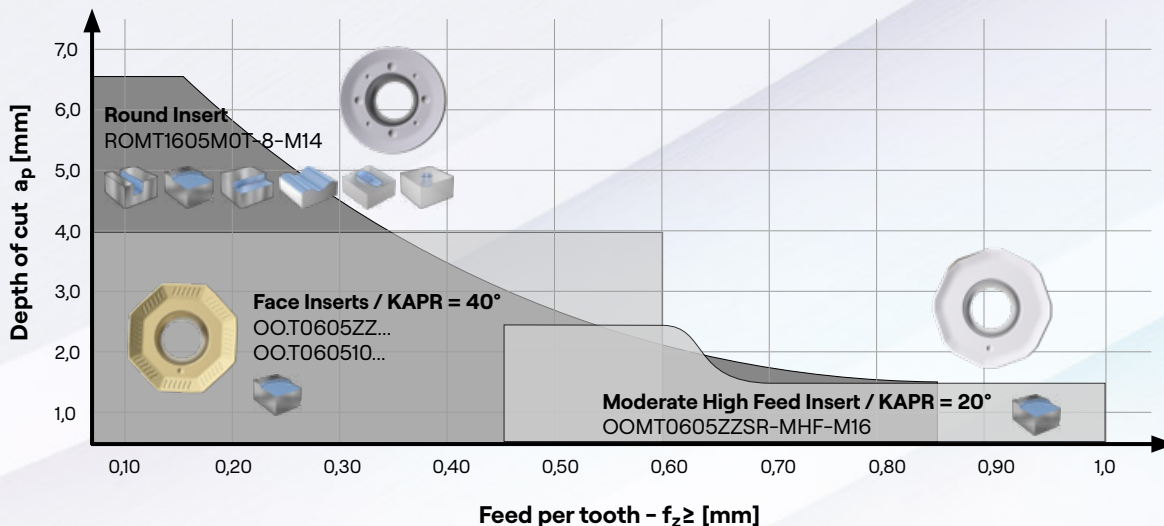


OOMT0605ZZSR-MHF-M16  
KAPR = 20°  
APMX = 1,5 mm  
Wiper = 1,2 mm

### Round 16 Insert



ROMT1605M0T-8-M14  
APMX = 2,2 mm (CEDC=8)  
APMX = 7,5 mm (CEDC=4)

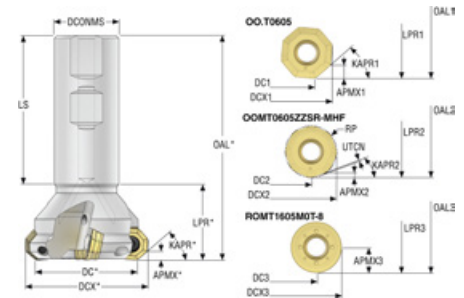


# Octomill™ 06

Octomill™ size 06 is a new generation and evolution of Seco's Octomill™ size 05 and 07 based on a OF-style design. The new generation of Octomill™ 06 tackles the major challenge of single-sided inserts, which is an easy and secured instert handling. Explore the favorable single-sided characteristics as cutting behavior together with a comparable handling of a double-sided solution.



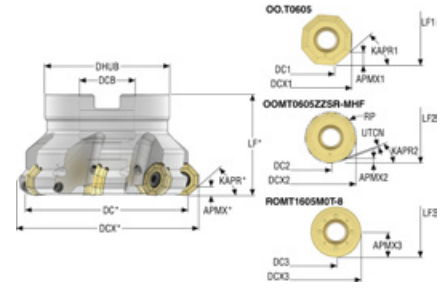
## Product program



### R217.43-06 - Metric range

Designation	Item number	Type of mounting	DC1	DC2	DC3	ZEFP	APMX1	APMX2	APMX3	KAPR1°	KAPR2°	LPR1	LPR2	LPR3
			mm	mm	mm		mm	mm	mm	mm	mm	mm	mm	mm
R217.43-3240.3-06-03SA	10260220	Weldon	40,0	36,0	34,5	3	4,0	1,5	7,5	40,0	20,0	50,0	50,15	50,0
R217.43-3250.3-06-04SA	10260221	Weldon	50,0	46,0	44,5	4	4,0	1,5	7,5	40,0	20,0	50,0	50,15	50,0

Designation	Item number	Type of mounting	DCX1	DCX2	DCX3	DCONMS	OAL1	OAL2	OAL3	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kg	
R217.43-3240.3-06-03SA	10260220	Weldon	50,4	50,7	50,35	32,0	110,0	110,15	110,0	71,4	96,8	13200	0,7	OO.T0605 / ROMT1605
R217.43-3250.3-06-04SA	10260221	Weldon	60,4	60,7	60,35	32,0	110,0	110,15	110,0	91,4	116,8	11500	0,9	OO.T0605 / ROMT1605

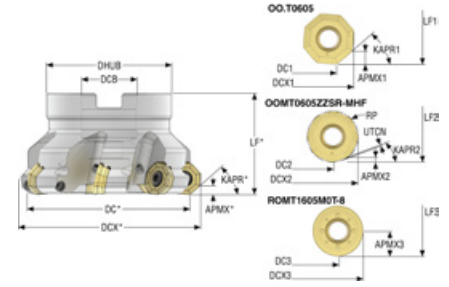


## R220.43-06 – Metric range

Designation	Item number	Type of mounting	DC1	DC2	DC3	ZEFP	APMX1	APMX2	APMX3	KAPR1°	KAPR2°	DCB	DHUB	LF1	LF2	LF3
			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
R220.43-0050-06-05SA	10260222	Arbor	50,0	46,0	44,5	5	4,0	1,5	7,5	40,0	20,0	22,0	47,0	40,0	40,15	40,0
R220.43-0063-06-04SA	10260223	Arbor	63,0	59,0	57,5	4	4,0	1,5	7,5	40,0	20,0	22,0	47,0	40,0	40,15	40,0
R220.43-0063-06-05SA	10260224	Arbor	63,0	59,0	57,5	5	4,0	1,5	7,5	40,0	20,0	22,0	47,0	40,0	40,15	40,0
R220.43-0063-06-06SA	10260225	Arbor	63,0	59,0	57,5	6	4,0	1,5	7,5	40,0	20,0	22,0	47,0	40,0	40,15	40,0
R220.43-0080-06-05SA	10260226	Arbor	80,0	76,0	74,5	5	4,0	1,5	7,5	40,0	20,0	27,0	62,0	50,0	50,15	50,0
R220.43-0080-06-07SA	10260227	Arbor	80,0	76,0	74,5	7	4,0	1,5	7,5	40,0	20,0	27,0	62,0	50,0	50,15	50,0
R220.43-0080-06-08SA	10260228	Arbor	80,0	76,0	74,5	8	4,0	1,5	7,5	40,0	20,0	27,0	62,0	50,0	50,15	50,0
R220.43-0100-06-06SA	10260229	Arbor	100,0	96,0	94,5	6	4,0	1,5	7,5	40,0	20,0	32,0	77,0	50,0	50,15	50,0
R220.43-0100-06-08SA	10260230	Arbor	100,0	96,0	94,5	8	4,0	1,5	7,5	40,0	20,0	32,0	77,0	50,0	50,15	50,0
R220.43-0100-06-10SA	10260231	Arbor	100,0	96,0	94,5	10	4,0	1,5	7,5	40,0	20,0	32,0	77,0	50,0	50,15	50,0
R220.43-0125-06-07SA	10260232	Arbor	125,0	121,0	119,5	7	4,0	1,5	7,5	40,0	20,0	40,0	90,0	63,0	63,15	63,0
R220.43-0125-06-10SA	10260233	Arbor	125,0	121,0	119,5	10	4,0	1,5	7,5	40,0	20,0	40,0	90,0	63,0	63,15	63,0
R220.43-0125-06-12SA	10260234	Arbor	125,0	121,0	119,5	12	4,0	1,5	7,5	40,0	20,0	40,0	90,0	63,0	63,15	63,0
R220.43-8160-06-08SA	10260235	Arbor	160,0	156,0	154,5	8	4,0	1,5	7,5	40,0	20,0	40,0	130,0	63,0	63,15	63,0
R220.43-8160-06-12SA	10260236	Arbor	160,0	156,0	154,5	12	4,0	1,5	7,5	40,0	20,0	40,0	130,0	63,0	63,15	63,0
R220.43-8200-06-12SA	10260236	Arbor	200,0	196,0	194,5	12	4,0	1,5	7,5	40,0	20,0	60,0	170,0	63,0	63,15	63,0
R220.43-8250-06-14SA	10260238	Arbor	250,0	246,0	224,5	14	4,0	1,5	7,5	40,0	20,0	60,0	200,0	63,0	63,15	63,0

## R220.43-06 – Metric range

Designation	Item number	Type of mounting	DCX1	DCX2	DCX3	DBC1	DCONMS	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm	mm	mm	mm	mm	mm	mm	kg	
R220.43-0050-06-05SA	10260222	Arbor	60,4	60,7	60,35	–	22,0	91,4	116,8	11300	0,5	OO.T0605 / ROMT1605
R220.43-0063-06-04SA	10260223	Arbor	73,4	73,7	73,35	–	22,0	117,4	142,8	10100	0,6	OO.T0605 / ROMT1605
R220.43-0063-06-05SA	10260224	Arbor	73,4	73,7	73,35	–	22,0	117,4	142,8	10100	0,6	OO.T0605 / ROMT1605
R220.43-0063-06-06SA	10260225	Arbor	73,4	73,7	73,35	–	22,0	117,4	142,8	10100	0,5	OO.T0605 / ROMT1605
R220.43-0080-06-05SA	10260226	Arbor	90,4	90,7	90,35	–	27,0	151,4	176,8	8900	1,3	OO.T0605 / ROMT1605
R220.43-0080-06-07SA	10260227	Arbor	90,4	90,7	90,35	–	27,0	151,4	176,8	8900	1,3	OO.T0605 / ROMT1605
R220.43-0080-06-08SA	10260228	Arbor	90,4	90,7	90,35	–	27,0	151,4	176,8	8900	1,0	OO.T0605 / ROMT1605
R220.43-0100-06-06SA	10260229	Arbor	110,4	110,7	110,35	–	32,0	191,4	216,8	8000	1,9	OO.T0605 / ROMT1605
R220.43-0100-06-08SA	10260230	Arbor	110,4	110,7	110,35	–	32,0	191,4	216,8	8000	1,8	OO.T0605 / ROMT1605
R220.43-0100-06-10SA	10260231	Arbor	110,4	110,7	110,35	–	32,0	191,4	216,8	8000	2,0	OO.T0605 / ROMT1605
R220.43-0125-06-07SA	10260232	Arbor	135,4	135,7	135,35	–	40,0	241,4	266,8	7100	3,0	OO.T0605 / ROMT1605
R220.43-0125-06-10SA	10260233	Arbor	135,4	135,7	135,35	–	40,0	241,4	266,8	7100	3,8	OO.T0605 / ROMT1605
R220.43-0125-06-12SA	10260234	Arbor	135,4	135,7	135,35	–	40,0	241,4	266,8	7100	3,8	OO.T0605 / ROMT1605
R220.43-8160-06-08SA	10260235	Arbor	170,4	170,7	170,35	66,7	40,0	311,4	336,8	6300	5,3	OO.T0605 / ROMT1605
R220.43-8160-06-12SA	10260236	Arbor	170,4	170,7	170,35	66,7	40,0	311,4	336,8	6300	5,6	OO.T0605 / ROMT1605
R220.43-8200-06-12SA	10260236	Arbor	210,4	210,7	210,35	101,6	60,0	391,4	416,8	5600	9,0	OO.T0605 / ROMT1605
R220.43-8250-06-14SA	10260238	Arbor	260,4	260,7	260,35	101,6	60,0	491,4	516,8	5000	16,4	OO.T0605 / ROMT1605

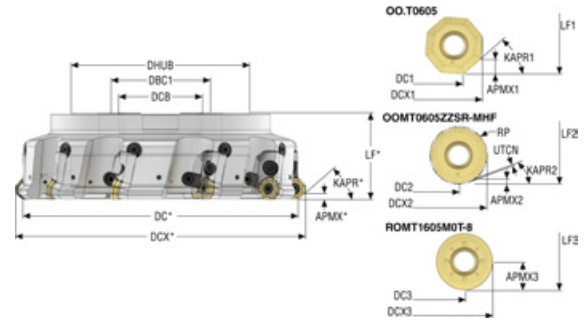
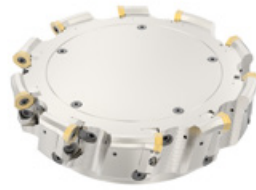


## R220.43-06 – Inch range

Designation	Item number	Type of mounting	DC1	DC2	DC3	ZEP	APMX1	APMX2	APMX3	KAPR1°	KAPR2°	DCB	DCB2	DHUB	LF1	LF2	LF3
			inch	inch	inch		inch	inch	inch							inch	inch
R220.43-02.00-06-05SA	10260239	Arbor	2.000	1.843	1.783	5	0.157	0.059	0.295	40,0	20,0	0.750	–	1.850	1.575	1.581	1.575
R220.43-02.50-06-05SA	10260240	Arbor	2.500	2.343	2.283	5	0.157	0.059	0.295	40,0	20,0	0.750	–	1.850	1.575	1.581	1.575
R220.43-02.50-06-06SA	10260241	Arbor	2.500	2.343	2.283	6	0.157	0.059	0.295	40,0	20,0	0.750	–	1.850	1.575	1.581	1.575
R220.43-03.00-06-05SA	10260242	Arbor	3.000	2.843	2.783	5	0.157	0.059	0.295	40,0	20,0	1.000	–	2.441	1.969	1.974	1.969
R220.43-03.00-06-07SA	10260243	Arbor	3.000	2.843	2.783	7	0.157	0.059	0.295	40,0	20,0	1.000	–	2.441	1.969	1.974	1.969
R220.43-04.00-06-06SA	10260244	Arbor	4.000	3.843	3.783	6	0.157	0.059	0.295	40,0	20,0	1.500	–	3.031	1.969	1.974	1.969
R220.43-04.00-06-08SA	10260245	Arbor	4.000	3.846	3.783	8	0.157	0.059	0.295	40,0	20,0	1.500	–	3.031	1.969	1.974	1.969
R220.43-05.00-06-07SA	10260246	Arbor	5.000	4.843	4.783	7	0.157	0.059	0.295	40,0	20,0	1.500	–	3.543	2.480	2.486	2.480
R220.43-05.00-06-10SA	10260247	Arbor	5.000	4.843	4.783	10	0.157	0.059	0.295	40,0	20,0	1.500	–	3.543	2.480	2.486	2.480
R220.43-06.00-06-12SA	10260248	Arbor	6.000	5.843	5.783	12	0.157	0.059	0.295	40,0	20,0	2.000	–	4.724	2.480	2.486	2.480
R220.43-808.00-06-12SA	10260249	Arbor	8.000	7.843	7.783	12	0.157	0.059	0.295	40,0	20,0	2.500	4.000	6.693	2.480	2.486	2.480

## R220.43-06 – Inch range

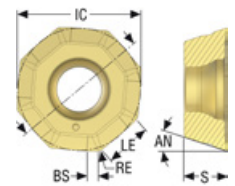
Designation	Item number	Type of mounting	DCX1	DCX2	DCX3	DBC1	DBC2	DCONMS	Cmin	Cmax	RPMX	Weight	Insert
			inch	inch	inch	inch	inch	inch	inch	inch	inch		
R220.43-02.00-06-05SA	10260239	Arbor	2.409	2.421	2.407	–	–	0.750	3.661	4.661	11300	1.100	OO.T0605 / ROMT1605
R220.43-02.50-06-05SA	10260240	Arbor	2.909	2.921	2.907	–	–	0.750	4.661	5.661	10100	1.540	OO.T0605 / ROMT1605
R220.43-02.50-06-06SA	10260241	Arbor	2.909	2.921	2.907	–	–	0.750	4.661	5.661	10100	1.540	OO.T0605 / ROMT1605
R220.43-03.00-06-05SA	10260242	Arbor	3.409	3.421	3.407	–	–	1.000	5.661	6.661	8900	2.650	OO.T0605 / ROMT1605
R220.43-03.00-06-07SA	10260243	Arbor	3.409	3.421	3.407	–	–	1.000	5.661	6.661	8900	2.430	OO.T0605 / ROMT1605
R220.43-04.00-06-06SA	10260244	Arbor	4.409	4.421	4.407	–	–	1.500	7.661	8.661	8000	4.190	OO.T0605 / ROMT1605
R220.43-04.00-06-08SA	10260245	Arbor	4.409	4.421	4.407	–	–	1.500	7.661	8.661	8000	4.190	OO.T0605 / ROMT1605
R220.43-05.00-06-07SA	10260246	Arbor	5.409	5.421	5.407	–	–	1.500	9.661	10.661	7100	11.020	OO.T0605 / ROMT1605
R220.43-05.00-06-10SA	10260247	Arbor	5.409	5.421	5.407	–	–	1.500	9.661	10.661	7100	8.600	OO.T0605 / ROMT1605
R220.43-06.00-06-12SA	10260248	Arbor	6.409	6.421	6.407	–	–	2.000	11.661	12.661	6500	10.140	OO.T0605 / ROMT1605
R220.43-808.00-06-12SA	10260249	Arbor	8.409	8.421	8.407	4.000	4.000	2.500	15.661	16.661	5900	22.050	OO.T0605 / ROMT1605



## R220.43-06 - Metric range

Designation	Item number	Type of mounting	DC1	DC2	DC3	ZEFP	APMX1	APMX2	APMX3	KAPR1°	KAPR2°	DCB	DHUB	LF1	LF2	LF3
			mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
R220.43-8200-06-10CSA	10260250	Arbor	200,0	196,0	194,5	10	4,0	1,5	7,5	40,0	20,0	60,0	160,0	63,0	63,15	63,0
R220.43-8250-06-12CSA	10260251	Arbor	250,0	246,0	244,5	12	4,0	1,5	7,5	40,0	20,0	60,0	200,0	63,0	63,15	63,0

Designation	Item number	Type of mounting	DCX1	DCX2	DCX3	DBC1	DCONMS	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm	mm	mm	mm	mm	mm	mm	kg	
R220.43-8200-06-10CSA	10260250	Arbor	210,4	210,7	210,35	101,6	60,0	391,4	416,8	1800	7,3	OO.T0605 / ROMT1605
R220.43-8250-06-12CSA	10260251	Arbor	260,4	260,7	260,35	101,6	60,0	491,4	516,8	1560	14,7	OO.T0605 / ROMT1605



## Insert program OOET/OOMT/OOEW06

Designation	RE mm / inch	BS mm / inch	GAN	PVD grades						CVD grades						Un coated grades	
				F15M	MK2050	MP3000	MS2050	F40M	MP2050	MK1500	MP1501	MP2501	MS2500	MP3501	H25		
OOET0605ZZFR-E08	0,6 0,024	1,5 0,059	20,0°														•
OOMT060510SN-ME12	1,0 0,039	-	15,0°				•										•
OOET0605ZZSR-ME12	0,6 0,024	1,5 0,059	15,0°				•	•	•	•				•	•	•	
OOMT060510EN-M10	1,0 0,039	-	10,0°					•		•							
OOET0605ZZER-M10	0,6 0,024	1,5 0,059	10,0°					•	•	•							•
OOET0605ZZER-W8-M10	1,0 0,039	2,5 0,098	10,0°				•	•									•
OOET0605ZZSR-W4-M15	0,9 0,035	4,9 0,19	5,0°		•			•	•					•	•		•
OOMT0605ZZSR-M15	0,6 0,024	1,5 0,059	10,0°		•			•	•		•	•	•				•
OOMT0605ZZSR-MHF-M16	2,0 0,079	1,3 0,051	6,0°					•						•			
OOMT060510SN-M20	1,0 0,039	-	12,0°		•						•	•	•				•
OOEW0605ZZSR-D20	0,6 0,024	1,5 0,059	0°	•													



For more information about Octomill™06, scan the QR-code or visit [www.secotools.com/milling/face-milling/octomill06](http://www.secotools.com/milling/face-milling/octomill06)



Seco® continuously supports more sustainable processes, that also generates a return for you as a customer. We recycle any carbide product, including bars and anvils, but no steel, ceramic or cermet.

For more information about how to become a recycling partner and our recycling program scan the QR-code or visit [www.secotools.com/recycling](http://www.secotools.com/recycling)



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