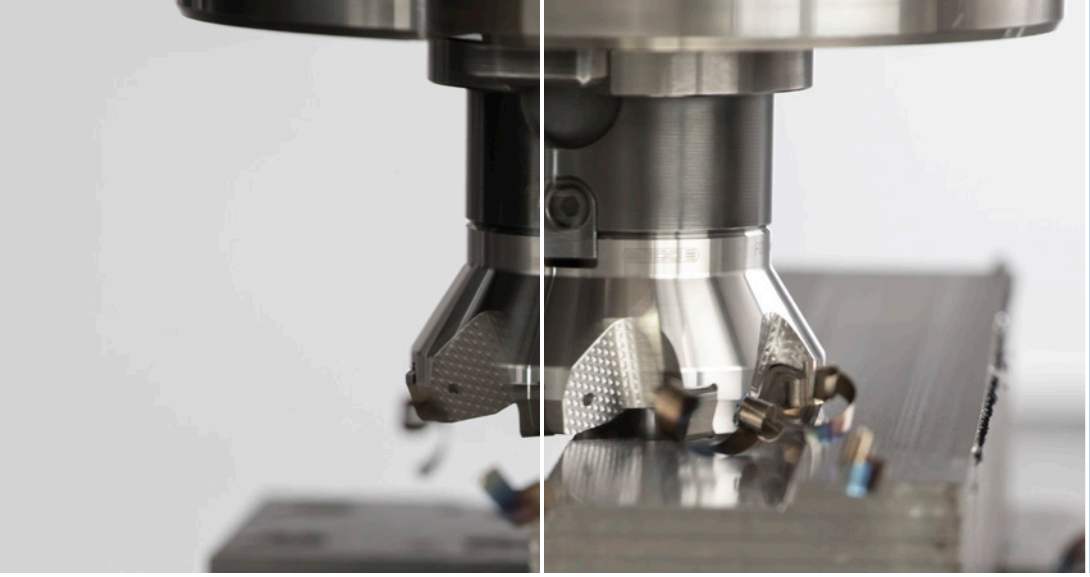


SECO DOUBLE QUATTROMILL™ 14 FACE MILL

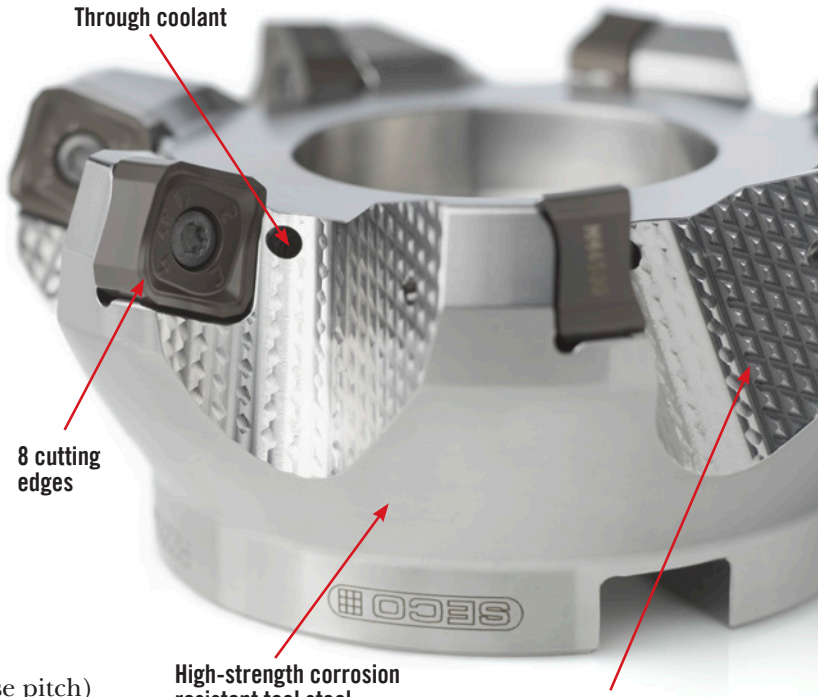
PRODUCT SUMMARY & RANGE

REDUCE CUTTING FORCES & INCREASE DEPTH OF CUT

DOUBLE QUATTROMILL 14

Maximize machine output and lower your cost per unit thanks to the double-sided, eight-edged inserts of the Double Quattromill 14 face milling cutter by Seco Tools. The specially developed and extremely free-cutting insert geometries actually lower cutting forces and require less machine power while also ensuring workpiece stability.

Significantly increase depth of cut for all roughing, semi-finishing and finishing operations with the two lead angle versions of the Double Quattromill 14 cutter. The 48° lead angle provides you with freer cutting and higher feed rates. Whereas, the 71° lead angle provides you with greater depth of cuts and more clearance for applications to avoid clamps and adjacent part features. The Double Quattromill works well in a variety of materials, including steels, cast iron, stainless steel, titanium and superalloys.



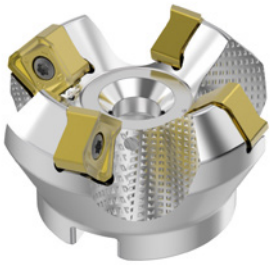
KEY BENEFITS

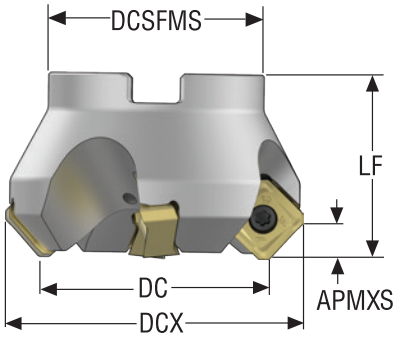
- Large d.o.c. capability
- Higher feed rates
- Lower radial cutting forces
- Better chip thinning
- Robust inserts stand up to sticky or unstable materials
- Better clearance
- Positive cutting rake
- Integrated wiper flat 0.059" (1.5 mm)

RANGE OVERVIEW

- **R220.54** - 48° lead angle, max d.o.c. 0.236" (6 mm), SNMX14-ANTR inserts
- **R220.56** - 71° lead angle, max d.o.c. 0.315" (8 mm), SNMX14-ZNTR inserts
- Fixed pocket (normal & close pitch) 2" - 8" (50 - 200 mm) dia.
- Cassettes 6" - 12.5" (160 - 315 mm) dia.
- ME10, M10 and M16 geometries

SECO





R220.54-14 - 48° LEAD ANGLE - METRIC

PRODUCT NUMBER	DESIGNATION	TYPE OF MOUNTING	DIMENSIONS IN MM						KAPRS°	ZNP	LBS	RPMX	INSERT
			APMXS	DCX	DC	DCSFMS	DCB	LF					
03213622	R220.54-0050-14-4A	Arbor	6,0	61,0	50,0	47,0	22,0	40,0	48,0	4	1,1	8500	SN..14..AN
03213629	R220.54-0050-14-5A	Arbor	6,0	61,0	50,0	47,0	22,0	40,0	48,0	5	0,9	8500	SN..14..AN
03213623	R220.54-0063-14-5A	Arbor	6,0	74,0	63,0	47,0	22,0	40,0	48,0	5	1,3	7600	SN..14..AN
03213630	R220.54-0063-14-7A	Arbor	6,0	74,0	63,0	47,0	22,0	40,0	48,0	7	1,3	7600	SN..14..AN
03213624	R220.54-0080-14-6A	Arbor	6,0	91,0	80,0	62,0	27,0	50,0	48,0	6	2,6	6700	SN..14..AN
03213631	R220.54-0080-14-8A	Arbor	6,0	91,0	80,0	62,0	27,0	50,0	48,0	8	2,6	6700	SN..14..AN
03213632	R220.54-0100-14-10A	Arbor	6,0	111,0	100,0	77,0	32,0	50,0	48,0	10	4,0	6000	SN..14..AN
03213625	R220.54-0100-14-7A	Arbor	6,0	111,0	100,0	77,0	32,0	50,0	48,0	7	4,0	6000	SN..14..AN
03213633	R220.54-0125-14-12A	Arbor	6,0	136,0	125,0	90,0	40,0	63,0	48,0	12	7,5	5400	SN..14..AN
03213626	R220.54-0125-14-8A	Arbor	6,0	136,0	125,0	90,0	40,0	63,0	48,0	8	7,7	5400	SN..14..AN
03213627	R220.54-8160-14-10A	Arbor	6,0	171,0	160,0	90,0	40,0	63,0	48,0	10	13,0	4700	SN..14..AN
03213634	R220.54-8160-14-15A	Arbor	6,0	171,0	160,0	90,0	40,0	63,0	48,0	15	12,8	4700	SN..14..AN
03213628	R220.54-8200-14-12A	Arbor	6,0	211,0	200,0	130,0	60,0	63,0	48,0	12	18,1	4200	SN..14..AN
03213635	R220.54-8200-14-17A	Arbor	6,0	211,0	200,0	130,0	60,0	63,0	48,0	17	16,8	4200	SN..14..AN

R220.54-14 - 48° LEAD ANGLE - INCH

PRODUCT NUMBER	DESIGNATION	TYPE OF MOUNTING	DIMENSIONS IN INCH						KAPRS°	ZNP	LBS	RPMX	INSERT
			APMXS	DCX	DC	DCSFMS	DCB	LF					
03213636	R220.54-02.00-14-4A	Arbor	0.236	2.402	1.969	1.85	0.75	1.57	48.0	4	1.1	8500	SN..14..AN
03213643	R220.54-02.00-14-5A	Arbor	0.236	2.402	1.969	1.85	0.75	1.57	48.0	5	1.1	8500	SN..14..AN
03213637	R220.54-02.50-14-5A	Arbor	0.236	2.913	2.480	1.85	0.75	1.57	48.0	5	1.3	7600	SN..14..AN
03213644	R220.54-02.50-14-7A	Arbor	0.236	2.913	2.480	1.85	0.75	1.57	48.0	7	1.3	7600	SN..14..AN
03213638	R220.54-03.00-14-6A	Arbor	0.236	3.583	3.150	2.44	1.00	1.97	48.0	6	2.9	6700	SN..14..AN
03213645	R220.54-03.00-14-8A	Arbor	0.236	3.583	3.150	2.44	1.00	1.97	48.0	8	2.9	6700	SN..14..AN
03213646	R220.54-04.00-14-10A	Arbor	0.236	4.370	3.937	3.03	1.50	1.97	48.0	10	3.7	6000	SN..14..AN
03213639	R220.54-04.00-14-7A	Arbor	0.236	4.370	3.937	3.03	1.50	1.97	48.0	7	4.0	6000	SN..14..AN
03213647	R220.54-05.00-14-12A	Arbor	0.236	5.354	4.921	3.54	1.50	2.48	48.0	12	8.2	5400	SN..14..AN
03213640	R220.54-05.00-14-8A	Arbor	0.236	5.354	4.921	3.54	1.50	2.48	48.0	8	8.2	5400	SN..14..AN
03213641	R220.54-06.00-14-10A	Arbor	0.236	6.732	6.299	4.33	2.00	2.48	48.0	10	13.7	4700	SN..14..AN
03213648	R220.54-06.00-14-15A	Arbor	0.236	6.732	6.299	4.33	2.00	2.48	48.0	15	15.0	4700	SN..14..AN
03213642	R220.54-808.00-14-12A	Arbor	0.236	8.307	7.874	5.12	2.50	2.48	48.0	12	16.8	4200	SN..14..AN
03213649	R220.54-808.00-14-17A	Arbor	0.236	8.307	7.874	5.12	2.50	2.48	48.0	17	16.5	4200	SN..14..AN

R220.56-14 - 71° LEAD ANGLE - METRIC

PRODUCT NUMBER	DESIGNATION	TYPE OF MOUNTING	DIMENSIONS IN MM						KAPRS°	ZNP	LBS	RPMX	INSERT
			APMXS	DCX	DC	DCSFMS	DCB	LF					
03241895	R220.56-0050-14-4A	Arbor	8,0	55,0	50,0	47,0	22,0	40,0	71,0	4	0,9	8500	SN..14..ZN
03241902	R220.56-0050-14-5A	Arbor	8,0	55,0	50,0	47,0	22,0	40,0	71,0	5	0,9	8500	SN..14..ZN
03241896	R220.56-0063-14-5A	Arbor	8,0	68,0	63,0	47,0	22,0	40,0	71,0	5	1,1	7600	SN..14..ZN
03241903	R220.56-0063-14-6A	Arbor	8,0	68,0	63,0	47,0	22,0	40,0	71,0	6	1,1	7600	SN..14..ZN
03241897	R220.56-0080-14-6A	Arbor	8,0	85,0	80,0	62,0	27,0	50,0	71,0	6	2,2	6700	SN..14..ZN
03241904	R220.56-0080-14-8A	Arbor	8,0	85,0	80,0	62,0	27,0	50,0	71,0	8	2,2	6700	SN..14..ZN
03241905	R220.56-0100-14-10A	Arbor	8,0	105,0	100,0	77,0	32,0	50,0	71,0	10	3,5	6000	SN..14..ZN
03241898	R220.56-0100-14-7A	Arbor	8,0	105,0	100,0	77,0	32,0	50,0	71,0	7	3,5	6000	SN..14..ZN
03241906	R220.56-0125-14-12A	Arbor	8,0	130,0	125,0	90,0	40,0	63,0	71,0	12	6,8	5400	SN..14..ZN
03241899	R220.56-0125-14-8A	Arbor	8,0	130,0	125,0	90,0	40,0	63,0	71,0	8	6,8	5400	SN..14..ZN
03241900	R220.56-8160-14-10A	Arbor	8,0	165,0	160,0	90,0	40,0	63,0	71,0	10	11,2	4700	SN..14..ZN
03241907	R220.56-8160-14-15A	Arbor	8,0	165,0	160,0	90,0	40,0	63,0	71,0	15	11,2	4700	SN..14..ZN
03241901	R220.56-8200-14-12A	Arbor	8,0	205,0	200,0	130,0	60,0	63,0	71,0	12	15,2	4200	SN..14..ZN
03241908	R220.56-8200-14-17A	Arbor	8,0	205,0	200,0	130,0	60,0	63,0	71,0	17	15,2	4200	SN..14..ZN

R220.56-14 - 71° LEAD ANGLE - INCH

PRODUCT NUMBER	DESIGNATION	TYPE OF MOUNTING	DIMENSIONS IN INCH						KAPRS°	ZNP	LBS	RPMX	INSERT
			APMXS	DCX	DC	DCSFMS	DCB	LF					
03241909	R220.56-02.00-14-4A	Arbor	0.315	2.165	1.969	1.85	0.75	1.58	71.0	4	0.9	8500	SN..14..ZN
03241916	R220.56-02.00-14-5A	Arbor	0.315	2.165	1.969	1.85	0.75	1.58	71.0	5	0.9	8500	SN..14..ZN
03241910	R220.56-02.50-14-5A	Arbor	0.315	2.677	2.480	1.85	0.75	1.58	71.0	5	1.1	7600	SN..14..ZN
03241917	R220.56-02.50-14-6A	Arbor	0.315	2.677	2.480	1.85	0.75	1.58	71.0	6	1.1	7600	SN..14..ZN
03241911	R220.56-03.00-14-6A	Arbor	0.315	3.346	3.150	2.44	1.00	1.97	71.0	6	2.6	6700	SN..14..ZN
03241918	R220.56-03.00-14-8A	Arbor	0.315	3.346	3.150	2.44	1.00	1.97	71.0	8	2.6	6700	SN..14..ZN
03241919	R220.56-04.00-14-10A	Arbor	0.315	4.134	3.937	3.03	1.50	1.97	71.0	10	3.5	6000	SN..14..ZN
03241912	R220.56-04.00-14-7A	Arbor	0.315	4.134	3.937	3.03	1.50	1.97	71.0	7	3.5	6000	SN..14..ZN
03241920	R220.56-05.00-14-12A	Arbor	0.315	5.118	4.921	3.54	1.50	2.48	71.0	12	7.5	5400	SN..14..ZN
03241913	R220.56-05.00-14-8A	Arbor	0.315	5.118	4.921	3.54	1.50	2.48	71.0	8	7.5	5400	SN..14..ZN
03241914	R220.56-06.00-14-10A	Arbor	0.315	6.496	6.299	4.33	2.00	2.48	71.0	10	12.6	4700	SN..14..ZN
03241921	R220.56-06.00-14-15A	Arbor	0.315	6.496	6.299	4.33	2.00	2.48	71.0	15	12.6	4700	SN..14..ZN
03241915	R220.56-808.00-14-12A	Arbor	0.315	8.071	7.874	5.12	2.50	2.48	71.0	12	15.2	4200	SN..14..ZN
03241922	R220.56-808.00-14-17A	Arbor	0.315	8.071	7.874	5.12	2.50	2.48	71.0	17	15.0	4200	SN..14..ZN

R220.54/R220.56-14 - CASSETTE VERSION - METRIC

PRODUCT NUMBER	DESIGNATION	TYPE OF MOUNTING	DIMENSIONS IN MM						KAPRS°	ZNP	LBS	RPMX	INSERT
			APMXS	DCX	DC	DCSFMS	DCB	LF					
03213787	R220.54-8160-14-9CA	Arbor	6,0	171,0	160,0	90,0	40,0	80,0	48,0	9	17,9	4700	SN..14..AN
03213788	R220.54-8200-14-11CA	Arbor	6,0	211,0	200,0	90,0	40,0	80,0	48,0	11	23,4	4200	SN..14..AN
03213789	R220.54-8250-14-14CA	Arbor	6,0	261,0	250,0	90,0	40,0	80,0	48,0	14	43,7	3800	SN..14..AN
03213790	R220.54-8315-14-16CA	Arbor	6,0	326,0	315,0	225,0	60,0	80,0	48,0	16	70,8	3400	SN..14..AN
03245958	R220.56-8160-14-9CA	Arbor	8,0	165,0	160,0	90,0	40,0	80,0	71,0	9	17,9	4700	SN..14..ZN
03245959	R220.56-8200-14-11CA	Arbor	8,0	205,0	200,0	90,0	60,0	80,0	71,0	11	22,5	4200	SN..14..ZN
03245960	R220.56-8250-14-14CA	Arbor	8,0	255,0	250,0	130,0	60,0	80,0	71,0	14	43,9	3800	SN..14..ZN
03245961	R220.56-8315-14-16CA	Arbor	8,0	320,0	315,0	225,0	60,0	80,0	71,0	16	71,4	3400	SN..14..ZN

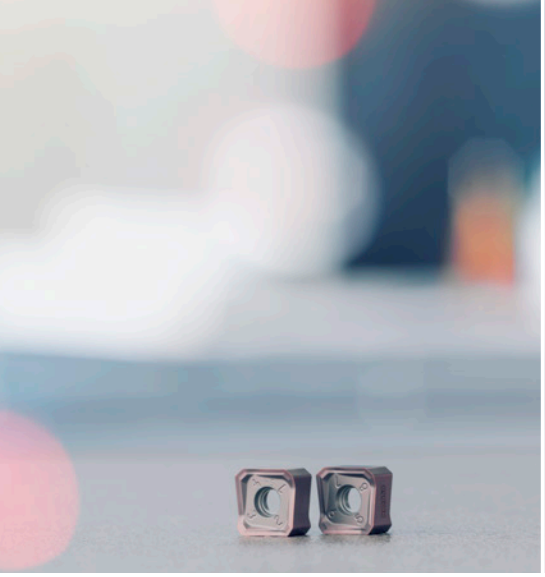
R220.54/R220.56-14 - CASSETTE VERSION - INCH

PRODUCT NUMBER	DESIGNATION	TYPE OF MOUNTING	DIMENSIONS IN INCH						KAPRS°	ZNP	LBS	RPMX	INSERT
			APMXS	DCX	DC	DCSFMS	DCB	LF					
03213791	R220.54-06.00-14-9CA	Arbor	0.236	6.496	6.299	4.33	2.00	3.15	48.0	9	18.7	4700	SN..14..AN
03213792	R220.54-808.00-14-11CA	Arbor	0.236	8.307	7.874	5.12	2.50	3.15	48.0	11	23.6	4200	SN..14..AN
03213793	R220.54-810.00-14-14CA	Arbor	0.236	10.276	9.843	5.12	2.50	3.15	48.0	14	43.9	3800	SN..14..AN
03213794	R220.54-812.50-14-16CA	Arbor	0.236	12.835	12.402	8.86	2.50	3.15	48.0	16	71.7	3400	SN..14..AN
03245962	R220.56-06.00-14-9CA	Arbor	0.315	6.496	6.299	4.33	2.00	3.15	71.0	9	19.0	4700	SN..14..ZN
03245963	R220.56-808.00-14-11CA	Arbor	0.315	8.071	7.874	5.12	2.50	3.15	71.0	11	23.6	4200	SN..14..ZN
03245964	R220.56-810.00-14-14CA	Arbor	0.315	10.039	9.843	5.12	2.50	3.15	71.0	14	43.7	3800	SN..14..ZN
03245965	R220.56-812.50-14-16CA	Arbor	0.315	12.598	12.402	8.86	2.50	3.15	71.0	16	71.7	3400	SN..14..ZN

SNMX14 INSERTS

LEAD ANGLE	DESIGNATION	GRADES (WITH PRODUCT NUMBERS)											
		MP1500	MP2500	MP3000	MP2050	MK1500	MK2050	T350M	MS2500	MS2050	F40M	MM4500	H25
48°	SNHX1407ANR-ME10				03213542			03213546		03213544	03213547	03213543	03213545
	SNMX1407ANTR-M10	03213548	03213551	03213552	03213549	03213554	03213555	03213558	03213557	03213556	03213570	03213553	
	SNMX1407ANTR-M16	03213559	03213560	03213561		03213563	03213564	03213567	03213566		03213568	03213562	
71°	SNHX1407ZNR-ME10				03241853			03241856		03241855	03241857	03241854	03241878
	SNMX1407ZNTR-M10	03241858	03241860	03241861	03241859	03241863	03241864	03241867	03241866	03241865	03241868	03241862	
	SNMX1407ZNTR-M16	03241869	03241870	03241871		03241873	03241874	03241876	03241875		03241877	03241872	

Visit **SECOTOOLS.COM** for additional details including speeds, feeds and complementary products.



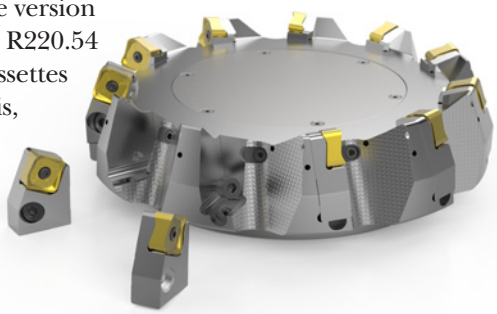
SECO DOUBLE QUATTROMILL™ 14 FACE MILL

PRODUCT SUMMARY & RANGE

INTERCHANGEABLE CASSETTES

Offering you even greater flexibility, our cassette version allows you to interchange the cassettes from the R220.54 to the R220.56. In the case of cutter damage, cassettes allow for replacing pockets on a one by one basis, instead of the entire cutter body itself.

For all of the advantages at even greater MRR, check out the larger Double Quattromill 22, with d.o.c. capabilities of up to 0.433".



MATERIAL GROUPS
Steel P1-P11
Stainless Steel M1-M5
Cast Iron K1-K7
Non-ferrous N1-N11
Superalloys S1-S3
Hardened Steels H5-H21

INDUSTRY TARGETS

- **Aerospace:** This cutter's many geometries and grades cover a large variety of materials, making it perfect for components like engine mounts and casings, flap tracks, and landing gear.
- **Automotive:** A high performance solution for components such as axle housings, differential cases, bearing caps, block machining heads, gear box carriers and more.
- **General Machining:** The large depth of cut capability makes it extremely useful in steel manufacturing plant operations, such as when machining billets and cubing and squaring up material blocks.
- **Oil & Gas:** Effective for facing components including manifolds, valves, wellheads, pumps, risers and flanges that are generally alloyed steels, and/or stainless steels.

FEATURES	ADVANTAGES	BENEFITS	IMPACT
Optimized body design	• Large flute spacing design to enhance chip flow • Optimal chip evacuation from the cutting zone • Decreased risk of insert breakage	• Improved machining processes (less risk of machine down time) • Extended tool life • Process security	• Maximize machine utilization • More predictable costs and timelines on face milling processes
8 cutting edges	• Lower cost per edge • Less inventory	• More economical • Fewer insert changes	• Lower tooling costs per unit
Positive rake geometries	• Lower power consumption • Effective in sticky materials even at high depths of cut	• Enables higher speed or feed to reduce cycle time • Longer tool life and wider range of applications	• Get more metal removal out of medium-powered machine tools • Lessen wear on your machine tools
Corrosion resistant tool steel	• Material optimized for cutter longevity • No longer requires the nickel coating	• Tool steel material is very durable for face milling operations • Less chance of chip jamming especially in sticky materials	• Reduce maintenance and tooling replacement costs • Lessen environmental impact by eliminating nickel coating process

P-1904-3000 GT19-103