CATALOG & TECHNICAL GUIDE 2021.1

MILLING

AHB TOOLING & MACHINERY

Complete Metalworking Solutions

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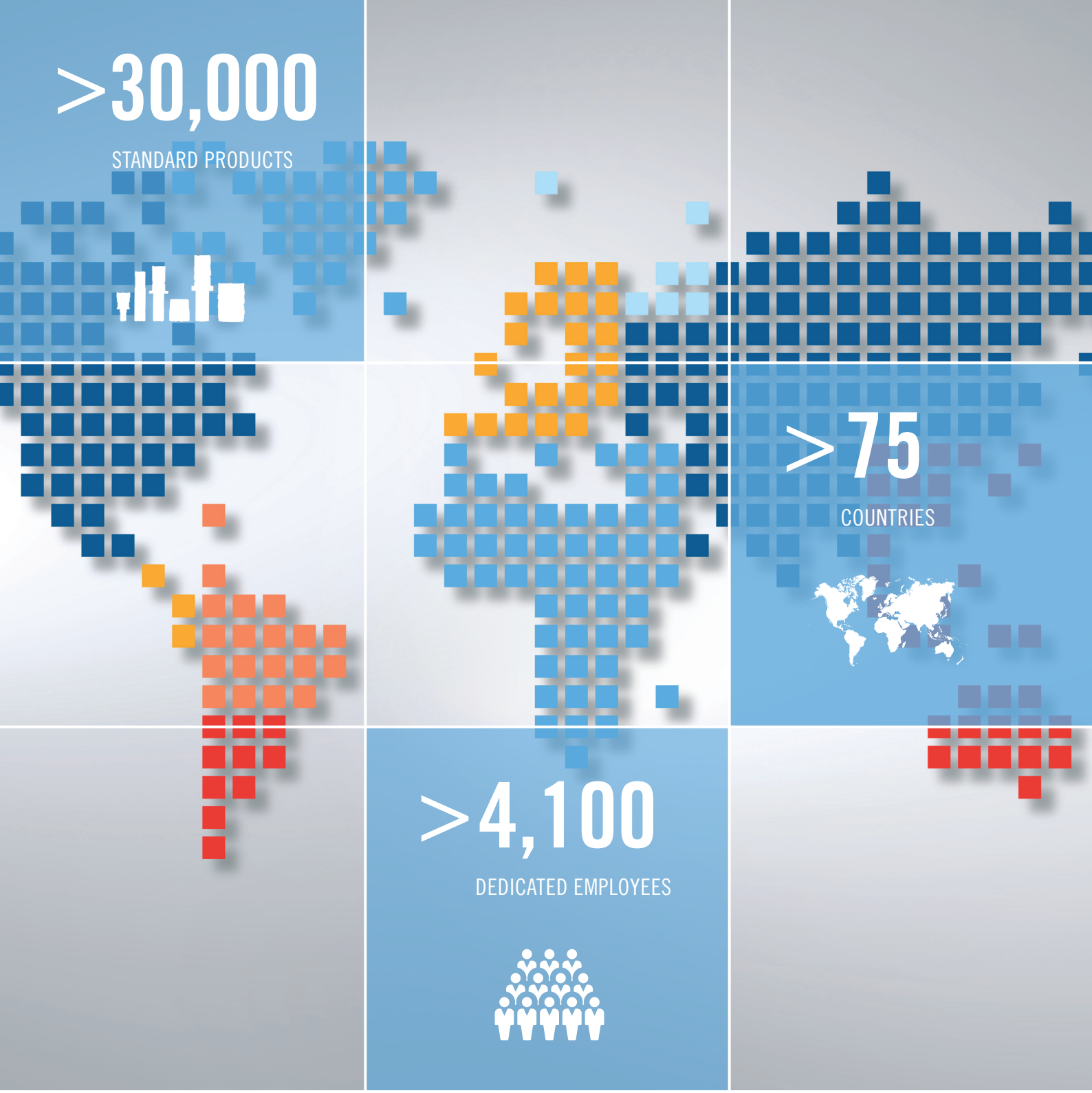
SECO



Headquartered in Fagersta, Sweden and present in more than 75 countries, Seco Tools is a leading global provider of metal cutting solutions for milling, stationary tools, holemaking and tooling systems.

For more than 80 years, the company has provided the technologies, processes and support that manufacturers depend on for maximum productivity and profitability. For more information on how Seco's innovative products and expert services bring success to manufacturers across all industry segments, please visit www.secotools.com.

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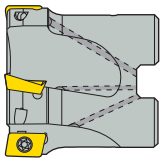
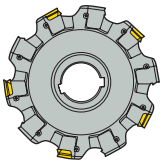
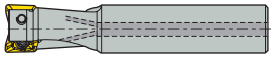
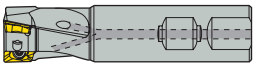
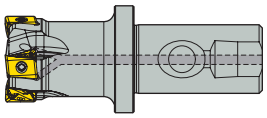
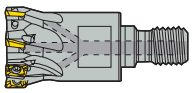
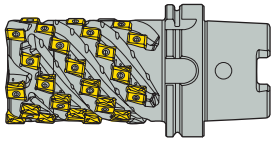
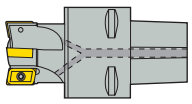
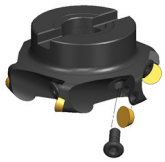
Mounting type

Type – Arbor (Shell end)	Type – Arbor hole
 Ex.: R220.69-0050-12-5AN	 Ex.: 335.25-160.15.40-7N
Type 0 – Cylindrical	**Type 3 – Weldon Tool chucks acc. to ISO 5414 DIN 1835**
 Ex.: R217.69-1616.**0**-10-2A	 Ex.: R217.69-2525.**3**-12-3AN
Type 3S – Seco/Weldon® Tool chucks acc. to ISO 5414 DIN 1835	**Type RE – Combimaster**
 Ex.: R217.69-2532.**3S**-12-4AN	 Ex.: R217.69-1225.**RE**-12-3AN
Type HSK	**Type Cx – Seco-Capto™**
 Ex.: R217.94-**HSK**100A-080-104-12.5SA	 Ex.: **C5**-R217.69-054-10-5A

Insert clamping system

Centre lock clamping



The inserts are clamped by an inclined screw which holds the insert in position in its seat.

Clamping by a wedge

The inserts are held in position by a wedge and a screw which clamps the insert onto the seat. (Example shows milling cutter with cassettes).

Centre lock clamping

The inserts are secured through a centre hole by means of a screw which clamps the insert firmly against the bottom and side of its seat.

Clamping by spring action

The inserts are retained by a clamping/spring action into a fixed insert seat

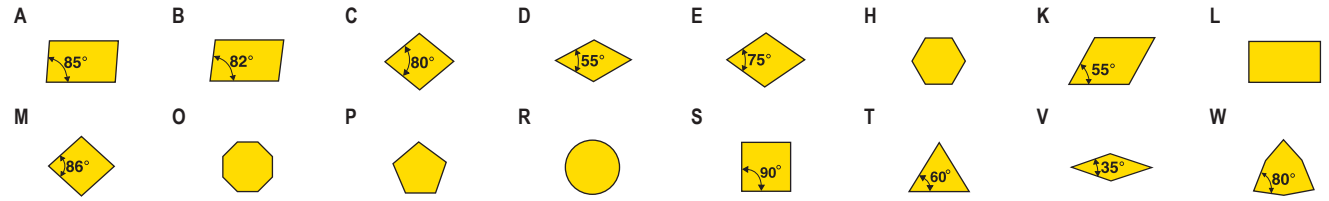
Square T4

The inserts are secured through a centre hole by means of a screw which clamps the insert firmly against the bottom and side of its seat.

Code key inserts

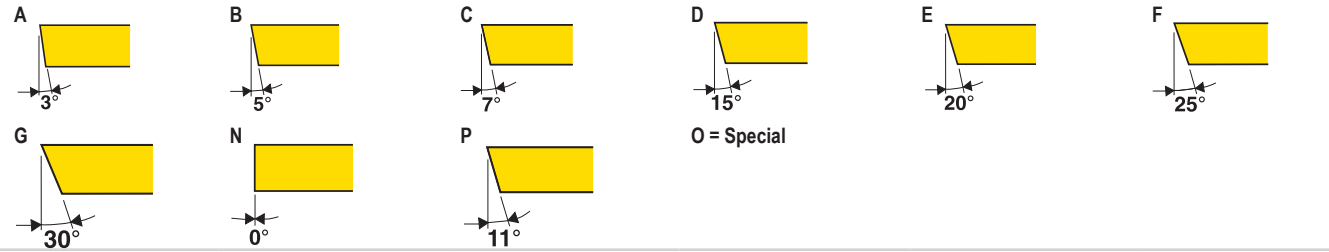
S	E	M	X	12	04	AF	T	N	-	ME12
1	2	3	4	5	6	7	8	9		10

1. Insert shape



X=Special shapes

2. Insert side clearance angle



Code keys inserts

3. Tolerances

Tolerance class	Tolerances: mm/In				For IC, dimension in mm/In												
	S mm	IC mm	S Inch	IC Inch	3,175*	3,969	4,064	4,760	6,350	9,525	12,700	15,875	19,050	20,000	25,400	31,750	38,100
					0.125			0.187	0.250	0.375	0.500	0.625	0.750		1.000	1.250	1.500
A	0,025	0,025	0.0010	0.0010	•			•	•	•	•	•	•	•	•	•	•
C	0,025	0,025	0.0010	0.0010	•	•	•	•	•	•	•	•	•	•	•	•	•
E	0,025	0,025	0.0010	0.0010	•			•	•	•	•	•	•	•	•	•	•
F	0,025	0,013	0.0010	0.0005	•			•	•	•	•	•	•	•	•	•	•
G	0,050*	0,025	0.0020	0.0010	•			•	•								
	0,130	0,025	0.0051	0.0010						•	•	•	•	•	•	•	•
H	0,025	0,013	0.0010	0.0005	•			•	•	•	•	•	•	•	•	•	•
J	0,025	0,050	0.0010	0.0020	•			•	•	•							
	0,025	0,080	0.0010	0.0031							•						
	0,025	0,100	0.0010	0.0039								•	•	•			
	0,025	0,130	0.0010	0.0051											•		
	0,025	0,150	0.0010	0.0059												•	•
K	0,025	0,050	0.0010	0.0020	•			•	•	•							
	0,025	0,080	0.0010	0.0031							•						
	0,025	0,100	0.0010	0.0039								•	•	•			
	0,025	0,130	0.0010	0.0051											•		
	0,025	0,150	0.0010	0.0059												•	•
M	0,050*	0,050	0.0020	0.0020	•			•	•								
	0,130	0,050	0.0051	0.0020						•							
	0,130	0,080	0.0051	0.0031							•						
	0,130	0,100	0.0051	0.0039								•	•	•			
	0,130	0,130	0.0051	0.0051											•		
	0,130	0,150	0.0051	0.0059												•	•
U	0,050*	0,080	0.0020	0.0031	•			•	•								
	0,130	0,080	0.0051	0.0031						•							
	0,130	0,130	0.0051	0.0051							•						
	0,130	0,180	0.0051	0.0071								•	•	•			
	0,130	0,250	0.0051	0.0098											•	•	•

* Not ISO

4. Fixing and/or chipbreaker

A B G M N R

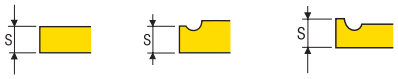
T U W X = Special

5. Cutting edge length

A, B, K C, D, E, M, V H, O, P L R S T W

Code keys inserts

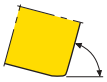
6. Thickness



01 = 1,59 mm	01 = 0.0626 Inch	T3 = 3,97 mm	T3 = 0.1563 Inch	07 = 7,94 mm	07 = 0.3126 Inch
T1 = 1,98 mm	T1 = 0.0780 Inch	04 = 4,76 mm	04 = 0.1874 Inch	08 = 8,00 mm	08 = 0.3150 Inch
02 = 2,38 mm	02 = 0.0937 Inch	05 = 5,56 mm	05 = 0.2189 Inch	09 = 9,52 mm	09 = 0.3748 Inch
03 = 3,18 mm	03 = 0.1252 Inch	06 = 6,35 mm	06 = 0.2500 Inch		

7. Corner configuration

1st letter



A = 45°
D = 60°
E = 75°
F = 85°
P = 90°
Z = Special

2nd letter

A = 45°
B = 5°
C = 7°
D = 15°
E = 20°
F = 25°
G = 30°
N = 0°
P = 11°
Z = Special

nose radius

M0 = round inserts (metric version)
005 = 0,05 mm
01 = 0,1 mm
02 = 0,2 mm
04 = 0,4 mm
08 = 0,8 mm
12 = 1,2 mm
etc.

M0 = round inserts (inch version)
005 = 0.0020 Inch
01 = 0.0039 Inch
02 = 0.0079 Inch
04 = 0.0157 Inch
08 = 0.0315 Inch
12 = 0.0472 Inch
etc.

8. Cutting edge condition

F

E

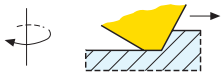
T

S

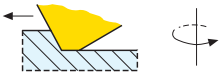
W = High feed inserts
Not mandatory information

9. Direction of cutting

R



L



N

Neutral
(R - and L - rotated)

10. Internal designations

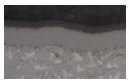
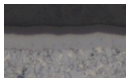
Machining conditions
E = Easy
M = Medium
D = Difficult

Insert grades

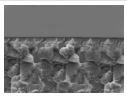
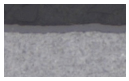
Uncoated Grades

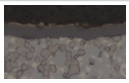
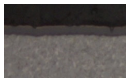
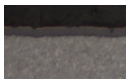
	HX	Wear resistant grade for milling in cast iron and non-ferrous alloys.
	H15	Hard, wear resistant grade for milling in aluminium.
	H25	Tough micro-grain carbide grade for milling in superalloys and aluminium.

CVD Coated Grades

	MP2501	CVD-coated grade based on Duratomic™ coating, First choice in steel for maximizing manufacturing output under most varying productivity. Alternative choice stainless steel applications under stable condition. Ti(C, N)-Al_2O_3
	MK1500	CVD-coated grade based on Duratomic™ coating. Basic grade for milling cast iron and nodular cast iron, with or without coolant. Ti (C, N) – Al_2O_3
	MP1501	CVD-coated grade based on Duratomic™ coating. Grade for high performance and productivity in steel material under stable conditions and for milliing hardened steel. Excellent grade for grey and nodular cast iron. Ti (C, N) – Al_2O_3
	MS2500	Optimization grade for superalloy materials, also suitable for rough milling in tool steel. Ti (C, N) – Al_2O_3
	**MM4500**	Extremly tough grade for duplex stainless steel. Can also be used for a wide range of materials when cutting conditions are unstable. Ti(C, N)-Al_2O_3
	**T350M**	CVD-coated grade as basic choice for difficult stainless steel and an alternative in difficult operations in steel. Ti (C, N) – Al_2O_3

PVD Coated Grades

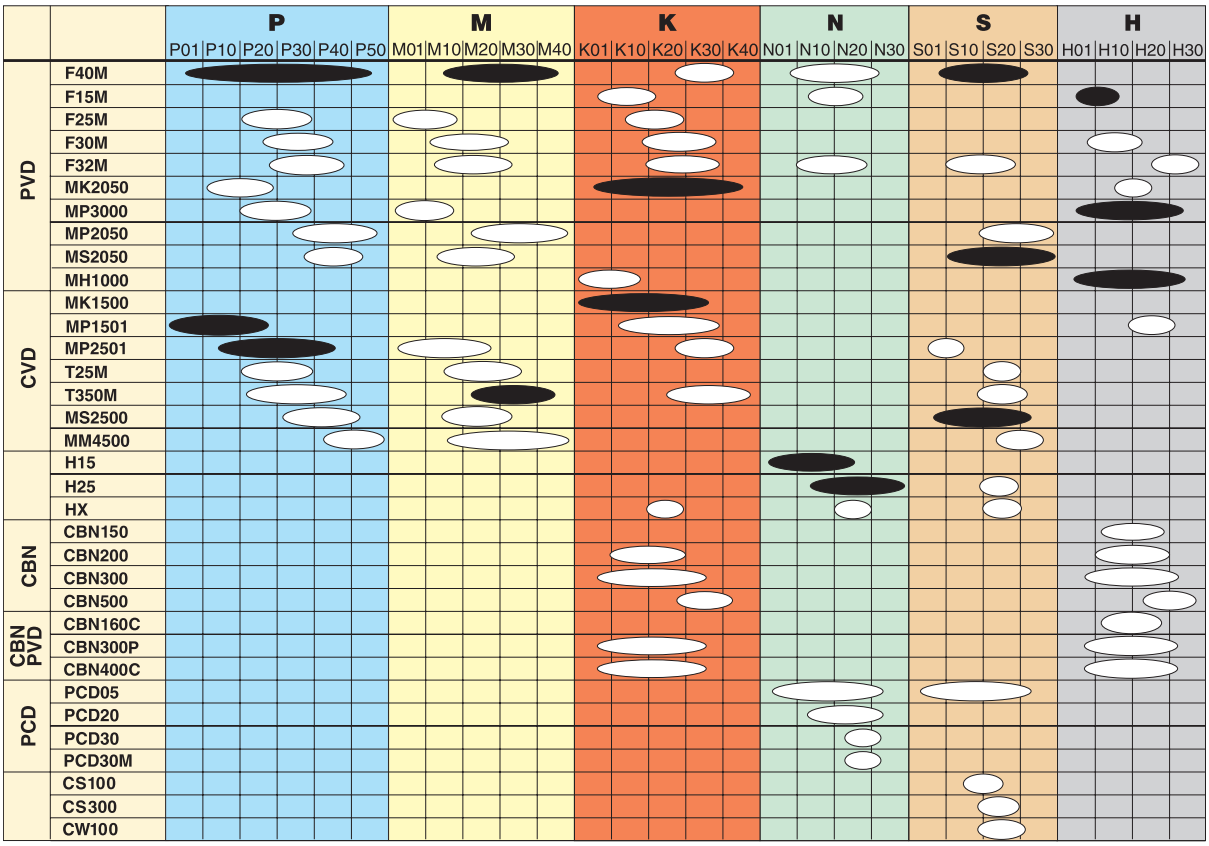
	F40M	PVD-coated grade for fine to medium rough milling. First choice for milling with small feeds and/or low cutting speeds. Excellent for milling when there is a risk of vibrations and when coolant is used. Recommended for machining superalloys. (Ti, Al) N – TiN
	**MK2050**	PVD-coated grade for cast iron, Improved edge integrity. First choice in all cast iron materials. Excellent for milling with and without coolant. (Ti,Si)N/(Ti,Al)N
	**MH1000**	Extremely hard grade for milling hard steel but also favourable in finishing operations in cast iron. (Ti;Al)N
	MS2050	PVD-coated grade first choice for machining titanium alloys. Can also be used as a complementary grade for milling stainless steels when increased toughness is needed. (Ti;Al) N – NbN
	MP3000	Highly wear resistant optimized grade for milling in steel. (Ti;Al)N
	F15M	Hard and wear resistant grade for milling in aluminium and non-ferrous alloys. Excellent grade, in combination with protected cutting edges, for high speed machining in hardened steel. (Ti, Al) N – TiN

PVD Coated Grades		
	**F25M**	Tough grade for rough milling in tool steel. (Ti, Al) N – TiN
	**F30M**	Basic grade for Minimaster inserts and thread milling inserts. Also suitable for milling stainless steel, hardened steel and superalloys. (Ti, Al) N – TiN
	MP2050	PVD-coated grade for tough machining conditions and high temperatures in martensitic and austenitic stainless steels, dry and wet machining possible. Alternative in super alloys in unstable conditions. (Ti,Si)N/(Ti,Al)N
	**F32M**	Universal grade for R335.14 replaceable head offering an excellent combination of strength and toughness. The F32M shows an exceptionally broad application range and is applicable in all type of material with this type of tool. (Ti, Al) N – TiN

Insert grades

Cemented carbide is an alloy of tungsten carbide (WC) and cobalt (Co). Cubic carbides like tantalum carbide (TaC), titanium carbide (TiC) and niobium carbide (NbC) can also be added. Tungsten carbide is the main component and gives the hardness. Cobalt is the binder phase and gives the toughness. Cubic carbides are added in order to affect properties like hot hardness, deformation resistance and chemical wear resistance.

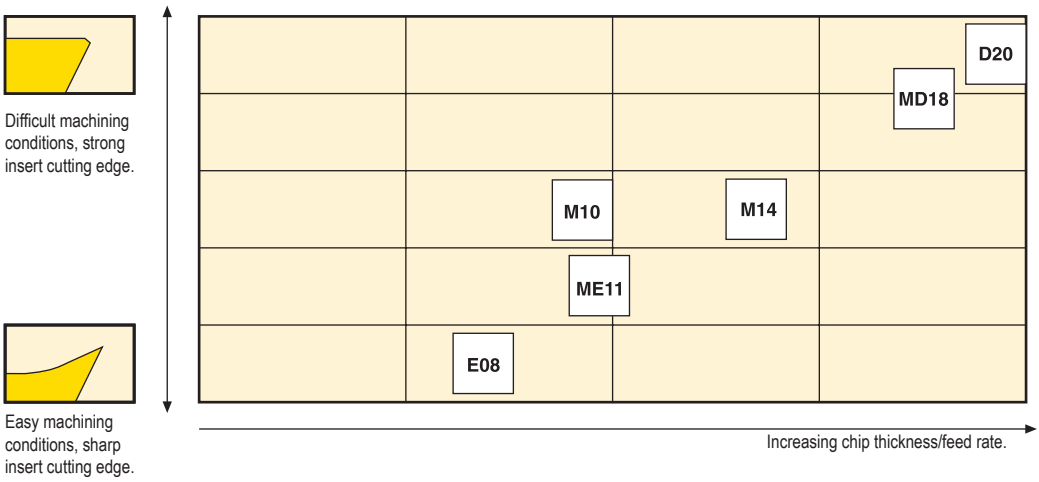
Most modern grades are coated with either CVD (Chemical Vapour Deposition) or PVD (Physical Vapour Deposition) technique.
The coating improves the wear resistance of the grade.
CVD-coated grades are suitable for wear resistance in demanding applications with high feed rates and intermediate to high cutting speed.
PVD-coated grades are recommended for applications with low feed rate where high edge toughness is required. PVD-coated grades are suitable for applications with low to intermediate cutting speed.

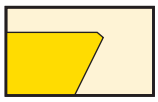


The black oval circle areas in the chart indicate an inserts main ISO application groups.
The white oval circle area in the chart indicate an inserts other complementary ISO application groups.

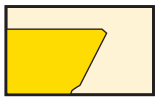
For MP1500 and MP2500 use ISO application areas respectively for MP1501 and MP2501
For TGP45 use ISO application area for MP2501
For CP500 and CP600 use ISO application area respectively for F30M and F40M

Insert geometries - Designation system

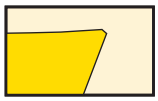




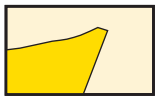
..AFTN-D20 Negative and very protected cutting edge



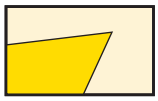
..AFTN-MD18 Negative and protected cutting edge



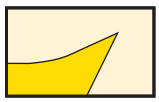
..AFTN-M14 Positive and protected cutting edge



..AFTN-ME11 Very positive and protected cutting edge



..AFN-M10 Positive and sharp cutting edge



..AFN-E08 Very positive and very sharp cutting edge

ISO attribute

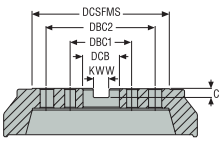
ISO attribute	Explanation
APMXE	Depth of cut maximum in feed direction end
APMXS	Depth of cut maximum in feed direction side
AZ	Plunge depth maximum
BD	Body diameter
BHTA	Body half taper angle
BS	Wiper edge length
C	Keyway depth
CBTHN	Connection body thickness
CCER	Curved cutting edge radius
CDX	Cutting depth maximum
CF	Spot chamfer
CHW	Corner chamfer width
Cmax	Helical interpolation hole diameter maximum
Cmin	Helical interpolation hole diameter minimum
CPNDIA	Connection pin diameter
CTMS	Connection text machine side
CW	Cutting width
DC	Cutting diameter
DCB	Connection bore diameter
DCB1	Connection bore diameter 1
DCSFMS	Contact surface diameter machine side
DCSFWS	Contact surface diameter work piece side
DCX	Cutting diameter maximum
DMM	Shank diameter
FDESU	Feed direction suitability end
FDP	Feed direction primary
FDSSU	Feed direction suitability side
GAMF	Rake angle radial
GAMO	Rake angle orthogonal
GAMP	Rake angle axial
HC	Thread height actual
IC	Inscribed circle diameter
INSD	Insert diameter
INSL	Insert length
KAPRE	Tool cutting edge angle in feed direction end
KAPRS	Tool cutting edge angle in feed direction side
KCH	Corner chamfer angle
KWW	Keyway width
L	Cutting edge length
LB	Body length
LE	Cutting edge effective length
LF	Functional length
LS	Shank length
LUX	Usable length maximum
OAL	Overall length
PDX	Profile distance ex
PNA	Profile included angle
RE	Corner radius
RP	Programming radius
RMPX	Ramping angle maximum
RPMX	Rotational speed maximum
S	Insert thickness
S1	Insert thickness alt 1
UTCN	Uncut thickness
TDZ	Thread diameter size
THUB	Hub thickness
TTL	True tip length
W1	Insert width
ZEFP	Peripheral effective cutting edge count
ZNP	Peripheral mounted insert count
SA	sphere angle
TACH	Cutting half taper angle
DC1	Cutting diameter 1
LPR	Protruding length
FHA	Flute helix angle
PL	Point length
SIG	Point angle
BEC	Back end chamfer angle
DN	Neck diameter
RA	Relief angle

Code keys metric and *inch*

R	217	.	69	-	25	32	.	3S	-	12	-	4	AN
1	2		3		4	5		6		7		8	9

R	217	.	69	-	01.25	.	3S	-	12	-	4	AN
1	2		3		5		6		7		8	9

1.	2.	3
Right hand rotation Cx = For Seco-Capto	217 = With shank 220 = For arbor	Cutter system
4. (Not applicable for inch designation)	**5.**	**6.**
Shank diameter	Cutter diameter	Shank type 0 = Cylindrical 3 = Weldon 3S = Seco Weldon RE = Combimaster
7.	**8.**	**9.**
Insert size	Effective No. of teeth (ZEFP)	A = With through coolant supply AD = Anti vibration material with through coolant supply T = Close pitch version for contouring operations C = With adjustable cassettes N = Coated



Dimensions in mm					
DCB	DCSFMS	DBC1	DBC2	KWW	C
16	30-35	–	–	8,4	5,6
22	42-47	–	–	10,4	6.3
27	48-62	–	–	12,4	7
32	60-90	–	–	14,4	8
40	90-130	66,7	–	16,4	9
60	130-270	101,6	177,8	25,7	14

Dimensions in inch					
DCB	DCSFMS	DBC1	DBC2	KWW	C
0.500	*1.181 - 1.378*			*0.258*	*0.165*
0.750	*1.378 - 1.850*	–	–	*0.321*	*0.193*
1.000	*1.803 - 2.441*	–	–	*0.382*	*0.224*
1.250	*2.250 - 3.031*	–	–	*0.508*	*0.287*
1.500	*2.750 - 3.543*	–	–	*0.630*	*0.382*
2.000	*4.331*	–	–	*0.756*	*0.445*
2.500	*5.118 - 6.299 (8.858)*	*4.000*	*(7.000)*	*1.000*	*0.551*

Selection – Metric

Cutter	Insert	Recommended a_p		Material suitability					Corner radius (mm)					
				P	M	K	N	S						
Double Turbo	ZOMX16	6	15	■	◩	■	□	◩	0,8/1,6	□	■	–	–	◩
Turbo	XO..06	3	5	■	■	■	■	■	0,2/0,4/0,8/1,6	■	□	■	■	◩
	XO..10	5	9	■	■	■	■	■	0,2/0,4/0,8/1,2/ 1,6/2,0/2,4/3,1	■	◩	■	■	◩
	XO..12	6	11	■	■	■	■	■	0,2/0,4/0,8/1,2/1,6/ 2,0/2,4/3,1/4,0/ 5,0/6,3	◩	■	■	■	◩
	XOMX16	8	15	■	■	■	■	■	0,2/0,4/0,8/1,2/	□	■	■	■	◩
	XO..18	9	17	■	◩	■	■	◩	0,4/0,8/1,2/1,6/2,0/ 2,4/3,1/4,0/5,0/6,3	□	■	■	■	◩
ABEX26	ABEX26	13	20	■	◩	■	-	-	1,6	□	■	■	□	□
Square T4	LO..08	3	7	■	◩	■	□	□	0,4/0,8/1,2/1,6	■	◩	◩	-	□
	LO..12	6	10	■	■	■	■	■	0,4/0,8/1,2/1,6/2,0/ 2,4/3,1/4,0/5,0/6,3	■	◩	◩	-	□
Square 6	XN..04..R	2	3	■	◩	■	-	□	0,4/0,8	■	□	◩	-	◩
	XN..08..R	4	7	■	◩	■	-	□	0,4/0,8/1,2/1,6	□	■	□	-	◩
SONX	SONX09	4	6	■	■	■	□	-	0,4/0,8	■	◩	□	-	-
	SONX12	6	10	■	■	■	□	-	0,8	◩	■	□	-	-

1st choice	■
Alternative choice	◩
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Metric

Cutter	No. of cutting edges	Applica-tion	Cutter diameter (mm) available with effective number of teeth																							See page
			10	12	14	16	18	20	22	25	32	40	44	50	52 54	63	66	80	84	100	125	160	200	250	315	
Double Turbo	4										2	3		4		5		6		8	10	12	14			23
												4		5		6		8		10	12	14	16			
Turbo 06	2		2	2	3	3	4	4																		30, 31
				3		4		5		7	8	10														
Turbo 10	2					2	2	2		3	3	4	4	5	5	5	5	8								37
								3		4	5	6		7		8		10		12						
Turbo 12	2							2		2	3	4	4	5	5	6	6	7	7	8	8/10	10	12	16		45
										3	4	5		7		8		10		12	14					
Turbo 16	2									2	2	3		4	5	5	6	6		8	8/10	10/11	12	16		54
											3	4		5/6		6/7		8/9	8	10	12	13				
Turbo 18	2										2	3		4	4	4/5	5	5/6	6	7	7/8	7/9/10	12	16		63
											3	4		5		6		8		9	11	12				
ABEX	2															4/5		5		7		8	10	12	14	78
																6										
Square T4 08	4					2	2	2	3	3	3	4		5	5	6										85
								3		4	5	6		7		9										
Square T4 12	4									2	3	3/4	4	5	5	6	6	7		9	12					93
												5		6		8		10		12						
Square 6 04	6							2		4	5	5		6		7										93-99
								3		5	6	7		8/9		9										
Square 6 08	6											3	3	4	4	6	7	5/7	7	6/8	7/11	12	8	10		100-108
												4	4	5	5	7		9		11	14	16	12	10		
SONX09	4											4		4		7										110
														6												
SONX12	4													4		4		6		8						110
														5		6										

x — Fixed pocket (x indicates number of teeth)

x — With cassette (x indicates number of teeth)

Slotting and contouring

Optimized for contouring

Selection – Inch

Cutter	Insert	Recommended a_p		Material suitability					Corner radius (mm)					
				P	M	K	N	S						
Double Turbo	ZOMX16	6	15	■	◪	■	□	◪	031/.063	□	■	–	–	◪
Turbo	XO..06	0.118	0.197	■	■	■	■	■	.008/.016 .031/.063	■	□	■	■	◪
	XO..10	0.197	0.354	■	■	■	■	■	016/.031 .047/.063 .079/.094 .122	■	◪	■	■	◪
	XO..12	0.236	0.433	■	■	■	■	■	.016/.031 .047/.063 .079/.094 .122/.157 .197/.248	◪	■	■	■	◪
	XOMX16	0.315	0.590	■	■	■	■	■	.016/.031 .047/.063 .079/.095 .122/.157 .197/.248	◪	■	■	■	◪
	XO..18	0.354	0.669	■	◪	■	■	◪	.016/.031 .047/.063 .079/.094 .122/.157 .197/.248	□	■	■	■	◪
Square T4	LO..08	0.118	0.276	■	◪	■	□	□	.016/.031 .047/.063	■	◪	◪	-	□
	LO..12	0.276	0.393	■	■	■	■	■	0.079/.031/.047 .063/.094	■	◪	◪	-	□
Square 6	XN..04..R	0.079	0.118	■	◪	■	-	□	.016/.031	■	□	◪	-	◪
	XN..08..R	0.157	0.276	■	◪	■	-	□	.016/.031 .047/.063	□	■	□	-	◪

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Inch

Cutter	No. of cutting edges	Application	Cutter diameter available (inch)/number of teeth																Page
			0.375	0.50	0.625	0.75	0.875	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	
Double Turbo	4								2	3	4	5	6	8	10				23
											5	6	8	10	12				
Turbo 06	2		2	2	3	4	5	6											30, 31
				3	4	5	6	7	8	10									
Turbo 10	2			1	2	2	3	3	3	4	5								37
						3		4	5	6	7		10						
Turbo 12	2					2	2	2	3/4	4	4/5	4	4/7	5/8	8		12		47, 48
								3	4	5	7	6	10	12					
Turbo 16	2							2	2	3	4	5	6	8	9	12			47, 48
									3	4	5/6	6	8	10					
Turbo 18	2							2	2	3	3/4	5	4/6	5	8	9	12		63
									3	4	5	6	8	7/9	11	12			
Square T4 08	4				2	2		3	4	4	5								78
						3		4											
Square T4 12	4							2	3	4	5	6	8	10	12	14			85
												8							
Square 6 04	6							4	5	6	6								93
						3		5	6	7	8/9								
Square 6 08	6									3	4/5	4	5	6	7	12	8/12	10	93
											5	6/7	7/9	8/11	11				

x — Fixed pocket (x indicates number of teeth)

x — With cassette (x indicates number of teeth)

Slotting and contouring

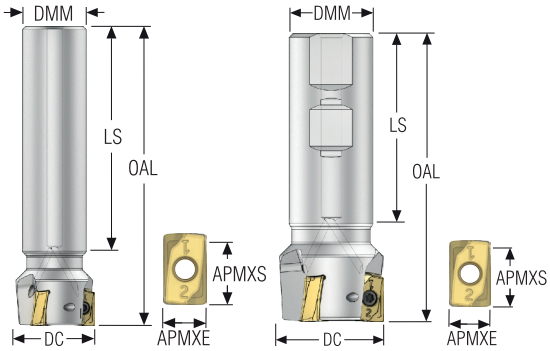
Optimized for contouring

DOUBLE TURBO 16

Using the most positive helix cutting angle geometry on the market today means less power consumption, smoother cutting and longer tool life. Together with the impressive 90-degree angle accuracy and the double-sided inserts, this generates a good surface finish and reduces costs.

- Reduced downtime boosts your material removal rate with a depth of cut capability up to 15 mm (0.59”)
- Cutter range metric, Ø 32-200 mm (Imperial Ø 1.250-5.000 inch)
- Reduced cost because of double-sided inserts with 4 cutting edges
- Insert type ZOMX16

Double Turbo 16 – R217.64-ZO16 – Metric



- For insert selection and cutting data recommendations, see page(s) 27-28
- For complete insert programme, see page(s) 785
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.64-3232.0-ZO16-2A	03290227	Cylindrical	32,0	2	15,0	5,0	32,0	113,0	150,0	0,35	49,0	62,0	11400	0,8	ZOMX16..
R217.64-3240.0-ZO16-3A	03290228	Cylindrical	40,0	3	15,0	5,0	32,0	113,0	150,0	0,25	65,0	78,0	11400	0,9	ZOMX16..
R217.64-3240.0-ZO16-4A	03290229	Cylindrical	40,0	4	15,0	5,0	32,0	113,0	150,0	0,25	65,0	78,0	11400	0,9	ZOMX16..
R217.64-3232.3-ZO16-2A	03290222	Weldon	32,0	2	15,0	5,0	32,0	73,0	110,0	0,35	49,0	62,0	11400	0,6	ZOMX16..
R217.64-3240.3-ZO16-3A	03290223	Weldon	40,0	3	15,0	5,0	32,0	73,0	110,0	0,25	65,0	78,0	10000	0,7	ZOMX16..
R217.64-3240.3-ZO16-4A	03290224	Weldon	40,0	4	15,0	5,0	32,0	73,0	110,0	0,25	65,0	78,0	10000	0,7	ZOMX16..

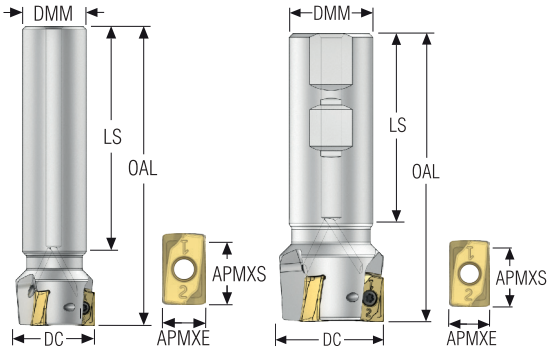
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.64-3232-3240	C04011B-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Turbo 16 – R217.64-ZO16 – *Inch*



- For insert selection and cutting data recommendations, see page(s) 27-28
- For complete insert programme, see page(s) 785
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.64-01.25-0-ZO16-2A	03290230	Cylindrical	1.250	2	0.591	0.197	1.250	4.449	7.677	0.35	1.890	2.402	11400	2.430	ZOMX16..
R217.64-01.50-0-ZO16-3A	03290231	Cylindrical	1.500	3	0.591	0.197	1.250	4.449	7.677	0.25	2.402	2.913	10000	2.430	ZOMX16..
R217.64-01.25-3-ZO16-2A	03290225	Weldon	1.250	2	0.591	0.197	1.250	2.874	4.331	0.25	1.890	2.402	11400	1.320	ZOMX16..
R217.64-01.50-3-ZO16-3A	03290226	Weldon	1.500	3	0.591	0.197	1.250	2.874	4.331	0.25	2.402	2.913	10000	1.320	ZOMX16..

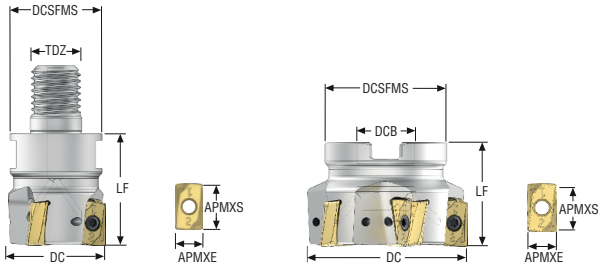
Spare Parts

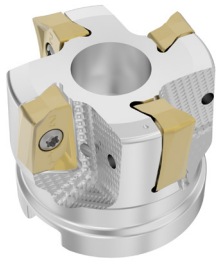
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.64-..	C04011B-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Turbo 16 – R217/220.64-ZO16 – Metric





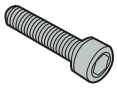
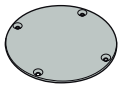
- For insert selection and cutting data recommendations, see page(s) 27-28
- For complete insert programme, see page(s) 785
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm		mm	mm	kg		
R217.64-1632.RE-ZO16-2A	03290232	Combimaster	32,0	2	15,0	5,0	–	M16	30,0	45,0	0,35	49,0	62,0	0,3	11400	ZOMX16..
R217.64-2040.RE-ZO16-3A	03290233	Combimaster	40,0	3	15,0	5,0	–	M20	37,0	45,0	0,25	65,0	78,0	0,4	10000	ZOMX16..
R217.64-2040.RE-ZO16-4A	03290234	Combimaster	40,0	4	15,0	5,0	–	M20	37,0	45,0	0,25	65,0	78,0	0,4	10000	ZOMX16..
R220.64-0050-ZO16-4A	03290239	Arbor	50,0	4	15,0	5,0	22,0	–	47,0	40,0	0,2	85,0	98,0	0,3	9000	ZOMX16..
R220.64-0050-ZO16-5A	03290240	Arbor	50,0	5	15,0	5,0	22,0	–	47,0	40,0	0,2	85,0	98,0	0,3	9000	ZOMX16..
R220.64-0063-ZO16-5A	03290241	Arbor	63,0	5	15,0	5,0	22,0	–	47,0	40,0	0,15	111,0	124,0	0,5	8200	ZOMX16..
R220.64-0063-ZO16-5A-27	10000039	Arbor	63,0	5	15,0	5,0	27,0	–	56,0	40,0	0,15	111,0	124,0	0,5	8200	ZOMX16..
R220.64-0063-ZO16-6A	03290242	Arbor	63,0	6	15,0	5,0	22,0	–	47,0	40,0	0,15	111,0	124,0	0,5	8200	ZOMX16..
R220.64-0063-ZO16-6A-27	10000040	Arbor	63,0	6	15,0	5,0	27,0	–	56,0	40,0	0,15	111,0	124,0	0,5	8200	ZOMX16..
R220.64-0080-ZO16-6A	03290243	Arbor	80,0	6	15,0	5,0	27,0	–	62,0	50,0	0,1	145,0	158,0	0,9	7200	ZOMX16..
R220.64-0080-ZO16-8A	03290244	Arbor	80,0	8	15,0	5,0	27,0	–	62,0	50,0	0,1	145,0	158,0	0,9	7200	ZOMX16..
R220.64-0100-ZO16-8A	03290245	Arbor	100,0	8	15,0	5,0	32,0	–	77,0	50,0	0,0	–	–	1,5	6500	ZOMX16..
R220.64-0100-ZO16-10A	03290246	Arbor	100,0	10	15,0	5,0	32,0	–	77,0	50,0	0,0	–	–	1,5	6500	ZOMX16..
R220.64-0125-ZO16-10A	03290247	Arbor	125,0	10	15,0	5,0	40,0	–	90,0	63,0	0,0	–	–	2,9	5800	ZOMX16..
R220.64-0125-ZO16-12A	03290248	Arbor	125,0	12	15,0	5,0	40,0	–	90,0	63,0	0,0	–	–	2,9	5800	ZOMX16..
R220.64-8160-ZO16-12A	03307754	Arbor	160,0	12	15,0	5,0	40,0	–	90,0	63,0	0,0	–	–	5,1	5100	ZOMX16..
R220.64-8160-ZO16-14A	03307755	Arbor	160,0	14	15,0	5,0	40,0	–	90,0	63,0	0,0	–	–	9,6	5100	ZOMX16..
R220.64-8200-ZO16-14A	03307756	Arbor	200,0	14	15,0	5,0	60,0	–	130,0	63,0	0,0	–	–	6,7	4500	ZOMX16..
R220.64-8200-ZO16-16A	03307757	Arbor	200,0	16	15,0	5,0	60,0	–	130,0	63,0	0,0	–	–	6,8	4500	ZOMX16..

For Combimaster Shanks, see Machining Navigator Tooling System

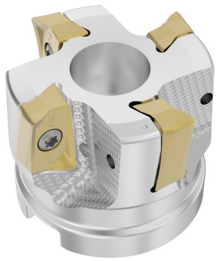
Spare Parts

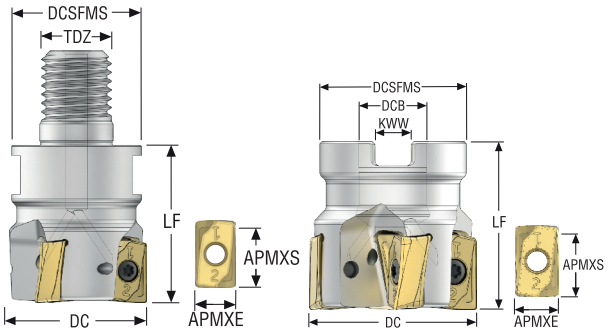
Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R217.64-1632-2040	–	C04011B-T15P	–	–	T00-15P35	3.5NM
R220.64-0050-0063	220.17-692	C04011B-T15P	–	–	T00-15P35	3.5NM
R220.64-0063-27	MLC6S12X30	C04011B-T15P	–	–	T00-15P35	3.5NM
R220.64-0080-0125	–	C04011B-T15P	–	–	T00-15P35	3.5NM
R220.64-8160	–	C04011B-T15P	SC-160-90	MF6S4X8	T00-15P35	3.5NM
R220.64-8200	–	C04011B-T15P	SC-200-90	MF6S4X8	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Turbo 16 – R217/220.64-ZO16 – Inch





- For insert selection and cutting data recommendations, see page(s) 27-28
- For complete insert programme, see page(s) 785
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch		Inch	Inch	lbs		
R217.64-01.25-16RE-ZO16-2A	03290235	Combimaster	1.250	2	0.591	0.197	–	M16	1.181	1.772	0.35	1.890	2.402	0.660	11400	ZOMX16..
R217.64-01.50-20RE-ZO16-3A	03290236	Combimaster	1.500	3	0.591	0.197	–	M20	1.457	1.772	0.25	2.402	2.913	0.880	10000	ZOMX16..
R220.64-02.00-ZO16-4A	03290250	Arbor	2.000	4	0.591	0.197	0.750	–	1.850	1.575	0.2	3.386	3.898	0.880	9000	ZOMX16..
R220.64-02.00-ZO16-5A	03290251	Arbor	2.000	5	0.591	0.197	0.750	–	1.850	1.575	0.2	3.386	3.898	0.880	9000	ZOMX16..
R220.64-02.50-ZO16-5A	03290252	Arbor	2.500	5	0.591	0.197	0.750	–	1.850	1.575	0.15	4.409	4.921	1.100	8200	ZOMX16..
R220.64-02.50-ZO16-6A	03290253	Arbor	2.500	6	0.591	0.197	0.750	–	1.850	1.575	0.15	4.409	4.921	1.100	8200	ZOMX16..
R220.64-03.00-ZO16-6A	03290254	Arbor	3.000	6	0.591	0.197	1.000	–	2.441	1.969	0.1	5.394	5.906	2.200	7200	ZOMX16..
R220.64-03.00-ZO16-8A	03290255	Arbor	3.000	8	0.591	0.197	1.000	–	2.441	1.969	0.1	5.394	5.906	2.200	7200	ZOMX16..
R220.64-04.00-ZO16-8A	03290256	Arbor	4.000	8	0.591	0.197	1.500	–	3.031	1.969	0.0	–	–	3.530	6500	ZOMX16..
R220.64-04.00-ZO16-10A	03290257	Arbor	4.000	10	0.591	0.197	1.500	–	3.031	1.969	0.0	–	–	3.530	6500	ZOMX16..
R220.64-05.00-ZO16-10A	03290258	Arbor	5.000	10	0.591	0.197	1.500	–	3.543	2.480	0.0	–	–	5.730	5800	ZOMX16..
R220.64-05.00-ZO16-12A	03290259	Arbor	5.000	12	0.591	0.197	1.500	–	3.543	2.480	0.0	–	–	7.280	5800	ZOMX16..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.64-..	–	C04011B-T15P	T00-15P35	31.0IN.LBS
R220.64-02.00-02.50	UC6S3/8UNFX1	C04011B-T15P	T00-15P35	31.0IN.LBS
R220.64-03.00	UC6S1/2UNFX1-1/4	C04011B-T15P	T00-15P35	31.0IN.LBS
R220.64-04.00-05.00	UC6S3/4UNFX1-1/4	C04011B-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.64-16 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	ZOMX160708TR-ME10 F40M	7,0 *0.28*	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
P2	ZOMX160708TR-ME10 F40M	7,0 *0.28*	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P3	ZOMX160708TR-M12 MP2500	7,0 *0.28*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P4	ZOMX160708TR-M12 MP2500	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P5	ZOMX160708TR-M12 MP2500	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P6	ZOMX160708TR-M12 MP2500	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P7	ZOMX160708TR-M12 MP2500	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P8	ZOMX160708TR-M12 MP2500	7,0 *0.28*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P11	ZOMX160708TR-M12 MS2500	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P12	ZOMX160708TR-M12 MS2500	6,0 *0.24*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M1	ZOMX160708TR-ME10 F40M	7,0 *0.28*	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
M2	ZOMX160708TR-ME10 F40M	7,0 *0.28*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
M3	ZOMX160708TR-ME10 F40M	6,0 *0.24*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M4	ZOMX160708TR-ME10 MS2050	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M5	ZOMX160708TR-ME10 MS2050	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
K1	ZOMX160708TR-M12 MK2050	7,0 *0.28*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K2	ZOMX160708TR-M12 MK2050	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K3	ZOMX160708TR-M12 MK2050	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K4	ZOMX160708TR-M12 MK2050	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K5	ZOMX160708TR-M12 MK2050	7,0 *0.28*	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
K6	ZOMX160708TR-M12 MK2050	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K7	ZOMX160708TR-M12 MP3000	7,0 *0.28*	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
S1	ZOMX160708TR-ME10 MS2050	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S2	ZOMX160708TR-ME10 MS2050	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S3	ZOMX160708TR-ME10 MS2050	4,5 *0.18*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S11	ZOMX160708TR-ME10 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*
S12	ZOMX160708TR-ME10 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*
S13	ZOMX160708TR-ME10 F40M	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
H5	ZOMX160708TR-M12 MP3000	6,0 *0.24*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
H8	ZOMX160708TR-M12 MP3000	5,0 *0.20*	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*
H11	ZOMX160708TR-M12 MP3000	6,0 *0.24*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
H12	ZOMX160708TR-M12 MP3000	5,0 *0.20*	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.64-16 – Cutting data v_c = (m/min)/*(sf/min)*

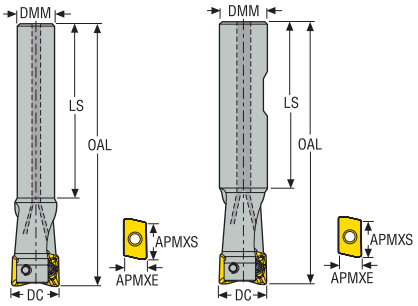
SMG	MP1500			MP2500			MP3000			MK2050			MS2050			MS2500			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	305	410	480	270	365	425	255	345	405	265	355	420	255	340	400	295	395	465	205	275	325
	1000	*1350*	*1575*	*890*	*1200*	*1400*	*840*	*1125*	*1325*	*870*	*1175*	*1375*	*840*	*1125*	*1300*	*970*	*1300*	*1525*	*670*	*900*	*1075*
P2	300	390	470	265	350	415	250	330	395	260	340	410	250	325	390	290	380	455	200	265	315
	980	*1275*	*1550*	*870*	*1150*	*1350*	*820*	*1075*	*1300*	*850*	*1125*	*1350*	*820*	*1075*	*1275*	*950*	*1250*	*1500*	*660*	*870*	*1025*
P3	260	345	405	230	305	360	220	290	340	230	300	355	215	285	340	250	330	390	175	230	270
	850	*1125*	*1325*	*750*	*1000*	*1175*	*720*	*950*	*1125*	*750*	*980*	*1175*	*710*	*940*	*1125*	*820*	*1075*	*1275*	*570*	*750*	*890*
P4	230	305	365	205	270	320	195	260	305	200	270	315	195	250	300	220	295	350	155	205	245
	750	*1000*	*1200*	*670*	*890*	*1050*	*640*	*850*	*1000*	*660*	*890*	*1025*	*640*	*820*	*980*	*720*	*970*	*1150*	*510*	*670*	*800*
P5	220	295	345	195	260	305	185	245	290	190	255	305	185	245	290	210	285	335	145	195	235
	720	*970*	*1125*	*640*	*850*	*1000*	*610*	*800*	*950*	*620*	*840*	*1000*	*610*	*800*	*950*	*690*	*940*	*1100*	*475*	*640*	*770*
P6	245	330	390	220	290	345	205	275	325	215	285	340	205	275	325	240	320	375	165	220	260
	800	*1075*	*1275*	*720*	*950*	*1125*	*670*	*900*	*1075*	*710*	*940*	*1125*	*670*	*900*	*1075*	*790*	*1050*	*1225*	*540*	*720*	*850*
P7	235	310	370	205	275	325	195	260	310	205	270	320	195	260	305	225	300	355	155	210	245
	770	*1025*	*1225*	*670*	*900*	*1075*	*640*	*850*	*1025*	*670*	*890*	*1050*	*640*	*850*	*1000*	*740*	*980*	*1175*	*510*	*690*	*800*
P8	220	290	340	195	255	300	185	240	285	190	250	295	180	240	290	210	280	330	145	195	230
	720	*950*	*1125*	*640*	*840*	*980*	*610*	*790*	*940*	*620*	*820*	*970*	*590*	*790*	*950*	*690*	*920*	*1075*	*475*	*640*	*750*
P11	225	300	355	200	265	315	190	255	300	195	265	310	190	255	295	220	290	345	150	205	240
	740	*980*	*1175*	*660*	*870*	*1025*	*620*	*840*	*980*	*640*	*870*	*1025*	*620*	*840*	*970*	*720*	*950*	*1125*	*490*	*670*	*790*
P12	150	195	235	130	175	205	125	165	195	130	170	205	125	165	195	145	190	225	100	130	155
	490	*640*	*770*	*425*	*570*	*670*	*410*	*540*	*640*	*425*	*560*	*670*	*410*	*540*	*640*	*475*	*620*	*740*	*330*	*425*	*510*
M1	—	—	—	190	250	300	185	245	295	—	—	—	200	265	315	205	270	325	160	210	255
	—	—	—	*620*	*820*	*980*	*610*	*800*	*970*	—	—	—	*660*	*870*	*1025*	*670*	*890*	*1075*	*520*	*690*	*840*
M2	—	—	—	155	210	245	155	205	245	—	—	—	165	220	260	170	225	270	135	175	210
	—	—	—	*510*	*690*	*800*	*510*	*670*	*800*	—	—	—	*540*	*720*	*850*	*560*	*740*	*890*	*445*	*570*	*690*
M3	—	—	—	125	170	205	125	165	200	—	—	—	135	180	210	140	185	220	110	145	170
	—	—	—	*410*	*560*	*670*	*410*	*540*	*660*	—	—	—	*445*	*590*	*690*	*460*	*610*	*720*	*360*	*475*	*560*
M4	—	—	—	100	135	155	100	130	155	—	—	—	105	140	165	110	145	170	85	110	130
	—	—	—	*330*	*445*	*510*	*330*	*425*	*510*	—	—	—	*345*	*460*	*540*	*360*	*475*	*560*	*280*	*360*	*425*
M5	—	—	—	85	110	130	80	110	130	—	—	—	90	115	135	90	120	140	70	95	110
	—	—	—	*280*	*360*	*425*	*260*	*360*	*425*	—	—	—	*295*	*375*	*445*	*295*	*395*	*460*	*230*	*310*	*360*
K1	235	310	370	210	275	330	200	260	310	280	370	440	—	—	—	—	—	—	160	210	250
	770	*1025*	*1225*	*690*	*900*	*1075*	*660*	*850*	*1025*	*920*	*1225*	*1450*	—	—	—	—	—	—	*520*	*690*	*820*
K2	210	280	330	185	245	290	175	235	275	250	330	390	—	—	—	—	—	—	140	185	220
	690	*920*	*1075*	*610*	*800*	*950*	*570*	*770*	*900*	*820*	*1075*	*1275*	—	—	—	—	—	—	*460*	*610*	*720*
K3	175	235	280	155	210	245	150	200	235	210	280	330	—	—	—	—	—	—	120	160	185
	570	*770*	*920*	*510*	*690*	*800*	*490*	*660*	*770*	*690*	*920*	*1075*	—	—	—	—	—	—	*395*	*520*	*610*
K4	170	225	265	150	200	235	140	190	225	200	265	315	—	—	—	—	—	—	115	150	180
	560	*740*	*870*	*490*	*660*	*770*	*460*	*620*	*740*	*660*	*870*	*1025*	—	—	—	—	—	—	*375*	*490*	*590*
K5	105	140	160	90	125	145	85	115	135	125	165	190	—	—	—	—	—	—	70	95	110
	345	*460*	*520*	*295*	*410*	*475*	*280*	*375*	*445*	*410*	*540*	*620*	—	—	—	—	—	—	*230*	*310*	*360*
K6	150	200	235	130	175	210	125	165	195	175	235	280	—	—	—	—	—	—	100	135	155
	490	*660*	*770*	*425*	*570*	*690*	*410*	*540*	*640*	*570*	*770*	*920*	—	—	—	—	—	—	*330*	*445*	*510*
K7	135	180	205	120	155	185	110	150	175	160	210	245	—	—	—	—	—	—	90	120	140
	445	*590*	*670*	*395*	*510*	*610*	*360*	*490*	*570*	*520*	*690*	*800*	—	—	—	—	—	—	*295*	*395*	*460*
S1	—	—	—	—	—	—	46	60	70	—	—	—	49	65	75	55	70	85	40	50	60
	—	—	—	—	—	—	*150*	*195*	*230*	—	—	—	*160*	*215*	*245*	*180*	*230*	*280*	*130*	*165*	*195*
S2	—	—	—	—	—	—	37	49	60	—	—	—	40	50	60	43	55	65	32	42	50
	—	—	—	—	—	—	*120*	*160*	*195*	—	—	—	*130*	*165*	*195*	*140*	*180*	*215*	*105*	*140*	*165*
S3	—	—	—	—	—	—	33	43	50	—	—	—	35	46	55	38	50	60	28	37	43
	—	—	—	—	—	—	*110*	*140*	*165*	—	—	—	*115*	*150*	*180*	*125*	*165*	*195*	*90*	*120*	*140*
S11	—	—	—	—	—	—	65	85	100	—	—	—	70	90	105	75	95	115	55	70	85
	—	—	—	—	—	—	*215*	*280*	*330*	—	—	—	*230*	*295*	*345*	*245*	*310*	*375*	*180*	*230*	*280*
S12	—	—	—	—	—	—	44	60	70	—	—	—	47	65	75	50	65	80	38	50	60
	—	—	—	—	—	—	*145*	*195*	*230*	—	—	—	*155*	*215*	*245*	*165*	*215*	*260*	*125*	*165*	*195*
S13	—	—	—	—	—	—	26	34	40	—	—	—	28	36	43	30	40	47	22	30	35
	—	—	—	—	—	—	*85*	*110*	*130*	—	—	—	*90*	*120*	*140*	*100*	*130*	*155*	*70*	*100*	*115*
H5	49	65	75	40	55	60	39	50	60	—	—	—	—	—	—	—	—	—	33	44	50
	160	*215*	*245*	*130*	*180*	*195*	*130*	*165*	*195*	—	—	—	—	—	—	—	—	—	*110*	*145*	*165*
H8	55	70	80	43	55	65	42	55	65	—	—	—	—	—	—	—	—	—	36	47	55
	180	*230*	*260*	*140*	*180*	*215*	*140*	*180*	*215*	—	—	—	—	—	—	—	—	—	*120*	*155*	*180*
H11	65	85	100	50	65	80	49	65	75	—	—	—	—	—	—	—	—	—	42	55	65
	215	*280*	*330*	*165*	*215*	*260*	*160*	*215*	*245*	—	—	—	—	—	—	—	—	—	*140*	*180*	*215*
H12	95	125	145	85	110	130	80	105	125	—	—	—	—	—	—	—	—	—	65	85	100
	310	*410*	*475*	*280*	*360*	*425*	*260*	*345*	*410*	—	—	—	—	—	—	—	—	—	*215*	*280*	*330*

TURBO CUTTERS

The Turbo family takes square shoulder milling to the max. Suitable for most roughing, semi-finishing and finishing operations, these highly versatile cutters offer long tool life and high precision via optimized properties that reduce heat generation and cutting forces.

- Turbo 06 Insert size 06, cutter range metric, Ø 10-40 mm (Imperial Ø 0.375-1.500 inch)
- Turbo 10 Insert size 10, cutter range metric, Ø 16-100mm (Imperial Ø 0.500-3.000 inch)
- Turbo 12 Insert size 12, cutter range metric, Ø 20-250 mm (Imperial Ø 0.750-4.000 inch)
- Turbo 16 Insert size 16, cutter range metric, Ø 25-250 mm (Imperial Ø 1.000-6.000 inch)
- Turbo 18 Insert size 18, cutter range metric, Ø 32-250 mm (Imperial Ø 1.000-6.000 inch)

Turbo 06 – R217.69-06 – Metric



- For insert selection and cutting data recommendations, see page(s) 35-36
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.69-0810.0-06-2AN	02690707	Cylindrical	10,0	2	5,0	3,0	8,0	82,0	100,0	10,0	14,5	19,0	60000	0,1	XO.X06..
R217.69-0810.0-06-2N	02690736	Cylindrical	10,0	2	5,0	3,0	8,0	82,0	100,0	10,0	14,5	19,0	60000	0,1	XO.X06..
R217.69-1010.0-06-2AD	00035456	Cylindrical	10,0	2	5,0	3,0	10,0	38,0	55,0	10,0	14,5	19,0	60000	0,2	XO.X06..
R217.69-1010.0-06-2AN	02690714	Cylindrical	10,0	2	5,0	3,0	10,0	38,0	55,0	10,0	14,5	19,0	60000	0,1	XO.X06..
R217.69-1010.0-06-2N	02690737	Cylindrical	10,0	2	5,0	3,0	10,0	82,0	100,0	10,0	14,5	19,0	60000	0,1	XO.X06..
R217.69-1012.0-06-2AN	02690712	Cylindrical	12,0	2	5,0	3,0	10,0	102,0	120,0	6,5	18,5	23,0	54400	0,1	XO.X06..
R217.69-1012.0-06-2N	02690738	Cylindrical	12,0	2	5,0	3,0	10,0	102,0	120,0	6,5	18,5	23,0	54400	0,1	XO.X06..
R217.69-1212.0-06-2AN	02690715	Cylindrical	12,0	2	5,0	3,0	12,0	62,0	80,0	6,5	18,5	23,0	54400	0,1	XO.X06..
R217.69-1212.0-06-2N	02690739	Cylindrical	12,0	2	5,0	3,0	12,0	102,0	120,0	6,5	18,5	23,0	54400	0,2	XO.X06..
R217.69-1212.0-06-3AD	00035457	Cylindrical	12,0	3	5,0	3,0	12,0	62,0	80,0	6,5	18,5	23,0	54400	0,2	XO.X06..
R217.69-1212.0-06-3AN	02690724	Cylindrical	12,0	3	5,0	3,0	12,0	42,0	60,0	6,5	18,5	23,0	54400	0,1	XO.X06..
R217.69-1214.0-06-3AN	02690708	Cylindrical	14,0	3	5,0	3,0	12,0	122,0	140,0	5,0	22,5	27,0	51200	0,2	XO.X06..
R217.69-1416.0-06-3AN	02690713	Cylindrical	16,0	3	5,0	3,0	14,0	140,0	160,0	4,0	26,5	31,0	48000	0,2	XO.X06..
R217.69-1616.0-06-3AN	02690717	Cylindrical	16,0	3	5,0	3,0	16,0	70,0	90,0	4,0	26,5	31,0	48000	0,2	XO.X06..
R217.69-1616.0-06-4AD	00035458	Cylindrical	16,0	4	5,0	3,0	16,0	70,0	90,0	4,0	26,5	31,0	48000	0,3	XO.X06..
R217.69-1616.0-06-4AN	02690718	Cylindrical	16,0	4	5,0	3,0	16,0	70,0	90,0	4,0	26,5	31,0	48000	0,2	XO.X06..
R217.69-1618.0-06-4AN	02690710	Cylindrical	18,0	4	5,0	3,0	16,0	160,0	180,0	3,0	30,5	35,0	45600	0,3	XO.X06..
R217.69-1820.0-06-4AN	02690711	Cylindrical	20,0	4	5,0	3,0	18,0	180,0	200,0	2,5	34,5	39,0	44000	0,4	XO.X06..
R217.69-2020.0-06-4AN	02690703	Cylindrical	20,0	4	5,0	3,0	20,0	85,0	105,0	2,5	34,5	39,0	44000	0,3	XO.X06..
R217.69-2020.0-06-5AD	00035459	Cylindrical	20,0	5	5,0	3,0	20,0	85,0	105,0	2,5	34,5	39,0	44000	0,5	XO.X06..
R217.69-2020.0-06-5AN	02690720	Cylindrical	20,0	5	5,0	3,0	20,0	85,0	105,0	2,5	34,5	39,0	44000	0,3	XO.X06..
R217.69-2025.0-06-7AN	02690721	Cylindrical	25,0	7	5,0	3,0	20,0	95,0	115,0	2,5	44,5	49,0	37600	0,3	XO.X06..
R217.69-2532.0-06-8AN	02690723	Cylindrical	32,0	8	5,0	3,0	25,0	105,0	130,0	1,5	58,5	63,0	33600	0,5	XO.X06..
R217.69-3240.0-06-10AN	02690725	Cylindrical	40,0	10	5,0	3,0	32,0	115,0	140,0	1,0	74,5	79,0	28000	0,9	XO.X06..
R217.69-1616.3-06-3AN	02690646	Weldon	16,0	3	5,0	3,0	16,0	50,0	70,0	4,0	26,5	31,0	48000	0,1	XO.X06..
R217.69-1616.3-06-4AN	02690647	Weldon	16,0	4	5,0	3,0	16,0	50,0	70,0	4,0	26,5	31,0	48000	0,1	XO.X06..
R217.69-2020.3-06-4AN	02690648	Weldon	20,0	4	5,0	3,0	20,0	60,0	80,0	2,5	34,5	39,0	44000	0,2	XO.X06..
R217.69-2020.3-06-5AN	02690649	Weldon	20,0	5	5,0	3,0	20,0	65,0	85,0	2,5	34,5	39,0	44000	0,3	XO.X06..
R217.69-2025.3-06-7AN	02690650	Weldon	25,0	7	5,0	3,0	20,0	70,0	90,0	2,5	44,5	49,0	37600	0,2	XO.X06..

Modification of the cutter body needed for radii > 0,8 mm

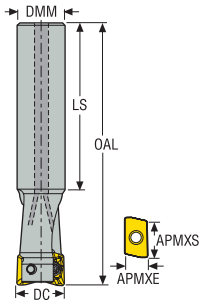
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..	C01804-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 06 – R217.69-06 – Inch



- For insert selection and cutting data recommendations, see page(s) 35-36
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.69-00.375-0-06-2AN	02694880	Cylindrical	0.375	2	0.197	0.118	0.375	1.496	2.165	10.0	0.531	0.709	60000	0.220	XO.X06..
R217.69-00.375-0-06-2LAN	02694883	Cylindrical	0.375	2	0.197	0.118	0.313	3.228	3.937	10.0	0.531	0.709	60000	0.440	XO.X06..
R217.69-00.50-0-06-2AN	02694884	Cylindrical	0.500	2	0.197	0.118	0.500	2.441	3.150	6.5	0.768	0.945	54000	0.440	XO.X06..
R217.69-00.50-0-06-2LAN	02694886	Cylindrical	0.500	2	0.197	0.118	0.375	3.228	3.937	6.5	0.768	0.945	54000	0.440	XO.X06..
R217.69-00.50-0-06-3AN	02694887	Cylindrical	0.500	3	0.197	0.118	0.500	1.654	2.362	6.0	0.768	0.945	54000	0.440	XO.X06..
R217.69-00.625-0-06-3AN	02694889	Cylindrical	0.625	3	0.197	0.118	0.625	2.756	3.543	4.0	1.024	1.201	48000	0.440	XO.X06..
R217.69-00.625-0-06-3LAN	02694890	Cylindrical	0.625	3	0.197	0.118	0.500	4.134	4.921	4.0	1.024	1.201	48000	0.440	XO.X06..
R217.69-00.625-0-06-4AN	02694891	Cylindrical	0.625	4	0.197	0.118	0.625	2.756	3.543	4.0	1.024	1.201	48000	0.440	XO.X06..
R217.69-00.75-0-06-4AN	02694892	Cylindrical	0.750	4	0.197	0.118	0.750	3.150	3.937	2.0	1.280	1.457	44000	0.660	XO.X06..
R217.69-00.75-0-06-4LAN	02694898	Cylindrical	0.750	4	0.197	0.118	0.625	5.118	5.906	2.0	1.280	1.457	44000	0.660	XO.X06..
R217.69-00.75-0-06-5AN	02694896	Cylindrical	0.750	5	0.197	0.118	0.750	3.150	3.937	2.5	1.280	1.457	44000	0.660	XO.X06..
R217.69-00.875-0-06-5LAN	02694899	Cylindrical	0.875	5	0.197	0.118	0.750	5.118	5.906	2.0	1.535	1.713	44000	0.660	XO.X06..
R217.69-01.00-0-06-6LAN	02694903	Cylindrical	1.000	6	0.197	0.118	0.750	7.087	7.874	1.0	1.772	1.949	37600	1.100	XO.X06..
R217.69-01.00-0-06-7AN	02694904	Cylindrical	1.000	7	0.197	0.118	1.000	3.740	4.528	1.5	1.772	1.949	37600	0.880	XO.X06..
R217.69-01.25-0-06-8AN	02694907	Cylindrical	1.250	8	0.197	0.118	1.000	4.134	5.118	1.0	2.283	2.461	33600	1.320	XO.X06..

Modification of the cutter body needed for radii > 0.031 in

Spare Parts

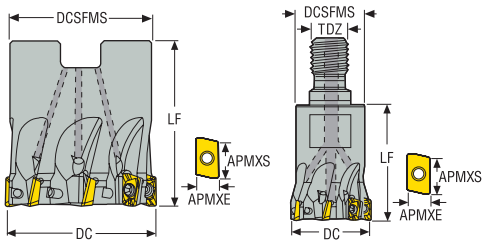
For cutter	Insert screw
R217.69-..	C01804-T06P

Accessories

Torque key	Torque value
T00-06P05	4.4IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 06 – R217/220.69-06 – Metric



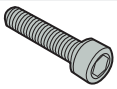
- For insert selection and cutting data recommendations, see page(s) 35-36
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm		mm	mm	kg		
R217.69-0816.RE-06-4AN	02690643	Combimaster	16,0	4	5,0	3,0	–	M8	13,5	23,0	7,5	26,5	31,0	0,1	48000	XO.X06..
R217.69-1020.RE-06-5AN	02690641	Combimaster	20,0	5	5,0	3,0	–	M10	18,0	28,0	4,5	34,5	39,0	0,1	44000	XO.X06..
R217.69-1225.RE-06-7AN	02690642	Combimaster	25,0	7	5,0	3,0	–	M12	21,0	30,0	2,5	44,5	49,0	0,1	37600	XO.X06..
R217.69-1632.RE-06-8AN	02690638	Combimaster	32,0	8	5,0	3,0	–	M16	28,0	35,0	1,5	58,5	63,0	0,2	33600	XO.X06..
R217.69-1640.RE-06-10AN	02690639	Combimaster	40,0	10	5,0	3,0	–	M16	28,0	40,0	1,0	74,5	79,0	0,3	28000	XO.X06..
R220.69-0032-06-8AN	02690741	Arbor	32,0	8	5,0	3,0	16,0	–	30,0	35,0	1,5	58,5	63,0	0,2	33600	XO.X06..
R220.69-0040-06-10AN	02690742	Arbor	40,0	10	5,0	3,0	16,0	–	35,0	35,0	1,0	74,5	79,0	0,2	18600	XO.X06..

Modification of the cutter body needed for radii > 0,8 mm
For Combimaster Shanks, see Machining Navigator Tooling System

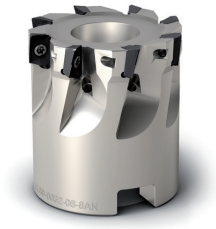
Spare Parts

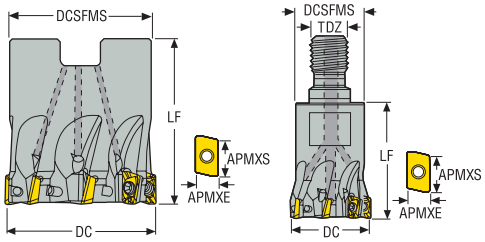
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.69-..	–	C01804-T06P	T00-06P05	0.5NM
R220.69-..	TCEI0825	C01804-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 06 – R217/220.69-06 – Inch





- For insert selection and cutting data recommendations, see page(s) 35-36
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch		Inch	Inch	lbs		
R217.69-00.75-10RE-06-5AN	02695008	Combimaster	0.750	5	0.197	0.118	–	M10	0.709	1.181	2.0	1.280	1.457	0.440	44000	XO.X06..
R217.69-00.87-12RE-06-6AN	02695012	Combimaster	0.875	6	0.197	0.118	–	M12	0.827	1.378	2.0	1.516	1.693	0.440	44000	XO.X06..
R217.69-01.00-12RE-06-7AN	02695013	Combimaster	1.000	7	0.197	0.118	–	M12	0.906	1.378	1.5	1.772	1.949	0.440	37600	XO.X06..
R220.69-01.25-06-8AN	02694913	Arbor	1.250	8	0.197	0.118	0.500	–	1.181	1.378	1.0	2.283	2.461	0.440	33600	XO.X06..
R220.69-01.50-06-10AN	02694915	Arbor	1.500	10	0.197	0.118	0.500	–	1.378	1.378	1.0	2.776	2.953	0.660	28000	XO.X06..

Modification of the cutter body needed for radii > 0.031 in
For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.69-..	–	C01804-T06P	T00-06P05	4.4IN.LBS
R220.69-..	UC6S1/4UNFX1	C01804-T06P	T00-06P05	4.4IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-06 – Insert selection – mm/*Inch*

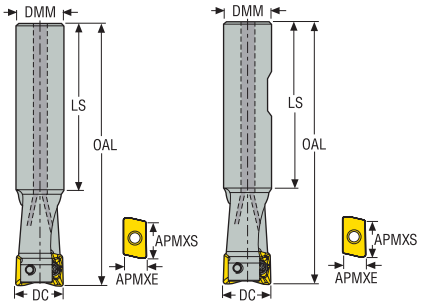
SMG		a_p	f_z		
			100%	30%	10%
P1	XOMX060204R-M05 F40M	2,5 *0.10*	0,070 *0.0028*	0,075 *0.0030*	0,12 *0.0048*
P2	XOMX060204R-M05 F40M	2,5 *0.10*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
P3	XOMX060204R-M05 F40M	2,5 *0.10*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*
P4	XOMX060204R-M05 F40M	2,5 *0.10*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
P5	XOMX060204R-M05 F40M	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
P6	XOMX060204R-M05 F40M	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
P7	XOMX060204R-M05 F40M	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
P8	XOMX060204R-M05 F40M	2,5 *0.10*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*
P11	XOMX060204R-M05 MP3000	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
P12	XOMX060204R-M05 MP3000	2,0 *0.080*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*
M1	XOMX060204R-M05 F40M	2,5 *0.10*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
M2	XOMX060204R-M05 F40M	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
M3	XOMX060204R-M05 F40M	2,0 *0.080*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
M4	XOMX060204R-M05 MP3000	1,5 *0.060*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*
M5	XOMX060204R-M05 MM4500	1,5 *0.060*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*
K1	XOMX060204R-M05 MP3000	2,5 *0.10*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
K2	XOMX060204R-M05 MP3000	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
K3	XOMX060204R-M05 MP3000	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
K4	XOMX060204R-M05 MP3000	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
K5	XOMX060204R-M05 MP3000	2,5 *0.10*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
K6	XOMX060204R-M05 MP3000	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
K7	XOMX060204R-M05 MP3000	2,5 *0.10*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
N1	XOEX060204FR-E03 H15	2,5 *0.10*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
N2	XOEX060204FR-E03 H15	2,5 *0.10*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
N3	XOEX060204FR-E03 H15	2,5 *0.10*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
N11	XOEX060204FR-E03 H15	2,5 *0.10*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S1	XOMX060204R-M05 F40M	1,5 *0.060*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*
S2	XOMX060204R-M05 F40M	1,5 *0.060*	0,048 *0.0019*	0,050 *0.0020*	0,075 *0.0030*
S3	XOMX060204R-M05 F40M	1,5 *0.060*	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*
S11	XOMX060204R-M05 MS2050	1,7 *0.065*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
S12	XOMX060204R-M05 MS2050	1,7 *0.065*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
S13	XOMX060208R-M05 MS2050	1,5 *0.060*	0,050 *0.0020*	0,055 *0.0022*	0,080 *0.0032*
H5	XOMX060204R-M05 MP3000	2,0 *0.080*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*
H8	XOMX060204R-M05 MP3000	1,7 *0.065*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
H11	XOMX060204R-M05 MP3000	2,0 *0.080*	0,046 *0.0018*	0,050 *0.0020*	0,075 *0.0030*
H12	XOMX060204R-M05 MP3000	1,7 *0.065*	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*

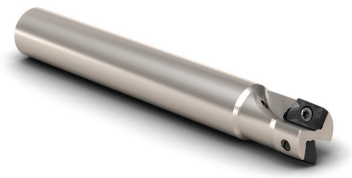
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.69-06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			MM4500			MS2050			F30M			F40M			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	340	450	520	220	290	340	300	395	460	285	375	440	275	360	420	—	—	—
	1125	*1475*	*1700*	*720*	*950*	*1125*	*980*	*1300*	*1500*	*940*	*1225*	*1450*	*900*	*1175*	*1375*	—	—	—
P2	330	430	510	215	280	330	290	380	450	280	360	425	265	345	405	—	—	—
	1075	*1400*	*1675*	*710*	*920*	*1075*	*950*	*1250*	*1475*	*920*	*1175*	*1400*	*870*	*1125*	*1325*	—	—	—
P3	285	375	445	185	245	290	250	330	390	240	315	375	230	300	355	—	—	—
	940	*1225*	*1450*	*610*	*800*	*950*	*820*	*1075*	*1275*	*790*	*1025*	*1225*	*750*	*980*	*1175*	—	—	—
P4	255	330	395	165	215	255	225	290	345	215	280	330	205	265	315	—	—	—
	840	*1075*	*1300*	*540*	*710*	*840*	*740*	*950*	*1125*	*710*	*920*	*1075*	*670*	*870*	*1025*	—	—	—
P5	245	320	375	160	210	245	215	280	330	205	270	315	195	255	300	—	—	—
	800	*1050*	*1225*	*520*	*690*	*800*	*710*	*920*	*1075*	*670*	*890*	*1025*	*640*	*840*	*980*	—	—	—
P6	275	360	420	180	235	275	240	315	370	230	305	355	220	290	335	—	—	—
	900	*1175*	*1375*	*590*	*770*	*900*	*790*	*1025*	*1225*	*750*	*1000*	*1175*	*720*	*950*	*1100*	—	—	—
P7	260	340	395	170	220	260	230	300	350	215	285	335	205	270	320	—	—	—
	850	*1125*	*1300*	*560*	*720*	*850*	*750*	*980*	*1150*	*710*	*940*	*1100*	*670*	*890*	*1050*	—	—	—
P8	240	315	375	155	205	245	210	280	330	200	265	315	190	255	300	—	—	—
	790	*1025*	*1225*	*510*	*670*	*800*	*690*	*920*	*1075*	*660*	*870*	*1025*	*620*	*840*	*980*	—	—	—
P11	250	330	385	165	215	250	220	290	340	210	275	325	200	265	310	—	—	—
	820	*1075*	*1275*	*540*	*710*	*820*	*720*	*950*	*1125*	*690*	*900*	*1075*	*660*	*870*	*1025*	—	—	—
P12	160	210	245	105	135	160	140	185	215	135	175	205	130	170	195	—	—	—
	520	*690*	*800*	*345*	*445*	*520*	*460*	*610*	*710*	*445*	*570*	*670*	*425*	*560*	*640*	—	—	—
M1	250	320	380	185	240	285	235	305	360	225	290	345	215	280	330	—	—	—
	820	*1050*	*1250*	*610*	*790*	*940*	*770*	*1000*	*1175*	*740*	*950*	*1125*	*710*	*920*	*1075*	—	—	—
M2	205	270	315	150	200	235	195	255	295	185	245	285	175	230	270	—	—	—
	670	*890*	*1025*	*490*	*660*	*770*	*640*	*840*	*970*	*610*	*800*	*940*	*570*	*750*	*890*	—	—	—
M3	160	215	250	120	160	185	155	200	235	145	195	225	140	185	215	—	—	—
	520	*710*	*820*	*395*	*520*	*610*	*510*	*660*	*770*	*475*	*640*	*740*	*460*	*610*	*710*	—	—	—
M4	125	165	195	95	125	145	120	160	185	115	150	175	110	145	165	—	—	—
	410	*540*	*640*	*310*	*410*	*475*	*395*	*520*	*610*	*375*	*490*	*570*	*360*	*475*	*540*	—	—	—
M5	105	140	160	80	105	120	100	130	150	95	125	145	90	120	140	—	—	—
	345	*460*	*520*	*260*	*345*	*395*	*330*	*425*	*490*	*310*	*410*	*475*	*295*	*395*	*460*	—	—	—
K1	265	340	405	—	—	—	—	—	—	220	285	340	210	275	325	—	—	—
	870	*1125*	*1325*	—	—	—	—	—	—	*720*	*940*	*1125*	*690*	*900*	*1075*	—	—	—
K2	230	305	355	—	—	—	—	—	—	195	255	300	185	245	285	—	—	—
	750	*1000*	*1175*	—	—	—	—	—	—	*640*	*840*	*980*	*610*	*800*	*940*	—	—	—
K3	195	260	300	—	—	—	—	—	—	165	215	255	155	205	240	—	—	—
	640	*850*	*980*	—	—	—	—	—	—	*540*	*710*	*840*	*510*	*670*	*790*	—	—	—
K4	185	245	285	—	—	—	—	—	—	155	205	240	150	195	230	—	—	—
	610	*800*	*940*	—	—	—	—	—	—	*510*	*670*	*790*	*490*	*640*	*750*	—	—	—
K5	115	150	175	—	—	—	—	—	—	95	125	145	90	120	140	—	—	—
	375	*490*	*570*	—	—	—	—	—	—	*310*	*410*	*475*	*295*	*395*	*460*	—	—	—
K6	165	215	255	—	—	—	—	—	—	140	180	215	130	175	205	—	—	—
	540	*710*	*840*	—	—	—	—	—	—	*460*	*590*	*710*	*425*	*570*	*670*	—	—	—
K7	145	190	225	—	—	—	—	—	—	120	160	190	115	150	180	—	—	—
	475	*620*	*740*	—	—	—	—	—	—	*395*	*520*	*620*	*375*	*490*	*590*	—	—	—
N1	1950	2575	3025	—	—	—	—	—	—	1650	2150	2550	1575	2050	2425	1650	2175	2575
	6400	*8450*	*9925*	—	—	—	—	—	—	*5425*	*7050*	*8375*	*5175*	*6725*	*7950*	*5425*	*7125*	*8450*
N2	790	1025	1225	—	—	—	—	—	—	660	870	1025	630	830	980	670	880	1050
	2600	*3375*	*4025*	—	—	—	—	—	—	*2175*	*2850*	*3375*	*2075*	*2725*	*3225*	*2200*	*2875*	*3450*
N3	530	690	820	—	—	—	—	—	—	445	580	690	420	550	650	445	590	690
	1750	*2275*	*2700*	—	—	—	—	—	—	*1450*	*1900*	*2275*	*1375*	*1800*	*2125*	*1450*	*1925*	*2275*
N11	600	790	930	—	—	—	—	—	—	510	660	780	480	630	750	510	670	790
	1975	*2600*	*3050*	—	—	—	—	—	—	*1675*	*2175*	*2550*	*1575*	*2075*	*2450*	*1675*	*2200*	*2600*
S1	60	80	90	29	38	44	55	75	85	55	70	80	50	65	80	—	—	—
	195	*260*	*295*	*95*	*125*	*145*	*180*	*245*	*280*	*180*	*230*	*260*	*165*	*215*	*260*	—	—	—
S2	48	65	70	23	30	35	45	60	70	43	55	65	41	55	60	—	—	—
	155	*215*	*230*	*75*	*100*	*115*	*150*	*195*	*230*	*140*	*180*	*215*	*135*	*180*	*195*	—	—	—
S3	42	55	65	20	26	31	39	50	60	38	49	55	36	47	55	—	—	—
	140	*180*	*215*	*65*	*85*	*100*	*130*	*165*	*195*	*125*	*160*	*180*	*120*	*155*	*180*	—	—	—
S11	80	110	125	40	55	60	80	100	120	75	100	115	70	95	110	—	—	—
	260	*360*	*410*	*130*	*180*	*195*	*260*	*330*	*395*	*245*	*330*	*375*	*230*	*310*	*360*	—	—	—
S12	55	75	85	37	48	55	55	70	80	43	55	65	49	65	75	—	—	—
	180	*245*	*280*	*120*	*155*	*180*	*180*	*230*	*260*	*140*	*180*	*215*	*160*	*215*	*245*	—	—	—
S13	33	44	50	22	28	33	31	41	48	25	33	38	29	38	44	—	—	—
	110	*145*	*165*	*70*	*90*	*110*	*100*	*135*	*155*	*80*	*110*	*125*	*95*	*125*	*145*	—	—	—
H5	50	65	75	—	—	—	—	—	—	45	60	70	43	55	65	—	—	—
	165	*215*	*245*	—	—	—	—	—	—	*150*	*195*	*230*	*140*	*180*	*215*	—	—	—
H8	55	70	80	—	—	—	—	—	—	47	60	70	45	60	70	—	—	—
	180	*230*	*260*	—	—	—	—	—	—	*155*	*195*	*230*	*150*	*195*	*230*	—	—	—
H11	65	85	95	—	—	—	—	—	—	55	75	85	55	70	85	—	—	—
	215	*280*	*310*	—	—	—	—	—	—	*180*	*245*	*280*	*180*	*230*	*280*	—	—	—
H12	100	130	155	—	—	—	—	—	—	85	110	130	80	105	125	—	—	—
	330	*425*	*510*	—	—	—	—	—	—	*280*	*360*	*425*	*260*	*345*	*410*	—	—	—

Turbo 10 – R217.69-10 – Metric





- For insert selection and cutting data recommendations, see page(s) 42-44
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.69-1416.0-10-2A	02772250	Cylindrical	16,0	2	9,0	6,0	14,0	134,0	160,0	7,5	21,0	30,5	29400	0,2	XO.X10..
R217.69-1616.0-10-2A	02769179	Cylindrical	16,0	2	9,0	6,0	16,0	105,0	135,0	7,5	21,0	30,5	29400	0,2	XO.X10..
R217.69-1618.0-10-2A	02772252	Cylindrical	18,0	2	9,0	6,0	16,0	134,0	160,0	6,0	25,0	34,5	27800	0,3	XO.X10..
R217.69-1820.0-10-2A	02769205	Cylindrical	20,0	2	9,0	6,0	18,0	170,0	200,0	4,5	29,0	38,5	26300	0,4	XO.X10..
R217.69-2020.0-10-2A	02769206	Cylindrical	20,0	2	9,0	6,0	20,0	115,0	150,0	4,5	29,0	38,5	26300	0,4	XO.X10..
R217.69-2020.0-10-3A	02769209	Cylindrical	20,0	3	9,0	6,0	20,0	115,0	150,0	4,5	29,0	38,5	26300	0,3	XO.X10..
R217.69-2225.0-10-3A	02772253	Cylindrical	25,0	3	9,0	6,0	22,0	170,0	200,0	3,0	39,0	48,5	23500	0,6	XO.X10..
R217.69-2525.0-10-3A	02769218	Cylindrical	25,0	3	9,0	6,0	25,0	130,0	170,0	3,0	39,0	48,5	23500	0,6	XO.X10..
R217.69-2525.0-10-4A	02769224	Cylindrical	25,0	4	9,0	6,0	25,0	130,0	170,0	3,0	39,0	48,5	23500	0,6	XO.X10..
R217.69-3232.0-10-3A	02769230	Cylindrical	32,0	3	9,0	6,0	32,0	155,0	195,0	2,0	53,0	62,5	20800	1,1	XO.X10..
R217.69-3232.0-10-5A	02769231	Cylindrical	32,0	5	9,0	6,0	32,0	155,0	195,0	2,0	53,0	62,5	20800	1,1	XO.X10..
R217.69-1616.3-10-2A	02769180	Weldon	16,0	2	9,0	6,0	16,0	54,0	78,0	7,5	21,0	30,5	29400	0,1	XO.X10..
R217.69-2018.3-10-2A	02772254	Weldon	18,0	2	9,0	6,0	20,0	56,0	85,0	6,0	25,0	34,5	27800	0,2	XO.X10..
R217.69-2020.3-10-2A	02769210	Weldon	20,0	2	9,0	6,0	20,0	61,0	90,0	4,5	29,0	38,5	26300	0,2	XO.X10..
R217.69-2020.3-10-3A	02769212	Weldon	20,0	3	9,0	6,0	20,0	61,0	90,0	4,5	29,0	38,5	26300	0,2	XO.X10..
R217.69-2525.3-10-3A	02769225	Weldon	25,0	3	9,0	6,0	25,0	67,0	101,0	3,0	39,0	48,5	23500	0,4	XO.X10..
R217.69-2525.3-10-4A	02769227	Weldon	25,0	4	9,0	6,0	25,0	67,0	101,0	3,0	39,0	48,5	23500	0,3	XO.X10..
R217.69-3232.3-10-3A	02769232	Weldon	32,0	3	9,0	6,0	32,0	75,0	110,0	2,0	53,0	62,5	20800	0,6	XO.X10..
R217.69-3232.3-10-5A	02769233	Weldon	32,0	5	9,0	6,0	32,0	75,0	110,0	2,0	53,0	62,5	20800	0,6	XO.X10..

Modification of the cutter body needed for radii > 2,0 mm

Spare Parts

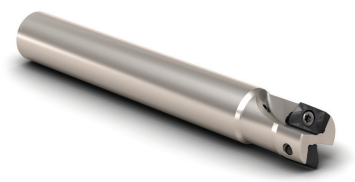
For cutter	Insert screw
R217.69-..	C02506-T07P

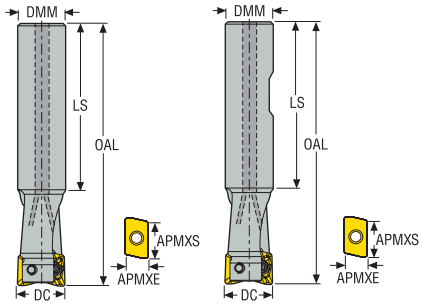
Accessories

Torque key	Torque value
T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 10 – R217.69-10 – Inch





- For insert selection and cutting data recommendations, see page(s) 42-44
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.69-00.62-0-10-2A	02772633	Cylindrical	0.625	2	0.354	0.236	0.625	4.232	5.315	7.5	0.807	1.181	29400	0.440	XO.X10..
R217.69-00.75-0-10-2A	02772636	Cylindrical	0.750	2	0.354	0.236	0.750	4.724	5.906	5.0	1.063	1.437	26300	0.660	XO.X10..
R217.69-00.87-0-10-3A	02772719	Cylindrical	0.875	3	0.354	0.236	0.750	4.724	5.906	5.0	1.299	1.673	26300	0.660	XO.X10..
R217.69-01.00-0-10-3A	02772707	Cylindrical	1.000	3	0.354	0.236	1.000	5.413	6.693	3.0	1.555	1.929	23500	1.320	XO.X10..
R217.69-01.00-0-10-4A	02772710	Cylindrical	1.000	4	0.354	0.236	1.000	5.413	6.693	3.0	1.555	1.929	23500	1.320	XO.X10..
R217.69-01.25-0-10-5A	02772728	Cylindrical	1.250	5	0.354	0.236	1.250	6.437	7.677	2.0	2.067	2.441	20800	2.430	XO.X10..
R217.69-01.50-0-10-4A	02773425	Cylindrical	1.500	4	0.354	0.236	1.250	6.437	7.677	1.5	2.559	2.933	18600	2.650	XO.X10..
R217.69-00.50-3-10-1A	03058730	Weldon	0.500	1	0.354	0.236	0.625	2.169	3.252	3.0	1.516	1.890	33100	0.220	XO.X10..
R217.69-00.62-3-10-2A	02772634	Weldon	0.625	2	0.354	0.236	0.625	2.169	3.252	7.5	0.827	1.201	29400	0.220	XO.X10..
R217.69-00.75-3-10-2A	02772637	Weldon	0.750	2	0.354	0.236	0.750	2.201	3.390	5.0	1.063	1.437	26300	0.440	XO.X10..
R217.69-00.750-3-10-3A	02903111	Weldon	0.750	3	0.354	0.236	0.750	2.201	3.390	4.5	1.083	1.457	26300	0.440	XO.X10..
R217.69-00.87-3-10-3A	02772720	Weldon	0.875	3	0.354	0.236	0.750	2.201	3.390	5.0	1.319	1.693	25000	0.440	XO.X10..
R217.69-01.00-3-10-3A	02772711	Weldon	1.000	3	0.354	0.236	1.000	2.500	3.780	3.0	1.575	1.949	23500	0.660	XO.X10..
R217.69-01.00-3-10-4A	02772713	Weldon	1.000	4	0.354	0.236	1.000	2.500	3.780	3.0	1.575	1.949	23500	0.660	XO.X10..
R217.69-01.25-3-10-5A	02772731	Weldon	1.250	5	0.354	0.236	1.250	2.760	4.000	2.0	2.067	2.441	20800	1.320	XO.X10..
R217.69-01.50-3-10-4A	02773428	Weldon	1.500	4	0.354	0.236	1.250	2.760	4.000	1.5	2.579	2.953	18600	1.320	XO.X10..

Modification of the cutter body needed for radii > 0.079 in

Spare Parts

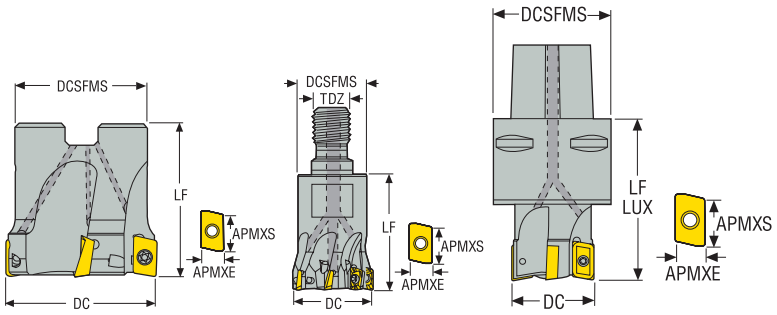
For cutter	Insert screw
R217.69-..	C02506-T07P

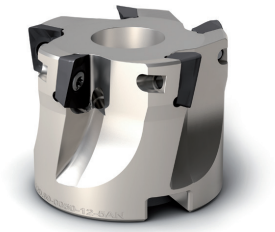
Accessories

Torque key	Torque value
T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 10 – R217/220.69-10 – Metric





- For insert selection and cutting data recommendations, see page(s) 42-44
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm		mm	mm	kg		
R217.69-0816.RE-10-2A	02769181	Combimaster	16,0	2	9,0	6,0	–	M8	14,0	23,0	7,5	21,0	30,5	0,1	29400	XO.X10..
R217.69-1020.RE-10-2A	02769213	Combimaster	20,0	2	9,0	6,0	–	M10	19,0	28,0	4,5	29,0	38,5	0,1	26300	XO.X10..
R217.69-1020.RE-10-3A	02769214	Combimaster	20,0	3	9,0	6,0	–	M10	19,0	28,0	4,5	29,0	38,5	0,1	26300	XO.X10..
R217.69-1225.RE-10-3A	02769228	Combimaster	25,0	3	9,0	6,0	–	M12	23,0	30,0	3,0	39,0	48,5	0,1	23500	XO.X10..
R217.69-1225.RE-10-4A	02769229	Combimaster	25,0	4	9,0	6,0	–	M12	23,0	30,0	3,0	39,0	48,5	0,1	23500	XO.X10..
R217.69-1632.RE-10-3A	02769234	Combimaster	32,0	3	9,0	6,0	–	M16	30,0	40,0	2,0	53,0	62,5	0,2	20800	XO.X10..
R217.69-1632.RE-10-5A	02769235	Combimaster	32,0	5	9,0	6,0	–	M16	30,0	40,0	2,0	53,0	62,5	0,2	20800	XO.X10..
R217.69-2040.RE-10-4A	02769295	Combimaster	40,0	4	9,0	6,0	–	M20	36,5	40,0	1,5	69,0	78,5	0,4	18600	XO.X10..
R217.69-2040.RE-10-6A	02769296	Combimaster	40,0	6	9,0	6,0	–	M20	36,5	40,0	1,5	69,0	78,5	0,4	18600	XO.X10..
C4-R217.69-044-10-4A	02824179	Seco-Capto	44,0	4	9,0	6,0	–	–	40,0	60,0	1,3	77,0	86,5	0,6	28000	XO.X10..
C5-R217.69-054-10-5A	02824181	Seco-Capto	54,0	5	9,0	6,0	–	–	50,0	60,0	1,2	97,0	106,5	0,9	14200	XO.X10..
R220.69-0032-10-4A	02840940	Arbor	32,0	4	9,0	6,0	16,0	–	30,0	35,0	2,0	53,0	62,5	0,2	20800	XO.X10..
R220.69-0032-10-5A	02841295	Arbor	32,0	5	9,0	6,0	16,0	–	30,0	35,0	2,0	53,0	62,5	0,2	20800	XO.X10..
R220.69-0040-10-4A	02769302	Arbor	40,0	4	9,0	6,0	16,0	–	35,0	40,0	1,5	69,0	78,5	0,2	18600	XO.X10..
R220.69-0040-10-6A	02769304	Arbor	40,0	6	9,0	6,0	16,0	–	35,0	40,0	1,5	69,0	78,5	0,2	18600	XO.X10..
R220.69-0044-10-4A	02969079	Arbor	44,0	4	9,0	6,0	16,0	–	35,0	40,0	1,3	77,0	86,5	0,3	18600	XO.X10..
R220.69-0050-10-5A	02769710	Arbor	50,0	5	9,0	6,0	22,0	–	47,0	40,0	1,2	89,0	98,5	0,4	16600	XO.X10..
R220.69-0050-10-7A	02769713	Arbor	50,0	7	9,0	6,0	22,0	–	47,0	40,0	1,2	89,0	98,5	0,4	16600	XO.X10..
R220.69-0052-10-5A	02969080	Arbor	52,0	5	9,0	6,0	22,0	–	47,0	40,0	1,2	93,0	102,5	0,4	16400	XO.X10..
R220.69-0063-10-5A	02770205	Arbor	63,0	5	9,0	6,0	27,0	–	52,0	40,0	0,9	115,0	124,5	0,6	14800	XO.X10..
R220.69-0063-10-8A	02770206	Arbor	63,0	8	9,0	6,0	27,0	–	52,0	40,0	0,9	115,0	124,5	0,6	14800	XO.X10..
R220.69-0066-10-5A	02969081	Arbor	66,0	5	9,0	6,0	27,0	–	52,0	40,0	0,9	121,0	130,5	0,7	14800	XO.X10..
R220.69-0080-10-8A	02770207	Arbor	80,0	8	9,0	6,0	27,0	–	62,0	50,0	0,5	149,0	158,5	1,1	13200	XO.X10..
R220.69-0080-10-10A	02770208	Arbor	80,0	10	9,0	6,0	27,0	–	62,0	50,0	0,5	149,0	158,5	1,1	13200	XO.X10..
R220.69-0100-10-12A	02770209	Arbor	100,0	12	9,0	6,0	32,0	–	77,0	50,0	0,5	189,0	198,5	1,8	11800	XO.X10..

Modification of the cutter body needed for radii > 2,0 mm
For Combimaster Shanks, see Machining Navigator Tooling System

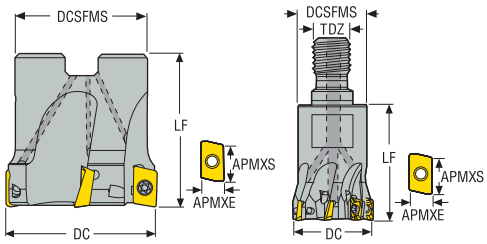
Spare Parts

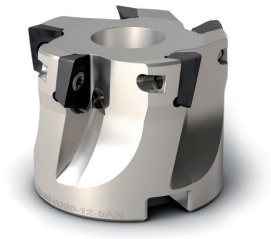
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
Cx/R217.69/R220.69-0080-0100	–	C02506-T07P	T00-07P09	0.9NM
R220.69-0032	220.17-690	C02506-T07P	T00-07P09	0.9NM
R220.69-0040-0044	MC6S8X30	C02506-T07P	T00-07P09	0.9NM
R220.69-0050-0052	220.17-692	C02506-T07P	T00-07P09	0.9NM
R220.69-0063-0066	220.17-693	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 10 – R217/220.69-10 – Inch





- For insert selection and cutting data recommendations, see page(s) 42-44
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch		Inch	Inch	lbs		
R217.69-00.62-08RE-10-2A	02772627	Combimaster	0.625	2	0.354	0.236	–	M8	0.531	0.906	7.5	0.807	1.181	0.220	29400	XO.X10
R217.69-00.75-10RE-10-2A	02772635	Combimaster	0.750	2	0.354	0.236	–	M10	0.728	1.378	5.0	1.063	1.437	0.220	26300	XO.X10
R217.69-01.00-12RE-10-3A	02772703	Combimaster	1.000	3	0.354	0.236	–	M12	0.906	1.575	2.5	1.555	1.929	0.440	23500	XO.X10
R217.69-01.00-12RE-10-4A	02772705	Combimaster	1.000	4	0.354	0.236	–	M12	0.906	1.575	2.5	1.555	1.929	0.440	23500	XO.X10
R217.69-01.25-16RE-10-3A	02772722	Combimaster	1.250	3	0.354	0.236	–	M16	1.181	1.575	1.5	2.067	2.441	0.440	20800	XO.X10
R217.69-01.25-16RE-10-5A	02772725	Combimaster	1.250	5	0.354	0.236	–	M16	1.181	1.575	1.5	2.067	2.441	0.440	20800	XO.X10
R217.69-01.50-20RE-10-4A	03170243	Combimaster	1.500	4	0.354	0.236	–	M20	1.457	1.575	1.5	2.559	2.933	0.660	18600	XO.X10
R217.69-01.50-20RE-10-6A	03170244	Combimaster	1.500	6	0.354	0.236	–	M20	1.457	1.575	1.5	2.559	2.933	0.880	18600	XO.X10
R220.69-01.50-10-4A	02773432	Arbor	1.500	4	0.354	0.236	0.750	–	1.378	1.575	1.5	2.559	2.933	0.440	18600	XO.X10
R220.69-01.50-10-6A	02773433	Arbor	1.500	6	0.354	0.236	0.750	–	1.378	1.575	1.5	2.559	2.933	0.440	18600	XO.X10
R220.69-02.00-10-5A	02773434	Arbor	2.000	5	0.354	0.236	0.750	–	1.850	1.575	1.0	3.563	3.937	0.880	16600	XO.X10
R220.69-02.00-10-7A	02773435	Arbor	2.000	7	0.354	0.236	0.750	–	1.850	1.575	1.0	3.563	3.937	0.880	16600	XO.X10
R220.69-03.00-10-10A	02773438	Arbor	3.000	10	0.354	0.236	1.000	–	2.441	1.969	0.5	5.551	5.925	2.430	13200	XO.X10

Modification of the cutter body needed for radii > 0.079 in
For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.69-..	–	C02506-T07P	T00-07P09	8.0IN.LBS
R220.69-01.50 - 02.50	UC6S3/8UNFX1	C02506-T07P	T00-07P09	8.0IN.LBS
R220.69-03.00	UC6S1/2UNFX1-1/4	C02506-T07P	T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-10 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	XOMX10T308TR-ME07 F40M	4,5 *0.18*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P2	XOMX10T308TR-ME07 F40M	4,5 *0.18*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P3	XOMX10T308TR-ME07 MP2501	4,5 *0.18*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P4	XOMX10T308TR-ME07 MP2501	4,5 *0.18*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P5	XOMX10T308TR-M09 MP2501	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P6	XOMX10T308TR-M09 MP2501	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P7	XOMX10T308TR-M09 MP2501	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P8	XOMX10T308TR-M09 MP2501	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P11	XOMX10T308TR-M09 T350M	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P12	XOEX10T308R-M06 MS2500	3,5 *0.14*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
M1	XOEX10T308R-M06 F40M	4,5 *0.18*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
M2	XOEX10T308R-M06 F40M	4,5 *0.18*	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M3	XOEX10T308R-M06 F40M	3,5 *0.14*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
M4	XOEX10T308R-M06 T350M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
M5	XOEX10T308R-M06 T350M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
K1	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K2	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K3	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K4	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K5	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K6	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K7	XOMX10T308TR-M09 MK2050	4,5 *0.18*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N1	XOEX10T308FR-E05 H15	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
N2	XOEX10T308FR-E05 H15	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
N3	XOEX10T308FR-E05 H15	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
N11	XOEX10T308FR-E05 H15	4,5 *0.18*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S1	XOEX10T308R-M06 T350M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
S2	XOEX10T308R-M06 T350M	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
S3	XOEX10T308R-M06 T350M	2,5 *0.10*	0,055 *0.0022*	0,055 *0.0022*	0,085 *0.0034*
S11	XOEX10T308R-M06 MS2050	3,0 *0.12*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
S12	XOEX10T308R-M06 MS2050	3,0 *0.12*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
S13	XOEX10T308R-M06 MS2050	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
H5	XOMX10T308TR-M09 MP3000	3,5 *0.14*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
H8	XOMX10T308TR-M09 MP3000	3,0 *0.12*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*
H11	XOMX10T308TR-M09 MP1501	3,5 *0.14*	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
H12	XOMX10T308TR-M09 MP1501	3,0 *0.12*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

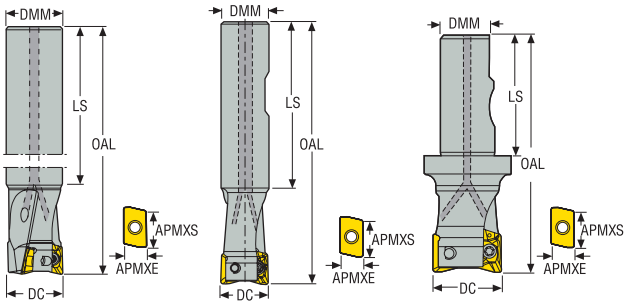
R217/220.69-10 – Cutting data v_c = (m/min)/*(sf/min)*

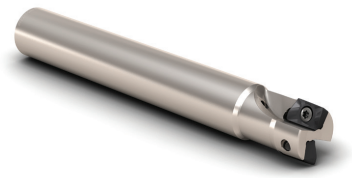
SMG	MP1501			MP2050			MP2501			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	330 *1075*	435 *1425*	510 *1675*	330 *1075*	430 *1400*	510 *1675*	290 *950*	385 *1275*	450 *1475*	275 *900*	365 *1200*	425 *1400*	205 *670*	270 *890*	320 *1050*	— —	— —	— —
P2	320 *1050*	425 *1400*	495 *1625*	320 *1050*	420 *1375*	500 *1650*	285 *940*	375 *1225*	440 *1450*	270 *890*	355 *1175*	415 *1350*	200 *660*	265 *870*	310 *1025*	— —	— —	— —
P3	280 *920*	370 *1225*	435 *1425*	280 *920*	365 *1200*	430 *1400*	250 *820*	330 *1075*	385 *1275*	235 *770*	310 *1025*	365 *1200*	175 *570*	230 *750*	270 *890*	— —	— —	— —
P4	245 *800*	325 *1075*	385 *1275*	245 *800*	320 *1050*	385 *1275*	220 *720*	290 *950*	340 *1125*	210 *690*	275 *900*	325 *1075*	155 *510*	200 *660*	240 *790*	— —	— —	— —
P5	235 *770*	315 *1025*	370 *1225*	235 *770*	310 *1025*	365 *1200*	210 *690*	275 *900*	325 *1075*	200 *660*	260 *850*	310 *1025*	145 *475*	195 *640*	230 *750*	— —	— —	— —
P6	265 *870*	350 *1150*	415 *1350*	265 *870*	350 *1150*	410 *1350*	235 *770*	310 *1025*	365 *1200*	225 *740*	295 *970*	345 *1125*	165 *540*	220 *720*	255 *840*	— —	— —	— —
P7	250 *820*	330 *1075*	390 *1275*	250 *820*	330 *1075*	390 *1275*	220 *720*	295 *970*	345 *1125*	210 *690*	280 *920*	325 *1075*	155 *510*	205 *670*	245 *800*	— —	— —	— —
P8	235 *770*	315 *1025*	370 *1225*	235 *770*	310 *1025*	360 *1175*	210 *690*	275 *900*	325 *1075*	200 *660*	260 *850*	310 *1025*	145 *475*	190 *620*	225 *740*	— —	— —	— —
P11	245 *800*	320 *1050*	380 *1250*	240 *790*	320 *1050*	375 *1225*	215 *710*	285 *940*	335 *1100*	205 *670*	270 *890*	315 *1025*	150 *490*	200 *660*	235 *770*	— —	— —	— —
P12	160 *520*	210 *690*	250 *820*	155 *510*	205 *670*	240 *790*	140 *460*	185 *610*	220 *720*	135 *445*	175 *570*	210 *690*	100 *330*	130 *425*	150 *490*	— —	— —	— —
M1	— —	— —	— —	230 *750*	300 *980*	355 *1175*	205 *670*	270 *890*	315 *1025*	200 *660*	265 *870*	310 *1025*	170 *560*	225 *740*	265 *870*	— —	— —	— —
M2	— —	— —	— —	190 *620*	250 *820*	295 *970*	170 *560*	225 *740*	260 *850*	165 *540*	220 *720*	260 *850*	140 *460*	185 *610*	220 *720*	— —	— —	— —
M3	— —	— —	— —	150 *490*	200 *660*	230 *750*	140 *460*	185 *610*	210 *690*	135 *445*	180 *590*	210 *690*	115 *375*	150 *490*	175 *570*	— —	— —	— —
M4	— —	— —	— —	120 *395*	155 *510*	180 *590*	110 *360*	140 *460*	165 *540*	105 *345*	140 *460*	160 *520*	90 *295*	115 *375*	135 *445*	— —	— —	— —
M5	— —	— —	— —	100 *330*	130 *425*	150 *490*	90 *295*	115 *375*	135 *445*	90 *295*	115 *375*	135 *445*	75 *245*	95 *310*	115 *375*	— —	— —	— —
K1	255 *840*	335 *1100*	395 *1300*	255 *840*	335 *1100*	395 *1300*	225 *740*	295 *970*	350 *1150*	210 *690*	280 *920*	330 *1075*	— —	— —	— —	320 *1050*	420 *1375*	495 *1625*
K2	225 *740*	295 *970*	350 *1150*	225 *740*	295 *970*	350 *1150*	200 *660*	265 *870*	310 *1025*	190 *620*	250 *820*	295 *970*	— —	— —	— —	280 *920*	370 *1225*	440 *1450*
K3	190 *620*	250 *820*	295 *970*	190 *620*	250 *820*	295 *970*	170 *560*	220 *720*	260 *850*	160 *520*	210 *690*	250 *820*	— —	— —	— —	240 *790*	315 *1025*	370 *1225*
K4	180 *590*	240 *790*	280 *920*	180 *590*	240 *790*	280 *920*	160 *520*	210 *690*	250 *820*	150 *490*	200 *660*	235 *770*	— —	— —	— —	225 *740*	300 *980*	355 *1175*
K5	110 *360*	145 *475*	170 *560*	110 *360*	145 *475*	170 *560*	100 *330*	130 *425*	155 *510*	95 *310*	120 *395*	145 *475*	— —	— —	— —	140 *460*	185 *610*	215 *710*
K6	160 *520*	210 *690*	250 *820*	160 *520*	210 *690*	245 *800*	140 *460*	185 *610*	220 *720*	135 *445*	175 *570*	210 *690*	— —	— —	— —	200 *660*	265 *870*	310 *1025*
K7	140 *460*	185 *610*	220 *720*	140 *460*	185 *610*	220 *720*	125 *410*	165 *540*	195 *640*	120 *395*	155 *510*	185 *610*	— —	— —	— —	175 *570*	235 *770*	275 *900*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	1550 *5075*	2075 *6800*	2450 *8050*	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	630 *2075*	840 *2750*	980 *3225*	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	420 *1375*	560 *1825*	660 *2175*	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	480 *1575*	640 *2100*	750 *2450*	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	60 *195*	75 *245*	90 *295*	55 *180*	70 *230*	80 *260*	50 *165*	65 *215*	75 *245*	27 *90*	36 *120*	41 *135*	— —	— —	— —
S2	— —	— —	— —	47 *155*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*	40 *130*	50 *165*	60 *195*	22 *70*	29 *95*	33 *110*	— —	— —	— —
S3	— —	— —	— —	41 *135*	55 *180*	60 *195*	37 *120*	49 *160*	55 *180*	35 *115*	46 *150*	55 *180*	19 *60*	25 *80*	29 *95*	— —	— —	— —
S11	— —	— —	— —	80 *260*	105 *345*	125 *410*	75 *245*	95 *310*	110 *360*	70 *230*	90 *295*	105 *345*	38 *125*	50 *165*	55 *180*	— —	— —	— —
S12	— —	— —	— —	55 *180*	75 *245*	85 *280*	50 *165*	65 *215*	75 *245*	48 *155*	65 *215*	75 *245*	35 *115*	46 *150*	55 *180*	— —	— —	— —
S13	— —	— —	— —	33 *110*	43 *140*	50 *165*	30 *100*	38 *125*	45 *150*	28 *90*	36 *120*	42 *140*	21 *70*	27 *90*	31 *100*	— —	— —	— —
H5	55 *180*	70 *230*	80 *260*	47 *155*	60 *195*	70 *230*	43 *140*	55 *180*	65 *215*	42 *140*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —
H8	55 *180*	75 *245*	85 *280*	50 *165*	65 *215*	75 *245*	45 *150*	60 *195*	70 *230*	44 *145*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —
H11	70 *230*	90 *295*	105 *345*	60 *195*	80 *260*	90 *295*	55 *180*	70 *230*	85 *280*	55 *180*	70 *230*	80 *260*	— —	— —	— —	— —	— —	— —
H12	100 *330*	135 *445*	155 *510*	100 *330*	130 *425*	150 *490*	90 *295*	120 *395*	140 *460*	85 *280*	110 *360*	130 *425*	— —	— —	— —	— —	— —	— —

R217/220.69-10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MS2050			MS2500			T350M			F40M			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	285 *940*	380 *1250*	445 *1450*	280 *920*	365 *1200*	435 *1425*	365 *1200*	480 *1575*	570 *1875*	255 *840*	335 *1100*	395 *1300*	220 *720*	290 *950*	340 *1125*	— —	— —	— —
P2	280 *920*	370 *1225*	435 *1425*	270 *890*	355 *1175*	425 *1400*	355 *1175*	465 *1525*	550 *1800*	245 *800*	325 *1075*	385 *1275*	215 *710*	285 *940*	335 *1100*	— —	— —	— —
P3	245 *800*	325 *1075*	380 *1250*	240 *790*	310 *1025*	365 *1200*	310 *1025*	405 *1325*	475 *1550*	215 *710*	285 *940*	340 *1125*	190 *620*	250 *820*	295 *970*	— —	— —	— —
P4	215 *710*	285 *940*	335 *1100*	210 *690*	275 *900*	325 *1075*	275 *900*	360 *1175*	425 *1400*	190 *620*	255 *840*	295 *970*	165 *540*	220 *720*	260 *850*	— —	— —	— —
P5	205 *670*	275 *900*	320 *1050*	200 *660*	265 *870*	310 *1025*	260 *850*	345 *1125*	405 *1325*	180 *590*	240 *790*	285 *940*	160 *520*	210 *690*	245 *800*	— —	— —	— —
P6	230 *750*	305 *1000*	360 *1175*	225 *740*	295 *970*	350 *1150*	295 *970*	390 *1275*	455 *1500*	205 *670*	270 *890*	320 *1050*	180 *590*	235 *770*	275 *900*	— —	— —	— —
P7	220 *720*	290 *950*	340 *1125*	210 *690*	280 *920*	330 *1075*	275 *900*	365 *1200*	430 *1400*	195 *640*	255 *840*	300 *980*	170 *560*	220 *720*	260 *850*	— —	— —	— —
P8	205 *670*	275 *900*	320 *1050*	200 *660*	260 *850*	305 *1000*	260 *850*	340 *1125*	400 *1300*	180 *590*	240 *790*	285 *940*	160 *520*	210 *690*	245 *800*	— —	— —	— —
P11	210 *690*	280 *920*	330 *1075*	205 *670*	270 *890*	320 *1050*	270 *890*	355 *1175*	420 *1375*	190 *620*	250 *820*	290 *950*	165 *540*	215 *710*	255 *840*	— —	— —	— —
P12	140 *460*	185 *610*	215 *710*	135 *445*	175 *570*	205 *670*	175 *570*	230 *750*	265 *870*	125 *410*	160 *520*	190 *620*	110 *360*	140 *460*	165 *540*	— —	— —	— —
M1	— —	— —	— —	220 *720*	285 *940*	340 *1125*	255 *840*	335 *1100*	395 *1300*	190 *620*	250 *820*	295 *970*	175 *570*	230 *750*	270 *890*	— —	— —	— —
M2	— —	— —	— —	180 *590*	240 *790*	280 *920*	210 *690*	275 *900*	325 *1075*	155 *510*	210 *690*	245 *800*	145 *475*	190 *620*	220 *720*	— —	— —	— —
M3	— —	— —	— —	145 *475*	190 *620*	220 *720*	170 *560*	220 *720*	255 *840*	130 *425*	170 *560*	195 *640*	115 *375*	155 *510*	180 *590*	— —	— —	— —
M4	— —	— —	— —	115 *375*	150 *490*	175 *570*	135 *445*	175 *570*	200 *660*	100 *330*	130 *425*	150 *490*	90 *295*	120 *395*	140 *460*	— —	— —	— —
M5	— —	— —	— —	95 *310*	125 *410*	145 *475*	110 *360*	145 *475*	165 *540*	85 *280*	110 *360*	125 *410*	75 *245*	100 *330*	115 *375*	— —	— —	— —
K1	300 *980*	400 *1300*	465 *1525*	— —	— —	— —	— —	— —	— —	195 *640*	260 *850*	305 *1000*	— —	— —	— —	— —	— —	— —
K2	265 *870*	355 *1175*	415 *1350*	— —	— —	— —	— —	— —	— —	175 *570*	230 *750*	270 *890*	— —	— —	— —	— —	— —	— —
K3	225 *740*	300 *980*	350 *1150*	— —	— —	— —	— —	— —	— —	145 *475*	195 *640*	230 *750*	— —	— —	— —	— —	— —	— —
K4	215 *710*	285 *940*	335 *1100*	— —	— —	— —	— —	— —	— —	140 *460*	185 *610*	220 *720*	— —	— —	— —	— —	— —	— —
K5	130 *425*	175 *570*	205 *670*	— —	— —	— —	— —	— —	— —	85 *280*	110 *360*	135 *445*	— —	— —	— —	— —	— —	— —
K6	190 *620*	250 *820*	295 *970*	— —	— —	— —	— —	— —	— —	125 *410*	165 *540*	190 *620*	— —	— —	— —	— —	— —	— —
K7	170 *560*	220 *720*	260 *850*	— —	— —	— —	— —	— —	— —	110 *360*	145 *475*	170 *560*	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1250 *4100*	1650 *5425*	1950 *6400*	1525 *5000*	2000 *6550*	2350 *7700*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	500 *1650*	670 *2200*	790 *2600*	610 *2000*	800 *2625*	950 *3125*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	335 *1100*	445 *1450*	530 *1750*	410 *1350*	540 *1775*	630 *2075*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	380 *1250*	510 *1675*	600 *1975*	470 *1550*	610 *2000*	720 *2350*
S1	— —	— —	— —	55 *180*	70 *230*	80 *260*	65 *215*	85 *280*	100 *330*	47 *155*	60 *195*	70 *230*	43 *140*	55 *180*	65 *215*	— —	— —	— —
S2	— —	— —	— —	43 *140*	55 *180*	65 *215*	50 *165*	70 *230*	80 *260*	38 *125*	49 *160*	55 *180*	34 *110*	45 *150*	50 *165*	— —	— —	— —
S3	— —	— —	— —	37 *120*	49 *160*	55 *180*	45 *150*	60 *195*	70 *230*	33 *110*	44 *145*	50 *165*	30 *100*	40 *130*	46 *150*	— —	— —	— —
S11	— —	— —	— —	75 *245*	95 *310*	110 *360*	90 *295*	120 *395*	135 *445*	65 *215*	85 *280*	100 *330*	60 *195*	80 *260*	90 *295*	— —	— —	— —
S12	— —	— —	— —	50 *165*	65 *215*	75 *245*	60 *195*	80 *260*	95 *310*	45 *150*	60 *195*	70 *230*	41 *135*	55 *180*	65 *215*	— —	— —	— —
S13	— —	— —	— —	30 *100*	39 *130*	45 *150*	37 *120*	48 *155*	55 *180*	26 *85*	34 *110*	40 *130*	24 *80*	31 *100*	36 *120*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	41 *135*	55 *180*	65 *215*	36 *120*	47 *155*	55 *180*	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	44 *145*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	50 *165*	70 *230*	80 *260*	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	80 *260*	100 *330*	120 *395*	— —	— —	— —	— —	— —	— —

Turbo 12 – R217.69-12 – Metric





- For insert selection and cutting data recommendations, see page(s) 51-53
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.69-1820.0-12-2AN	02676791	Cylindrical	20,0	2	11,0	7,0	18,0	120,0	150,0	8,0	27,5	38,0	23200	0,3	XO.X12..
R217.69-2020.0-12-2AN	02676793	Cylindrical	20,0	2	11,0	7,0	20,0	120,0	150,0	8,0	27,5	38,0	23200	0,4	XO.X12..
R217.69-2225.0-12-2AN	02676794	Cylindrical	25,0	2	11,0	7,0	22,0	135,0	170,0	5,0	37,5	48,0	20800	0,5	XO.X12..
R217.69-2525.0-12-2AN	02676795	Cylindrical	25,0	2	11,0	7,0	25,0	135,0	170,0	5,0	37,5	48,0	20800	0,6	XO.X12..
R217.69-2525.0-12-3AN	02676800	Cylindrical	25,0	3	11,0	7,0	25,0	135,0	170,0	5,0	37,5	48,0	20800	0,6	XO.X12..
R217.69-3032.0-12-3AN	02676801	Cylindrical	32,0	3	11,0	7,0	30,0	155,0	195,0	3,0	51,5	62,0	18400	1,0	XO.X12..
R217.69-3232.0-12-3AN	02676802	Cylindrical	32,0	3	11,0	7,0	32,0	155,0	195,0	3,0	51,5	62,0	18400	1,1	XO.X12..
R217.69-3232.0-12-4AN	02676803	Cylindrical	32,0	4	11,0	7,0	32,0	155,0	195,0	3,0	51,5	62,0	18400	1,1	XO.X12..
R217.69-2020.3-12-2AN	02676817	Weldon	20,0	2	11,0	7,0	20,0	55,0	85,0	8,0	27,5	38,0	23200	0,2	XO.X12..
R217.69-2525.3-12-3AN	02676819	Weldon	25,0	3	11,0	7,0	25,0	60,0	95,0	5,0	37,5	48,0	20800	0,3	XO.X12..
R217.69-3232.3-12-3AN	02676820	Weldon	32,0	3	11,0	7,0	32,0	65,0	105,0	3,0	51,5	62,0	18400	0,6	XO.X12..
R217.69-3232.3-12-4AN	02676823	Weldon	32,0	4	11,0	7,0	32,0	65,0	105,0	3,0	51,5	62,0	18400	0,6	XO.X12..
R217.69-2025.3S-12-3AN	02676812	Seco-Weldon	25,0	3	11,0	7,0	20,0	50,0	100,0	5,0	37,5	48,0	20800	0,3	XO.X12..
R217.69-2532.3S-12-4AN	02676814	Seco-Weldon	32,0	4	11,0	7,0	25,0	56,0	110,0	3,0	51,5	62,0	18400	0,5	XO.X12..
R217.69-3240.3S-12-5AN	02676815	Seco-Weldon	40,0	5	11,0	7,0	32,0	60,0	120,0	2,5	67,5	78,0	16400	0,8	XO.X12..

Modification of the cutter body needed for radii > 3,1 mm

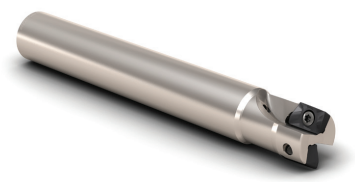
Spare Parts

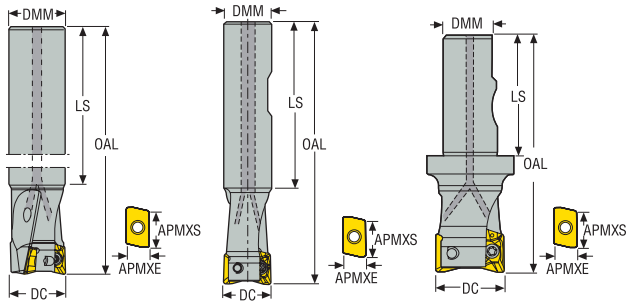
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-.. Ø20-25	C03507-T10P	T00-10P30	3.0NM
R217.69-.. Ø32	C03508-T10P	T00-10P30	3.0NM
R217.69-.. Ø40	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 12 – R217.69-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 51-53
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.69-00.75-0-12-2AN	02688842	Cylindrical	0.750	2	0.433	0.276	0.750	4.724	5.906	8.0	1.004	1.417	23200	0.880	XO.X12
R217.69-00.87-0-12-2AN	02688849	Cylindrical	0.875	2	0.433	0.276	0.750	4.724	5.906	6.0	1.240	1.654	22000	0.880	XO.X12
R217.69-01.00-0-12-2AN	02688853	Cylindrical	1.000	2	0.433	0.276	1.000	5.315	6.693	5.0	1.476	1.890	20800	1.540	XO.X12
R217.69-01.00-0-12-3AN	02688854	Cylindrical	1.000	3	0.433	0.276	1.000	5.315	6.693	5.0	1.476	1.890	20800	1.540	XO.X12
R217.69-01.25-0-12-3AN	02688855	Cylindrical	1.250	3	0.433	0.276	1.250	6.102	7.677	3.0	1.988	2.421	18400	2.650	XO.X12
R217.69-00.75-3-12-2AN	02688950	Weldon	0.750	2	0.433	0.276	0.750	2.205	3.378	8.0	1.004	1.417	23200	0.660	XO.X12
R217.69-00.87-3-12-2AN	02688951	Weldon	0.875	2	0.433	0.276	0.750	2.205	3.378	6.0	1.240	1.654	22000	0.660	XO.X12
R217.69-01.00-3-12-3AN	02688954	Weldon	1.000	3	0.433	0.276	1.000	2.433	4.000	5.0	1.496	1.909	20800	0.880	XO.X12
R217.69-01.25-3-12-3AN	02688957	Weldon	1.250	3	0.433	0.276	1.250	2.913	4.252	3.0	2.008	2.421	18400	1.320	XO.X12
R217.69-01.25-3-12-4AN	02688960	Weldon	1.250	4	0.433	0.276	1.250	2.913	4.252	3.0	2.008	2.421	18400	1.540	XO.X12
R217.69-01.00-3S-12-3AN	02688974	Seco-Weldon	1.000	3	0.433	0.276	0.750	1.969	4.000	5.0	1.496	1.909	20800	0.880	XO.X12
R217.69-01.25-3S-12-4AN	02688976	Seco-Weldon	1.250	4	0.433	0.276	1.000	2.441	4.252	3.0	2.008	2.421	18400	1.320	XO.X12
R217.69-01.50-3S-12-5AN	02688996	Seco-Weldon	1.500	5	0.433	0.276	1.250	2.441	4.780	2.5	2.500	2.913	16400	1.980	XO.X12

Modification of the cutter body needed for radii > 0.122 in

Spare Parts

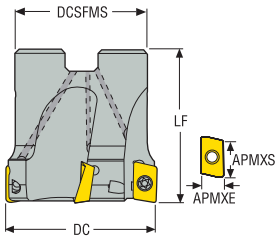
For cutter	Insert screw
R217.69-..	C03507-T10P

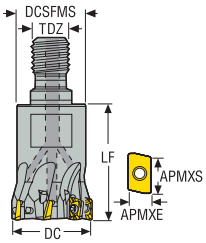
Accessories

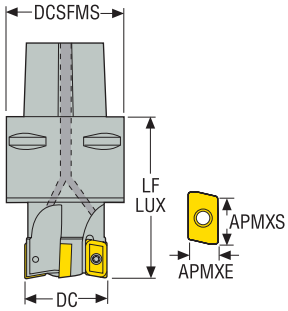
Torque key	Torque value
T00-10P30	26.6IN.LBS

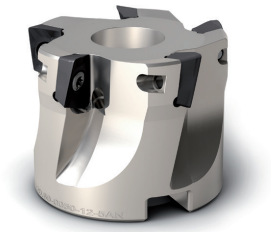
Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 12 – R217/220.69-12 – Metric









- For insert selection and cutting data recommendations, see page(s) 51-53
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm		mm	mm	kg		
R217.69-1020.RE-12-2AN	02676828	Combimaster	20,0	2	11,0	7,0	–	M10	18,0	28,0	8,0	27,5	38,0	0,1	23200	XO.X12..
R217.69-1225.RE-12-3AN	02676833	Combimaster	25,0	3	11,0	7,0	–	M12	23,0	30,0	5,0	37,5	48,0	0,1	20800	XO.X12..
R217.69-1632.RE-12-3AN	02676838	Combimaster	32,0	3	11,0	7,0	–	M16	30,0	40,0	3,0	51,5	62,0	0,2	18400	XO.X12..
R217.69-1632.RE-12-4AN	02676839	Combimaster	32,0	4	11,0	7,0	–	M16	30,0	40,0	3,0	51,5	62,0	0,2	18400	XO.X12..
R217.69-1640.RE-12-4AN	02676840	Combimaster	40,0	4	11,0	7,0	–	M16	30,0	40,0	2,5	67,5	78,0	0,3	16400	XO.X12..
R217.69-1640.RE-12-5AN	02676845	Combimaster	40,0	5	11,0	7,0	–	M16	30,0	40,0	2,5	67,5	78,0	0,3	16400	XO.X12..
R217.69-2040.RE-12-4AN	02972700	Combimaster	40,0	4	11,0	7,0	–	M20	36,5	40,0	2,5	67,5	78,0	0,4	16400	XO.X12..
R217.69-2040.RE-12-5AN	02972704	Combimaster	40,0	5	11,0	7,0	–	M20	36,5	40,0	2,5	67,5	78,0	0,4	16400	XO.X12..
C5-R217.69-040-12-4AN	02677616	Seco-Capto	40,0	4	11,0	7,0	–	–	50,0	80,0	2,5	67,5	78,0	0,9	16400	XO.X12..
C5-R217.69-054-12-5AN	02677619	Seco-Capto	54,0	5	11,0	7,0	–	–	50,0	60,0	1,7	95,5	106,0	1,0	14200	XO.X12..
R220.69-0032-12-3AN	02841296	Arbor	32,0	3	11,0	7,0	16,0	–	30,0	35,0	3,0	51,5	62,0	0,3	18400	XO.X12..
R220.69-0032-12-4AN	02841297	Arbor	32,0	4	11,0	7,0	16,0	–	30,0	35,0	3,0	51,5	62,0	0,3	18400	XO.X12..
R220.69-0040-12-4AN	02677566	Arbor	40,0	4	11,0	7,0	16,0	–	35,0	40,0	2,5	67,5	78,0	0,4	16400	XO.X12..
R220.69-0040-12-5AN	02677570	Arbor	40,0	5	11,0	7,0	16,0	–	35,0	40,0	2,5	67,5	78,0	0,2	16400	XO.X12..
R220.69-0044-12-4AN	02969083	Arbor	44,0	4	11,0	7,0	16,0	–	36,0	40,0	2,2	75,5	86,0	0,1	15600	XO.X12..
R220.69-0050-12-5AN	02677572	Arbor	50,0	5	11,0	7,0	22,0	–	47,0	40,0	2,0	87,5	98,0	0,4	14800	XO.X12..
R220.69-0050-12-7AN	02677573	Arbor	50,0	7	11,0	7,0	22,0	–	47,0	40,0	2,0	87,5	98,0	0,4	14800	XO.X12..
R220.69-0052-12-5AN	02497527	Arbor	52,0	5	11,0	7,0	22,0	–	47,0	40,0	1,7	91,5	102,0	0,6	14200	XO.X12..
R220.69-0063-12-6AN	02677576	Arbor	63,0	6	11,0	7,0	27,0	–	52,0	40,0	1,5	113,5	124,0	0,5	13200	XO.X12..
R220.69-0063-12-8AN	02677578	Arbor	63,0	8	11,0	7,0	27,0	–	52,0	40,0	1,5	113,5	124,0	0,6	13200	XO.X12..
R220.69-0066-12-6AN	02969085	Arbor	66,0	6	11,0	7,0	27,0	–	52,0	40,0	1,5	119,5	130,0	0,9	13200	XO.X12..
R220.69-0080-12-7AN	02677608	Arbor	80,0	7	11,0	7,0	27,0	–	62,0	50,0	1,0	147,5	158,0	1,1	11600	XO.X12..
R220.69-0080-12-10AN	02677581	Arbor	80,0	10	11,0	7,0	27,0	–	62,0	50,0	1,0	147,5	158,0	1,0	11600	XO.X12..
R220.69-0084-12-7AN	02969086	Arbor	84,0	7	11,0	7,0	27,0	–	62,0	50,0	1,0	155,5	166,0	1,4	11300	XO.X12..
R220.69-0100-12-8AN	02677610	Arbor	100,0	8	11,0	7,0	32,0	–	77,0	50,0	0,5	187,5	198,0	1,7	10400	XO.X12..
R220.69-0100-12-12AN	02677609	Arbor	100,0	12	11,0	7,0	32,0	–	77,0	50,0	0,5	187,5	198,0	1,7	10400	XO.X12..
R220.69-0125-12-10AN	02677611	Arbor	125,0	10	11,0	7,0	40,0	–	90,0	63,0	0,5	237,5	248,0	3,2	9200	XO.X12..
R220.69-0125-12-14AN	02677613	Arbor	125,0	14	11,0	7,0	40,0	–	90,0	63,0	0,5	237,5	248,0	3,2	9200	XO.X12..

Modification of the cutter body needed for radii > 3,1 mm
For Combimaster Shanks, see Machining Navigator Tooling System

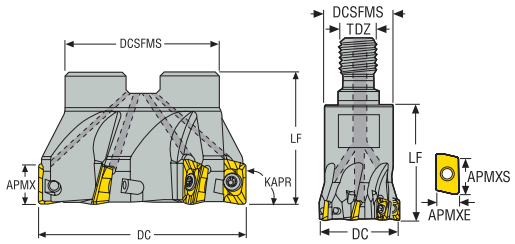
Spare Parts

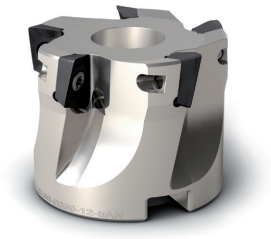
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.69-.. Ø20-25	–	C03507-T10P	T00-10P30	3.0NM
R217.69- Ø32	–	C03508-T10P	T00-10P30	3.0NM
R217.69- Ø40	–	C03509-T10P	T00-10P30	3.0NM
C5-R217.69-..	–	C03509-T10P	T00-10P30	3.0NM
R220.69-0032	220.17-690	C03507-T10P	T00-10P30	3.0NM
R220.69-0040-0044	MC6S8X30	C03509-T10P	T00-10P30	3.0NM
R220.69-0050-0052	220.17-692	C03509-T10P	T00-10P30	3.0NM
R220.69-0063-0066	220.17-693	C03509-T10P	T00-10P30	3.0NM
R220.69-0080-0125	–	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 12 – R217/220.69-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 51-53
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch		Inch	Inch	lbs		
R217.69-00.75-10RE-12-2AN	02689794	Combimaster	0.750	2	0.433	0.276	–	M10	0.709	1.378	8.0	1.004	1.417	0.440	23200	XO.X12
R217.69-01.00-12RE-12-3AN	02689797	Combimaster	1.000	3	0.433	0.276	–	M12	0.906	1.575	5.0	1.496	1.909	0.440	20800	XO.X12
R217.69-01.25-16RE-12-3AN	02689799	Combimaster	1.250	3	0.433	0.276	–	M16	1.181	1.575	3.0	2.008	2.421	0.660	18400	XO.X12
R217.69-01.25-16RE-12-4AN	02689801	Combimaster	1.250	4	0.433	0.276	–	M16	1.181	1.575	3.0	2.008	2.421	0.660	18400	XO.X12
R217.69-01.50-16RE-12-4AN	02689802	Combimaster	1.500	4	0.433	0.276	–	M16	1.181	1.575	2.5	2.500	2.913	0.880	16400	XO.X12
R217.69-01.50-16RE-12-5AN	02689805	Combimaster	1.500	5	0.433	0.276	–	M16	1.181	1.575	2.5	2.500	2.913	0.880	16400	XO.X12
R220.69-01.50-12-4AN	02689808	Arbor	1.500	4	0.433	0.276	0.750	–	1.378	1.575	2.5	2.500	2.913	0.660	16400	XO.X12
R220.69-01.50-12-5AN	02689809	Arbor	1.500	5	0.433	0.276	0.750	–	1.378	1.575	2.5	2.500	2.913	0.880	16400	XO.X12
R220.69-02.00-12-4AN	02689812	Arbor	2.000	4	0.433	0.276	0.750	–	1.850	1.575	2.0	3.504	3.917	0.880	14800	XO.X12
R220.69-02.00-12-5AN	02689813	Arbor	2.000	5	0.433	0.276	0.750	–	1.850	1.575	2.0	3.504	3.917	0.880	14800	XO.X12
R220.69-02.00-12-7AN	02689815	Arbor	2.000	7	0.433	0.276	0.750	–	1.850	1.575	2.0	3.504	3.917	0.880	14800	XO.X12
R220.69-02.50-12-4AN	02689816	Arbor	2.500	4	0.433	0.276	0.750	–	1.850	1.575	1.5	4.508	4.921	1.100	13200	XO.X12
R220.69-02.50-12-6AN	02689817	Arbor	2.500	6	0.433	0.276	0.750	–	1.850	1.575	1.5	4.508	4.921	1.320	13200	XO.X12
R220.69-03.00-12-4AN	02689820	Arbor	3.000	4	0.433	0.276	1.000	–	2.441	2.000	1.0	5.492	5.906	2.200	11600	XO.X12
R220.69-03.00-12-7AN	02689822	Arbor	3.000	7	0.433	0.276	1.000	–	2.441	2.000	1.0	5.492	5.906	2.430	11600	XO.X12
R220.69-03.00-12-10AN	02689821	Arbor	3.000	10	0.433	0.276	1.000	–	2.441	2.000	1.0	5.492	5.906	2.200	11600	XO.X12
R220.69-04.00-12-5AN	02689824	Arbor	4.000	5	0.433	0.276	1.500	–	3.543	2.000	0.5	7.500	7.913	5.070	10400	XO.X12
R220.69-04.00-12-8AN	02689826	Arbor	4.000	8	0.433	0.276	1.500	–	3.543	2.000	0.5	7.500	7.913	4.410	10400	XO.X12
R220.69-04.00-12-12AN	02689825	Arbor	4.000	12	0.433	0.276	1.500	–	3.543	2.000	0.5	7.500	7.913	3.750	10400	XO.X12

Modification of the cutter body needed for radii > 0.122 in
For Combimaster Shanks, see Machining Navigator Tooling System

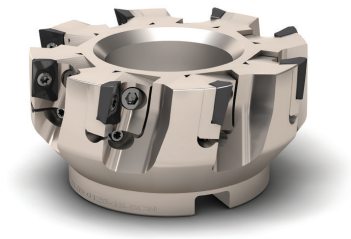
Spare Parts

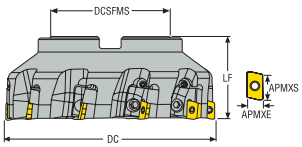
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.69-00.75 - 01.25	–	C03507-T10P	T00-10P30	26.6IN.LBS
R217.69- 01.50	–	C03509-T10P	T00-10P30	26.6IN.LBS
R220.69-01.50	220.17-698	C03509-T10P	T00-10P30	26.6IN.LBS
R220.69-02.00-02.50	UC6S3/8UNFX1	C03509-T10P	T00-10P30	26.6IN.LBS
R220.69-03.00	UC6S1/2UNFX1-1/4	C03509-T10P	T00-10P30	26.6IN.LBS
R220.69-04.00	UC6S3/4UNFX1-1/4	C03509-T10P	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 12 – R217/220.69-12 – Metric





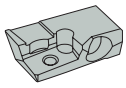
- For insert selection and cutting data recommendations, see page(s) 51-53
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm	mm	mm		mm	mm	kg		
R220.69-0125-12-8CN	02706936	Arbor	125,0	8	11,0	7,0	40,0	90,0	63,0	0,5	237,5	248,0	3,1	9200	XO.X12..
R220.69-8160-12-10CN	02706940	Arbor	160,0	10	11,0	7,0	40,0	90,0	63,0	0,3	307,5	318,0	5,3	8200	XO.X12..
R220.69-8200-12-12CN	02706943	Arbor	200,0	12	11,0	7,0	60,0	130,0	63,0	0,3	387,5	398,0	7,4	7300	XO.X12..
R220.69-8250-12-16CN	02706945	Arbor	250,0	16	11,0	7,0	60,0	130,0	63,0	0,2	487,5	498,0	14,8	6500	XO.X12..

Modification of the cutter body needed for radii > 3,1 mm

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Setting gauge	Allen key	Torque key	Torque value
							
R220.69-0125-8250	XO12PRN	FS96018	C03509-T10P	AU1114T-T15P	H05-4	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-12 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	XOMX120408TR-ME08 F40M	5,0 *0.20*	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
P2	XOMX120408TR-ME08 F40M	5,0 *0.20*	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P3	XOMX120408TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P4	XOMX120408TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,18 *0.0070*	0,26 *0.010*
P5	XOMX120408TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P6	XOMX120408TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P7	XOMX120408TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P8	XOMX120408TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P11	XOMX120408TR-M12 T350M	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P12	XOEX120408R-M07 MS2500	4,5 *0.18*	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
M1	XOEX120408R-M07 F40M	5,0 *0.20*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
M2	XOEX120408R-M07 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*
M3	XOEX120408R-M07 F40M	4,5 *0.18*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M4	XOEX120408R-M07 T350M	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
M5	XOEX120408R-M07 T350M	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
K1	XOMX120408TR-M12 MK2050	5,0 *0.20*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K2	XOMX120408TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K3	XOMX120408TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K4	XOMX120408TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K5	XOMX120408TR-MD13 MK2050	5,0 *0.20*	0,15 *0.0060*	0,17 *0.0065*	0,26 *0.010*
K6	XOMX120408TR-MD13 MK2050	5,0 *0.20*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K7	XOMX120408TR-MD13 MK2050	5,0 *0.20*	0,15 *0.0060*	0,17 *0.0065*	0,26 *0.010*
N1	XOEX120408FR-E06 H15	5,0 *0.20*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N2	XOEX120408FR-E06 H15	5,0 *0.20*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N3	XOEX120408FR-E06 H15	5,0 *0.20*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N11	XOEX120408FR-E06 H15	5,0 *0.20*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
S1	XOEX120408R-M07 T350M	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S2	XOEX120408R-M07 T350M	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S3	XOEX120408R-M07 T350M	3,0 *0.12*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*
S11	XOEX120408R-M07 MS2050	4,0 *0.16*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S12	XOEX120408R-M07 MS2050	4,0 *0.16*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S13	XOEX120408R-M07 MS2050	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H5	XOMX120408TR-MD13 MP3000	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
H8	XOMX120408TR-MD13 MP3000	4,0 *0.16*	0,090 *0.0036*	0,095 *0.0038*	0,15 *0.0060*
H11	XOMX120408TR-MD13 MP1501	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
H12	XOMX120408TR-MD13 MP1501	4,0 *0.16*	0,090 *0.0036*	0,095 *0.0038*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

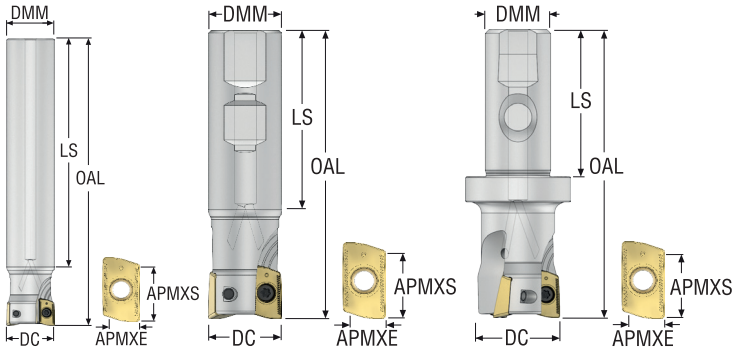
R217/220.69-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	295	390	465	315	415	480	265	345	410	250	325	390	195	260	300	—	—	—
	970	*1275*	*1525*	*1025*	*1350*	*1575*	*870*	*1125*	*1350*	*820*	*1075*	*1275*	*640*	*850*	*980*	—	—	—
P2	290	380	450	300	395	470	255	335	400	245	320	380	185	245	295	—	—	—
	950	*1250*	*1475*	*980*	*1300*	*1550*	*840*	*1100*	*1300*	*800*	*1050*	*1250*	*610*	*800*	*970*	—	—	—
P3	255	330	390	265	345	410	225	295	345	215	280	325	165	215	255	—	—	—
	840	*1075*	*1275*	*870*	*1125*	*1350*	*740*	*970*	*1125*	*710*	*920*	*1075*	*540*	*710*	*840*	—	—	—
P4	225	290	350	230	305	360	200	260	310	185	245	295	145	190	225	—	—	—
	740	*950*	*1150*	*750*	*1000*	*1175*	*660*	*850*	*1025*	*610*	*800*	*970*	*475*	*620*	*740*	—	—	—
P5	215	285	335	220	295	350	190	250	295	180	240	280	140	185	220	—	—	—
	710	*940*	*1100*	*720*	*970*	*1150*	*620*	*820*	*970*	*590*	*790*	*920*	*460*	*610*	*720*	—	—	—
P6	240	320	375	255	335	390	210	280	330	200	265	315	160	210	245	—	—	—
	790	*1050*	*1225*	*840*	*1100*	*1275*	*690*	*920*	*1075*	*660*	*870*	*1025*	*520*	*690*	*800*	—	—	—
P7	225	300	355	240	315	370	200	265	315	190	250	295	150	195	230	—	—	—
	740	*980*	*1175*	*790*	*1025*	*1225*	*660*	*870*	*1025*	*620*	*820*	*970*	*490*	*640*	*750*	—	—	—
P8	215	280	325	220	290	345	190	245	290	180	235	275	140	180	215	—	—	—
	710	*920*	*1075*	*720*	*950*	*1125*	*620*	*800*	*950*	*590*	*770*	*900*	*460*	*590*	*710*	—	—	—
P11	220	290	345	235	305	360	195	260	305	185	245	290	145	190	225	—	—	—
	720	*950*	*1125*	*770*	*1000*	*1175*	*640*	*850*	*1000*	*610*	*800*	*950*	*475*	*620*	*740*	—	—	—
P12	145	190	225	150	195	230	130	170	200	120	160	190	95	120	145	—	—	—
	475	*620*	*740*	*490*	*640*	*750*	*425*	*560*	*660*	*395*	*520*	*620*	*310*	*395*	*475*	—	—	—
M1	—	—	—	215	280	335	185	240	290	180	240	285	160	210	250	—	—	—
	—	—	—	*710*	*920*	*1100*	*610*	*790*	*950*	*590*	*790*	*940*	*520*	*690*	*820*	—	—	—
M2	—	—	—	175	240	280	150	200	240	150	200	235	130	180	210	—	—	—
	—	—	—	*570*	*790*	*920*	*490*	*660*	*790*	*490*	*660*	*770*	*425*	*590*	*690*	—	—	—
M3	—	—	—	145	190	220	125	165	195	120	160	190	110	145	165	—	—	—
	—	—	—	*475*	*620*	*720*	*410*	*540*	*640*	*395*	*520*	*620*	*360*	*475*	*540*	—	—	—
M4	—	—	—	115	150	175	100	130	150	95	130	150	85	110	130	—	—	—
	—	—	—	*375*	*490*	*570*	*330*	*425*	*490*	*310*	*425*	*490*	*280*	*360*	*425*	—	—	—
M5	—	—	—	95	125	145	80	110	125	80	105	125	70	95	110	—	—	—
	—	—	—	*310*	*410*	*475*	*260*	*360*	*410*	*260*	*345*	*410*	*230*	*310*	*360*	—	—	—
K1	230	300	360	235	310	370	205	265	320	190	250	300	—	—	—	290	380	450
	750	*980*	*1175*	*770*	*1025*	*1225*	*670*	*870*	*1050*	*620*	*820*	*980*	—	—	—	*950*	*1250*	*1475*
K2	200	270	315	210	280	330	180	240	280	170	225	265	—	—	—	255	340	400
	660	*890*	*1025*	*690*	*920*	*1075*	*590*	*790*	*920*	*560*	*740*	*870*	—	—	—	*840*	*1125*	*1300*
K3	170	230	270	175	240	280	150	200	240	145	190	225	—	—	—	215	285	335
	560	*750*	*890*	*570*	*790*	*920*	*490*	*660*	*790*	*475*	*620*	*740*	—	—	—	*710*	*940*	*1100*
K4	165	220	255	170	230	265	145	195	225	135	185	215	—	—	—	205	275	320
	540	*720*	*840*	*560*	*750*	*870*	*475*	*640*	*740*	*445*	*610*	*710*	—	—	—	*670*	*900*	*1050*
K5	100	135	155	105	140	160	90	120	140	85	115	130	—	—	—	125	170	195
	330	*445*	*510*	*345*	*460*	*520*	*295*	*395*	*460*	*280*	*375*	*425*	—	—	—	*410*	*560*	*640*
K6	145	190	225	150	200	235	130	170	200	120	160	190	—	—	—	180	240	285
	475	*620*	*740*	*490*	*660*	*770*	*425*	*560*	*660*	*395*	*520*	*620*	—	—	—	*590*	*790*	*940*
K7	130	170	200	135	180	205	115	150	175	110	145	170	—	—	—	165	215	250
	425	*560*	*660*	*445*	*590*	*670*	*375*	*490*	*570*	*360*	*475*	*560*	—	—	—	*540*	*710*	*820*
N1	—	—	—	—	—	—	—	—	—	1400	1850	2200	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*4600*	*6075*	*7225*	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	570	750	890	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*1875*	*2450*	*2925*	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	380	500	590	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*1250*	*1650*	*1925*	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	430	570	680	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*1400*	*1875*	*2225*	—	—	—	—	—	—
S1	—	—	—	55	75	85	48	65	75	45	60	70	26	34	40	—	—	—
	—	—	—	*180*	*245*	*280*	*155*	*215*	*245*	*150*	*195*	*230*	*85*	*110*	*130*	—	—	—
S2	—	—	—	45	60	70	39	50	60	37	48	55	21	28	32	—	—	—
	—	—	—	*150*	*195*	*230*	*130*	*165*	*195*	*120*	*155*	*180*	*70*	*90*	*105*	—	—	—
S3	—	—	—	39	50	60	34	45	50	32	42	49	18	24	28	—	—	—
	—	—	—	*130*	*165*	*195*	*110*	*150*	*165*	*105*	*140*	*160*	*60*	*80*	*90*	—	—	—
S11	—	—	—	75	100	120	65	85	105	60	80	95	36	48	55	—	—	—
	—	—	—	*245*	*330*	*395*	*215*	*280*	*345*	*195*	*260*	*310*	*120*	*155*	*180*	—	—	—
S12	—	—	—	55	70	80	45	60	70	43	55	65	33	44	50	—	—	—
	—	—	—	*180*	*230*	*260*	*150*	*195*	*230*	*140*	*180*	*215*	*110*	*145*	*165*	—	—	—
S13	—	—	—	31	41	47	27	36	41	26	33	39	19	26	30	—	—	—
	—	—	—	*100*	*135*	*155*	*90*	*120*	*135*	*85*	*110*	*130*	*60*	*85*	*100*	—	—	—
H5	48	65	75	45	60	70	39	50	60	38	50	60	—	—	—	—	—	—
	155	*215*	*245*	*150*	*195*	*230*	*130*	*165*	*195*	*125*	*165*	*195*	—	—	—	—	—	—
H8	50	70	80	48	65	75	41	55	65	40	55	60	—	—	—	—	—	—
	165	*230*	*260*	*155*	*215*	*245*	*135*	*180*	*215*	*130*	*180*	*195*	—	—	—	—	—	—
H11	60	80	95	55	75	90	49	65	75	48	65	75	—	—	—	—	—	—
	195	*260*	*310*	*180*	*245*	*295*	*160*	*215*	*245*	*155*	*215*	*245*	—	—	—	—	—	—
H12	95	120	140	95	125	145	80	110	125	80	105	120	—	—	—	—	—	—
	310	*395*	*460*	*310*	*410*	*475*	*260*	*360*	*410*	*260*	*345*	*395*	—	—	—	—	—	—

R217/220.69-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MS2050			MS2500			T350M			F40M			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	260 *850*	340 *1125*	405 *1325*	265 *870*	350 *1150*	410 *1350*	350 *1150*	460 *1500*	530 *1750*	230 *750*	300 *980*	360 *1175*	225 *740*	300 *980*	350 *1150*	— —	— —	— —
P2	255 *840*	330 *1075*	395 *1300*	255 *840*	335 *1100*	395 *1300*	330 *1075*	435 *1425*	520 *1700*	225 *740*	295 *970*	350 *1150*	220 *720*	285 *940*	340 *1125*	— —	— —	— —
P3	220 *720*	290 *950*	340 *1125*	225 *740*	295 *970*	345 *1125*	290 *950*	385 *1275*	455 *1500*	195 *640*	255 *840*	300 *980*	190 *620*	250 *820*	300 *980*	— —	— —	— —
P4	195 *640*	255 *840*	305 *1000*	195 *640*	260 *850*	305 *1000*	255 *840*	340 *1125*	400 *1300*	170 *560*	225 *740*	270 *890*	170 *560*	220 *720*	265 *870*	— —	— —	— —
P5	185 *610*	250 *820*	290 *950*	185 *610*	250 *820*	295 *970*	245 *800*	330 *1075*	385 *1275*	165 *540*	220 *720*	260 *850*	165 *540*	215 *710*	250 *820*	— —	— —	— —
P6	210 *690*	280 *920*	325 *1075*	215 *710*	285 *940*	330 *1075*	280 *920*	370 *1225*	435 *1425*	185 *610*	245 *800*	290 *950*	185 *610*	240 *790*	280 *920*	— —	— —	— —
P7	195 *640*	260 *850*	310 *1025*	205 *670*	265 *870*	315 *1025*	265 *870*	350 *1150*	410 *1350*	175 *570*	230 *750*	275 *900*	170 *560*	230 *750*	265 *870*	— —	— —	— —
P8	185 *610*	245 *800*	285 *940*	185 *610*	245 *800*	290 *950*	245 *800*	325 *1075*	380 *1250*	165 *540*	215 *710*	255 *840*	160 *520*	210 *690*	250 *820*	— —	— —	— —
P11	190 *620*	255 *840*	300 *980*	200 *660*	260 *850*	305 *1000*	260 *850*	340 *1125*	400 *1300*	170 *560*	225 *740*	265 *870*	170 *560*	220 *720*	260 *850*	— —	— —	— —
P12	125 *410*	165 *540*	195 *640*	130 *425*	165 *540*	195 *640*	165 *540*	215 *710*	255 *840*	110 *360*	145 *475*	175 *570*	110 *360*	145 *475*	170 *560*	— —	— —	— —
M1	— —	— —	— —	205 *670*	270 *890*	320 *1050*	235 *770*	315 *1025*	375 *1225*	170 *560*	225 *740*	270 *890*	180 *590*	230 *750*	275 *900*	— —	— —	— —
M2	— —	— —	— —	170 *560*	225 *740*	265 *870*	195 *640*	265 *870*	310 *1025*	140 *460*	190 *620*	220 *720*	145 *475*	195 *640*	225 *740*	— —	— —	— —
M3	— —	— —	— —	140 *460*	185 *610*	210 *690*	160 *520*	210 *690*	245 *800*	115 *375*	155 *510*	180 *590*	115 *375*	160 *520*	185 *610*	— —	— —	— —
M4	— —	— —	— —	110 *360*	140 *460*	165 *540*	125 *410*	165 *540*	190 *620*	90 *295*	120 *395*	140 *460*	95 *310*	125 *410*	145 *475*	— —	— —	— —
M5	— —	— —	— —	90 *295*	120 *395*	135 *445*	105 *345*	140 *460*	160 *520*	75 *245*	100 *330*	115 *375*	80 *260*	105 *345*	120 *395*	— —	— —	— —
K1	270 *890*	355 *1175*	425 *1400*	— —	— —	— —	— —	— —	— —	175 *570*	230 *750*	275 *900*	— —	— —	— —	— —	— —	— —
K2	240 *790*	320 *1050*	375 *1225*	— —	— —	— —	— —	— —	— —	155 *510*	210 *690*	245 *800*	— —	— —	— —	— —	— —	— —
K3	205 *670*	270 *890*	320 *1050*	— —	— —	— —	— —	— —	— —	130 *425*	175 *570*	205 *670*	— —	— —	— —	— —	— —	— —
K4	195 *640*	260 *850*	305 *1000*	— —	— —	— —	— —	— —	— —	125 *410*	170 *560*	200 *660*	— —	— —	— —	— —	— —	— —
K5	120 *395*	160 *520*	185 *610*	— —	— —	— —	— —	— —	— —	80 *260*	105 *345*	120 *395*	— —	— —	— —	— —	— —	— —
K6	170 *560*	230 *750*	270 *890*	— —	— —	— —	— —	— —	— —	110 *360*	150 *490*	175 *570*	— —	— —	— —	— —	— —	— —
K7	155 *510*	205 *670*	235 *770*	— —	— —	— —	— —	— —	— —	100 *330*	135 *445*	155 *510*	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1275 *4175*	1675 *5500*	2000 *6550*	1400 *4600*	1850 *6075*	2175 *7125*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	520 *1700*	680 *2225*	810 *2650*	570 *1875*	750 *2450*	880 *2875*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	345 *1125*	455 *1500*	540 *1775*	380 *1250*	500 *1650*	580 *1900*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	395 *1300*	520 *1700*	610 *2000*	430 *1400*	570 *1875*	670 *2200*
S1	— —	— —	— —	50 *165*	65 *215*	75 *245*	60 *195*	80 *260*	95 *310*	43 *140*	55 *180*	65 *215*	43 *140*	55 *180*	65 *215*	— —	— —	— —
S2	— —	— —	— —	41 *135*	55 *180*	60 *195*	50 *165*	65 *215*	75 *245*	35 *115*	45 *150*	55 *180*	35 *115*	46 *150*	55 *180*	— —	— —	— —
S3	— —	— —	— —	36 *120*	47 *155*	55 *180*	43 *140*	55 *180*	65 *215*	31 *100*	40 *130*	46 *150*	31 *100*	40 *130*	47 *155*	— —	— —	— —
S11	— —	— —	— —	70 *230*	95 *310*	105 *345*	85 *280*	115 *375*	130 *425*	60 *195*	75 *245*	90 *295*	60 *195*	80 *260*	95 *310*	— —	— —	— —
S12	— —	— —	— —	48 *155*	65 *215*	75 *245*	60 *195*	80 *260*	90 *295*	41 *135*	55 *180*	65 *215*	41 *135*	55 *180*	65 *215*	— —	— —	— —
S13	— —	— —	— —	28 *90*	37 *120*	43 *140*	35 *115*	46 *150*	55 *180*	24 *80*	32 *105*	37 *120*	24 *80*	32 *105*	37 *120*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	37 *120*	49 *160*	55 *180*	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	40 *130*	55 *180*	60 *195*	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	47 *155*	60 *195*	75 *245*	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	70 *230*	95 *310*	110 *360*	— —	— —	— —	— —	— —	— —

Turbo 16 – R217.69-XO16 – Metric



- For insert selection and cutting data recommendations, see page(s) 60-62
- For complete insert programme, see page(s) 780, 781
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.69-2525.0-XO16-2A	03336100	Cylindrical	25,0	2	15,0	9,0	25,0	135,0	170,0	11,0	33,5	47,7	16700	0,6	XO.X16
R217.69-3232.0-XO16-2A	03336101	Cylindrical	32,0	2	15,0	9,0	32,0	155,0	195,0	6,0	47,5	61,7	14800	1,1	XO.X16
R217.69-3232.0-XO16-3A	03336102	Cylindrical	32,0	3	15,0	9,0	32,0	155,0	195,0	6,0	47,5	61,7	14800	1,1	XO.X16
R217.69-2525.3-XO16-2A	03336092	Weldon	25,0	2	15,0	9,0	25,0	62,0	100,0	11,0	33,5	47,7	16700	0,3	XO.X16
R217.69-3232.3-XO16-2A	03336093	Weldon	32,0	2	15,0	9,0	32,0	72,0	110,0	6,0	47,5	61,7	14800	0,6	XO.X16
R217.69-3232.3-XO16-3A	03336094	Weldon	32,0	3	15,0	9,0	32,0	72,0	110,0	6,0	47,5	61,7	14800	0,6	XO.X16
R217.69-2025.3S-XO16-2A	03336095	Seco-Weldon	25,0	2	15,0	9,0	20,0	50,0	100,0	11,0	33,5	47,7	16700	0,3	XO.X16
R217.69-2532.3S-XO16-2A	03336096	Seco-Weldon	32,0	2	15,0	9,0	25,0	56,0	110,0	6,0	47,5	61,7	14800	0,5	XO.X16
R217.69-2532.3S-XO16-3A	03336097	Seco-Weldon	32,0	3	15,0	9,0	25,0	56,0	110,0	6,0	47,5	61,7	14800	0,5	XO.X16
R217.69-3240.3S-XO16-3A	03336098	Seco-Weldon	40,0	3	15,0	9,0	32,0	60,0	120,0	3,5	63,5	77,7	13200	0,8	XO.X16
R217.69-3240.3S-XO16-4A	03336099	Seco-Weldon	40,0	4	15,0	9,0	32,0	60,0	120,0	3,5	63,5	77,7	13200	0,8	XO.X16

Modification of the cutter body needed for radii > 4,0 mm

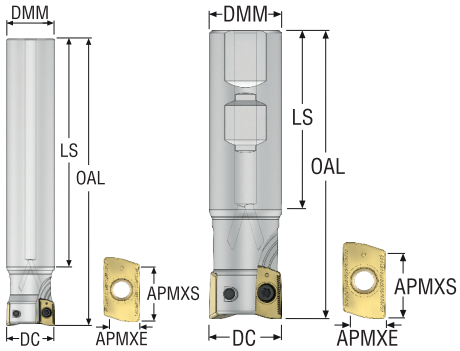
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-2525-2532	C04008-T15P	T00-15P35	3.5NM
R217.69-3240	C04009-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 16 – R217.69-XO16 – Inch



- For insert selection and cutting data recommendations, see page(s) 60-62
- For complete insert programme, see page(s) 780, 781
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.69-01.00-0-XO16-2A	03336134	Cylindrical	1.000	2	0.591	0.354	1.000	5.315	6.693	9.0	1.350	1.909	16600	1.320	XO.X16
R217.69-01.25-0-XO16-2A	03336135	Cylindrical	1.250	2	0.591	0.354	1.250	6.102	7.677	5.5	1.850	2.409	14800	2.430	XO.X16
R217.69-01.50-0-XO16-3A	03336136	Cylindrical	1.500	3	0.591	0.354	1.250	6.496	8.268	4.0	2.350	2.909	13500	2.650	XO.X16
R217.69-01.50-0-XO16-4A	03336137	Cylindrical	1.500	4	0.591	0.354	1.250	6.496	8.268	4.0	2.350	2.906	13500	2.650	XO.X16
R217.69-01.00-3-XO16-2A	03336130	Weldon	1.000	2	0.591	0.354	1.000	2.362	3.937	10.0	1.350	1.909	16600	0.660	XO.X16
R217.69-01.25-3-XO16-3A	03336131	Weldon	1.250	3	0.591	0.354	1.250	2.756	4.331	6.0	1.850	2.409	14800	1.320	XO.X16
R217.69-01.50-3-XO16-3A	03336132	Weldon	1.500	3	0.591	0.354	1.250	3.150	4.724	4.0	2.350	2.909	13500	1.540	XO.X16
R217.69-01.50-3-XO16-4A	03336133	Weldon	1.500	4	0.591	0.354	1.250	3.150	4.724	4.0	2.350	2.909	13500	1.540	XO.X16

Modification of the cutter body needed for radii > 0.158 in

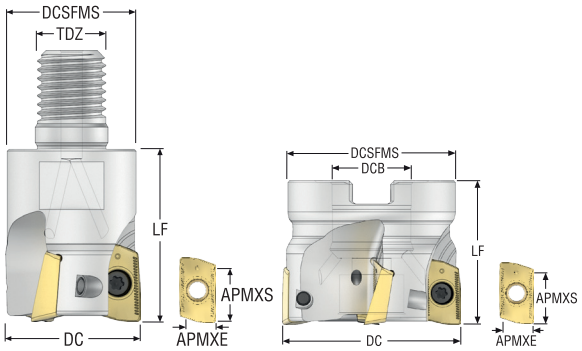
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-01.00-01.25	C04008-T15P	T00-15P35	31.0IN.LBS
R217.69-01.50	C04009-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 16 – R217/220.69-XO16 – Metric



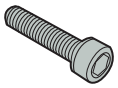
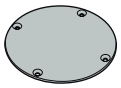
- For insert selection and cutting data recommendations, see page(s) 60-62
- For complete insert programme, see page(s) 780, 781
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm		mm	mm	kg		
R217.69-1225.RE-XO16-2A	03336103	Combimaster	25,0	2	15,0	9,0	–	M12	23,0	40,0	11,0	33,5	47,7	0,2	16700	XO.X16
R217.69-1632.RE-XO16-2A	03336104	Combimaster	32,0	2	15,0	9,0	–	M16	30,0	40,0	6,0	47,5	61,7	0,2	14800	XO.X16
R217.69-1632.RE-XO16-3A	03336105	Combimaster	32,0	3	15,0	9,0	–	M16	30,0	40,0	6,0	47,5	61,7	0,2	14800	XO.X16
R217.69-2040.RE-XO16-3A	03336106	Combimaster	40,0	3	15,0	9,0	–	M20	36,0	45,0	3,5	63,5	77,7	0,4	13200	XO.X16
R217.69-2040.RE-XO16-4A	03336107	Combimaster	40,0	4	15,0	9,0	–	M20	36,0	45,0	3,5	63,5	77,7	0,1	13200	XO.X16
R220.69-0040-XO16-3A	03336108	Arbor	40,0	3	15,0	9,0	16,0	–	35,0	40,0	3,5	63,5	77,7	0,2	13200	XO.X16
R220.69-0040-XO16-4A	03336109	Arbor	40,0	4	15,0	9,0	16,0	–	35,0	40,0	3,5	63,5	77,7	0,2	13200	XO.X16
R220.69-0050-XO16-4A	03336110	Arbor	50,0	4	15,0	9,0	22,0	–	47,0	40,0	2,6	83,5	97,7	0,3	11800	XO.X16
R220.69-0050-XO16-5A	03336111	Arbor	50,0	5	15,0	9,0	22,0	–	47,0	40,0	2,6	83,5	97,7	0,3	11800	XO.X16
R220.69-0050-XO16-6A	10010246	Arbor	50,0	6	15,0	9,0	22,0	–	47,0	40,0	2,6	83,5	97,7	0,3	11800	XO.X16
R220.69-0052-XO16-5A	03336112	Arbor	52,0	5	15,0	9,0	22,0	–	47,0	40,0	2,5	87,5	101,7	0,4	11600	XO.X16
R220.69-0063-XO16-5A	03336113	Arbor	63,0	5	15,0	9,0	27,0	–	52,0	40,0	2,0	109,5	123,7	0,5	10500	XO.X16
R220.69-0063-XO16-6A	03336115	Arbor	63,0	6	15,0	9,0	27,0	–	52,0	40,0	2,0	109,5	123,7	0,5	10500	XO.X16
R220.69-0063-XO16-7A	10010247	Arbor	63,0	7	15,0	9,0	27,0	–	52,0	40,0	2,0	109,5	123,7	0,5	10549	XO.X16
R220.69-0066-XO16-6A	03336117	Arbor	66,0	6	15,0	9,0	27,0	–	52,0	40,0	1,8	115,5	129,7	0,5	10300	XO.X16
R220.69-0080-XO16-6A	03336118	Arbor	80,0	6	15,0	9,0	27,0	–	62,0	50,0	1,5	143,5	157,7	1,0	9300	XO.X16
R220.69-0080-XO16-8A	03336119	Arbor	80,0	8	15,0	9,0	27,0	–	62,0	50,0	1,5	143,5	157,7	1,0	9300	XO.X16
R220.69-0080-XO16-9A	10010248	Arbor	80,0	9	15,0	9,0	27,0	–	62,0	50,0	1,5	143,5	157,7	1,0	9300	XO.X16
R220.69-0084-XO16-8A	03336120	Arbor	84,0	8	15,0	9,0	27,0	–	62,0	50,0	1,3	151,5	165,7	1,0	9100	XO.X16
R220.69-0100-XO16-8A	03336121	Arbor	100,0	8	15,0	9,0	32,0	–	77,0	50,0	1,1	183,5	197,7	1,6	8300	XO.X16
R220.69-0100-XO16-10A	03336122	Arbor	100,0	10	15,0	9,0	32,0	–	77,0	50,0	1,1	183,5	197,7	1,6	8300	XO.X16
R220.69-0125-XO16-10A	03336123	Arbor	125,0	10	15,0	9,0	40,0	–	90,0	63,0	0,85	233,5	247,7	3,0	7400	XO.X16
R220.69-0125-XO16-12A	03336124	Arbor	125,0	12	15,0	9,0	40,0	–	90,0	63,0	0,85	234,0	247,0	3,0	7400	XO.X16
R220.69-8160-XO16-11A	03336125	Arbor	160,0	11	15,0	9,0	40,0	–	90,0	63,0	0,65	303,5	317,7	5,0	6600	XO.X16
R220.69-8160-XO16-13A	03336126	Arbor	160,0	13	15,0	9,0	40,0	–	90,0	63,0	0,65	303,5	317,7	5,0	6600	XO.X16

Modification of the cutter body needed for radii > 4,0 mm
For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert key	Insert screw	Lid	Lid screw	Torque key	Torque value
							
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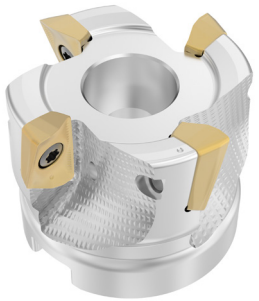
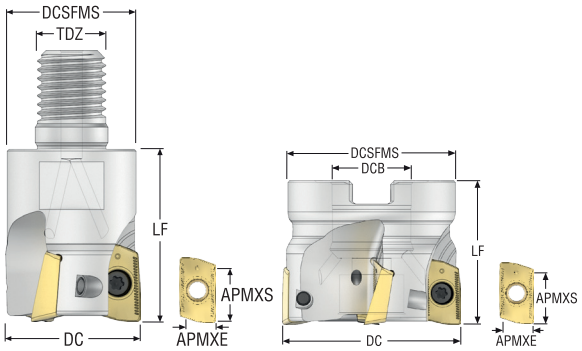
R217.69-2040/R220.69-0080-0125	–	T15P-2	C04009-T15P	–	–	T00-15P35	3.5NM
R220.69-0040	TCEI0825	T15P-2	C04009-T15P	–	–	T00-15P35	3.5NM
R220.69-0050-0052	220.17-692	T15P-2	C04009-T15P	–	–	T00-15P35	3.5NM
R220.69-0063-0066	MLC6S12X30	T15P-2	C04009-T15P	–	–	T00-15P35	3.5NM
R220.69-8160	–	T15P-2	C04009-T15P	SC-160-90	MF6S4X10	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 16 – R217/220.69-XO16 – Inch





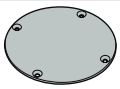
- For insert selection and cutting data recommendations, see page(s) 60-62
- For complete insert programme, see page(s) 780, 781
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch		Inch	Inch	lbs		
R217.69-01.00-12RE-XO16-2A	03336138	Combimaster	1.000	2	0.591	0.354	–	M12	0.906	1.575	11.0	1.350	1.909	0.440	16600	XO.X16
R217.69-01.25-16RE-XO16-3A	03336139	Combimaster	1.250	3	0.591	0.354	–	M16	1.181	1.575	6.0	1.850	2.409	0.440	14800	XO.X16
R217.69-01.50-20RE-XO16-4A	03336140	Combimaster	1.500	4	0.591	0.354	–	M20	1.437	1.772	4.0	2.350	2.909	0.880	13500	XO.X16
R220.69-01.50-XO16-4A	03336141	Arbor	1.500	4	0.591	0.354	0.500	–	1.378	1.575	4.0	2.350	2.909	0.440	13500	XO.X16
R220.69-02.00-XO16-4A	03336142	Arbor	2.000	4	0.591	0.354	0.750	–	1.850	1.575	2.5	3.350	3.909	0.880	11700	XO.X16
R220.69-02.00-XO16-5A	03336143	Arbor	2.000	5	0.591	0.354	0.750	–	1.850	1.575	2.5	3.350	3.909	0.880	11700	XO.X16
R220.69-02.00-XO16-6A	03336144	Arbor	2.000	6	0.591	0.354	0.750	–	1.850	1.575	2.5	3.350	3.909	0.880	11700	XO.X16
R220.69-02.50-XO16-5A	03336145	Arbor	2.500	5	0.591	0.354	0.750	–	1.850	1.575	2.0	4.350	4.909	1.100	10500	XO.X16
R220.69-02.50-XO16-6A	03336146	Arbor	2.500	6	0.591	0.354	0.750	–	1.850	1.575	2.0	4.370	4.882	1.100	10500	XO.X16
R220.69-03.00-XO16-6A	03336147	Arbor	3.000	6	0.591	0.354	1.000	–	2.441	1.969	1.5	5.354	5.906	2.200	9500	XO.X16
R220.69-03.00-XO16-8A	03336148	Arbor	3.000	8	0.591	0.354	1.000	–	2.441	1.969	1.5	5.354	5.906	2.200	9500	XO.X16
R220.69-04.00-XO16-8A	03336149	Arbor	4.000	8	0.591	0.354	1.500	–	3.543	1.969	1.1	7.362	7.874	4.410	8300	XO.X16
R220.69-04.00-XO16-10A	03336150	Arbor	4.000	10	0.591	0.354	1.500	–	3.543	1.969	1.1	7.362	7.874	4.410	8300	XO.X16
R220.69-05.00-XO16-9A	03336151	Arbor	5.000	9	0.591	0.354	1.500	–	3.543	2.480	0.85	9.370	9.882	7.500	7400	XO.X16
R220.69-06.00-XO16-12A	10000967	Arbor	6.000	12	0.591	0.354	2.000	–	4.331	2.480	0.7	11.378	11.890	9.920	6700	XO.X16

Modification of the cutter body needed for radii > 0.158 in
For Combimaster Shanks, see Machining Navigator Tooling System

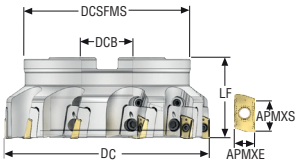
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R217.69-01.00-01.25	–	C04008-T15P	–	–	T00-15P35	31.0IN.LBS
R217.69-01.50	–	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
R220.69-01.50	UC6S1/4UNFX1	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
R220.69-02.00-02.50	UC6S3/8UNFX1	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
R220.69-03.00	UC6S1/2UNFX1-1/4	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
R220.69-04.00	UF6S3/4UNFX2	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
R220.69-05.00	UC6S3/4UNFX1-1/4	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
R220.69-06.00	–	C04009-T15P	SC-160-90	MF6S4X10	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 16 – R220.69-XO16 – Metric



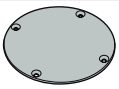
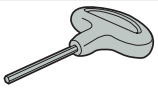
- For insert selection and cutting data recommendations, see page(s) 60-62
- For complete insert programme, see page(s) 780, 781
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm	mm	mm		mm	mm	kg		
R220.69-0125-XO16-8CA	03336127	Arbor	125,0	8	15,0	9,0	40,0	90,0	63,0	0,85	233,5	247,7	2,8	7400	XO.X16
R220.69-8160-XO16-10CA	10000966	Arbor	160,0	10	15,0	9,0	40,0	90,0	63,0	0,65	303,5	317,7	4,7	6600	XO.X16
R220.69-8200-XO16-12CA	03336128	Arbor	200,0	12	15,0	9,0	60,0	130,0	63,0	0,5	383,5	397,7	6,6	5900	XO.X16
R220.69-8250-XO16-16CA	03336129	Arbor	250,0	16	15,0	9,0	60,0	130,0	63,0	0,4	483,5	497,7	13,3	5200	XO.X16

Modification of the cutter body needed for radii > 4,0 mm

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Lid	Lid screw	Setting gauge	Allen key	Torque key	Torque value
									
R220.69-0125	XO16PRA	FS96018	C04009-T15P	–	–	AU1114T-T15P	H05-4	T00-15P35	3.5NM
R220.69-8160	XO16PRA	FS96018	C04009-T15P	SC-160-90	MF6S4X10	AU1114T-T15P	H05-4	T00-15P35	3.5NM
R220.69-8200	XO16PRA	FS96018	C04009-T15P	SC-200-90	MF6S4X8	AU1114T-T15P	H05-4	T00-15P35	3.5NM
R220.69-8250	XO16PRA	FS96018	C04009-T15P	SC-250-90	MF6S4X10	AU1114T-T15P	H05-4	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-16 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	XOMX160508TR-ME11 F40M	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P2	XOMX160508TR-ME11 F40M	7,0 *0.28*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P3	XOMX160508TR-M13 MP2501	7,0 *0.28*	0,18 *0.0070*	0,19 *0.0075*	0,30 *0.012*
P4	XOMX160508TR-M13 MP2501	7,0 *0.28*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
P5	XOMX160508TR-M13 MP2501	7,0 *0.28*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
P6	XOMX160508TR-M13 MP2501	7,0 *0.28*	0,17 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P7	XOMX160508TR-M13 MP2501	7,0 *0.28*	0,17 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P8	XOMX160508TR-M13 MP2501	7,0 *0.28*	0,18 *0.0070*	0,19 *0.0075*	0,30 *0.012*
P11	XOMX160508TR-M13 T350M	7,0 *0.28*	0,17 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P12	XOEX160508R-M09 MS2500	6,0 *0.24*	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M1	XOEX160508R-M09 F40M	7,0 *0.28*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
M2	XOEX160508R-M09 F40M	7,0 *0.28*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
M3	XOEX160508R-M09 F40M	6,0 *0.24*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
M4	XOEX160508R-M09 T350M	4,5 *0.18*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M5	XOEX160508R-M09 T350M	4,5 *0.18*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
K1	XOMX160508TR-M13 MK2050	7,0 *0.28*	0,19 *0.0075*	0,20 *0.0080*	0,32 *0.013*
K2	XOMX160508TR-M13 MK2050	7,0 *0.28*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K3	XOMX160508TR-M13 MK2050	7,0 *0.28*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K4	XOMX160508TR-M13 MK2050	7,0 *0.28*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K5	XOMX160508TR-MD14 MK2050	7,0 *0.28*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
K6	XOMX160508TR-MD14 MK2050	7,0 *0.28*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K7	XOMX160508TR-MD14 MK2050	7,0 *0.28*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
N1	XOEX160508FR-E07 H25	7,0 *0.28*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N2	XOEX160508FR-E07 H25	7,0 *0.28*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N3	XOEX160508FR-E07 H25	7,0 *0.28*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N11	XOEX160508FR-E07 H25	7,0 *0.28*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
S1	XOEX160508R-M09 T350M	4,5 *0.18*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S2	XOEX160508R-M09 T350M	4,5 *0.18*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S3	XOEX160508R-M09 T350M	4,5 *0.18*	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
S11	XOEX160508R-M09 MS2500	5,0 *0.20*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
S12	XOEX160508R-M09 MS2500	5,0 *0.20*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
S13	XOEX160508R-M09 MS2500	4,5 *0.18*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
H5	XOMX160508TR-MD14 MP3000	6,0 *0.24*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
H8	XOMX160508TR-MD14 MP3000	5,0 *0.20*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
H11	XOMX160508TR-MD14 MP1501	6,0 *0.24*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
H12	XOMX160508TR-MD14 MP1501	5,0 *0.20*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

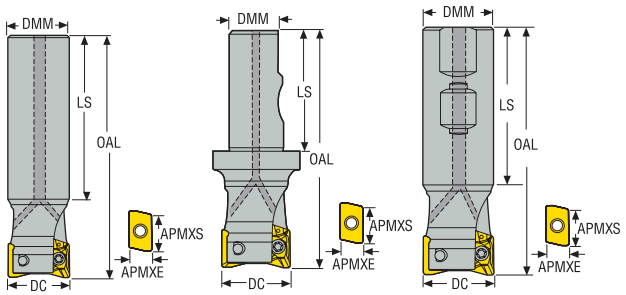
R217/220.69-16 – Cutting data v_c = (m/min)/*(sf/min)*

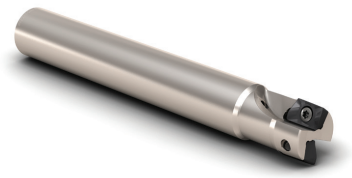
SMG	MP1501			MP2050			MP2501			MP3000			MK1500			MK2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	295	385	460	285	380	445	260	345	410	245	325	385	—	—	—	255	335	400
	970	*1275*	*1500*	*940*	*1250*	*1450*	*850*	*1125*	*1350*	*800*	*1075*	*1275*	—	—	—	*840*	*1100*	*1300*
P2	280	375	440	280	370	435	250	335	390	235	315	370	—	—	—	245	330	385
	920	*1225*	*1450*	*920*	*1225*	*1425*	*820*	*1100*	*1275*	*770*	*1025*	*1225*	—	—	—	*800*	*1075*	*1275*
P3	245	330	385	245	325	380	220	290	340	205	275	325	—	—	—	215	285	335
	800	*1075*	*1275*	*800*	*1075*	*1250*	*720*	*950*	*1125*	*670*	*900*	*1075*	—	—	—	*710*	*940*	*1100*
P4	220	290	345	215	285	335	195	255	305	185	245	290	—	—	—	190	255	300
	720	*950*	*1125*	*710*	*940*	*1100*	*640*	*840*	*1000*	*610*	*800*	*950*	—	—	—	*620*	*840*	*980*
P5	210	275	330	205	275	320	185	245	295	175	230	275	—	—	—	185	240	290
	690	*900*	*1075*	*670*	*900*	*1050*	*610*	*800*	*970*	*570*	*750*	*900*	—	—	—	*610*	*790*	*950*
P6	235	315	370	230	305	365	210	280	330	200	265	310	—	—	—	205	275	325
	770	*1025*	*1225*	*750*	*1000*	*1200*	*690*	*920*	*1075*	*660*	*870*	*1025*	—	—	—	*670*	*900*	*1075*
P7	225	300	350	220	290	345	195	265	310	185	250	295	—	—	—	195	260	305
	740	*980*	*1150*	*720*	*950*	*1125*	*640*	*870*	*1025*	*610*	*820*	*970*	—	—	—	*640*	*850*	*1000*
P8	205	275	325	205	275	320	185	245	285	175	230	270	—	—	—	180	240	285
	670	*900*	*1075*	*670*	*900*	*1050*	*610*	*800*	*940*	*570*	*750*	*890*	—	—	—	*590*	*790*	*940*
P11	215	290	340	210	280	335	190	255	300	180	245	285	—	—	—	190	250	295
	710	*950*	*1125*	*690*	*920*	*1100*	*620*	*840*	*980*	*590*	*800*	*940*	—	—	—	*620*	*820*	*970*
P12	140	190	225	140	185	215	125	165	200	120	155	185	—	—	—	125	165	195
	460	*620*	*740*	*460*	*610*	*710*	*410*	*540*	*660*	*395*	*510*	*610*	—	—	—	*410*	*540*	*640*
M1	—	—	—	200	265	310	180	240	280	175	235	275	—	—	—	—	—	—
	—	—	—	*660*	*870*	*1025*	*590*	*790*	*920*	*570*	*770*	*900*	—	—	—	—	—	—
M2	—	—	—	165	220	255	150	195	235	145	195	230	—	—	—	—	—	—
	—	—	—	*540*	*720*	*840*	*490*	*640*	*770*	*475*	*640*	*750*	—	—	—	—	—	—
M3	—	—	—	135	180	205	120	160	190	120	160	190	—	—	—	—	—	—
	—	—	—	*445*	*590*	*670*	*395*	*520*	*620*	*395*	*520*	*620*	—	—	—	—	—	—
M4	—	—	—	105	140	160	95	125	150	95	125	145	—	—	—	—	—	—
	—	—	—	*345*	*460*	*520*	*310*	*410*	*490*	*310*	*410*	*475*	—	—	—	—	—	—
M5	—	—	—	85	115	135	80	105	125	80	105	120	—	—	—	—	—	—
	—	—	—	*280*	*375*	*445*	*260*	*345*	*410*	*260*	*345*	*395*	—	—	—	—	—	—
K1	220	300	350	220	295	345	195	265	310	185	250	290	280	375	435	265	355	415
	720	*980*	*1150*	*720*	*970*	*1125*	*640*	*870*	*1025*	*610*	*820*	*950*	*920*	*1225*	*1425*	*870*	*1175*	*1350*
K2	200	265	315	195	260	305	175	235	280	165	220	265	250	330	395	235	310	375
	660	*870*	*1025*	*640*	*850*	*1000*	*570*	*770*	*920*	*540*	*720*	*870*	*820*	*1075*	*1300*	*770*	*1025*	*1225*
K3	170	220	265	165	220	260	150	195	235	140	185	225	210	280	335	200	265	315
	560	*720*	*870*	*540*	*720*	*850*	*490*	*640*	*770*	*460*	*610*	*740*	*690*	*920*	*1100*	*660*	*870*	*1025*
K4	160	210	255	160	210	245	145	190	225	135	180	215	200	265	320	190	250	300
	520	*690*	*840*	*520*	*690*	*800*	*475*	*620*	*740*	*445*	*590*	*710*	*660*	*870*	*1050*	*620*	*820*	*980*
K5	100	130	155	95	125	150	90	115	135	85	110	130	125	165	195	120	155	185
	330	*425*	*510*	*310*	*410*	*490*	*295*	*375*	*445*	*280*	*360*	*425*	*410*	*540*	*640*	*395*	*510*	*610*
K6	140	185	225	140	185	215	125	165	200	120	155	185	180	235	280	170	220	265
	460	*610*	*740*	*460*	*610*	*710*	*410*	*540*	*660*	*395*	*510*	*610*	*590*	*770*	*920*	*560*	*720*	*870*
K7	125	165	195	125	165	195	115	150	175	105	140	165	160	210	250	150	200	235
	410	*540*	*640*	*410*	*540*	*640*	*375*	*490*	*570*	*345*	*460*	*540*	*520*	*690*	*820*	*490*	*660*	*770*
N1	—	—	—	—	—	—	—	—	—	1375	1825	2150	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*4500*	*6000*	*7050*	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	550	740	870	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*1800*	*2425*	*2850*	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	370	490	580	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*1225*	*1600*	*1900*	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	420	560	660	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*1375*	*1825*	*2175*	—	—	—	—	—	—
S1	—	—	—	50	70	80	47	60	70	44	60	70	—	—	—	—	—	—
	—	—	—	*165*	*230*	*260*	*155*	*195*	*230*	*145*	*195*	*230*	—	—	—	—	—	—
S2	—	—	—	41	55	65	38	50	60	36	47	55	—	—	—	—	—	—
	—	—	—	*135*	*180*	*215*	*125*	*165*	*195*	*120*	*155*	*180*	—	—	—	—	—	—
S3	—	—	—	37	48	55	33	44	50	31	41	48	—	—	—	—	—	—
	—	—	—	*120*	*155*	*180*	*110*	*145*	*165*	*100*	*135*	*155*	—	—	—	—	—	—
S11	—	—	—	70	95	110	65	85	100	60	80	95	—	—	—	—	—	—
	—	—	—	*230*	*310*	*360*	*215*	*280*	*330*	*195*	*260*	*310*	—	—	—	—	—	—
S12	—	—	—	49	65	75	45	60	70	42	55	65	—	—	—	—	—	—
	—	—	—	*160*	*215*	*245*	*150*	*195*	*230*	*140*	*180*	*215*	—	—	—	—	—	—
S13	—	—	—	29	38	44	26	35	40	25	33	38	—	—	—	—	—	—
	—	—	—	*95*	*125*	*145*	*85*	*115*	*130*	*80*	*110*	*125*	—	—	—	—	—	—
H5	47	60	75	42	55	65	38	50	60	37	49	60	—	—	—	—	—	—
	155	*195*	*245*	*140*	*180*	*215*	*125*	*165*	*195*	*120*	*160*	*195*	—	—	—	—	—	—
H8	50	70	80	45	60	70	41	55	65	40	55	60	—	—	—	—	—	—
	165	*230*	*260*	*150*	*195*	*230*	*135*	*180*	*215*	*130*	*180*	*195*	—	—	—	—	—	—
H11	60	80	95	55	70	85	48	65	75	47	60	75	—	—	—	—	—	—
	195	*260*	*310*	*180*	*230*	*280*	*155*	*215*	*245*	*155*	*195*	*245*	—	—	—	—	—	—
H12	90	120	140	90	115	135	80	110	125	75	100	120	—	—	—	—	—	—
	295	*395*	*460*	*295*	*375*	*445*	*260*	*360*	*410*	*245*	*330*	*395*	—	—	—	—	—	—

R217/220.69-16 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MS2050			MS2500			T350M			F40M			H25		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	245 *800*	320 *1050*	375 *1225*	320 *1050*	420 *1375*	495 *1625*	225 *740*	300 *980*	355 *1175*	220 *720*	295 *970*	345 *1125*	— —	— —	— —
P2	235 *770*	315 *1025*	365 *1200*	310 *1025*	410 *1350*	480 *1575*	215 *710*	290 *950*	340 *1125*	215 *710*	285 *940*	335 *1100*	— —	— —	— —
P3	210 *690*	275 *900*	325 *1075*	270 *890*	360 *1175*	425 *1400*	190 *620*	255 *840*	295 *970*	190 *620*	250 *820*	295 *970*	— —	— —	— —
P4	185 *610*	240 *790*	285 *940*	240 *790*	315 *1025*	375 *1225*	170 *560*	225 *740*	265 *870*	165 *540*	220 *720*	260 *850*	— —	— —	— —
P5	175 *570*	230 *750*	275 *900*	230 *750*	305 *1000*	355 *1175*	160 *520*	215 *710*	255 *840*	160 *520*	210 *690*	250 *820*	— —	— —	— —
P6	195 *640*	260 *850*	310 *1025*	255 *840*	340 *1125*	405 *1325*	180 *590*	245 *800*	285 *940*	180 *590*	235 *770*	280 *920*	— —	— —	— —
P7	185 *610*	245 *800*	295 *970*	240 *790*	320 *1050*	385 *1275*	170 *560*	230 *750*	270 *890*	170 *560*	225 *740*	265 *870*	— —	— —	— —
P8	175 *570*	230 *750*	275 *900*	230 *750*	305 *1000*	355 *1175*	160 *520*	215 *710*	250 *820*	160 *520*	210 *690*	250 *820*	— —	— —	— —
P11	180 *590*	240 *790*	285 *940*	235 *770*	310 *1025*	370 *1225*	165 *540*	225 *740*	265 *870*	165 *540*	215 *710*	260 *850*	— —	— —	— —
P12	120 *395*	155 *510*	185 *610*	155 *510*	205 *670*	240 *790*	110 *360*	145 *475*	170 *560*	110 *360*	140 *460*	165 *540*	— —	— —	— —
M1	190 *620*	255 *840*	295 *970*	220 *720*	295 *970*	345 *1125*	165 *540*	225 *740*	260 *850*	175 *570*	230 *750*	270 *890*	— —	— —	— —
M2	155 *510*	210 *690*	245 *800*	185 *610*	240 *790*	285 *940*	140 *460*	185 *610*	220 *720*	145 *475*	190 *620*	225 *740*	— —	— —	— —
M3	130 *425*	170 *560*	200 *660*	150 *490*	200 *660*	230 *750*	115 *375*	150 *490*	180 *590*	115 *375*	155 *510*	180 *590*	— —	— —	— —
M4	100 *330*	130 *425*	155 *510*	115 *375*	155 *510*	180 *590*	90 *295*	120 *395*	140 *460*	90 *295*	120 *395*	140 *460*	— —	— —	— —
M5	85 *280*	110 *360*	130 *425*	95 *310*	130 *425*	150 *490*	75 *245*	100 *330*	115 *375*	75 *245*	100 *330*	115 *375*	— —	— —	— —
K1	— —	— —	— —	— —	— —	— —	170 *560*	230 *750*	270 *890*	— —	— —	— —	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	155 *510*	205 *670*	240 *790*	— —	— —	— —	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	130 *425*	170 *560*	205 *670*	— —	— —	— —	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	125 *410*	165 *540*	195 *640*	— —	— —	— —	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	75 *245*	100 *330*	120 *395*	— —	— —	— —	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	110 *360*	145 *475*	170 *560*	— —	— —	— —	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	100 *330*	130 *425*	150 *490*	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	1275 *4175*	1675 *5500*	1950 *6400*	1350 *4425*	1800 *5900*	2125 *6975*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	510 *1675*	670 *2200*	790 *2600*	550 *1800*	730 *2400*	850 *2800*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	340 *1125*	450 *1475*	530 *1750*	365 *1200*	485 *1600*	570 *1875*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	390 *1275*	510 *1675*	600 *1975*	420 *1375*	560 *1825*	650 *2125*
S1	47 *155*	60 *195*	70 *230*	55 *180*	75 *245*	85 *280*	42 *140*	55 *180*	65 *215*	42 *140*	55 *180*	65 *215*	— —	— —	— —
S2	37 *120*	50 *165*	60 *195*	46 *150*	60 *195*	70 *230*	34 *110*	45 *150*	50 *165*	34 *110*	45 *150*	50 *165*	— —	— —	— —
S3	33 *110*	43 *140*	50 *165*	41 *135*	55 *180*	60 *195*	30 *100*	39 *130*	46 *150*	30 *100*	39 *130*	46 *150*	— —	— —	— —
S11	65 *215*	85 *280*	100 *330*	80 *260*	105 *345*	120 *395*	60 *195*	75 *245*	90 *295*	60 *195*	80 *260*	90 *295*	— —	— —	— —
S12	45 *150*	60 *195*	70 *230*	55 *180*	75 *245*	85 *280*	40 *130*	55 *180*	65 *215*	41 *135*	55 *180*	65 *215*	— —	— —	— —
S13	26 *85*	35 *115*	40 *130*	32 *105*	42 *140*	49 *160*	24 *80*	31 *100*	36 *120*	24 *80*	32 *105*	37 *120*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	36 *120*	48 *155*	55 *180*	36 *120*	47 *155*	55 *180*	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	39 *130*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	46 *150*	60 *195*	75 *245*	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	70 *230*	95 *310*	110 *360*	— —	— —	— —	— —	— —	— —

Turbo 18 – R217.69-18 – Metric





- For insert selection and cutting data recommendations, see page(s) 69-71
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.69-3032.0-18-2AN	02691799	Cylindrical	32,0	2	17,0	10,0	30,0	170,0	210,0	7,0	46,0	61,5	11100	1,1	XO.X18..
R217.69-3232.0-18-2AN	02691795	Cylindrical	32,0	2	17,0	10,0	32,0	170,0	210,0	7,0	46,0	61,5	11100	1,2	XO.X18..
R217.69-3232.0-18-3AN	02691796	Cylindrical	32,0	3	17,0	10,0	32,0	170,0	210,0	7,0	46,0	61,5	11100	1,2	XO.X18..
R217.69-3240.0-18-3AN	02691797	Cylindrical	40,0	3	17,0	10,0	32,0	165,0	210,0	4,5	62,0	77,5	9900	1,2	XO.X18..
R217.69-3240.0-18-4AN	02691798	Cylindrical	40,0	4	17,0	10,0	32,0	165,0	210,0	4,5	62,0	77,5	9900	1,2	XO.X18..
R217.69-3232.3-18-2AN	02691792	Weldon	32,0	2	17,0	10,0	32,0	70,0	110,0	7,0	46,0	61,5	11100	0,6	XO.X18..
R217.69-3232.3-18-3AN	02691793	Weldon	32,0	3	17,0	10,0	32,0	70,0	110,0	7,0	46,0	61,5	11100	0,6	XO.X18..
R217.69-2532.3S-18-2AN	02691790	Seco-Weldon	32,0	2	17,0	10,0	25,0	55,5	109,5	7,0	46,0	61,5	11100	0,5	XO.X18..
R217.69-3240.3S-18-3AN	02691791	Seco-Weldon	40,0	3	17,0	10,0	32,0	59,5	119,5	4,5	62,0	77,5	9900	0,8	XO.X18..

Modification of the cutter body needed for radii > 4,0 mm

Spare Parts

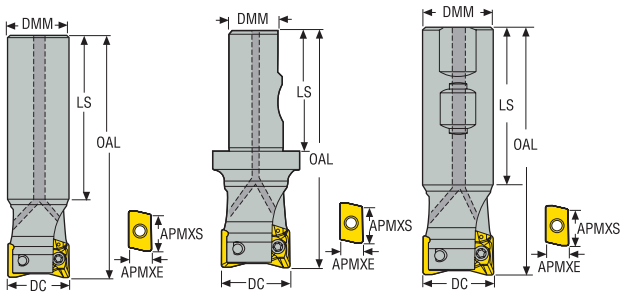
For cutter	Insert screw
R217.69-..	C04510-T20P

Accessories

Torque key	Torque value
T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 18 – R217.69-18 – Inch



- For insert selection and cutting data recommendations, see page(s) 69-71
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.69-01.00-0-18-2LAN	02699117	Cylindrical	1.000	2	0.669	0.394	1.000	5.118	6.693	5.0	1.280	1.890	13800	1.540	XO.X18
R217.69-01.25-0-18-2LAN	02694932	Cylindrical	1.250	2	0.669	0.394	1.000	6.102	7.677	2.0	1.791	2.402	11100	1.980	XO.X18
R217.69-01.25-0-18-3LAN	02694936	Cylindrical	1.250	3	0.669	0.394	1.000	6.102	7.677	7.0	1.791	2.402	11100	1.980	XO.X18
R217.69-01.50-0-18-3LAN	02694937	Cylindrical	1.500	3	0.669	0.394	1.250	6.496	8.268	4.5	2.283	2.894	9900	3.090	XO.X18
R217.69-01.50-0-18-4LAN	02694938	Cylindrical	1.500	4	0.669	0.394	1.250	6.496	8.268	4.5	2.283	2.894	9900	2.870	XO.X18
R217.69-02.00-0-18-5LAN	02694941	Cylindrical	2.000	5	0.669	0.394	1.500	6.890	8.661	3.0	3.287	3.898	8900	4.630	XO.X18
R217.69-01.00-3-18-2AN	02699130	Weldon	1.000	2	0.669	0.394	1.000	2.362	3.937	6.0	1.280	1.890	13800	1.100	XO.X18
R217.69-01.25-3-18-2AN	02694943	Weldon	1.250	2	0.669	0.394	1.250	2.756	4.331	7.0	1.791	2.402	11100	1.100	XO.X18
R217.69-01.25-3-18-3AN	02694949	Weldon	1.250	3	0.669	0.394	1.250	2.760	4.331	7.0	1.791	2.402	11100	1.320	XO.X18
R217.69-01.50-3-18-3AN	02694951	Weldon	1.500	3	0.669	0.394	1.250	3.150	4.724	4.5	2.283	2.894	9900	1.540	XO.X18
R217.69-01.50-3-18-4AN	02694954	Weldon	1.500	4	0.669	0.394	1.250	3.150	4.724	4.5	2.283	2.894	9900	1.540	XO.X18
R217.69-01.50-3S-18-3AN	02694972	Seco-Weldon	1.500	3	0.669	0.394	1.250	2.441	4.803	4.5	2.283	2.894	9900	1.980	XO.X18

Modification of the cutter body needed for radii > 0.158 in

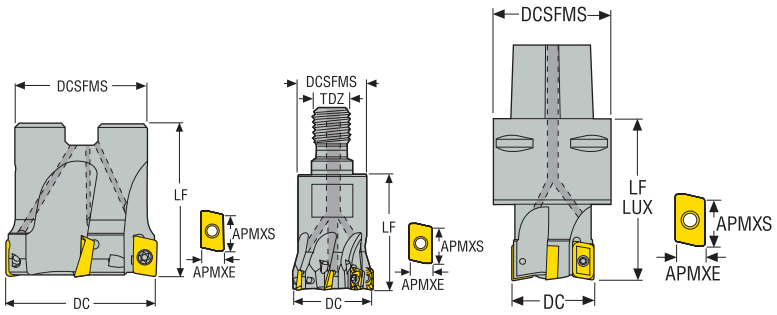
Spare Parts

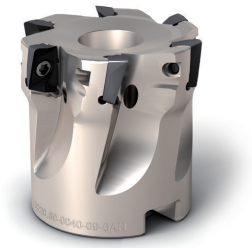
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..	C04510-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 18 – R217/220.69-18 – Metric





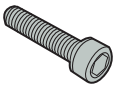
- For insert selection and cutting data recommendations, see page(s) 69-71
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm		mm	mm	kg		
R217.69-1632.RE-18-2AN	02691807	Combimaster	32,0	2	17,0	10,0	–	M16	30,0	45,0	7,0	46,0	61,5	0,2	11100	XO.X18..
R217.69-1632.RE-18-3AN	02691805	Combimaster	32,0	3	17,0	10,0	–	M16	30,0	45,0	7,0	46,0	61,5	0,2	11100	XO.X18..
R217.69-1640.RE-18-3AN	02691808	Combimaster	40,0	3	17,0	10,0	–	M16	30,0	45,0	4,5	62,0	77,5	0,3	9900	XO.X18..
R217.69-1640.RE-18-4AN	02691806	Combimaster	40,0	4	17,0	10,0	–	M16	30,0	45,0	4,5	62,0	77,5	0,3	9900	XO.X18..
R217.69-2040.RE-18-3AN	02972711	Combimaster	40,0	3	17,0	10,0	–	M20	36,5	45,0	4,5	62,0	77,5	0,4	9900	XO.X18..
R217.69-2040.RE-18-4AN	02753402	Combimaster	40,0	4	17,0	10,0	–	M20	36,5	45,0	4,5	62,0	77,5	0,4	9900	XO.X18..
C6-R217.69-040-18-3AN	02707507	Seco-Capto	40,0	3	17,0	10,0	–	–	63,0	80,0	4,5	62,0	77,5	1,1	9900	XO.X18..
C6-R217.69-066-18-5AN	02707509	Seco-Capto	66,0	5	17,0	10,0	–	–	63,0	60,0	2,0	114,0	129,5	1,4	7700	XO.X18..
C6-R217.69-080-18-6AN	02707511	Seco-Capto	80,0	6	17,0	10,0	–	–	63,0	60,0	1,5	142,0	157,5	1,7	7000	XO.X18..
R220.69-0040-18-4AN	03004031	Arbor	40,0	4	17,0	10,0	16,0	–	35,0	40,0	4,5	62,0	77,5	0,2	9900	XO.X18..
R220.69-0050-18-4AN	02701130	Arbor	50,0	4	17,0	10,0	22,0	–	47,0	40,0	3,0	82,0	97,5	0,3	8900	XO.X18..
R220.69-0050-18-5AN	02691824	Arbor	50,0	5	17,0	10,0	22,0	–	47,0	40,0	3,0	82,0	97,5	0,3	8900	XO.X18..
R220.69-0052-18-4AN	02969087	Arbor	52,0	4	17,0	10,0	22,0	–	47,0	40,0	3,15	86,0	101,5	0,5	8900	XO.X18..
R220.69-0063-18-4AN	02691810	Arbor	63,0	4	17,0	10,0	27,0	–	52,0	40,0	2,4	108,0	123,5	0,5	7900	XO.X18..
R220.69-0063-18-5AN	02691825	Arbor	63,0	5	17,0	10,0	27,0	–	52,0	40,0	2,4	108,0	123,5	0,5	7900	XO.X18..
R220.69-0063-18-6AN	02691826	Arbor	63,0	6	17,0	10,0	27,0	–	52,0	40,0	2,4	108,0	123,5	0,5	7900	XO.X18..
R220.69-0066-18-5AN	02969088	Arbor	66,0	5	17,0	10,0	27,0	–	52,0	40,0	2,0	114,0	129,5	0,6	7900	XO.X18..
R220.69-0080-18-5AN	02691811	Arbor	80,0	5	17,0	10,0	27,0	–	62,0	50,0	1,5	142,0	157,5	1,0	7000	XO.X18..
R220.69-0080-18-6AN	02691827	Arbor	80,0	6	17,0	10,0	27,0	–	62,0	50,0	1,5	142,0	157,5	1,0	7000	XO.X18..
R220.69-0080-18-8AN	02691828	Arbor	80,0	8	17,0	10,0	27,0	–	62,0	50,0	1,5	142,0	157,5	1,0	7000	XO.X18..
R220.69-0084-18-6AN	02440816	Arbor	84,0	6	17,0	10,0	27,0	–	62,0	50,0	1,5	150,0	165,5	1,3	7000	XO.X18..
R220.69-0100-18-6AN	02691817	Arbor	100,0	6	17,0	10,0	32,0	–	77,0	50,0	1,0	182,0	197,5	1,6	6300	XO.X18..
R220.69-0100-18-7AN	02691820	Arbor	100,0	7	17,0	10,0	32,0	–	77,0	50,0	1,0	182,0	197,5	1,6	6300	XO.X18..
R220.69-0100-18-9AN	02691822	Arbor	100,0	9	17,0	10,0	32,0	–	77,0	50,0	1,0	182,0	197,5	1,6	6300	XO.X18..
R220.69-0125-18-7AN	02691818	Arbor	125,0	7	17,0	10,0	40,0	–	90,0	63,0	1,0	232,0	247,5	3,1	5600	XO.X18..
R220.69-0125-18-8AN	02691823	Arbor	125,0	8	17,0	10,0	40,0	–	90,0	63,0	1,0	232,0	247,5	3,0	5600	XO.X18..
R220.69-0125-18-11AN	02691815	Arbor	125,0	11	17,0	10,0	40,0	–	90,0	63,0	1,0	232,0	247,5	3,0	5600	XO.X18..
R220.69-8160-18-7N	02691814	Arbor	160,0	7	17,0	10,0	40,0	–	90,0	63,0	0,5	302,0	317,5	4,5	5000	XO.X18..
R220.69-8160-18-9N	02691813	Arbor	160,0	9	17,0	10,0	40,0	–	90,0	63,0	0,5	302,0	317,5	4,6	5000	XO.X18..
R220.69-8160-18-12N	02691809	Arbor	160,0	12	17,0	10,0	40,0	–	90,0	63,0	0,5	302,0	317,5	4,6	5000	XO.X18..

Modification of the cutter body needed for radii > 4,0 mm
For Combimaster Shanks, see Machining Navigator Tooling System

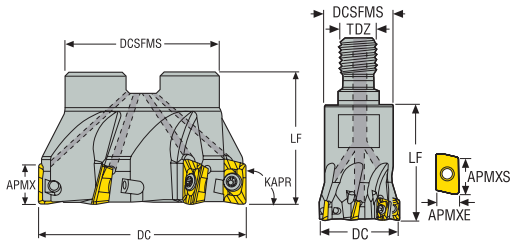
Spare Parts

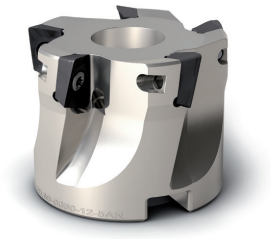
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
Cx/R217.69-..	–	C04510-T20P	T00-20P50	5.0NM
R220.69-0040	TCEI0825	C04510-T20P	T00-20P50	5.0NM
R220.69-0050-0052	220.17-692	C04510-T20P	T00-20P50	5.0NM
R220.69-0063-0066	220.17-693	C04510-T20P	T00-20P50	5.0NM
R220.69-0080-8160	–	C04510-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 18 – R217/220.69-18 – Inch





- For insert selection and cutting data recommendations, see page(s) 69-71
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch		Inch	Inch	lbs		
R217.69-01.00-12RE-18-2AN	02699134	Combimaster	1.000	2	0.669	0.394	–	M12	0.906	1.575	6.0	1.280	1.890	0.660	13800	XO.X18
R217.69-01.25-16RE-18-3AN	02699137	Combimaster	1.250	3	0.669	0.394	–	M16	1.181	1.772	7.0	1.791	2.402	0.660	11100	XO.X18
R217.69-01.50-16RE-18-3AN	02699141	Combimaster	1.500	3	0.669	0.394	–	M16	1.181	1.772	4.5	2.283	2.894	0.880	9900	XO.X18
R217.69-01.50-16RE-18-4AN	02699143	Combimaster	1.500	4	0.669	0.394	–	M16	1.181	1.772	4.5	2.283	2.894	0.880	9900	XO.X18
R220.69-02.00-18-3AN	02694974	Arbor	2.000	3	0.669	0.394	0.750	–	1.850	1.575	3.0	3.287	3.898	0.880	8900	XO.X18
R220.69-02.00-18-4AN	02694975	Arbor	2.000	4	0.669	0.394	0.750	–	1.850	1.575	3.0	3.287	3.898	0.880	8900	XO.X18
R220.69-02.00-18-5AN	02694976	Arbor	2.000	5	0.669	0.394	0.750	–	1.850	1.575	3.0	3.287	3.898	0.660	8900	XO.X18
R220.69-02.50-18-5AN	02694979	Arbor	2.500	5	0.669	0.394	0.750	–	1.850	1.575	2.0	4.291	4.902	1.100	7900	XO.X18
R220.69-02.50-18-6AN	02694981	Arbor	2.500	6	0.669	0.394	0.750	–	1.850	1.575	2.0	4.291	4.902	1.100	7900	XO.X18
R220.69-03.00-18-4AN	02694984	Arbor	3.000	4	0.669	0.394	1.000	–	2.441	1.969	1.5	5.276	5.886	2.200	7000	XO.X18
R220.69-03.00-18-6AN	02694985	Arbor	3.000	6	0.669	0.394	1.000	–	2.441	1.969	1.5	5.276	5.886	2.200	7000	XO.X18
R220.69-03.00-18-8AN	02694987	Arbor	3.000	8	0.669	0.394	1.000	–	2.441	1.969	1.5	5.276	5.886	1.980	7000	XO.X18
R220.69-04.00-18-5AN	02694990	Arbor	4.000	5	0.669	0.394	1.500	–	3.543	1.969	1.0	7.283	7.894	4.410	6300	XO.X18
R220.69-04.00-18-7AN	02694992	Arbor	4.000	7	0.669	0.394	1.500	–	3.543	1.969	1.0	7.283	7.894	4.410	6300	XO.X18
R220.69-04.00-18-9AN	02694993	Arbor	4.000	9	0.669	0.394	1.500	–	3.543	1.969	1.0	7.283	7.894	4.190	6300	XO.X18
R220.69-05.00-18-8AN	02694995	Arbor	5.000	8	0.669	0.394	1.500	–	3.543	2.480	1.0	9.291	9.902	7.720	5600	XO.X18
R220.69-05.00-18-11AN	02694994	Arbor	5.000	11	0.669	0.394	1.500	–	3.543	2.480	1.0	9.291	9.902	7.720	5600	XO.X18
R220.69-06.00-18-9N	02694997	Arbor	6.000	9	0.669	0.394	2.000	–	3.543	2.480	0.5	11.280	11.890	9.480	5000	XO.X18
R220.69-06.00-18-12N	02694996	Arbor	6.000	12	0.669	0.394	2.000	–	3.543	2.480	0.5	11.280	11.890	9.260	5000	XO.X18

Modification of the cutter body needed for radii > 0.158 in
For Combimaster Shanks, see Machining Navigator Tooling System

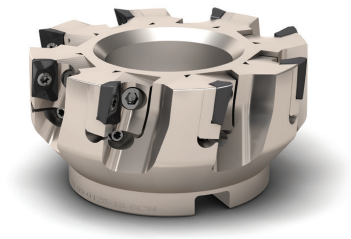
Spare Parts

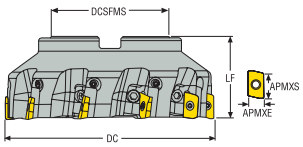
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.69-..	–	C04510-T20P	T00-20P50	44.3IN.LBS
R220.69-02.00-02.50	220.17-695	C04510-T20P	T00-20P50	44.3IN.LBS
R220.69-03.00	UC6S1/2UNFX1-1/4	C04510-T20P	T00-20P50	44.3IN.LBS
R220.69-04.00	UF6S3/4UNFX2	C04510-T20P	T00-20P50	44.3IN.LBS
R220.69-05.00	UC6S3/4UNFX1-1/4	C04510-T20P	T00-20P50	44.3IN.LBS
R220.69-06.00	–	C04510-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Turbo 18 – R220.69-18 – Metric





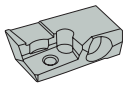
- For insert selection and cutting data recommendations, see page(s) 69-71
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm	mm	mm		mm	mm	kg		
R220.69-0125-18-8CN	02706947	Arbor	125,0	8	17,0	10,0	40,0	90,0	63,0	1,0	232,0	247,5	3,3	5600	XO.X18..
R220.69-8160-18-10CN	02706948	Arbor	160,0	10	17,0	10,0	40,0	90,0	63,0	0,7	302,0	317,5	5,2	5000	XO.X18..
R220.69-8200-18-12CN	02706950	Arbor	200,0	12	17,0	10,0	60,0	130,0	63,0	0,5	382,0	397,5	7,4	4400	XO.X18..
R220.69-8250-18-16CN	02706951	Arbor	250,0	16	17,0	10,0	60,0	130,0	63,0	0,4	482,0	497,5	14,7	3900	XO.X18..

Modification of the cutter body needed for radii > 4,0 mm

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Setting gauge	Allen key	Torque key	Torque value
							
R220.69-0125-8250	XO18PRN	FS96018	C04510-T20P	AU1114T-T15P	H05-4	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-18 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	XOMX180608TR-ME13 F40M	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P2	XOMX180608TR-ME13 F40M	8,0 *0.32*	0,19 *0.0075*	0,20 *0.0080*	0,32 *0.013*
P3	XOMX180608TR-M14 MP2501	8,0 *0.32*	0,19 *0.0075*	0,20 *0.0080*	0,32 *0.013*
P4	XOMX180608TR-M14 MP2501	8,0 *0.32*	0,19 *0.0075*	0,20 *0.0080*	0,32 *0.013*
P5	XOMX180608TR-M14 MP2501	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P6	XOMX180608TR-M14 MP2501	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P7	XOMX180608TR-M14 MP2501	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P8	XOMX180608TR-MD15 MP2501	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
P11	XOMX180608TR-M14 T350M	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P12	XOMX180608TR-MD15 MP2501	7,0 *0.28*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
M1	XOMX180608TR-M14 F40M	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
M2	XOMX180608TR-M14 F40M	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
M3	XOMX180608TR-M14 F40M	7,0 *0.28*	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
M4	XOMX180608R-M10 T350M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M5	XOMX180608R-M10 T350M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
K1	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
K2	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K3	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K4	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K5	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
K6	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K7	XOMX180608TR-M14 MK2050	8,0 *0.32*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
N1	XOEX180608FR-E10 H25	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
N2	XOEX180608FR-E10 H25	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
N3	XOEX180608FR-E10 H25	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
N11	XOEX180608FR-E10 H25	8,0 *0.32*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
S1	XOMX180608R-M10 T350M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S2	XOMX180608R-M10 T350M	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S3	XOMX180608R-M10 T350M	5,0 *0.20*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S11	XOMX180608R-M10 MS2050	6,0 *0.24*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
S12	XOMX180608R-M10 MS2050	6,0 *0.24*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
S13	XOMX180608R-M10 MS2050	5,0 *0.20*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
H5	XOMX180608TR-MD15 MP3000	7,0 *0.28*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
H8	XOMX180608TR-MD15 MP3000	6,0 *0.24*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
H11	XOMX180608TR-MD15 MP1501	7,0 *0.28*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
H12	XOMX180608TR-MD15 MP1501	6,0 *0.24*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.69-18 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	290 *950*	385 *1275*	460 *1500*	255 *840*	340 *1125*	410 *1350*	245 *800*	325 *1075*	385 *1275*	175 *570*	230 *750*	275 *900*	— —	— —	— —
P2	280 *920*	375 *1225*	440 *1450*	250 *820*	330 *1075*	390 *1275*	240 *790*	315 *1025*	375 *1225*	165 *540*	225 *740*	260 *850*	— —	— —	— —
P3	245 *800*	330 *1075*	385 *1275*	220 *720*	295 *970*	340 *1125*	210 *690*	280 *920*	325 *1075*	145 *475*	195 *640*	230 *750*	— —	— —	— —
P4	215 *710*	290 *950*	340 *1125*	190 *620*	260 *850*	300 *980*	185 *610*	245 *800*	290 *950*	130 *425*	170 *560*	205 *670*	— —	— —	— —
P5	210 *690*	280 *920*	330 *1075*	185 *610*	245 *800*	295 *970*	180 *590*	235 *770*	280 *920*	125 *410*	165 *540*	195 *640*	— —	— —	— —
P6	235 *770*	315 *1025*	370 *1225*	210 *690*	275 *900*	330 *1075*	200 *660*	265 *870*	315 *1025*	140 *460*	185 *610*	220 *720*	— —	— —	— —
P7	225 *740*	295 *970*	350 *1150*	200 *660*	260 *850*	310 *1025*	190 *620*	250 *820*	295 *970*	130 *425*	175 *570*	210 *690*	— —	— —	— —
P8	205 *670*	280 *920*	325 *1075*	185 *610*	245 *800*	290 *950*	175 *570*	235 *770*	275 *900*	120 *395*	165 *540*	190 *620*	— —	— —	— —
P11	215 *710*	285 *940*	340 *1125*	190 *620*	255 *840*	300 *980*	185 *610*	245 *800*	290 *950*	130 *425*	170 *560*	200 *660*	— —	— —	— —
P12	145 *475*	190 *620*	225 *740*	130 *425*	165 *540*	200 *660*	120 *395*	160 *520*	190 *620*	85 *280*	110 *360*	135 *445*	— —	— —	— —
M1	— —	— —	— —	180 *590*	240 *790*	280 *920*	180 *590*	235 *770*	280 *920*	145 *475*	190 *620*	225 *740*	— —	— —	— —
M2	— —	— —	— —	150 *490*	200 *660*	235 *770*	150 *490*	195 *640*	235 *770*	120 *395*	155 *510*	190 *620*	— —	— —	— —
M3	— —	— —	— —	120 *395*	160 *520*	190 *620*	120 *395*	160 *520*	190 *620*	95 *310*	130 *425*	155 *510*	— —	— —	— —
M4	— —	— —	— —	95 *310*	125 *410*	145 *475*	95 *310*	125 *410*	145 *475*	75 *245*	100 *330*	120 *395*	— —	— —	— —
M5	— —	— —	— —	80 *260*	105 *345*	125 *410*	80 *260*	105 *345*	120 *395*	65 *215*	85 *280*	100 *330*	— —	— —	— —
K1	225 *740*	295 *970*	350 *1150*	200 *660*	260 *850*	310 *1025*	190 *620*	250 *820*	295 *970*	— —	— —	— —	280 *920*	370 *1225*	440 *1450*
K2	200 *660*	265 *870*	315 *1025*	175 *570*	235 *770*	280 *920*	170 *560*	225 *740*	265 *870*	— —	— —	— —	250 *820*	330 *1075*	395 *1300*
K3	170 *560*	225 *740*	265 *870*	150 *490*	200 *660*	235 *770*	145 *475*	190 *620*	225 *740*	— —	— —	— —	215 *710*	280 *920*	335 *1100*
K4	160 *520*	215 *710*	255 *840*	145 *475*	190 *620*	225 *740*	135 *445*	180 *590*	215 *710*	— —	— —	— —	205 *670*	270 *890*	320 *1050*
K5	100 *330*	130 *425*	155 *510*	90 *295*	115 *375*	135 *445*	85 *280*	110 *360*	130 *425*	— —	— —	— —	125 *410*	165 *540*	195 *640*
K6	140 *460*	190 *620*	225 *740*	125 *410*	165 *540*	200 *660*	120 *395*	160 *520*	190 *620*	— —	— —	— —	180 *590*	235 *770*	280 *920*
K7	130 *425*	170 *560*	195 *640*	115 *375*	150 *490*	175 *570*	105 *345*	140 *460*	165 *540*	— —	— —	— —	160 *520*	210 *690*	250 *820*
N1	— —	— —	— —	— —	— —	— —	1375 *4500*	1825 *6000*	2175 *7125*	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	560 *1825*	740 *2425*	880 *2875*	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	370 *1225*	495 *1625*	590 *1925*	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	425 *1400*	570 *1875*	670 *2200*	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	47 *155*	60 *195*	70 *230*	45 *150*	60 *195*	70 *230*	23 *75*	31 *100*	36 *120*	— —	— —	— —
S2	— —	— —	— —	38 *125*	50 *165*	60 *195*	36 *120*	48 *155*	55 *180*	19 *60*	25 *80*	29 *95*	— —	— —	— —
S3	— —	— —	— —	33 *110*	44 *145*	50 *165*	32 *105*	42 *140*	48 *155*	17 *55*	22 *70*	26 *85*	— —	— —	— —
S11	— —	— —	— —	65 *215*	85 *280*	100 *330*	60 *195*	80 *260*	95 *310*	32 *105*	43 *140*	50 *165*	— —	— —	— —
S12	— —	— —	— —	45 *150*	60 *195*	70 *230*	43 *140*	55 *180*	65 *215*	30 *100*	39 *130*	47 *155*	— —	— —	— —
S13	— —	— —	— —	26 *85*	35 *115*	40 *130*	25 *80*	33 *110*	38 *125*	18 *60*	23 *75*	27 *90*	— —	— —	— —
H5	48 *155*	60 *195*	75 *245*	39 *130*	50 *165*	60 *195*	37 *120*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —
H8	50 *165*	70 *230*	80 *260*	41 *135*	55 *180*	65 *215*	41 *135*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —
H11	60 *195*	80 *260*	95 *310*	49 *160*	65 *215*	75 *245*	48 *155*	65 *215*	75 *245*	— —	— —	— —	— —	— —	— —
H12	90 *295*	125 *410*	140 *460*	80 *260*	110 *360*	125 *410*	80 *260*	105 *345*	120 *395*	— —	— —	— —	— —	— —	— —

R217/220.69-18 – Cutting data v_c = (m/min)/*(sf/min)*

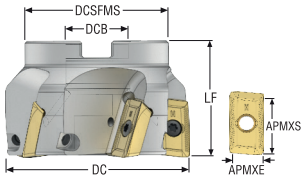
SMG	MK2050			MS2050			T350M			F40M			H25		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	255 *840*	335 *1100*	400 *1300*	245 *800*	330 *1075*	380 *1250*	225 *740*	295 *970*	355 *1175*	195 *640*	260 *850*	310 *1025*	— —	— —	— —
P2	245 *800*	325 *1075*	385 *1275*	240 *790*	315 *1025*	370 *1225*	220 *720*	290 *950*	340 *1125*	190 *620*	250 *820*	295 *970*	— —	— —	— —
P3	215 *710*	290 *950*	335 *1100*	205 *670*	275 *900*	330 *1075*	190 *620*	255 *840*	300 *980*	165 *540*	220 *720*	260 *850*	— —	— —	— —
P4	190 *620*	255 *840*	295 *970*	185 *610*	240 *790*	290 *950*	170 *560*	225 *740*	265 *870*	145 *475*	195 *640*	230 *750*	— —	— —	— —
P5	185 *610*	245 *800*	290 *950*	175 *570*	235 *770*	275 *900*	165 *540*	215 *710*	255 *840*	140 *460*	185 *610*	220 *720*	— —	— —	— —
P6	205 *670*	275 *900*	325 *1075*	200 *660*	265 *870*	310 *1025*	185 *610*	240 *790*	285 *940*	160 *520*	210 *690*	250 *820*	— —	— —	— —
P7	195 *640*	255 *840*	305 *1000*	190 *620*	250 *820*	290 *950*	170 *560*	230 *750*	270 *890*	150 *490*	200 *660*	235 *770*	— —	— —	— —
P8	180 *590*	245 *800*	285 *940*	175 *570*	230 *750*	275 *900*	160 *520*	215 *710*	250 *820*	140 *460*	185 *610*	220 *720*	— —	— —	— —
P11	190 *620*	250 *820*	295 *970*	180 *590*	240 *790*	285 *940*	170 *560*	220 *720*	265 *870*	145 *475*	190 *620*	230 *750*	— —	— —	— —
P12	125 *410*	165 *540*	195 *640*	120 *395*	160 *520*	185 *610*	110 *360*	145 *475*	175 *570*	95 *310*	125 *410*	150 *490*	— —	— —	— —
M1	— —	— —	— —	195 *640*	250 *820*	300 *980*	170 *560*	220 *720*	260 *850*	155 *510*	200 *660*	240 *790*	— —	— —	— —
M2	— —	— —	— —	160 *520*	210 *690*	250 *820*	140 *460*	185 *610*	220 *720*	125 *410*	170 *560*	200 *660*	— —	— —	— —
M3	— —	— —	— —	130 *425*	170 *560*	200 *660*	115 *375*	150 *490*	180 *590*	105 *345*	135 *445*	165 *540*	— —	— —	— —
M4	— —	— —	— —	100 *330*	135 *445*	155 *510*	90 *295*	120 *395*	135 *445*	80 *260*	110 *360*	125 *410*	— —	— —	— —
M5	— —	— —	— —	85 *280*	110 *360*	130 *425*	75 *245*	100 *330*	115 *375*	70 *230*	90 *295*	105 *345*	— —	— —	— —
K1	265 *870*	350 *1150*	415 *1350*	— —	— —	— —	170 *560*	230 *750*	270 *890*	— —	— —	— —	— —	— —	— —
K2	240 *790*	315 *1025*	375 *1225*	— —	— —	— —	155 *510*	205 *670*	245 *800*	— —	— —	— —	— —	— —	— —
K3	200 *660*	265 *870*	315 *1025*	— —	— —	— —	130 *425*	175 *570*	205 *670*	— —	— —	— —	— —	— —	— —
K4	190 *620*	255 *840*	300 *980*	— —	— —	— —	125 *410*	165 *540*	195 *640*	— —	— —	— —	— —	— —	— —
K5	120 *395*	155 *510*	185 *610*	— —	— —	— —	75 *245*	100 *330*	120 *395*	— —	— —	— —	— —	— —	— —
K6	170 *560*	225 *740*	265 *870*	— —	— —	— —	110 *360*	145 *475*	175 *570*	— —	— —	— —	— —	— —	— —
K7	150 *490*	200 *660*	235 *770*	— —	— —	— —	100 *330*	130 *425*	150 *490*	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	1075 *3525*	1450 *4750*	1725 *5650*	1275 *4175*	1675 *5500*	2000 *6550*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	440 *1450*	590 *1925*	700 *2300*	520 *1700*	680 *2225*	810 *2650*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	295 *970*	390 *1275*	465 *1525*	345 *1125*	455 *1500*	540 *1775*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	335 *1100*	450 *1475*	530 *1750*	395 *1300*	520 *1700*	620 *2025*
S1	— —	— —	— —	48 *155*	60 *195*	75 *245*	42 *140*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*	— —	— —	— —
S2	— —	— —	— —	38 *125*	50 *165*	60 *195*	34 *110*	45 *150*	50 *165*	31 *100*	40 *130*	47 *155*	— —	— —	— —
S3	— —	— —	— —	33 *110*	44 *145*	50 *165*	30 *100*	39 *130*	46 *150*	27 *90*	36 *120*	42 *140*	— —	— —	— —
S11	— —	— —	— —	65 *215*	85 *280*	100 *330*	60 *195*	75 *245*	90 *295*	50 *165*	70 *230*	80 *260*	— —	— —	— —
S12	— —	— —	— —	46 *150*	60 *195*	70 *230*	40 *130*	55 *180*	65 *215*	36 *120*	48 *155*	55 *180*	— —	— —	— —
S13	— —	— —	— —	27 *90*	35 *115*	41 *135*	23 *75*	31 *100*	36 *120*	21 *70*	28 *90*	33 *110*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	37 *120*	48 *155*	60 *195*	32 *105*	42 *140*	50 *165*	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	40 *130*	55 *180*	60 *195*	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	47 *155*	60 *195*	75 *245*	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	70 *230*	95 *310*	110 *360*	— —	— —	— —	— —	— —	— —

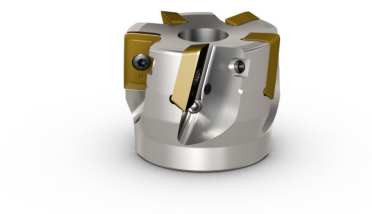
R220.90 ABEX

These multipurpose 90° square-shoulder milling cutters are for heavy roughing applications, delivering large depth-of-cut capability and high feed rates for consistent performance and excellent metal-removal rates.

- Cutter range 63-315 mm (2.5-12 inch)
- Max depth of cut 24 mm (0.94 inch)
- Recommended slotting depth of cut 13 mm (0.51 inch)
- Insert corner radii range 1.6 mm (0.063 inch)

R220.90-26 ABEX – Metric



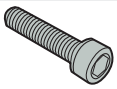


- For insert selection and cutting data recommendations, see page(s) 75-76
- For complete insert programme, see page(s) 734
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm	mm	mm		mm	mm	kg		
R220.90-0063-26-4AM	02789822	Arbor	63,0	4	20,0	10,0	27,0	55,0	50,0	1,5	107,6	123,5	0,7	6700	ABEX26..
R220.90-0063-26-5AM	02789823	Arbor	63,0	5	20,0	10,0	27,0	55,0	50,0	1,5	107,6	123,5	0,7	6700	ABEX26..
R220.90-0063-26-6AM	02789825	Arbor	63,0	6	20,0	10,0	27,0	55,0	50,0	1,5	107,6	123,5	1,9	6700	ABEX26..
R220.90-0080-26-5AM	02789826	Arbor	80,0	5	20,0	10,0	27,0	62,0	50,0	1,0	141,6	157,5	1,9	5900	ABEX26..
R220.90-0125-26-7AM	02789831	Arbor	125,0	7	20,0	10,0	40,0	90,0	63,0	0,5	231,6	247,5	1,9	4700	ABEX26..

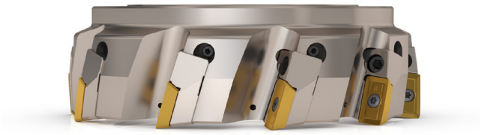
Spare Parts

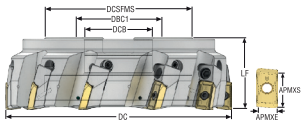
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.90-0063-0080	MC6S12X35	C05013-T20P	T00-20P50	5.0NM
R220.90-0100-0125	–	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.90 ABEX – Metric



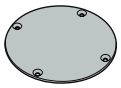
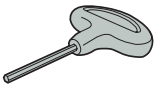


- For insert selection and cutting data recommendations, see page(s) 75-76
- For complete insert programme, see page(s) 734
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm		mm	mm	mm	mm	mm		mm	mm	kg		
R220.90-8160-26-8CAN	02830886	Arbor	160,0	8	20,0	10,0	40,0	90,0	63,0	0,4	296,5	316,8	5,3	4200	ABEX26..
R220.90-8200-26-10CAN	02830887	Arbor	200,0	10	20,0	10,0	60,0	130,0	63,0	0,35	376,5	396,8	7,5	3800	ABEX26..
R220.90-8250-26-12CAN	02830888	Arbor	250,0	12	20,0	10,0	60,0	130,0	63,0	0,3	476,5	496,8	13,4	3400	ABEX26..
R220.90-8315-26-14CAN	02830889	Arbor	315,0	14	20,0	10,0	60,0	225,0	80,0	0,3	606,5	626,8	28,1	3000	ABEX26..

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Cassette screw 2	Insert screw	Lid	Lid screw	Setting gauge	Allen key	Torque key	Torque value
										
R220.90-8160	AB26PRN	FS96018	C05018-T20P	C05013-T20P	SC-160-90	MF6S4X10	AU1114T-T15P	H05-4	T00-20P50	5.0NM
R220.90-8200	AB26PRN	FS96018	C05018-T20P	C05013-T20P	SC-200-90	MF6S4X10	AU1114T-T15P	H05-4	T00-20P50	5.0NM
R220.90-8250	AB26PRN	FS96018	C05018-T20P	C05013-T20P	SC-250-90	MF6S4X10	AU1114T-T15P	H05-4	T00-20P50	5.0NM
R220.90-8315	AB26PRN	FS96018	C05018-T20P	C05013-T20P	SC-315-90	MF6S4X10	AU1114T-T15P	H05-4	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.90-26 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	ABEX2606ZFFR-M15 F40M	10,0 *0.40*	0,22 *0.0085*	0,24 *0.0095*	0,36 *0.014*
P2	ABEX2606ZFFR-M15 F40M	10,0 *0.40*	0,22 *0.0085*	0,24 *0.0095*	0,36 *0.014*
P3	ABEX2606ZFFR-M15 MP2501	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
P4	ABEX2606ZFFR-M15 MP2501	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
P5	ABEX2606ZFFR-M15 MP2501	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
P6	ABEX2606ZFFR-M15 MP2501	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
P7	ABEX2606ZFFR-M15 MP2501	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
P8	ABEX2606ZFFR-M15 MP2501	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
P11	ABEX2606ZFFR-M15 T350M	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
P12	ABEX2606ZFFR-M15 MP2501	8,0 *0.32*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
M1	ABEX2606ZFFR-M15 F40M	10,0 *0.40*	0,22 *0.0085*	0,24 *0.0095*	0,36 *0.014*
M2	ABEX2606ZFFR-M15 F40M	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
M3	ABEX2606ZFFR-M15 F40M	8,0 *0.32*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
M4	ABEX2606ZFFR-M15 T350M	6,0 *0.24*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
M5	ABEX2606ZFFR-M15 T350M	6,0 *0.24*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
K1	ABEX2606ZFFR-M15 MK1500	10,0 *0.40*	0,22 *0.0085*	0,24 *0.0095*	0,36 *0.014*
K2	ABEX2606ZFFR-M15 MK1500	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
K3	ABEX2606ZFFR-M15 MK1500	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
K4	ABEX2606ZFFR-M15 MK1500	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
K5	ABEX2606ZFFR-M15 T350M	10,0 *0.40*	0,18 *0.0070*	0,19 *0.0075*	0,30 *0.012*
K6	ABEX2606ZFFR-M15 T350M	10,0 *0.40*	0,20 *0.0080*	0,22 *0.0085*	0,32 *0.013*
K7	ABEX2606ZFFR-M15 T350M	10,0 *0.40*	0,18 *0.0070*	0,19 *0.0075*	0,30 *0.012*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.90-26 – Cutting data v_c = (m/min)/*(sf/min)*

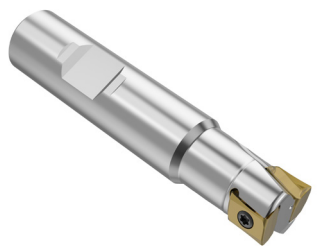
SMG	MP1501			MP2501			MK1500			T350M			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	280 *920*	370 *1225*	440 *1450*	245 *800*	330 *1075*	390 *1275*	— —	— —	— —	215 *710*	285 *940*	340 *1125*	185 *610*	250 *820*	295 *970*
P2	270 *890*	360 *1175*	430 *1400*	240 *790*	320 *1050*	380 *1250*	— —	— —	— —	210 *690*	280 *920*	330 *1075*	180 *590*	240 *790*	285 *940*
P3	240 *790*	320 *1050*	375 *1225*	215 *710*	285 *940*	330 *1075*	— —	— —	— —	185 *610*	245 *800*	290 *950*	160 *520*	215 *710*	250 *820*
P4	210 *690*	280 *920*	330 *1075*	190 *620*	250 *820*	290 *950*	— —	— —	— —	165 *540*	215 *710*	255 *840*	145 *475*	190 *620*	220 *720*
P5	205 *670*	270 *890*	320 *1050*	180 *590*	240 *790*	285 *940*	— —	— —	— —	155 *510*	205 *670*	250 *820*	135 *445*	180 *590*	215 *710*
P6	230 *750*	300 *980*	360 *1175*	200 *660*	265 *870*	320 *1050*	— —	— —	— —	175 *570*	230 *750*	280 *920*	155 *510*	200 *660*	240 *790*
P7	215 *710*	285 *940*	340 *1125*	190 *620*	250 *820*	300 *980*	— —	— —	— —	165 *540*	220 *720*	260 *850*	145 *475*	190 *620*	230 *750*
P8	205 *670*	270 *890*	315 *1025*	180 *590*	240 *790*	280 *920*	— —	— —	— —	155 *510*	205 *670*	245 *800*	135 *445*	180 *590*	210 *690*
P11	210 *690*	275 *900*	330 *1075*	185 *610*	245 *800*	295 *970*	— —	— —	— —	160 *520*	215 *710*	255 *840*	140 *460*	185 *610*	220 *720*
P12	140 *460*	185 *610*	215 *710*	125 *410*	165 *540*	190 *620*	— —	— —	— —	105 *345*	140 *460*	165 *540*	95 *310*	125 *410*	145 *475*
M1	— —	— —	— —	175 *570*	230 *750*	275 *900*	— —	— —	— —	160 *520*	215 *710*	255 *840*	145 *475*	195 *640*	230 *750*
M2	— —	— —	— —	145 *475*	190 *620*	230 *750*	— —	— —	— —	135 *445*	180 *590*	215 *710*	120 *395*	160 *520*	195 *640*
M3	— —	— —	— —	120 *395*	160 *520*	185 *610*	— —	— —	— —	110 *360*	150 *490*	175 *570*	100 *330*	135 *445*	155 *510*
M4	— —	— —	— —	95 *310*	125 *410*	145 *475*	— —	— —	— —	90 *295*	115 *375*	135 *445*	80 *260*	105 *345*	125 *410*
M5	— —	— —	— —	80 *260*	105 *345*	120 *395*	— —	— —	— —	75 *245*	95 *310*	115 *375*	65 *215*	90 *295*	105 *345*
K1	215 *710*	285 *940*	340 *1125*	190 *620*	255 *840*	300 *980*	270 *890*	360 *1175*	425 *1400*	165 *540*	220 *720*	260 *850*	145 *475*	190 *620*	225 *740*
K2	190 *620*	255 *840*	305 *1000*	170 *560*	225 *740*	270 *890*	240 *790*	320 *1050*	380 *1250*	150 *490*	195 *640*	235 *770*	130 *425*	170 *560*	205 *670*
K3	165 *540*	215 *710*	260 *850*	145 *475*	190 *620*	230 *750*	205 *670*	270 *890*	325 *1075*	125 *410*	165 *540*	200 *660*	110 *360*	145 *475*	175 *570*
K4	155 *510*	205 *670*	245 *800*	140 *460*	180 *590*	220 *720*	195 *640*	260 *850*	310 *1025*	120 *395*	160 *520*	190 *620*	105 *345*	140 *460*	165 *540*
K5	95 *310*	130 *425*	150 *490*	85 *280*	115 *375*	130 *425*	120 *395*	160 *520*	185 *610*	75 *245*	100 *330*	115 *375*	65 *215*	85 *280*	100 *330*
K6	135 *445*	180 *590*	215 *710*	120 *395*	160 *520*	190 *620*	170 *560*	225 *740*	270 *890*	105 *345*	140 *460*	165 *540*	90 *295*	120 *395*	145 *475*
K7	120 *395*	165 *540*	190 *620*	110 *360*	145 *475*	170 *560*	155 *510*	205 *670*	240 *790*	95 *310*	125 *410*	145 *475*	80 *260*	110 *360*	130 *425*

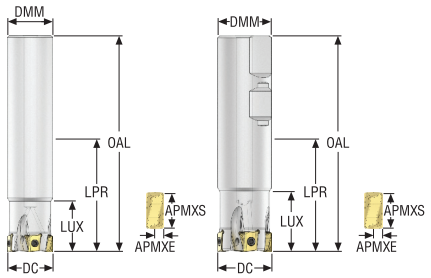
SQUARE T4

Made for roughing and semi-finishing operations, the Square T4 features four cutting edges and an innovative tangential cutter design that increases the surface area of contact between the insert and the cutter body resulting in good surface finish during slotting, contouring and plunging applications.

- Multi-edge inserts optimize cutting stability
- Available in two inserts size, 08 and 12
- Allow for clean 90-degree walls

Square T4 – R217.94-08 – Metric





- For insert selection and cutting data recommendations, see page(s) 82-84
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LUX	LPR	OAL	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm	mm		kg	
R217.94-1616.0-08-2A	02827519	Cylindrical	16,0	2	8,0	2,0	16,0	29,0	42,0	90,0	20600	0,2	LOEX08..
R217.94-1820.0-08-2A	02827520	Cylindrical	20,0	2	8,0	2,0	18,0	110,0	110,0	160,0	18400	0,3	LOEX08..
R217.94-2020.0-08-2A	02827522	Cylindrical	20,0	2	8,0	2,0	20,0	29,0	110,0	160,0	18400	0,4	LOEX08..
R217.94-2020.0-08-3A	02827523	Cylindrical	20,0	3	8,0	2,0	20,0	29,0	60,0	110,0	18400	0,3	LOEX08..
R217.94-2225.0-08-3A	02827524	Cylindrical	25,0	3	8,0	2,0	22,0	124,0	124,0	180,0	17600	0,5	LOEX08..
R217.94-2525.0-08-3A	02827525	Cylindrical	25,0	3	8,0	2,0	25,0	29,0	124,0	180,0	16500	0,7	LOEX08..
R217.94-2525.0-08-4A	02827526	Cylindrical	25,0	4	8,0	2,0	25,0	29,0	64,0	120,0	16500	0,4	LOEX08..
R217.94-3232.0-08-3A	02827528	Cylindrical	32,0	3	8,0	2,0	32,0	29,0	140,0	200,0	14600	1,2	LOEX08..
R217.94-3232.0-08-5A	02827529	Cylindrical	32,0	5	8,0	2,0	32,0	29,0	70,0	130,0	14600	0,8	LOEX08..
R217.94-1616.3-08-2A	02827530	Weldon	16,0	2	8,0	2,0	16,0	23,4	30,0	78,0	20600	0,1	LOEX08..
R217.94-2018.3-08-2A	02829812	Weldon	18,0	2	8,0	2,0	20,0	26,7	40,0	90,0	19400	0,2	LOEX08..
R217.94-2020.3-08-2A	02827531	Weldon	20,0	2	8,0	2,0	20,0	28,8	40,0	90,0	18400	0,2	LOEX08..
R217.94-2020.3-08-3A	02827533	Weldon	20,0	3	8,0	2,0	20,0	28,9	40,0	90,0	18400	0,2	LOEX08..
R217.94-2522.3-08-3A	02829813	Weldon	22,0	3	8,0	2,0	25,0	26,5	45,0	101,0	17600	0,3	LOEX08..
R217.94-2525.3-08-3A	02827534	Weldon	25,0	3	8,0	2,0	25,0	28,9	45,0	101,0	16500	0,4	LOEX08..
R217.94-2525.3-08-4A	02827535	Weldon	25,0	4	8,0	2,0	25,0	28,9	45,0	101,0	16500	0,4	LOEX08..
R217.94-3232.3-08-5A	02827537	Weldon	32,0	5	8,0	2,0	32,0	28,2	45,0	105,0	14600	0,6	LOEX08..

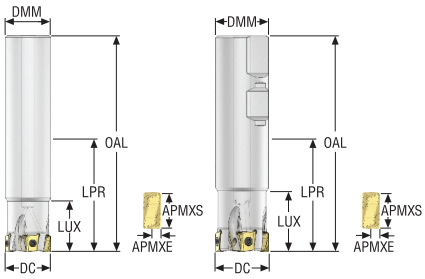
Spare Parts

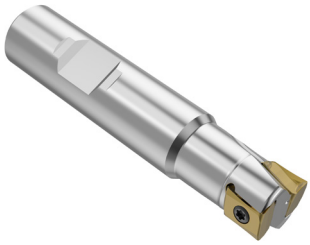
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.94-.. Ø16-18	C02707B-T08P	T00-08P12	1.2NM
R217.94-.. Ø20-32	C02708B-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square T4 – R217.94-08 – Inch





- For insert selection and cutting data recommendations, see page(s) 82-84
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LUX	LPR	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch	Inch		lbs	
R217.94-00.62-0-08-2A	02887518	Cylindrical	0.625	2	0.315	0.079	0.625	1.122	3.630	5.520	20600	0.440	LOEX08..
R217.94-00.75-0-08-2A	02887520	Cylindrical	0.750	2	0.315	0.079	0.750	1.138	4.031	6.000	18400	0.660	LOEX08..
R217.94-01.00-0-08-3A	02887523	Cylindrical	1.000	3	0.315	0.079	1.000	1.138	5.665	7.870	16500	1.540	LOEX08..
R217.94-00.75-3-08-3A	02887522	Weldon	0.750	3	0.315	0.079	0.750	1.138	1.531	3.500	18400	0.440	LOEX08..
R217.94-01.00-3-08-3A	02887524	Weldon	1.000	3	0.315	0.079	1.000	1.138	2.031	4.000	16500	0.880	LOEX08..
R217.94-01.00-3-08-4A	02887525	Weldon	1.000	4	0.315	0.079	1.000	1.138	2.031	4.000	16500	0.880	LOEX08..
R217.94-01.25-3-08-4A	02887527	Weldon	1.250	4	0.315	0.079	1.250	1.110	2.138	4.500	14600	1.540	LOEX08..

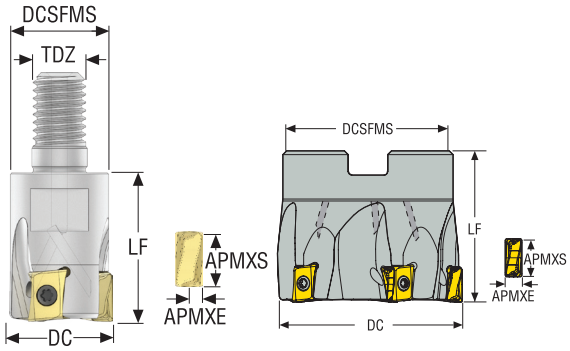
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.94-00.62-00.75	C02707B-T08P	T00-08P12	10.6IN.LBS
R217.94-01.00-01.25	C02708B-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square T4 – R217/220.94-08 – Metric



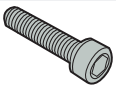
- For insert selection and cutting data recommendations, see page(s) 82-84
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm	kg		
R217.94-0816.RE-08-2A	02827538	Combimaster	16,0	2	8,0	2,0	–	M8	13,5	23,0	0,1	20600	LOEX08..
R217.94-1020.RE-08-2A	02827539	Combimaster	20,0	2	8,0	2,0	–	M10	18,5	28,0	0,1	18400	LOEX08..
R217.94-1020.RE-08-3A	02827540	Combimaster	20,0	3	8,0	2,0	–	M10	18,5	28,0	0,1	18400	LOEX08..
R217.94-1225.RE-08-3A	02827541	Combimaster	25,0	3	8,0	2,0	–	M12	23,0	30,0	0,1	16500	LOEX08..
R217.94-1225.RE-08-4A	02827542	Combimaster	25,0	4	8,0	2,0	–	M12	23,0	30,0	0,1	16500	LOEX08..
R217.94-1632.RE-08-3A	02827543	Combimaster	32,0	3	8,0	2,0	–	M16	30,0	35,0	0,2	14600	LOEX08..
R217.94-1632.RE-08-5A	02827544	Combimaster	32,0	5	8,0	2,0	–	M16	30,0	35,0	0,2	14600	LOEX08..
R217.94-2040.RE-08-6A	02972755	Combimaster	40,0	6	8,0	2,0	–	M20	36,5	40,0	0,4	13000	LOEX08..
R220.94-0032-08-3A	02845460	Arbor	32,0	3	8,0	2,0	16,0	–	29,3	35,0	0,2	13000	LOEX08..
R220.94-0032-08-5A	02845461	Arbor	32,0	5	8,0	2,0	16,0	–	29,3	35,0	0,2	13000	LOEX08..
R220.94-0040-08-4A	02827545	Arbor	40,0	4	8,0	2,0	16,0	–	35,0	40,0	0,3	13000	LOEX08..
R220.94-0040-08-6A	02827546	Arbor	40,0	6	8,0	2,0	16,0	–	35,0	40,0	0,3	13000	LOEX08..
R220.94-0050-08-5A	02827547	Arbor	50,0	5	8,0	2,0	22,0	–	45,0	40,0	0,4	11700	LOEX08..
R220.94-0050-08-7A	02827548	Arbor	50,0	7	8,0	2,0	22,0	–	45,0	40,0	0,4	11700	LOEX08..
R220.94-0063-08-6A	02827549	Arbor	63,0	6	8,0	2,0	27,0	–	56,0	40,0	0,6	10400	LOEX08..
R220.94-0063-08-9A	02827550	Arbor	63,0	9	8,0	2,0	27,0	–	56,0	40,0	0,6	10400	LOEX08..

For Combimaster Shanks, see Machining Navigator Tooling System

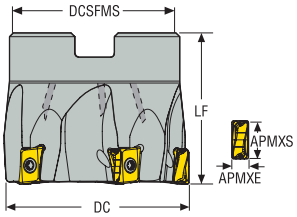
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.94-.. Ø16	–	C02707B-T08P	T00-08P12	1.2NM
R217.94-.. Ø20-40	–	C02708B-T08P	T00-08P12	1.2NM
R220.94-0032	TCEI0825	C02707B-T08P	T00-08P12	1.2NM
R220.94-0040	TCEI0825	C02708B-T08P	T00-08P12	1.2NM
R220.94-0050	220.17-692	C02708B-T08P	T00-08P12	1.2NM
R220.94-0063	MLC6S12X30	C02708B-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square T4 – R217/220.94-08 – Inch



- For insert selection and cutting data recommendations, see page(s) 82-84
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch	Inch	Inch	lbs		
R220.94-01.50-08-4A	02887529	Arbor	1.500	4	0.315	0.138	0.750	1.378	1.575	0.440	13000	LOEX08..
R220.94-02.00-08-5A	02887530	Arbor	2.000	5	0.315	0.138	0.750	1.772	1.575	0.880	11700	LOEX08..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.94-..	UC6S3/8UNFX1	C02708B-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.94-08 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	LOEX080408TR-M08 F40M	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P2	LOEX080408TR-M08 F40M	4,0 *0.16*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
P3	LOEX080408TR-M08 MP2501	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P4	LOEX080408TR-M08 MP2501	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P5	LOEX080408TR-M08 MP2501	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P6	LOEX080408TR-M08 MP2501	4,0 *0.16*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P7	LOEX080408TR-M08 MP2501	4,0 *0.16*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P8	LOEX080408TR-M08 MP2501	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P11	LOEX080408TR-M08 MP3000	4,0 *0.16*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P12	LOEX080408TR-M08 MP2501	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
M1	LOEX080408TR-M08 F40M	4,0 *0.16*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
M2	LOEX080408TR-M08 F40M	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M3	LOEX080408TR-M08 F40M	3,0 *0.12*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
M4	LOEX080404TR-M08 F40M	2,5 *0.10*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
M5	LOEX080404TR-M08 F40M	2,5 *0.10*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
K1	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
K2	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K3	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K4	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K5	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K6	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K7	LOEX080408TR-MD08 MK2050	4,0 *0.16*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
N1	LOEX080408TR-M08 F40M	4,0 *0.16*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N2	LOEX080408TR-M08 F40M	4,0 *0.16*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N3	LOEX080408TR-M08 F40M	4,0 *0.16*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N11	LOEX080408TR-M08 F40M	4,0 *0.16*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
S1	LOEX080408TR-M08 F40M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
S2	LOEX080408TR-M08 F40M	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
S3	LOEX080408TR-M08 F40M	2,5 *0.10*	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*
S11	LOEX080408TR-M08 MS2050	2,5 *0.10*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S12	LOEX080408TR-M08 MS2050	2,5 *0.10*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S13	LOEX080408TR-M08 MS2050	2,5 *0.10*	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
H5	LOEX080408TR-M08 MP3000	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H8	LOEX080408TR-M08 MP3000	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
H11	LOEX080408TR-M08 MP3000	3,0 *0.12*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H12	LOEX080408TR-M08 MP3000	2,5 *0.10*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

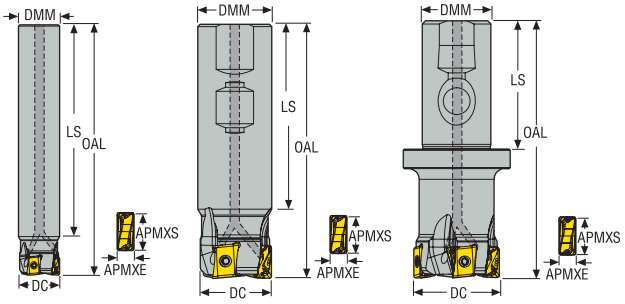
R217/220.94-08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	355 *1175*	470 *1550*	550 *1800*	295 *970*	390 *1275*	460 *1500*	315 *1025*	415 *1350*	485 *1600*	300 *980*	395 *1300*	460 *1500*	195 *640*	255 *840*	300 *980*	— —	— —	— —
P2	340 *1125*	445 *1450*	530 *1750*	290 *950*	380 *1250*	445 *1450*	300 *980*	395 *1300*	470 *1550*	285 *940*	375 *1225*	445 *1450*	185 *610*	245 *800*	290 *950*	— —	— —	— —
P3	300 *980*	395 *1300*	465 *1525*	255 *840*	330 *1075*	395 *1300*	265 *870*	350 *1150*	410 *1350*	250 *820*	330 *1075*	390 *1275*	160 *520*	215 *710*	255 *840*	— —	— —	— —
P4	260 *850*	345 *1125*	410 *1350*	225 *740*	295 *970*	345 *1125*	230 *750*	305 *1000*	360 *1175*	220 *720*	290 *950*	345 *1125*	145 *475*	190 *620*	225 *740*	— —	— —	— —
P5	250 *820*	330 *1075*	390 *1275*	215 *710*	280 *920*	330 *1075*	220 *720*	295 *970*	345 *1125*	210 *690*	275 *900*	330 *1075*	135 *445*	180 *590*	210 *690*	— —	— —	— —
P6	290 *950*	380 *1250*	445 *1450*	240 *790*	315 *1025*	370 *1225*	255 *840*	335 *1100*	395 *1300*	240 *790*	320 *1050*	375 *1225*	155 *510*	205 *670*	240 *790*	— —	— —	— —
P7	270 *890*	360 *1175*	420 *1375*	225 *740*	300 *980*	350 *1150*	240 *790*	315 *1025*	370 *1225*	230 *750*	300 *980*	350 *1150*	150 *490*	195 *640*	230 *750*	— —	— —	— —
P8	250 *820*	330 *1075*	390 *1275*	215 *710*	275 *900*	330 *1075*	220 *720*	295 *970*	345 *1125*	210 *690*	275 *900*	330 *1075*	135 *445*	180 *590*	210 *690*	— —	— —	— —
P11	265 *870*	350 *1150*	410 *1350*	220 *720*	290 *950*	340 *1125*	235 *770*	310 *1025*	360 *1175*	220 *720*	290 *950*	340 *1125*	145 *475*	190 *620*	220 *720*	— —	— —	— —
P12	170 *560*	220 *720*	260 *850*	145 *475*	190 *620*	225 *740*	150 *490*	195 *640*	230 *750*	140 *460*	185 *610*	220 *720*	90 *295*	120 *395*	140 *460*	— —	— —	— —
M1	— —	— —	— —	205 *670*	275 *900*	320 *1050*	215 *710*	285 *940*	340 *1125*	210 *690*	280 *920*	335 *1100*	160 *520*	210 *690*	250 *820*	— —	— —	— —
M2	— —	— —	— —	170 *560*	225 *740*	265 *870*	180 *590*	235 *770*	280 *920*	175 *570*	230 *750*	275 *900*	130 *425*	170 *560*	205 *670*	— —	— —	— —
M3	— —	— —	— —	140 *460*	185 *610*	215 *710*	145 *475*	190 *620*	225 *740*	145 *475*	190 *620*	220 *720*	105 *345*	140 *460*	165 *540*	— —	— —	— —
M4	— —	— —	— —	110 *360*	140 *460*	165 *540*	115 *375*	150 *490*	175 *570*	110 *360*	145 *475*	170 *560*	85 *280*	110 *360*	130 *425*	— —	— —	— —
M5	— —	— —	— —	90 *295*	120 *395*	135 *445*	95 *310*	125 *410*	145 *475*	95 *310*	120 *395*	145 *475*	70 *230*	90 *295*	105 *345*	— —	— —	— —
K1	270 *890*	355 *1175*	420 *1375*	230 *750*	300 *980*	355 *1175*	235 *770*	315 *1025*	375 *1225*	225 *740*	295 *970*	355 *1175*	— —	— —	— —	335 *1100*	445 *1450*	530 *1750*
K2	240 *790*	315 *1025*	370 *1225*	200 *660*	265 *870*	315 *1025*	210 *690*	280 *920*	330 *1075*	200 *660*	265 *870*	310 *1025*	— —	— —	— —	300 *980*	395 *1300*	465 *1525*
K3	200 *660*	265 *870*	315 *1025*	170 *560*	225 *740*	265 *870*	180 *590*	235 *770*	280 *920*	170 *560*	225 *740*	265 *870*	— —	— —	— —	250 *820*	335 *1100*	395 *1300*
K4	190 *620*	255 *840*	300 *980*	165 *540*	215 *710*	255 *840*	170 *560*	225 *740*	265 *870*	160 *520*	210 *690*	250 *820*	— —	— —	— —	240 *790*	320 *1050*	375 *1225*
K5	120 *395*	160 *520*	185 *610*	100 *330*	130 *425*	155 *510*	105 *345*	140 *460*	165 *540*	100 *330*	130 *425*	155 *510*	— —	— —	— —	150 *490*	200 *660*	230 *750*
K6	170 *560*	225 *740*	265 *870*	145 *475*	190 *620*	225 *740*	150 *490*	200 *660*	235 *770*	140 *460*	185 *610*	220 *720*	— —	— —	— —	210 *690*	280 *920*	330 *1075*
K7	150 *490*	200 *660*	235 *770*	125 *410*	170 *560*	200 *660*	135 *445*	180 *590*	210 *690*	125 *410*	170 *560*	195 *640*	— —	— —	— —	190 *620*	255 *840*	295 *970*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	55 *180*	70 *230*	80 *260*	55 *180*	70 *230*	85 *280*	50 *165*	70 *230*	80 *260*	25 *80*	33 *110*	39 *130*	— —	— —	— —
S2	— —	— —	— —	43 *140*	55 *180*	65 *215*	45 *150*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*	21 *70*	27 *90*	31 *100*	— —	— —	— —
S3	— —	— —	— —	37 *120*	49 *160*	55 *180*	39 *130*	50 *165*	60 *195*	37 *120*	49 *160*	55 *180*	18 *60*	24 *80*	28 *90*	— —	— —	— —
S11	— —	— —	— —	75 *245*	95 *310*	115 *375*	80 *260*	100 *330*	120 *395*	75 *245*	95 *310*	110 *360*	36 *120*	47 *155*	55 *180*	— —	— —	— —
S12	— —	— —	— —	50 *165*	65 *215*	80 *260*	55 *180*	70 *230*	80 *260*	50 *165*	65 *215*	80 *260*	33 *110*	43 *140*	50 *165*	— —	— —	— —
H5	55 *180*	75 *245*	85 *280*	43 *140*	55 *180*	65 *215*	45 *150*	60 *195*	70 *230*	44 *145*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —
H8	60 *195*	80 *260*	90 *295*	46 *150*	60 *195*	70 *230*	49 *160*	65 *215*	75 *245*	47 *155*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —
H11	70 *230*	95 *310*	110 *360*	55 *180*	70 *230*	85 *280*	55 *180*	75 *245*	90 *295*	55 *180*	75 *245*	85 *280*	— —	— —	— —	— —	— —	— —
H12	110 *360*	140 *460*	165 *540*	90 *295*	120 *395*	140 *460*	95 *310*	125 *410*	145 *475*	90 *295*	120 *395*	140 *460*	— —	— —	— —	— —	— —	— —

R217/220.94-08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MS2050			MS2500			T350M			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	310 *1025*	410 *1350*	475 *1550*	260 *850*	345 *1125*	405 *1325*	330 *1075*	435 *1425*	520 *1700*	275 *900*	360 *1175*	420 *1375*	240 *790*	315 *1025*	365 *1200*
P2	295 *970*	390 *1275*	465 *1525*	250 *820*	330 *1075*	395 *1300*	320 *1050*	425 *1400*	500 *1650*	260 *850*	345 *1125*	410 *1350*	225 *740*	300 *980*	355 *1175*
P3	260 *850*	345 *1125*	405 *1325*	220 *720*	290 *950*	345 *1125*	280 *920*	370 *1225*	430 *1400*	230 *750*	305 *1000*	360 *1175*	200 *660*	265 *870*	310 *1025*
P4	230 *750*	300 *980*	355 *1175*	195 *640*	255 *840*	300 *980*	250 *820*	325 *1075*	390 *1275*	200 *660*	265 *870*	315 *1025*	175 *570*	230 *750*	275 *900*
P5	220 *720*	290 *950*	340 *1125*	185 *610*	245 *800*	290 *950*	235 *770*	315 *1025*	370 *1225*	195 *640*	255 *840*	300 *980*	170 *560*	220 *720*	260 *850*
P6	250 *820*	330 *1075*	390 *1275*	215 *710*	280 *920*	330 *1075*	270 *890*	360 *1175*	420 *1375*	220 *720*	295 *970*	345 *1125*	195 *640*	255 *840*	300 *980*
P7	235 *770*	310 *1025*	365 *1200*	200 *660*	265 *870*	310 *1025*	255 *840*	340 *1125*	395 *1300*	210 *690*	275 *900*	325 *1075*	180 *590*	240 *790*	280 *920*
P8	220 *720*	290 *950*	340 *1125*	185 *610*	245 *800*	290 *950*	235 *770*	315 *1025*	365 *1200*	195 *640*	255 *840*	300 *980*	170 *560*	220 *720*	260 *850*
P11	230 *750*	305 *1000*	355 *1175*	195 *640*	255 *840*	300 *980*	250 *820*	330 *1075*	385 *1275*	205 *670*	270 *890*	315 *1025*	175 *570*	235 *770*	275 *900*
P12	145 *475*	195 *640*	230 *750*	125 *410*	165 *540*	190 *620*	160 *520*	210 *690*	245 *800*	130 *425*	170 *560*	200 *660*	115 *375*	150 *490*	175 *570*
M1	— —	— —	— —	200 *660*	265 *870*	315 *1025*	230 *750*	305 *1000*	360 *1175*	200 *660*	265 *870*	315 *1025*	185 *610*	240 *790*	290 *950*
M2	— —	— —	— —	165 *540*	220 *720*	260 *850*	190 *620*	250 *820*	300 *980*	165 *540*	220 *720*	260 *850*	150 *490*	200 *660*	235 *770*
M3	— —	— —	— —	135 *445*	180 *590*	210 *690*	155 *510*	205 *670*	240 *790*	135 *445*	180 *590*	210 *690*	125 *410*	160 *520*	190 *620*
M4	— —	— —	— —	105 *345*	140 *460*	165 *540*	120 *395*	160 *520*	185 *610*	105 *345*	140 *460*	165 *540*	95 *310*	125 *410*	150 *490*
M5	— —	— —	— —	90 *295*	115 *375*	135 *445*	100 *330*	130 *425*	155 *510*	90 *295*	115 *375*	135 *445*	80 *260*	105 *345*	125 *410*
K1	320 *1050*	420 *1375*	500 *1650*	— —	— —	— —	— —	— —	— —	205 *670*	275 *900*	325 *1075*	180 *590*	240 *790*	285 *940*
K2	280 *920*	370 *1225*	440 *1450*	— —	— —	— —	— —	— —	— —	185 *610*	240 *790*	285 *940*	160 *520*	210 *690*	250 *820*
K3	240 *790*	315 *1025*	375 *1225*	— —	— —	— —	— —	— —	— —	155 *510*	205 *670*	240 *790*	135 *445*	180 *590*	210 *690*
K4	230 *750*	300 *980*	355 *1175*	— —	— —	— —	— —	— —	— —	150 *490*	195 *640*	230 *750*	130 *425*	170 *560*	200 *660*
K5	140 *460*	185 *610*	220 *720*	— —	— —	— —	— —	— —	— —	90 *295*	120 *395*	140 *460*	80 *260*	105 *345*	125 *410*
K6	200 *660*	265 *870*	315 *1025*	— —	— —	— —	— —	— —	— —	130 *425*	170 *560*	205 *670*	115 *375*	150 *490*	175 *570*
K7	180 *590*	240 *790*	280 *920*	— —	— —	— —	— —	— —	— —	115 *375*	155 *510*	180 *590*	100 *330*	135 *445*	160 *520*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1325 *4350*	1775 *5825*	2075 *6800*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	540 *1775*	720 *2350*	840 *2750*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	360 *1175*	480 *1575*	560 *1825*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	410 *1350*	550 *1800*	640 *2100*
S1	— —	— —	— —	50 *165*	65 *215*	75 *245*	60 *195*	75 *245*	90 *295*	50 *165*	65 *215*	75 *245*	45 *150*	60 *195*	70 *230*
S2	— —	— —	— —	40 *130*	50 *165*	60 *195*	48 *155*	60 *195*	75 *245*	40 *130*	50 *165*	60 *195*	36 *120*	47 *155*	55 *180*
S3	— —	— —	— —	35 *115*	46 *150*	55 *180*	42 *140*	55 *180*	65 *215*	35 *115*	46 *150*	55 *180*	32 *105*	42 *140*	49 *160*
S11	— —	— —	— —	70 *230*	90 *295*	105 *345*	85 *280*	110 *360*	125 *410*	70 *230*	90 *295*	105 *345*	65 *215*	80 *260*	95 *310*
S12	— —	— —	— —	48 *155*	65 *215*	75 *245*	55 *180*	75 *245*	90 *295*	48 *155*	65 *215*	75 *245*	44 *145*	55 *180*	65 *215*
S13	— —	— —	— —	28 *90*	36 *120*	43 *140*	33 *110*	43 *140*	50 *165*	28 *90*	36 *120*	43 *140*	25 *80*	33 *110*	39 *130*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	43 *140*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	47 *155*	60 *195*	70 *230*	40 *130*	55 *180*	60 *195*
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	75 *245*	85 *280*	48 *155*	65 *215*	75 *245*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	85 *280*	110 *360*	125 *410*	75 *245*	95 *310*	110 *360*

Square T4 – R217.94-12 – Metric



- For insert selection and cutting data recommendations, see page(s) 89-91
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm	kg		
R217.94-2525.0-12-2A	02998333	Cylindrical	25,0	2	12,0	3,5	–	–	–	–	0,5	14000	LOEX12..
R217.94-3232.0-12-3A	02998334	Cylindrical	32,0	3	12,0	3,5	–	–	–	–	1,2	12400	LOEX12..
R217.94-3240.0-12-4A	02998335	Cylindrical	40,0	4	12,0	3,5	–	–	–	–	1,4	11100	LOEX12..
R217.94-2525.3-12-2A	02998328	Weldon	25,0	2	12,0	3,5	–	–	–	69,0	0,4	14000	LOEX12..
R217.94-3232.3-12-3A	02998329	Weldon	32,0	3	12,0	3,5	–	–	–	74,0	0,7	12400	LOEX12..
R217.94-2532.3S-12-3A	02998330	Seco-Weldon	32,0	3	12,0	3,5	–	–	–	–	0,7	12400	LOEX12..
R217.94-3240.3S-12-4A	02998331	Seco-Weldon	40,0	4	12,0	3,5	–	–	–	–	1,3	11100	LOEX12..

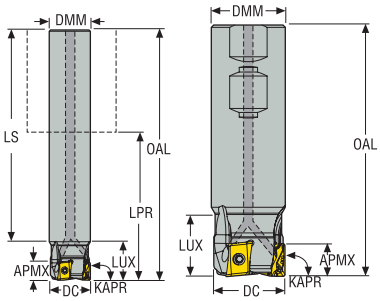
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.94-2525	C040105B-T15P	T00-15P35	3.5NM
R217.94-3232-3240	C04012B-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square T4 – R217.94-12 – Inch



- For insert selection and cutting data recommendations, see page(s) 89-91
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.94-01.00-0-12-2A	02998412	Cylindrical	1.000	2	0.472	0.138	–	–	–	–	1.540	13900	LOEX12
R217.94-01.25-0-12-3A	02998413	Cylindrical	1.250	3	0.472	0.138	–	–	–	–	2.650	12400	LOEX12
R217.94-01.50-0-12-4A	02998414	Cylindrical	1.500	4	0.472	0.138	–	–	–	–	3.970	11300	LOEX12
R217.94-01.00-3-12-2A	02998408	Weldon	1.000	2	0.472	0.138	–	–	–	2.740	0.880	14000	LOEX12
R217.94-01.25-3-12-3A	02998409	Weldon	1.250	3	0.472	0.138	–	–	–	3.108	1.540	12400	LOEX12
R217.94-01.50-3-12-4A	02998410	Weldon	1.500	4	0.472	0.138	–	–	–	3.583	2.430	11300	LOEX12

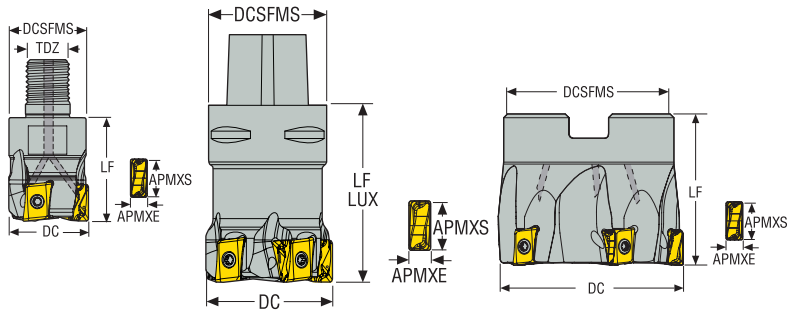
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.94-01.00	C040105B-T15P	T00-15P35	31.0IN.LBS
R217.94-01.25-01.50	C04012B-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square T4 – R217/220.94-12 – Metric



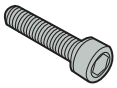
- For insert selection and cutting data recommendations, see page(s) 89-91
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm	kg		
R217.94-1632.RE-12-3A	02998337	Combimaster	32,0	3	12,0	3,5	–	M16	30,0	40,0	0,3	12400	LOEX12
R217.94-2040.RE-12-3A	02998338	Combimaster	40,0	3	12,0	3,5	–	M20	36,5	40,0	0,4	11100	LOEX12
R217.94-2040.RE-12-5A	02998339	Combimaster	40,0	5	12,0	3,5	–	M20	36,5	40,0	0,5	11100	LOEX12
C4-R217.94-044-12-4A	02998340	Seco-Capto	44,0	4	12,0	3,5	–	–	40,0	60,0	0,6	10600	LOEX12
C5-R217.94-054-12-5A	02998342	Seco-Capto	54,0	5	12,0	3,5	–	–	50,0	60,0	1,0	9500	LOEX12
C6-R217.94-066-12-6A	02998344	Seco-Capto	66,0	6	12,0	3,5	–	–	63,0	60,0	1,6	8600	LOEX12
R220.94-0040-12-4A	02998603	Arbor	40,0	4	12,0	3,5	16,0	–	35,0	40,0	0,3	11100	LOEX12
R220.94-0040-12-5A	02998347	Arbor	40,0	5	12,0	3,5	16,0	–	35,0	40,0	0,4	11100	LOEX12
R220.94-0050-12-5A	02998348	Arbor	50,0	5	12,0	3,5	22,0	–	45,0	40,0	0,5	9900	LOEX12
R220.94-0050-12-6A	02998349	Arbor	50,0	6	12,0	3,5	22,0	–	45,0	40,0	0,5	9900	LOEX12
R220.94-0063-12-6A	02998350	Arbor	63,0	6	12,0	3,5	27,0	–	56,0	40,0	0,7	8800	LOEX12
R220.94-0063-12-6A-22	03239179	Arbor	63,0	6	12,0	3,5	22,0	–	56,0	40,0	0,6	8800	LOEX12
R220.94-0063-12-8A	02998351	Arbor	63,0	8	12,0	3,5	27,0	–	56,0	40,0	0,7	8800	LOEX12
R220.94-0063-12-8A-22	03239181	Arbor	63,0	8	12,0	3,5	22,0	–	56,0	40,0	0,6	8800	LOEX12
R220.94-0080-12-7A	02998352	Arbor	80,0	7	12,0	3,5	27,0	–	62,0	50,0	1,3	7800	LOEX12
R220.94-0080-12-10A	02998353	Arbor	80,0	10	12,0	3,5	27,0	–	62,0	50,0	1,3	7800	LOEX12
R220.94-0100-12-9A	02998354	Arbor	100,0	9	12,0	3,5	32,0	–	77,0	50,0	1,8	7000	LOEX12
R220.94-0100-12-12A	02998355	Arbor	100,0	12	12,0	3,5	32,0	–	77,0	50,0	1,9	7000	LOEX12
R220.94-0125-12-12A	02998356	Arbor	125,0	12	12,0	3,5	40,0	–	90,0	63,0	3,3	6300	LOEX12

For Combimaster Shanks, see Machining Navigator Tooling System

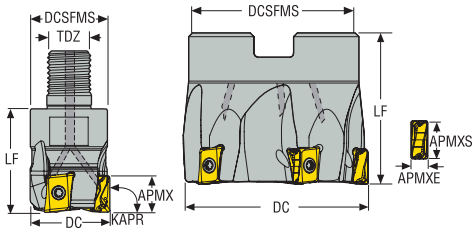
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
Cx/R217.94-..	–	C04012B-T15P	T00-15P35	3.5NM
R220.94-0040	TCEI0825	C04012B-T15P	T00-15P35	3.5NM
R220.94-0050	220.17-692	C04012B-T15P	T00-15P35	3.5NM
R220.94-0063	MLC6S12X30	C04012B-T15P	T00-15P35	3.5NM
R220.94-0063-22	220.17-692	C04012B-T15P	T00-15P35	3.5NM
R220.94-0080	MC6S12X35	C04012B-T15P	T00-15P35	3.5NM
R220.94-0100-0125	–	C04012B-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square T4 – R217/220.94-12 – Inch



- For insert selection and cutting data recommendations, see page(s) 89-91
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.94-01.25-16RE-12-3A	02998415	Combimaster	1.250	3	0.472	0.138	–	M16	1.181	1.575	0.660	12400	LOEX12..
R217.94-01.50-20RE-12-4A	02998417	Combimaster	1.500	4	0.472	0.138	–	M20	1.437	1.575	0.880	11300	LOEX12..
R220.94-01.50-12-4A	02998420	Arbor	1.500	4	0.472	0.138	0.500	–	1.378	1.575	0.660	11300	LOEX12..
R220.94-02.00-12-5A	02998421	Arbor	2.000	5	0.472	0.138	0.750	–	1.850	1.575	1.100	9800	LOEX12..
R220.94-02.00-12-6A	02998422	Arbor	2.000	6	0.472	0.138	0.750	–	1.850	1.575	1.100	9800	LOEX12..
R220.94-02.50-12-6A	02998423	Arbor	2.500	6	0.472	0.138	0.750	–	1.850	1.575	1.540	8800	LOEX12..
R220.94-02.50-12-8A	02998424	Arbor	2.500	8	0.472	0.138	0.750	–	1.850	1.575	1.540	8800	LOEX12..
R220.94-03.00-12-8A	02998425	Arbor	3.000	8	0.472	0.138	1.000	–	2.441	1.969	2.650	8000	LOEX12..
R220.94-04.00-12-10A	02998426	Arbor	4.000	10	0.472	0.138	1.500	–	3.543	1.969	4.850	7000	LOEX12..
R220.94-05.00-12-12A	02998427	Arbor	5.000	12	0.472	0.138	1.500	–	3.543	2.480	8.160	6200	LOEX12..
R220.94-06.00-12-14	03137209	Arbor	6.000	14	0.472	0.138	2.000	–	4.331	2.480	9.260	6200	LOEX12..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.94-01.25-01.50	–	C04012B-T15P	T00-15P35	31.0IN.LBS
R220.94-01.50	UC6S1/4UNFX1	C04012B-T15P	T00-15P35	31.0IN.LBS
R220.94-02.00-02.50	UC6S3/8UNFX1	C04012B-T15P	T00-15P35	31.0IN.LBS
R220.94-03.00	UC6S1/2UNFX1-1/4	C04012B-T15P	T00-15P35	31.0IN.LBS
R220.94-04.00	ULC6S3/4UNFX11/2	C04012B-T15P	T00-15P35	31.0IN.LBS
R220.94-05.00	UC6S3/4UNFX1-1/4	C04012B-T15P	T00-15P35	31.0IN.LBS
R220.94-06.00	–	C04012B-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.94-12 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	LOEX120708TR-M12 F40M	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P2	LOEX120708TR-M12 F40M	6,0 *0.24*	0,19 *0.0075*	0,20 *0.0080*	0,32 *0.013*
P3	LOEX120708TR-M12 MP2501	6,0 *0.24*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P4	LOEX120708TR-M12 MP2501	6,0 *0.24*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P5	LOEX120708TR-M12 MP2501	6,0 *0.24*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P6	LOEX120708TR-M12 MP2501	6,0 *0.24*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P7	LOEX120708TR-M12 MP2501	6,0 *0.24*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P8	LOEX120708TR-M12 MP2501	6,0 *0.24*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P11	LOEX120708TR-M12 T350M	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P12	LOEX120708TR-M12 MS2500	4,5 *0.18*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M1	LOEX120708R-M09 MS2050	6,0 *0.24*	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
M2	LOEX120708R-M09 MS2050	6,0 *0.24*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
M3	LOEX120708R-M09 F40M	4,5 *0.18*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*
M4	LOEX120708R-M09 F40M	3,5 *0.14*	0,095 *0.0038*	0,10 *0.0040*	0,15 *0.0060*
M5	LOEX120708R-M09 F40M	3,5 *0.14*	0,095 *0.0038*	0,10 *0.0040*	0,15 *0.0060*
K1	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,20 *0.0080*	0,22 *0.0085*	0,34 *0.013*
K2	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K3	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K4	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K5	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,28 *0.011*
K6	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
K7	LOEX120708TR-MD13 MK2050	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,28 *0.011*
N1	LOEX120708R-M09 F40M	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
N2	LOEX120708R-M09 F40M	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
N3	LOEX120708R-M09 F40M	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
N11	LOEX120708R-M09 F40M	6,0 *0.24*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
S1	LOEX120708R-M09 MS2050	3,5 *0.14*	0,095 *0.0038*	0,10 *0.0040*	0,15 *0.0060*
S2	LOEX120708R-M09 MS2050	3,5 *0.14*	0,095 *0.0038*	0,10 *0.0040*	0,15 *0.0060*
S3	LOEX120708TR-M12 MS2050	3,5 *0.14*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
S11	LOEX120708R-M09 MS2050	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,17 *0.0065*
S12	LOEX120708R-M09 MS2050	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,17 *0.0065*
S13	LOEX120708TR-M12 MS2050	3,5 *0.14*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
H5	LOEX120708TR-M12 MP3000	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
H8	LOEX120708TR-M12 MP3000	4,0 *0.16*	0,090 *0.0036*	0,095 *0.0038*	0,15 *0.0060*
H11	LOEX120708TR-MD13 MP1501	4,5 *0.18*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
H12	LOEX120708TR-MD13 MP1501	4,0 *0.16*	0,090 *0.0036*	0,095 *0.0038*	0,15 *0.0060*

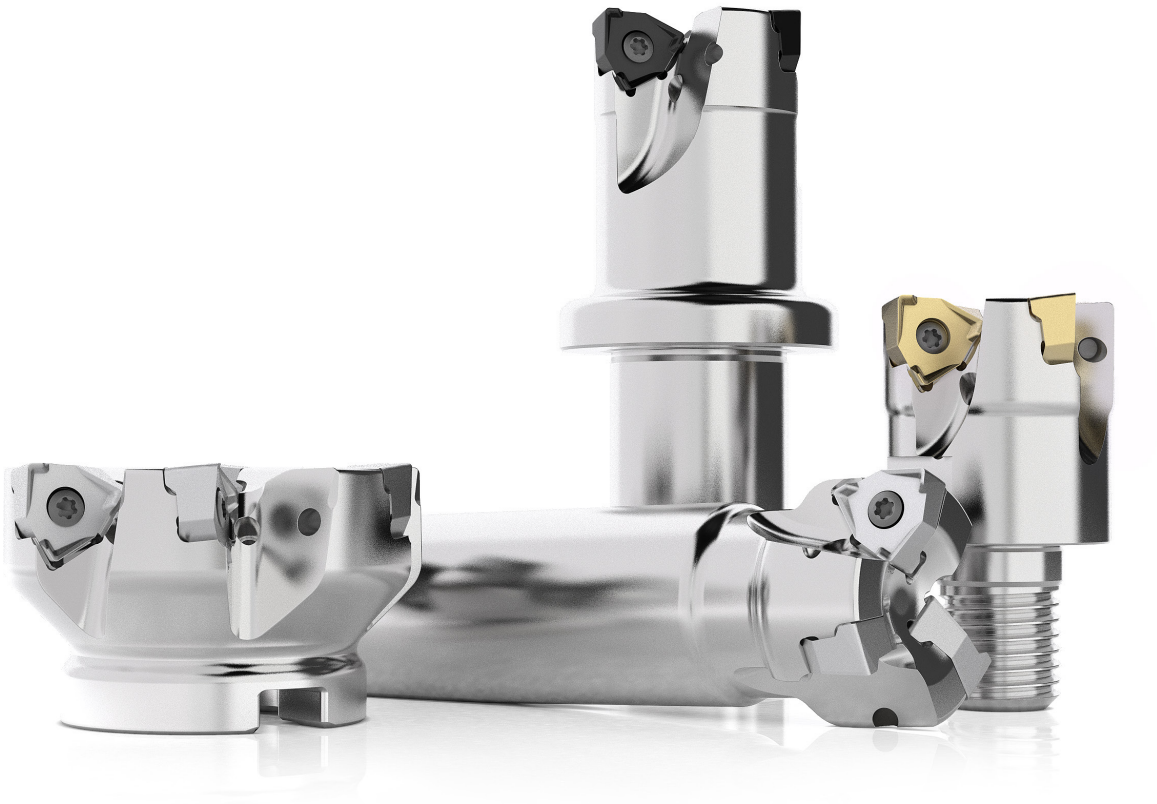
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.94-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	295 *970*	390 *1275*	465 *1525*	265 *870*	350 *1150*	420 *1375*	275 *900*	365 *1200*	435 *1425*	255 *840*	340 *1125*	405 *1325*	165 *540*	220 *720*	260 *850*	— —	— —	— —
P2	285 *940*	380 *1250*	445 *1450*	255 *840*	340 *1125*	400 *1300*	270 *890*	355 *1175*	425 *1400*	245 *800*	330 *1075*	385 *1275*	160 *520*	215 *710*	250 *820*	— —	— —	— —
P3	250 *820*	330 *1075*	390 *1275*	225 *740*	300 *980*	350 *1150*	235 *770*	310 *1025*	365 *1200*	215 *710*	290 *950*	340 *1125*	140 *460*	185 *610*	220 *720*	— —	— —	— —
P4	220 *720*	290 *950*	345 *1125*	200 *660*	265 *870*	310 *1025*	205 *670*	275 *900*	330 *1075*	195 *640*	255 *840*	300 *980*	125 *410*	165 *540*	195 *640*	— —	— —	— —
P5	210 *690*	280 *920*	335 *1100*	190 *620*	250 *820*	300 *980*	200 *660*	265 *870*	315 *1025*	185 *610*	240 *790*	290 *950*	120 *395*	155 *510*	190 *620*	— —	— —	— —
P6	240 *790*	320 *1050*	375 *1225*	215 *710*	285 *940*	340 *1125*	220 *720*	295 *970*	350 *1150*	205 *670*	275 *900*	325 *1075*	135 *445*	180 *590*	210 *690*	— —	— —	— —
P7	225 *740*	300 *980*	355 *1175*	200 *660*	270 *890*	320 *1050*	210 *690*	280 *920*	330 *1075*	195 *640*	260 *850*	310 *1025*	125 *410*	170 *560*	200 *660*	— —	— —	— —
P8	210 *690*	280 *920*	330 *1075*	190 *620*	250 *820*	295 *970*	200 *660*	260 *850*	305 *1000*	180 *590*	240 *790*	285 *940*	115 *375*	155 *510*	185 *610*	— —	— —	— —
P11	220 *720*	290 *950*	345 *1125*	195 *640*	265 *870*	310 *1025*	205 *670*	270 *890*	325 *1075*	190 *620*	255 *840*	300 *980*	125 *410*	165 *540*	195 *640*	— —	— —	— —
P12	145 *475*	190 *620*	225 *740*	130 *425*	170 *560*	205 *670*	135 *445*	180 *590*	210 *690*	125 *410*	165 *540*	195 *640*	80 *260*	105 *345*	125 *410*	— —	— —	— —
M1	— —	— —	— —	185 *610*	245 *800*	285 *940*	195 *640*	255 *840*	305 *1000*	185 *610*	245 *800*	290 *950*	135 *445*	185 *610*	215 *710*	— —	— —	— —
M2	— —	— —	— —	155 *510*	200 *660*	240 *790*	160 *520*	215 *710*	250 *820*	155 *510*	205 *670*	245 *800*	115 *375*	150 *490*	180 *590*	— —	— —	— —
M3	— —	— —	— —	125 *410*	165 *540*	195 *640*	130 *425*	170 *560*	205 *670*	125 *410*	165 *540*	200 *660*	95 *310*	125 *410*	145 *475*	— —	— —	— —
M4	— —	— —	— —	100 *330*	130 *425*	150 *490*	105 *345*	135 *445*	160 *520*	100 *330*	130 *425*	150 *490*	75 *245*	95 *310*	115 *375*	— —	— —	— —
M5	— —	— —	— —	80 *260*	110 *360*	125 *410*	85 *280*	115 *375*	135 *445*	80 *260*	110 *360*	125 *410*	60 *195*	80 *260*	95 *310*	— —	— —	— —
K1	225 *740*	300 *980*	350 *1150*	200 *660*	270 *890*	315 *1025*	215 *710*	280 *920*	335 *1100*	195 *640*	260 *850*	305 *1000*	— —	— —	— —	275 *900*	365 *1200*	435 *1425*
K2	200 *660*	265 *870*	315 *1025*	180 *590*	240 *790*	285 *940*	190 *620*	250 *820*	300 *980*	175 *570*	230 *750*	275 *900*	— —	— —	— —	250 *820*	325 *1075*	390 *1275*
K3	170 *560*	225 *740*	270 *890*	155 *510*	200 *660*	240 *790*	160 *520*	215 *710*	250 *820*	150 *490*	195 *640*	235 *770*	— —	— —	— —	210 *690*	275 *900*	330 *1075*
K4	160 *520*	215 *710*	255 *840*	145 *475*	195 *640*	230 *750*	150 *490*	205 *670*	240 *790*	140 *460*	185 *610*	225 *740*	— —	— —	— —	200 *660*	265 *870*	315 *1025*
K5	100 *330*	130 *425*	155 *510*	90 *295*	120 *395*	140 *460*	95 *310*	125 *410*	145 *475*	85 *280*	115 *375*	135 *445*	— —	— —	— —	120 *395*	160 *520*	190 *620*
K6	145 *475*	190 *620*	225 *740*	130 *425*	170 *560*	205 *670*	135 *445*	180 *590*	210 *690*	125 *410*	165 *540*	195 *640*	— —	— —	— —	175 *570*	235 *770*	280 *920*
K7	130 *425*	170 *560*	200 *660*	115 *375*	150 *490*	180 *590*	120 *395*	160 *520*	185 *610*	110 *360*	145 *475*	175 *570*	— —	— —	— —	155 *510*	210 *690*	245 *800*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	48 *155*	65 *215*	75 *245*	50 *165*	65 *215*	75 *245*	46 *150*	60 *195*	70 *230*	22 *70*	30 *100*	35 *115*	— —	— —	— —
S2	— —	— —	— —	39 *130*	50 *165*	60 *195*	40 *130*	55 *180*	60 *195*	37 *120*	49 *160*	55 *180*	18 *60*	24 *80*	28 *90*	— —	— —	— —
S3	— —	— —	— —	34 *110*	45 *150*	55 *180*	36 *120*	47 *155*	55 *180*	33 *110*	43 *140*	50 *165*	16 *50*	21 *70*	25 *80*	— —	— —	— —
S11	— —	— —	— —	65 *215*	90 *295*	105 *345*	70 *230*	90 *295*	110 *360*	65 *215*	85 *280*	100 *330*	31 *100*	41 *135*	49 *160*	— —	— —	— —
S12	— —	— —	— —	46 *150*	60 *195*	70 *230*	48 *155*	65 *215*	75 *245*	44 *145*	60 *195*	70 *230*	29 *95*	38 *125*	45 *150*	— —	— —	— —
S13	— —	— —	— —	27 *90*	36 *120*	42 *140*	28 *90*	37 *120*	44 *145*	26 *85*	34 *110*	40 *130*	17 *55*	22 *70*	26 *85*	— —	— —	— —
H5	48 *155*	65 *215*	75 *245*	39 *130*	50 *165*	60 *195*	41 *135*	55 *180*	65 *215*	39 *130*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —
H8	50 *165*	70 *230*	80 *260*	42 *140*	55 *180*	65 *215*	44 *145*	60 *195*	65 *215*	42 *140*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —
H11	60 *195*	80 *260*	95 *310*	49 *160*	65 *215*	80 *260*	50 *165*	70 *230*	80 *260*	49 *160*	65 *215*	80 *260*	— —	— —	— —	— —	— —	— —
H12	90 *295*	125 *410*	145 *475*	85 *280*	110 *360*	130 *425*	85 *280*	115 *375*	135 *445*	80 *260*	105 *345*	125 *410*	— —	— —	— —	— —	— —	— —

R217/220.94-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MS2050			MS2500			T350M			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	250 *820*	330 *1075*	390 *1275*	245 *800*	325 *1075*	380 *1250*	300 *980*	395 *1300*	475 *1550*	235 *770*	310 *1025*	370 *1225*	205 *670*	270 *890*	325 *1075*
P2	245 *800*	320 *1050*	380 *1250*	240 *790*	310 *1025*	370 *1225*	295 *970*	385 *1275*	465 *1525*	225 *740*	305 *1000*	355 *1175*	195 *640*	265 *870*	310 *1025*
P3	210 *690*	285 *940*	335 *1100*	205 *670*	275 *900*	330 *1075*	255 *840*	340 *1125*	400 *1300*	200 *660*	265 *870*	310 *1025*	170 *560*	230 *750*	270 *890*
P4	185 *610*	250 *820*	295 *970*	185 *610*	240 *790*	290 *950*	225 *740*	300 *980*	360 *1175*	175 *570*	235 *770*	275 *900*	155 *510*	205 *670*	240 *790*
P5	180 *590*	240 *790*	285 *940*	175 *570*	235 *770*	275 *900*	215 *710*	290 *950*	340 *1125*	170 *560*	225 *740*	265 *870*	145 *475*	195 *640*	230 *750*
P6	205 *670*	270 *890*	320 *1050*	200 *660*	265 *870*	310 *1025*	245 *800*	325 *1075*	385 *1275*	190 *620*	255 *840*	300 *980*	165 *540*	220 *720*	260 *850*
P7	190 *620*	255 *840*	305 *1000*	185 *610*	250 *820*	290 *950*	230 *750*	305 *1000*	360 *1175*	180 *590*	240 *790*	285 *940*	155 *510*	210 *690*	245 *800*
P8	180 *590*	240 *790*	280 *920*	175 *570*	230 *750*	275 *900*	215 *710*	285 *940*	335 *1100*	165 *540*	225 *740*	260 *850*	145 *475*	195 *640*	230 *750*
P11	185 *610*	245 *800*	295 *970*	180 *590*	240 *790*	285 *940*	220 *720*	295 *970*	350 *1150*	175 *570*	235 *770*	275 *900*	150 *490*	205 *670*	240 *790*
P12	120 *395*	160 *520*	195 *640*	120 *395*	155 *510*	185 *610*	145 *475*	195 *640*	230 *750*	115 *375*	150 *490*	180 *590*	100 *330*	130 *425*	155 *510*
M1	— —	— —	— —	195 *640*	250 *820*	300 *980*	210 *690*	275 *900*	330 *1075*	175 *570*	235 *770*	275 *900*	160 *520*	215 *710*	250 *820*
M2	— —	— —	— —	160 *520*	210 *690*	250 *820*	175 *570*	230 *750*	275 *900*	145 *475*	190 *620*	230 *750*	135 *445*	175 *570*	210 *690*
M3	— —	— —	— —	130 *425*	170 *560*	200 *660*	140 *460*	185 *610*	225 *740*	120 *395*	160 *520*	190 *620*	110 *360*	145 *475*	170 *560*
M4	— —	— —	— —	100 *330*	135 *445*	155 *510*	110 *360*	145 *475*	175 *570*	95 *310*	125 *410*	145 *475*	85 *280*	110 *360*	130 *425*
M5	— —	— —	— —	85 *280*	110 *360*	130 *425*	95 *310*	120 *395*	145 *475*	80 *260*	105 *345*	120 *395*	70 *230*	95 *310*	110 *360*
K1	260 *850*	345 *1125*	410 *1350*	— —	— —	— —	— —	— —	— —	180 *590*	240 *790*	280 *920*	155 *510*	210 *690*	245 *800*
K2	235 *770*	310 *1025*	370 *1225*	— —	— —	— —	— —	— —	— —	160 *520*	210 *690*	255 *840*	140 *460*	185 *610*	220 *720*
K3	200 *660*	260 *850*	315 *1025*	— —	— —	— —	— —	— —	— —	135 *445*	180 *590*	215 *710*	120 *395*	155 *510*	185 *610*
K4	190 *620*	250 *820*	300 *980*	— —	— —	— —	— —	— —	— —	130 *425*	170 *560*	205 *670*	115 *375*	150 *490*	180 *590*
K5	115 *375*	155 *510*	180 *590*	— —	— —	— —	— —	— —	— —	80 *260*	105 *345*	125 *410*	70 *230*	90 *295*	110 *360*
K6	165 *540*	220 *720*	265 *870*	— —	— —	— —	— —	— —	— —	115 *375*	150 *490*	180 *590*	100 *330*	130 *425*	155 *510*
K7	145 *475*	195 *640*	230 *750*	— —	— —	— —	— —	— —	— —	105 *345*	135 *445*	160 *520*	90 *295*	115 *375*	140 *460*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1150 *3775*	1525 *5000*	1800 *5900*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	460 *1500*	620 *2025*	730 *2400*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	310 *1025*	410 *1350*	485 *1600*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	350 *1150*	470 *1550*	560 *1825*
S1	— —	— —	— —	47 *155*	60 *195*	75 *245*	55 *180*	70 *230*	85 *280*	44 *145*	60 *195*	65 *215*	40 *130*	50 *165*	60 *195*
S2	— —	— —	— —	38 *125*	50 *165*	60 *195*	44 *145*	60 *195*	70 *230*	35 *115*	46 *150*	55 *180*	32 *105*	42 *140*	49 *160*
S3	— —	— —	— —	33 *110*	44 *145*	50 *165*	39 *130*	50 *165*	60 *195*	31 *100*	41 *135*	48 *155*	28 *90*	37 *120*	44 *145*
S11	— —	— —	— —	65 *215*	85 *280*	100 *330*	75 *245*	100 *330*	120 *395*	60 *195*	80 *260*	95 *310*	55 *180*	75 *245*	85 *280*
S12	— —	— —	— —	45 *150*	60 *195*	70 *230*	50 *165*	70 *230*	80 *260*	42 *140*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*
S13	— —	— —	— —	26 *85*	35 *115*	41 *135*	31 *100*	40 *130*	47 *155*	25 *80*	32 *105*	38 *125*	22 *70*	30 *100*	34 *110*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	38 *125*	50 *165*	60 *195*	33 *110*	44 *145*	50 *165*
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	41 *135*	55 *180*	65 *215*	36 *120*	48 *155*	55 *180*
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	48 *155*	65 *215*	75 *245*	42 *140*	55 *180*	65 *215*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	75 *245*	100 *330*	115 *375*	65 *215*	85 *280*	100 *330*

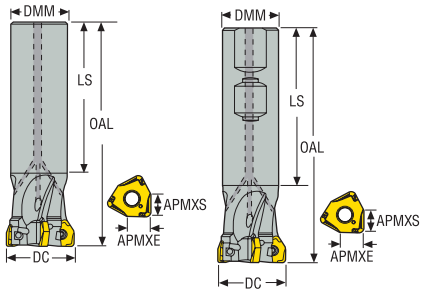


SQUARE 6

Seco's line of Square 6 shoulder milling cutters answers the need for added economy in square shoulder milling. This unique square shoulder milling cutter uses trigonal inserts with three cutting edges on each side – six total cutting edges – to lower the cost per cutting edge.

- With two different cutter family sizes - Insert size 04 and 08
- Wiper flats optimize surface finishes
- Multiple grades and geometries are available

Square 6™ – R217.96-04 – Metric



- For insert selection and cutting data recommendations, see page(s) 97-99
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		kg	
R217.96-1820.0-04-3A	02833459	Cylindrical	20,0	3	4,0	2,0	18,0	121,0	150,0	29400	0,3	XNEX04..
R217.96-2020.0-04-2A	02793069	Cylindrical	20,0	2	4,0	2,0	20,0	121,0	150,0	29400	1,9	XNEX04..
R217.96-2020.0-04-3A	02768343	Cylindrical	20,0	3	4,0	2,0	20,0	121,0	150,0	29400	0,3	XNEX04..
R217.96-2525.0-04-4A	02768359	Cylindrical	25,0	4	4,0	2,0	25,0	141,0	170,0	26300	0,6	XNEX04..
R217.96-2525.0-04-5A	02768361	Cylindrical	25,0	5	4,0	2,0	25,0	141,0	170,0	26300	0,6	XNEX04..
R217.96-3232.0-04-5A	02768370	Cylindrical	32,0	5	4,0	2,0	32,0	164,0	195,0	23200	1,2	XNEX04..
R217.96-3232.0-04-6A	02768371	Cylindrical	32,0	6	4,0	2,0	32,0	164,0	195,0	23200	1,2	XNEX04..
R217.96-2020.3-04-2A	02793071	Weldon	20,0	2	4,0	2,0	20,0	61,0	90,0	29400	1,9	XNEX04..
R217.96-2020.3-04-3A	02768349	Weldon	20,0	3	4,0	2,0	20,0	61,0	90,0	29400	0,2	XNEX04..
R217.96-2525.3-04-4A	02768362	Weldon	25,0	4	4,0	2,0	25,0	67,0	101,0	26300	0,4	XNEX04..
R217.96-2525.3-04-5A	02768364	Weldon	25,0	5	4,0	2,0	25,0	67,0	101,0	26300	0,4	XNEX04..
R217.96-3232.3-04-5A	02768372	Weldon	32,0	5	4,0	2,0	32,0	68,0	105,0	23200	0,5	XNEX04..

Spare Parts

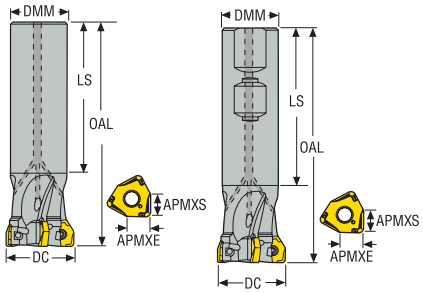
For cutter	Insert screw
R217.96-..	C02506-T08P

Accessories

Torque key	Torque value
T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R217.96-04 – Inch



- For insert selection and cutting data recommendations, see page(s) 97-99
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R217.96-00.75-0-04-3A	02770505	Cylindrical	0.750	3	0.157	0.079	0.750	4.516	5.910	29400	0.660	XNEX04..
R217.96-01.00-0-04-4A	02770591	Cylindrical	1.000	4	0.157	0.079	1.000	5.122	6.691	26300	1.320	XNEX04..
R217.96-01.00-0-04-5A	02770593	Cylindrical	1.000	5	0.157	0.079	1.000	5.122	6.690	26300	1.320	XNEX04..
R217.96-00.75-3-04-3A	02770536	Weldon	0.750	3	0.157	0.079	0.750	2.197	3.390	29400	0.440	XNEX04..
R217.96-01.00-3-04-5A	02770596	Weldon	1.000	5	0.157	0.079	1.000	2.602	3.780	26300	0.880	XNEX04..
R217.96-01.25-3-04-5A	02770602	Weldon	1.250	5	0.157	0.079	1.250	2.760	4.000	23200	1.320	XNEX04..
R217.96-01.25-3-04-6A	02770603	Weldon	1.250	6	0.157	0.079	1.250	2.760	4.000	23200	1.320	XNEX04..

Spare Parts

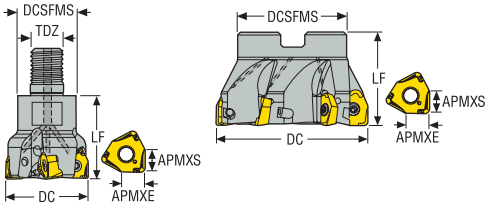
For cutter	Insert screw
R217.96..	C02506-T08P

Accessories

Torque key	Torque value
T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R217/220.96-04 – Metric



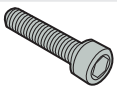
- For insert selection and cutting data recommendations, see page(s) 97-99
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm	kg		
R217.96-1020.RE-04-3A	02768351	Combimaster	20,0	3	4,0	2,0	–	M10	18,3	28,0	0,1	29400	XNEX04..
R217.96-1225.RE-04-4A	02768365	Combimaster	25,0	4	4,0	2,0	–	M12	23,0	30,0	0,1	26300	XNEX04..
R217.96-1225.RE-04-5A	02768367	Combimaster	25,0	5	4,0	2,0	–	M12	23,0	30,0	0,1	26300	XNEX04..
R217.96-1632.RE-04-5A	02768375	Combimaster	32,0	5	4,0	2,0	–	M16	30,0	40,0	0,3	23200	XNEX04..
R217.96-1632.RE-04-6A	02768376	Combimaster	32,0	6	4,0	2,0	–	M16	30,0	40,0	0,3	23200	XNEX04..
R217.96-2040.RE-04-7A	02768414	Combimaster	40,0	7	4,0	2,0	–	M20	37,0	40,0	0,4	20700	XNEX04..
R220.96-0032-04-4A	02841298	Arbor	32,0	4	4,0	2,0	16,0	–	35,0	40,0	0,2	23200	XNEX04..
R220.96-0032-04-6A	02841306	Arbor	32,0	6	4,0	2,0	16,0	–	35,0	40,0	0,2	23200	XNEX04..
R220.96-0040-04-5A	02841154	Arbor	40,0	5	4,0	2,0	16,0	–	35,0	40,0	0,3	20700	XNEX04..
R220.96-0040-04-7A	02768377	Arbor	40,0	7	4,0	2,0	16,0	–	35,0	40,0	0,3	20700	XNEX04..
R220.96-0050-04-6A	02841155	Arbor	50,0	6	4,0	2,0	22,0	–	47,0	40,0	0,4	18600	XNEX04..
R220.96-0050-04-8A	02768413	Arbor	50,0	8	4,0	2,0	22,0	–	47,0	40,0	0,4	18600	XNEX04..
R220.96-0050-04-9A	02768412	Arbor	50,0	9	4,0	2,0	22,0	–	47,0	40,0	0,4	18600	XNEX04..
R220.96-0063-04-7A	02841156	Arbor	63,0	7	4,0	2,0	27,0	–	62,0	40,0	0,7	16500	XNEX04..
R220.96-0063-04-9A	02768433	Arbor	63,0	9	4,0	2,0	27,0	–	52,0	40,0	0,7	16500	XNEX04..

For Combimaster Shanks, see Machining Navigator Tooling System

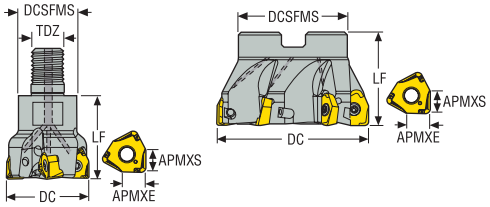
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.96-..	–	C02506-T08P	T00-08P12	1.2NM
R220.96-0032-0040	TCEI0825	C02506-T08P	T00-08P12	1.2NM
R220.96-0050	220.17-692	C02506-T08P	T00-08P12	1.2NM
R220.96-0063	–	C02506-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R217/220.96-04 – Inch



- For insert selection and cutting data recommendations, see page(s) 97-99
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.96-00.75-10RE-04-3A	02770501	Combimaster	0.750	3	0.157	0.079	–	M10	0.689	1.070	0.220	29400	XNEX04..
R217.96-01.00-12RE-04-5A	02770543	Combimaster	1.000	5	0.157	0.079	–	M12	0.906	1.570	0.440	26300	XNEX04..
R217.96-01.25-16RE-04-5A	02770599	Combimaster	1.250	5	0.157	0.079	–	M16	1.181	1.570	0.660	23200	XNEX04..
R217.96-01.50-20RE-04-6A	02770606	Combimaster	1.500	6	0.157	0.079	–	M20	1.417	1.570	0.220	20700	XNEX04..
R220.96-01.50-04-6A	02770608	Arbor	1.500	6	0.157	0.079	0.750	–	1.850	1.570	0.440	20700	XNEX04..
R220.96-02.00-04-9A	02770613	Arbor	2.000	9	0.157	0.079	0.750	–	1.850	1.570	0.880	18600	XNEX04..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.96-..	–	C02506-T08P	T00-08P12	1.2NM
R220.96-..	UC6S3/8UNFX1	C02506-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.96-04 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	XNEX040304TR-M08 F40M	2,0 *0.080*	0,11 *0.0044*	0,13 *0.0050*	0,19 *0.0075*
P2	XNEX040304TR-M08 F40M	2,0 *0.080*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
P3	XNEX040304TR-M08 MP2501	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P4	XNEX040304TR-M08 MP2501	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P5	XNEX040304TR-M08 MP2501	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P6	XNEX040304TR-M08 MP2501	2,0 *0.080*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P7	XNEX040304TR-M08 MP2501	2,0 *0.080*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P8	XNEX040304TR-M08 MP2501	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P11	XNEX040304TR-M08 MP3000	2,0 *0.080*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P12	XNEX040304TR-M08 MP2501	1,6 *0.065*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
M1	XNEX040304R-M06 F40M	2,0 *0.080*	0,085 *0.0034*	0,095 *0.0038*	0,15 *0.0060*
M2	XNEX040304R-M06 F40M	2,0 *0.080*	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M3	XNEX040304R-M06 F40M	1,6 *0.065*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
M4	XNEX040304R-M06 F40M	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*
M5	XNEX040304R-M06 F40M	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*
K1	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
K2	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K3	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K4	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K5	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K6	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K7	XNEX040304TR-M08 MK2050	2,0 *0.080*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
N1	XNEX040304R-M06 F40M	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
N2	XNEX040304R-M06 F40M	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
N3	XNEX040304R-M06 F40M	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
N11	XNEX040304R-M06 F40M	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
S1	XNEX040304R-M06 F40M	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*
S2	XNEX040304R-M06 F40M	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*
S3	XNEX040304R-M06 F40M	1,2 *0.048*	0,055 *0.0022*	0,060 *0.0024*	0,085 *0.0034*
S11	XNEX040304R-M06 MS2050	1,4 *0.055*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
S12	XNEX040304R-M06 MS2050	1,4 *0.055*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
S13	XNEX040304R-M06 MS2050	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*
H5	XNEX040304TR-M08 MP3000	1,6 *0.065*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H8	XNEX040304TR-M08 MP3000	1,4 *0.055*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
H11	XNEX040304TR-M08 MP3000	1,6 *0.065*	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H12	XNEX040304TR-M08 MP3000	1,4 *0.055*	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

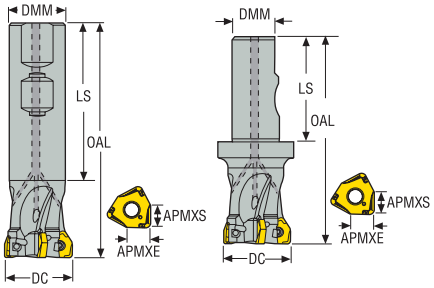
R217/220.96-04 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			MM4500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	350 *1150*	465 *1525*	540 *1775*	310 *1025*	410 *1350*	480 *1575*	295 *970*	390 *1275*	455 *1500*	190 *620*	255 *840*	295 *970*
P2	340 *1125*	455 *1500*	530 *1750*	300 *980*	400 *1300*	465 *1525*	285 *940*	380 *1250*	440 *1450*	185 *610*	245 *800*	285 *940*
P3	295 *970*	390 *1275*	460 *1500*	260 *850*	345 *1125*	405 *1325*	245 *800*	325 *1075*	385 *1275*	160 *520*	210 *690*	250 *820*
P4	265 *870*	350 *1150*	410 *1350*	235 *770*	310 *1025*	360 *1175*	220 *720*	295 *970*	345 *1125*	145 *475*	190 *620*	220 *720*
P5	255 *840*	335 *1100*	390 *1275*	225 *740*	295 *970*	345 *1125*	210 *690*	280 *920*	325 *1075*	135 *445*	180 *590*	210 *690*
P6	285 *940*	375 *1225*	440 *1450*	250 *820*	330 *1075*	390 *1275*	240 *790*	315 *1025*	365 *1200*	155 *510*	205 *670*	240 *790*
P7	270 *890*	355 *1175*	415 *1350*	235 *770*	315 *1025*	365 *1200*	225 *740*	295 *970*	345 *1125*	145 *475*	190 *620*	225 *740*
P8	245 *800*	325 *1075*	385 *1275*	220 *720*	290 *950*	340 *1125*	205 *670*	275 *900*	325 *1075*	135 *445*	180 *590*	210 *690*
P11	260 *850*	345 *1125*	400 *1300*	230 *750*	305 *1000*	355 *1175*	220 *720*	290 *950*	335 *1100*	140 *460*	185 *610*	220 *720*
P12	170 *560*	220 *720*	260 *850*	150 *490*	195 *640*	230 *750*	140 *460*	185 *610*	220 *720*	90 *295*	120 *395*	140 *460*
M1	— *—*	— *—*	— *—*	220 *720*	290 *950*	335 *1100*	215 *710*	285 *940*	330 *1075*	160 *520*	210 *690*	245 *800*
M2	— *—*	— *—*	— *—*	180 *590*	240 *790*	280 *920*	175 *570*	235 *770*	275 *900*	130 *425*	175 *570*	205 *670*
M3	— *—*	— *—*	— *—*	145 *475*	190 *620*	225 *740*	140 *460*	185 *610*	220 *720*	105 *345*	140 *460*	165 *540*
M4	— *—*	— *—*	— *—*	115 *375*	150 *490*	170 *560*	110 *360*	145 *475*	170 *560*	85 *280*	110 *360*	125 *410*
M5	— *—*	— *—*	— *—*	95 *310*	125 *410*	145 *475*	95 *310*	120 *395*	140 *460*	70 *230*	90 *295*	105 *345*
K1	270 *890*	360 *1175*	415 *1350*	240 *790*	320 *1050*	370 *1225*	225 *740*	300 *980*	350 *1150*	— *—*	— *—*	— *—*
K2	240 *790*	315 *1025*	370 *1225*	210 *690*	280 *920*	330 *1075*	200 *660*	265 *870*	310 *1025*	— *—*	— *—*	— *—*
K3	205 *670*	270 *890*	315 *1025*	180 *590*	240 *790*	280 *920*	170 *560*	225 *740*	265 *870*	— *—*	— *—*	— *—*
K4	195 *640*	255 *840*	300 *980*	170 *560*	225 *740*	265 *870*	160 *520*	215 *710*	250 *820*	— *—*	— *—*	— *—*
K5	120 *395*	155 *510*	185 *610*	105 *345*	140 *460*	160 *520*	100 *330*	130 *425*	155 *510*	— *—*	— *—*	— *—*
K6	170 *560*	225 *740*	265 *870*	150 *490*	200 *660*	235 *770*	145 *475*	190 *620*	220 *720*	— *—*	— *—*	— *—*
K7	150 *490*	200 *660*	235 *770*	135 *445*	175 *570*	210 *690*	125 *410*	165 *540*	195 *640*	— *—*	— *—*	— *—*
N1	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*
N2	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*
N3	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*
N11	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*	— *—*
S1	— *—*	— *—*	— *—*	55 *180*	70 *230*	85 *280*	50 *165*	70 *230*	80 *260*	25 *80*	33 *110*	38 *125*
S2	— *—*	— *—*	— *—*	44 *145*	60 *195*	65 *215*	42 *140*	55 *180*	65 *215*	20 *65*	27 *90*	31 *100*
S3	— *—*	— *—*	— *—*	39 *130*	50 *165*	60 *195*	37 *120*	48 *155*	55 *180*	18 *60*	23 *75*	27 *90*
S11	— *—*	— *—*	— *—*	75 *245*	100 *330*	120 *395*	70 *230*	95 *310*	110 *360*	35 *115*	46 *150*	55 *180*
S12	— *—*	— *—*	— *—*	55 *180*	70 *230*	80 *260*	50 *165*	65 *215*	75 *245*	33 *110*	43 *140*	50 *165*
S13	— *—*	— *—*	— *—*	31 *100*	40 *130*	47 *155*	29 *95*	38 *125*	44 *145*	19 *60*	25 *80*	29 *95*
H5	55 *180*	75 *245*	85 *280*	45 *150*	60 *195*	70 *230*	44 *145*	60 *195*	70 *230*	— *—*	— *—*	— *—*
H8	60 *195*	80 *260*	90 *295*	48 *155*	65 *215*	75 *245*	47 *155*	60 *195*	70 *230*	— *—*	— *—*	— *—*
H11	70 *230*	95 *310*	110 *360*	55 *180*	75 *245*	90 *295*	55 *180*	75 *245*	85 *280*	— *—*	— *—*	— *—*
H12	105 *345*	140 *460*	160 *520*	95 *310*	125 *410*	145 *475*	90 *295*	115 *375*	135 *445*	— *—*	— *—*	— *—*

R217/220.96-04 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			MS2050			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	—	—	—	305	405	470	290	380	445	235	310	360
	—	—	—	*1000*	*1325*	*1550*	*950*	*1250*	*1450*	*770*	*1025*	*1175*
P2	—	—	—	300	395	460	280	370	430	230	305	355
	—	—	—	*980*	*1300*	*1500*	*920*	*1225*	*1400*	*750*	*1000*	*1175*
P3	—	—	—	255	340	400	245	320	380	195	260	305
	—	—	—	*840*	*1125*	*1300*	*800*	*1050*	*1250*	*640*	*850*	*1000*
P4	—	—	—	230	305	355	215	285	335	180	235	275
	—	—	—	*750*	*1000*	*1175*	*710*	*940*	*1100*	*590*	*770*	*900*
P5	—	—	—	220	290	340	205	275	320	170	225	260
	—	—	—	*720*	*950*	*1125*	*670*	*900*	*1050*	*560*	*740*	*850*
P6	—	—	—	245	325	380	230	310	360	190	250	295
	—	—	—	*800*	*1075*	*1250*	*750*	*1025*	*1175*	*620*	*820*	*970*
P7	—	—	—	235	310	360	220	290	340	180	235	275
	—	—	—	*770*	*1025*	*1175*	*720*	*950*	*1125*	*590*	*770*	*900*
P8	—	—	—	215	285	335	205	270	320	165	220	260
	—	—	—	*710*	*940*	*1100*	*670*	*890*	*1050*	*540*	*720*	*850*
P11	—	—	—	225	300	350	215	280	330	175	230	270
	—	—	—	*740*	*980*	*1150*	*710*	*920*	*1075*	*570*	*750*	*890*
P12	—	—	—	145	195	225	135	180	210	115	150	175
	—	—	—	*475*	*640*	*740*	*445*	*590*	*690*	*375*	*490*	*570*
M1	—	—	—	—	—	—	225	300	350	185	245	285
	—	—	—	—	—	—	*740*	*980*	*1150*	*610*	*800*	*940*
M2	—	—	—	—	—	—	185	245	285	155	200	235
	—	—	—	—	—	—	*610*	*800*	*940*	*510*	*660*	*770*
M3	—	—	—	—	—	—	150	195	230	120	160	190
	—	—	—	—	—	—	*490*	*640*	*750*	*395*	*520*	*620*
M4	—	—	—	—	—	—	115	150	175	95	125	145
	—	—	—	—	—	—	*375*	*490*	*570*	*310*	*410*	*475*
M5	—	—	—	—	—	—	95	125	145	80	105	120
	—	—	—	—	—	—	*310*	*410*	*475*	*260*	*345*	*395*
K1	340	450	520	320	425	495	—	—	—	180	240	280
	1125	*1475*	*1700*	*1050*	*1400*	*1625*	—	—	—	*590*	*790*	*920*
K2	300	400	465	285	375	440	—	—	—	160	215	250
	980	*1300*	*1525*	*940*	*1225*	*1450*	—	—	—	*520*	*710*	*820*
K3	255	335	395	240	320	370	—	—	—	135	180	210
	840	*1100*	*1300*	*790*	*1050*	*1225*	—	—	—	*445*	*590*	*690*
K4	245	320	375	230	305	355	—	—	—	130	170	200
	800	*1050*	*1225*	*750*	*1000*	*1175*	—	—	—	*425*	*560*	*660*
K5	150	195	230	140	185	220	—	—	—	80	105	125
	490	*640*	*750*	*460*	*610*	*720*	—	—	—	*260*	*345*	*410*
K6	215	285	330	205	270	315	—	—	—	115	150	175
	710	*940*	*1075*	*670*	*890*	*1025*	—	—	—	*375*	*490*	*570*
K7	190	250	295	180	235	280	—	—	—	100	135	155
	620	*820*	*970*	*590*	*770*	*920*	—	—	—	*330*	*445*	*510*
N1	—	—	—	—	—	—	—	—	—	1325	1775	2075
	—	—	—	—	—	—	—	—	—	*4350*	*5825*	*6800*
N2	—	—	—	—	—	—	—	—	—	540	720	840
	—	—	—	—	—	—	—	—	—	*1775*	*2350*	*2750*
N3	—	—	—	—	—	—	—	—	—	355	480	560
	—	—	—	—	—	—	—	—	—	*1175*	*1575*	*1825*
N11	—	—	—	—	—	—	—	—	—	410	550	640
	—	—	—	—	—	—	—	—	—	*1350*	*1800*	*2100*
S1	—	—	—	—	—	—	55	70	85	45	60	70
	—	—	—	—	—	—	*180*	*230*	*280*	*150*	*195*	*230*
S2	—	—	—	—	—	—	44	55	65	36	47	55
	—	—	—	—	—	—	*145*	*180*	*215*	*120*	*155*	*180*
S3	—	—	—	—	—	—	38	50	60	32	41	48
	—	—	—	—	—	—	*125*	*165*	*195*	*105*	*135*	*155*
S11	—	—	—	—	—	—	75	100	115	60	80	95
	—	—	—	—	—	—	*245*	*330*	*375*	*195*	*260*	*310*
S12	—	—	—	—	—	—	55	70	80	43	55	65
	—	—	—	—	—	—	*180*	*230*	*260*	*140*	*180*	*215*
S13	—	—	—	—	—	—	31	40	46	25	33	38
	—	—	—	—	—	—	*100*	*130*	*150*	*80*	*110*	*125*
H5	—	—	—	—	—	—	—	—	—	37	49	60
	—	—	—	—	—	—	—	—	—	*120*	*160*	*195*
H8	—	—	—	—	—	—	—	—	—	40	50	60
	—	—	—	—	—	—	—	—	—	*130*	*165*	*195*
H11	—	—	—	—	—	—	—	—	—	48	65	75
	—	—	—	—	—	—	—	—	—	*155*	*215*	*245*
H12	—	—	—	—	—	—	—	—	—	70	95	110
	—	—	—	—	—	—	—	—	—	*230*	*310*	*360*

Square 6™ – R217.96-08 – Metric



- For insert selection and cutting data recommendations, see page(s) 106-108
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		kg	
R217.96-3240.3-08-3A	02622987	Weldon	40,0	3	7,5	3,0	32,0	85,0	120,0	11800	0,7	XNEX08..
R217.96-3240.3-08-4A	02622989	Weldon	40,0	4	7,5	3,0	32,0	85,0	120,0	11800	0,9	XNEX08..
R217.96-3240.3S-08-3A	02622914	Seco-Weldon	40,0	3	7,5	3,0	32,0	60,0	120,0	11800	0,8	XNEX08..
R217.96-3240.3S-08-4A	02622915	Seco-Weldon	40,0	4	7,5	3,0	32,0	60,0	120,0	11800	0,8	XNEX08..

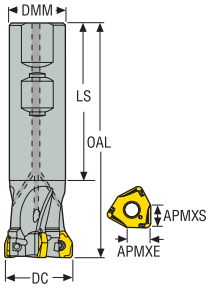
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.96-..	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R217.96-08 – Inch



- For insert selection and cutting data recommendations, see page(s) 106-108
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R217.96-01.50-3-08-3A	02642818	Weldon	1.500	3	0.295	0.118	1.250	3.346	4.500	20700	1.760	XNEX08..

Spare Parts

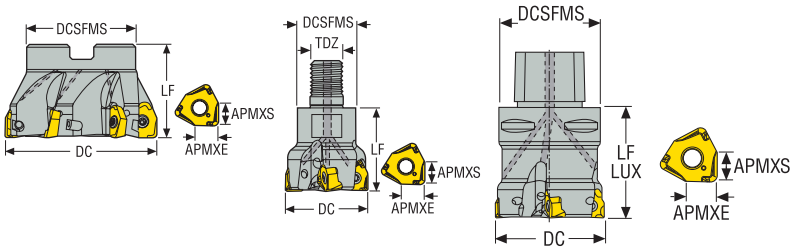
For cutter	Insert screw
R217.96-..	C04011-T15P

Accessories

Torque key	Torque value
T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R217/220.96-08 – Metric



- For insert selection and cutting data recommendations, see page(s) 106-108
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm	mm		mm	mm	kg		
R217.96-1640.RE-08-3A	02678953	Combimaster	40,0	3	7,5	3,0	–	M16	28,0	40,0	0,3	11800	XNEX08..
R217.96-1640.RE-08-4A	02678957	Combimaster	40,0	4	7,5	3,0	–	M16	28,0	40,0	0,2	11800	XNEX08..
R217.96-2040.RE-08-4A	02972745	Combimaster	40,0	4	7,5	3,0	–	M20	36,5	40,0	0,4	11800	XNEX08..
C4-R217.96-044-08-3A	02690109	Seco-Capto	44,0	3	7,5	3,0	–	–	40,0	60,0	0,6	11300	XNEX08..
C4-R217.96-044-08-4A	02690177	Seco-Capto	44,0	4	7,5	3,0	–	–	40,0	60,0	0,5	11300	XNEX08..
C5-R217.96-054-08-4A	02690178	Seco-Capto	54,0	4	7,5	3,0	–	–	50,0	60,0	0,9	10200	XNEX08..
C5-R217.96-054-08-5A	02690179	Seco-Capto	54,0	5	7,5	3,0	–	–	50,0	60,0	0,9	10200	XNEX08..
C5-R217.96-063-08-6A	02690180	Seco-Capto	63,0	6	7,5	3,0	–	–	50,0	60,0	1,0	9400	XNEX08..
C5-R217.96-063-08-7A	02690181	Seco-Capto	63,0	7	7,5	3,0	–	–	50,0	60,0	1,0	9400	XNEX08..
C6-R217.96-066-08-7A	02780514	Seco-Capto	66,0	7	7,5	3,0	–	–	63,0	60,0	1,4	9400	XNEX08..
C6-R217.96-080-08-7A	02690182	Seco-Capto	80,0	7	7,5	3,0	–	–	63,0	60,0	1,7	8400	XNEX08..
C6-R217.96-080-08-9A	02690183	Seco-Capto	80,0	9	7,5	3,0	–	–	63,0	60,0	1,2	8400	XNEX08..
R220.96-0050-08-4A	02623180	Arbor	50,0	4	7,5	3,0	22,0	–	47,0	40,0	0,3	10600	XNEX08..
R220.96-0050-08-5A	02623182	Arbor	50,0	5	7,5	3,0	22,0	–	47,0	40,0	0,3	10600	XNEX08..
R220.96-0052-08-5A	02969090	Arbor	52,0	5	7,5	3,0	22,0	–	47,0	40,0	0,4	10600	XNEX08..
R220.96-0063-08-4A	02623183	Arbor	63,0	4	7,5	3,0	22,0	–	47,0	40,0	0,5	9400	XNEX08..
R220.96-0063-08-5A-27	02768079	Arbor	63,0	5	7,5	3,0	27,0	–	62,0	40,0	0,6	9400	XNEX08..
R220.96-0063-08-6A	02623194	Arbor	63,0	6	7,5	3,0	22,0	–	47,0	40,0	0,5	9400	XNEX08..
R220.96-0063-08-6A-27	02679623	Arbor	63,0	6	7,5	3,0	27,0	–	62,0	40,0	0,6	9400	XNEX08..
R220.96-0063-08-7A	02623196	Arbor	63,0	7	7,5	3,0	22,0	–	47,0	40,0	0,7	9400	XNEX08..
R220.96-0063-08-7A-27	02679624	Arbor	63,0	7	7,5	3,0	27,0	–	62,0	40,0	0,6	9400	XNEX08..
R220.96-0066-08-6A	02711515	Arbor	66,0	6	7,5	3,0	22,0	–	47,0	40,0	0,6	9400	XNEX08..
R220.96-0080-08-5A	02623197	Arbor	80,0	5	7,5	3,0	27,0	–	62,0	50,0	1,1	8400	XNEX08..
R220.96-0080-08-7A	02623198	Arbor	80,0	7	7,5	3,0	27,0	–	62,0	50,0	1,0	8400	XNEX08..
R220.96-0080-08-9A	02623200	Arbor	80,0	9	7,5	3,0	27,0	–	62,0	50,0	1,0	8400	XNEX08..
R220.96-0084-08-7A	02969094	Arbor	84,0	7	7,5	3,0	27,0	–	62,0	50,0	1,2	8400	XNEX08..
R220.96-0100-08-6A	02623201	Arbor	100,0	6	7,5	3,0	32,0	–	77,0	50,0	1,6	7500	XNEX08..
R220.96-0100-08-8A	02623203	Arbor	100,0	8	7,5	3,0	32,0	–	77,0	50,0	1,5	7500	XNEX08..
R220.96-0100-08-11A	02623204	Arbor	100,0	11	7,5	3,0	32,0	–	77,0	50,0	1,5	7500	XNEX08..
R220.96-0125-08-7A	02640708	Arbor	125,0	7	7,5	3,0	40,0	–	90,0	63,0	2,9	6700	XNEX08..
R220.96-0125-08-11A	02640709	Arbor	125,0	11	7,5	3,0	40,0	–	90,0	63,0	2,8	6700	XNEX08..
R220.96-0125-08-14A	02640710	Arbor	125,0	14	7,5	3,0	40,0	–	90,0	63,0	2,7	6700	XNEX08..
R220.96-8160-08-12	02640711	Arbor	160,0	12	7,5	3,0	40,0	–	90,0	63,0	4,8	5900	XNEX08..
R220.96-8160-08-16	02640712	Arbor	160,0	16	7,5	3,0	40,0	–	90,0	63,0	4,8	5900	XNEX08..

For Combimaster Shanks, see Machining Navigator Tooling System

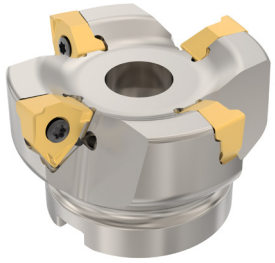
Spare Parts

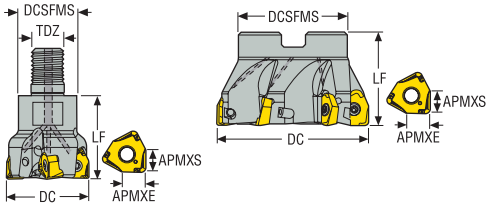
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
Cx/R217.96-..	–	C04011-T15P	T00-15P35	3.5NM
R220.96-0050-0052	220.17-696	C04011-T15P	T00-15P35	3.5NM
R220.96-0063-0066	220.17-692	C04011-T15P	T00-15P35	3.5NM
R220.96-0063-27	220.17-693	C04011-T15P	T00-15P35	3.5NM
R220.96-0080	MC6S12X35	C04011-T15P	T00-15P35	3.5NM
R220.96-0084-8160	–	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R217/220.96-08 – Inch





- For insert selection and cutting data recommendations, see page(s) 106-108
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.96-01.50-20RE-08-3A	03212088	Combimaster	1.500	3	0.295	0.118	–	M20	1.398	1.575	0.660	20700	XNEX08..
R220.96-02.00-08-4A	02642870	Arbor	2.000	4	0.295	0.118	0.750	–	1.850	1.575	1.100	10600	XNEX08..
R220.96-02.00-08-5A	02642872	Arbor	2.000	5	0.295	0.118	0.750	–	1.850	1.575	1.100	10600	XNEX08..
R220.96-02.50-08-4A	02642873	Arbor	2.500	4	0.295	0.118	0.750	–	1.850	1.575	1.540	9400	XNEX08..
R220.96-02.50-08-6A	02642874	Arbor	2.500	6	0.295	0.118	0.750	–	1.850	1.575	1.320	9400	XNEX08..
R220.96-02.50-08-7A	02642878	Arbor	2.500	7	0.295	0.118	0.750	–	1.850	1.575	1.320	9400	XNEX08..
R220.96-03.00-08-5A	02642879	Arbor	3.000	5	0.295	0.118	1.000	–	2.441	1.969	2.870	8400	XNEX08..
R220.96-03.00-08-7A	02642881	Arbor	3.000	7	0.295	0.118	1.000	–	2.441	1.969	2.200	8400	XNEX08..
R220.96-03.00-08-9A	02642882	Arbor	3.000	9	0.295	0.118	1.000	–	2.441	1.969	1.980	8400	XNEX08..
R220.96-04.00-08-6A	02642884	Arbor	4.000	6	0.295	0.118	1.500	–	3.543	1.969	3.530	7500	XNEX08..
R220.96-04.00-08-8A	02642886	Arbor	4.000	8	0.295	0.118	1.500	–	3.543	1.969	3.970	7500	XNEX08..
R220.96-04.00-08-11A	02642887	Arbor	4.000	11	0.295	0.118	1.500	–	3.543	1.969	4.190	7500	XNEX08..
R220.96-05.00-08-7A	02642888	Arbor	5.000	7	0.295	0.118	1.500	–	3.543	2.480	7.280	6700	XNEX08..
R220.96-05.00-08-11A	02642889	Arbor	5.000	11	0.295	0.118	1.500	–	3.543	2.480	7.050	6700	XNEX08..
R220.96-06.00-08-12	02642891	Arbor	6.000	12	0.295	0.118	2.000	–	4.331	2.480	9.480	5900	XNEX08..

For Combimaster Shanks, see Machining Navigator Tooling System

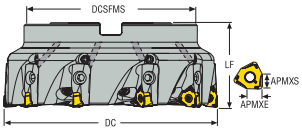
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.96-..	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.96-02.00-02.50	UC6S3/8UNFX1	C04011-T15P	T00-15P35	31.0IN.LBS
R220.96-03.00	UC6S1/2UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.96-04.00	UF6S3/4UNFX1-3/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.96-05.00-7A	UC6S3/4UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.96-05.00-06.00	–	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square 6™ – R220.96-08 – Metric

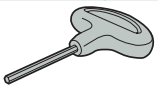


- For insert selection and cutting data recommendations, see page(s) 106-108
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm	mm	mm	mm	kg		
R220.96-8160-08-7C	02827066	Arbor	160,0	7	7,5	3,0	40,0	130,0	63,0	5,6	5900	XNEX08..
R220.96-8160-08-10C	02827062	Arbor	160,0	10	7,5	3,0	40,0	130,0	63,0	5,5	5900	XNEX08..
R220.96-8200-08-8C	02827067	Arbor	200,0	8	7,5	3,0	60,0	160,0	63,0	8,0	5300	XNEX08..
R220.96-8200-08-12C	02827063	Arbor	200,0	12	7,5	3,0	60,0	160,0	63,0	7,8	5300	XNEX08..
R220.96-8250-08-10C	02827068	Arbor	250,0	10	7,5	3,0	60,0	210,0	63,0	15,2	4200	XNEX08..

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Wedge clamp axial adj.	Wedge clamp radial adj.	Wedge screw	Allen key	Torque key	Torque value
									
R220.96-..	XN08PRN	FS96018	C04011-T15P	AU1114T-T15P	CW0810	LD8020-T25P	H05-4	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.96-08 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	XNEX080608TR-ME09 F40M	3,5 *0.14*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P2	XNEX080608TR-ME09 F40M	3,5 *0.14*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P3	XNEX080608TR-M13 MP2500	3,5 *0.14*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P4	XNEX080608TR-M13 MP2500	3,5 *0.14*	0,18 *0.0070*	0,19 *0.0075*	0,30 *0.012*
P5	XNEX080608TR-M13 MP2500	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
P6	XNEX080608TR-M13 MP2500	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
P7	XNEX080608TR-M13 MP2500	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
P8	XNEX080608TR-M13 MP2500	3,5 *0.14*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*
P11	XNEX080608TR-M13 T350M	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
P12	XNEX080608TR-M13 MP2500	3,0 *0.12*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
M1	XNEX080608R-M08 F40M	3,5 *0.14*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
M2	XNEX080608R-M08 F40M	3,5 *0.14*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M3	XNEX080608R-M08 F40M	3,0 *0.12*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
M4	XNEX080608R-M08 T350M	2,0 *0.080*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*
M5	XNEX080608R-M08 T350M	2,0 *0.080*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*
K1	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,19 *0.0075*	0,20 *0.0080*	0,32 *0.013*
K2	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K3	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K4	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K5	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K6	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K7	XNEX080608TR-M13 MK2050	3,5 *0.14*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
N1	XNEX080608R-M08 H25	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N2	XNEX080608R-M08 H25	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N3	XNEX080608R-M08 H25	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N11	XNEX080608R-M08 H25	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
S1	XNEX080608R-M08 T350M	2,0 *0.080*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*
S2	XNEX080608R-M08 T350M	2,0 *0.080*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*
S3	XNEX080608R-M08 T350M	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,11 *0.0044*
S11	XNEX080608R-M08 MS2050	2,5 *0.10*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S12	XNEX080608R-M08 MS2050	2,5 *0.10*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S13	XNEX080608R-M08 MS2050	2,0 *0.080*	0,080 *0.0032*	0,085 *0.0034*	0,12 *0.0048*
H5	XNEX080608TR-M13 MP3000	3,0 *0.12*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
H8	XNEX080608TR-M13 MP3000	2,5 *0.10*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
H11	XNEX080608TR-MD15 MP1500	3,0 *0.12*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
H12	XNEX080608TR-MD15 MP1500	2,5 *0.10*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.96-08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1500			MP2050			MP2500			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	345 *1125*	455 *1500*	530 *1750*	300 *980*	395 *1300*	475 *1550*	305 *1000*	405 *1325*	475 *1550*	290 *950*	385 *1275*	450 *1475*	185 *610*	250 *820*	290 *950*	— —	— —	— —
P2	335 *1100*	445 *1450*	520 *1700*	290 *950*	385 *1275*	460 *1500*	295 *970*	395 *1300*	460 *1500*	280 *920*	375 *1225*	435 *1425*	180 *590*	240 *790*	285 *940*	— —	— —	— —
P3	295 *970*	380 *1250*	460 *1500*	255 *840*	340 *1125*	400 *1300*	260 *850*	340 *1125*	405 *1325*	245 *800*	320 *1050*	385 *1275*	160 *520*	210 *690*	250 *820*	— —	— —	— —
P4	260 *850*	345 *1125*	405 *1325*	225 *740*	300 *980*	355 *1175*	230 *750*	305 *1000*	360 *1175*	220 *720*	290 *950*	340 *1125*	140 *460*	185 *610*	220 *720*	— —	— —	— —
P5	250 *820*	330 *1075*	385 *1275*	215 *710*	285 *940*	340 *1125*	220 *720*	290 *950*	340 *1125*	210 *690*	275 *900*	325 *1075*	135 *445*	180 *590*	210 *690*	— —	— —	— —
P6	280 *920*	370 *1225*	435 *1425*	245 *800*	325 *1075*	385 *1275*	245 *800*	325 *1075*	385 *1275*	235 *770*	310 *1025*	365 *1200*	150 *490*	200 *660*	235 *770*	— —	— —	— —
P7	265 *870*	345 *1125*	410 *1350*	230 *750*	310 *1025*	365 *1200*	235 *770*	310 *1025*	360 *1175*	220 *720*	290 *950*	345 *1125*	145 *475*	190 *620*	220 *720*	— —	— —	— —
P8	250 *820*	320 *1050*	385 *1275*	215 *710*	285 *940*	340 *1125*	220 *720*	285 *940*	340 *1125*	210 *690*	270 *890*	325 *1075*	135 *445*	175 *570*	210 *690*	— —	— —	— —
P11	255 *840*	340 *1125*	395 *1300*	220 *720*	300 *980*	355 *1175*	225 *740*	300 *980*	350 *1150*	215 *710*	285 *940*	335 *1100*	140 *460*	185 *610*	215 *710*	— —	— —	— —
P12	170 *560*	220 *720*	260 *850*	145 *475*	190 *620*	225 *740*	150 *490*	195 *640*	230 *750*	140 *460*	185 *610*	220 *720*	90 *295*	120 *395*	140 *460*	— —	— —	— —
M1	— —	— —	— —	210 *690*	275 *900*	330 *1075*	215 *710*	285 *940*	330 *1075*	210 *690*	280 *920*	325 *1075*	155 *510*	205 *670*	245 *800*	— —	— —	— —
M2	— —	— —	— —	175 *570*	230 *750*	270 *890*	175 *570*	235 *770*	275 *900*	175 *570*	230 *750*	270 *890*	130 *425*	170 *560*	200 *660*	— —	— —	— —
M3	— —	— —	— —	140 *460*	185 *610*	220 *720*	145 *475*	190 *620*	220 *720*	140 *460*	190 *620*	220 *720*	105 *345*	140 *460*	160 *520*	— —	— —	— —
M4	— —	— —	— —	110 *360*	145 *475*	170 *560*	110 *360*	145 *475*	170 *560*	110 *360*	145 *475*	170 *560*	80 *260*	105 *345*	125 *410*	— —	— —	— —
M5	— —	— —	— —	90 *295*	120 *395*	140 *460*	90 *295*	120 *395*	145 *475*	90 *295*	120 *395*	140 *460*	70 *230*	90 *295*	105 *345*	— —	— —	— —
K1	265 *870*	350 *1150*	410 *1350*	230 *750*	305 *1000*	365 *1200*	235 *770*	310 *1025*	365 *1200*	— —	— —	— —	— —	— —	— —	290 *950*	385 *1275*	450 *1475*
K2	235 *770*	310 *1025*	365 *1200*	205 *670*	270 *890*	320 *1050*	210 *690*	275 *900*	325 *1075*	— —	— —	— —	— —	— —	— —	260 *850*	340 *1125*	405 *1325*
K3	200 *660*	265 *870*	310 *1025*	175 *570*	230 *750*	270 *890*	175 *570*	235 *770*	275 *900*	— —	— —	— —	— —	— —	— —	220 *720*	285 *940*	345 *1125*
K4	190 *620*	250 *820*	295 *970*	165 *540*	220 *720*	260 *850*	170 *560*	225 *740*	260 *850*	— —	— —	— —	— —	— —	— —	210 *690*	275 *900*	325 *1075*
K5	115 *375*	155 *510*	180 *590*	100 *330*	135 *445*	160 *520*	105 *345*	135 *445*	160 *520*	— —	— —	— —	— —	— —	— —	125 *410*	170 *560*	200 *660*
K6	165 *540*	220 *720*	260 *850*	145 *475*	195 *640*	230 *750*	150 *490*	195 *640*	230 *750*	— —	— —	— —	— —	— —	— —	185 *610*	240 *790*	290 *950*
K7	150 *490*	195 *640*	230 *750*	130 *425*	175 *570*	205 *670*	130 *425*	175 *570*	205 *670*	— —	— —	— —	— —	— —	— —	160 *520*	215 *710*	255 *840*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	55 *180*	70 *230*	85 *280*	— —	— —	— —	50 *165*	65 *215*	80 *260*	25 *80*	33 *110*	38 *125*	— —	— —	— —
S2	— —	— —	— —	43 *140*	55 *180*	65 *215*	— —	— —	— —	41 *135*	55 *180*	65 *215*	20 *65*	26 *85*	31 *100*	— —	— —	— —
S3	— —	— —	— —	38 *125*	50 *165*	60 *195*	— —	— —	— —	36 *120*	48 *155*	55 *180*	18 *60*	23 *75*	27 *90*	— —	— —	— —
S11	— —	— —	— —	75 *245*	100 *330*	115 *375*	— —	— —	— —	70 *230*	95 *310*	110 *360*	35 *115*	45 *150*	55 *180*	— —	— —	— —
S12	— —	— —	— —	50 *165*	70 *230*	80 *260*	— —	— —	— —	49 *160*	65 *215*	75 *245*	32 *105*	42 *140*	50 *165*	— —	— —	— —
S13	— —	— —	— —	30 *100*	39 *130*	47 *155*	— —	— —	— —	29 *95*	38 *125*	44 *145*	19 *60*	25 *80*	29 *95*	— —	— —	— —
H5	55 *180*	75 *245*	85 *280*	43 *140*	55 *180*	70 *230*	— —	— —	— —	44 *145*	55 *180*	70 *230*	— —	— —	— —	— —	— —	— —
H8	60 *195*	75 *245*	90 *295*	47 *155*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	70 *230*	90 *295*	110 *360*	55 *180*	75 *245*	85 *280*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	105 *345*	140 *460*	165 *540*	95 *310*	120 *395*	140 *460*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

R217/220.96-08 – Cutting data v_c = (m/min)/*(sf/min)*

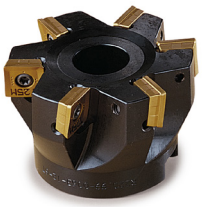
SMG	MK2050			MS2050			MS2500			T350M			F40M			H25		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	260 *850*	350 *1150*	415 *1350*	255 *840*	335 *1100*	400 *1300*	335 *1100*	440 *1450*	530 *1750*	265 *870*	350 *1150*	415 *1350*	230 *750*	305 *1000*	360 *1175*	— —	— —	— —
P2	255 *840*	340 *1125*	395 *1300*	250 *820*	330 *1075*	390 *1275*	325 *1075*	430 *1400*	510 *1675*	260 *850*	345 *1125*	400 *1300*	225 *740*	300 *980*	350 *1150*	— —	— —	— —
P3	220 *720*	290 *950*	345 *1125*	220 *720*	290 *950*	340 *1125*	285 *940*	375 *1225*	445 *1450*	230 *750*	295 *970*	355 *1175*	200 *660*	255 *840*	310 *1025*	— —	— —	— —
P4	195 *640*	260 *850*	305 *1000*	190 *620*	255 *840*	300 *980*	250 *820*	330 *1075*	395 *1300*	200 *660*	265 *870*	310 *1025*	175 *570*	230 *750*	270 *890*	— —	— —	— —
P5	190 *620*	250 *820*	295 *970*	185 *610*	240 *790*	285 *940*	240 *790*	315 *1025*	375 *1225*	190 *620*	255 *840*	300 *980*	165 *540*	220 *720*	260 *850*	— —	— —	— —
P6	210 *690*	280 *920*	335 *1100*	205 *670*	280 *920*	325 *1075*	270 *890*	365 *1200*	425 *1400*	215 *710*	285 *940*	335 *1100*	185 *610*	245 *800*	290 *950*	— —	— —	— —
P7	200 *660*	265 *870*	315 *1025*	195 *640*	260 *850*	310 *1025*	255 *840*	345 *1125*	405 *1325*	205 *670*	270 *890*	315 *1025*	175 *570*	235 *770*	275 *900*	— —	— —	— —
P8	185 *610*	245 *800*	290 *950*	185 *610*	240 *790*	285 *940*	240 *790*	315 *1025*	375 *1225*	190 *620*	250 *820*	300 *980*	165 *540*	215 *710*	260 *850*	— —	— —	— —
P11	195 *640*	255 *840*	305 *1000*	190 *620*	255 *840*	300 *980*	245 *800*	335 *1100*	390 *1275*	195 *640*	260 *850*	305 *1000*	170 *560*	225 *740*	265 *870*	— —	— —	— —
P12	125 *410*	170 *560*	200 *660*	125 *410*	160 *520*	190 *620*	160 *520*	215 *710*	250 *820*	130 *425*	170 *560*	200 *660*	110 *360*	145 *475*	175 *570*	— —	— —	— —
M1	— —	— —	— —	200 *660*	265 *870*	315 *1025*	230 *750*	305 *1000*	365 *1200*	200 *660*	265 *870*	310 *1025*	180 *590*	240 *790*	280 *920*	— —	— —	— —
M2	— —	— —	— —	165 *540*	220 *720*	260 *850*	190 *620*	255 *840*	300 *980*	165 *540*	220 *720*	255 *840*	150 *490*	200 *660*	235 *770*	— —	— —	— —
M3	— —	— —	— —	135 *445*	175 *570*	210 *690*	155 *510*	205 *670*	245 *800*	135 *445*	180 *590*	205 *670*	120 *395*	160 *520*	190 *620*	— —	— —	— —
M4	— —	— —	— —	105 *345*	135 *445*	160 *520*	120 *395*	160 *520*	190 *620*	105 *345*	135 *445*	160 *520*	95 *310*	125 *410*	145 *475*	— —	— —	— —
M5	— —	— —	— —	85 *280*	115 *375*	135 *445*	100 *330*	135 *445*	155 *510*	85 *280*	115 *375*	135 *445*	80 *260*	105 *345*	120 *395*	— —	— —	— —
K1	275 *900*	365 *1200*	425 *1400*	— —	— —	— —	— —	— —	— —	— —	— —	— —	180 *590*	235 *770*	275 *900*	— —	— —	— —
K2	245 *800*	320 *1050*	385 *1275*	— —	— —	— —	— —	— —	— —	— —	— —	— —	160 *520*	210 *690*	245 *800*	— —	— —	— —
K3	205 *670*	270 *890*	325 *1075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	135 *445*	175 *570*	210 *690*	— —	— —	— —
K4	195 *640*	260 *850*	310 *1025*	— —	— —	— —	— —	— —	— —	— —	— —	— —	130 *425*	170 *560*	200 *660*	— —	— —	— —
K5	120 *395*	160 *520*	190 *620*	— —	— —	— —	— —	— —	— —	— —	— —	— —	80 *260*	105 *345*	120 *395*	— —	— —	— —
K6	175 *570*	230 *750*	275 *900*	— —	— —	— —	— —	— —	— —	— —	— —	— —	110 *360*	150 *490*	175 *570*	— —	— —	— —
K7	155 *510*	205 *670*	240 *790*	— —	— —	— —	— —	— —	— —	— —	— —	— —	100 *330*	130 *425*	155 *510*	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1300 *4275*	1750 *5750*	2050 *6725*	1250 *4100*	1675 *5500*	1975 *6475*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	530 *1750*	700 *2300*	830 *2725*	510 *1675*	680 *2225*	790 *2600*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	350 *1150*	470 *1550*	550 *1800*	340 *1125*	450 *1475*	530 *1750*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	400 *1300*	540 *1775*	630 *2075*	390 *1275*	520 *1700*	610 *2000*
S1	— —	— —	— —	49 *160*	65 *215*	75 *245*	60 *195*	80 *260*	90 *295*	48 *155*	65 *215*	75 *245*	44 *145*	60 *195*	70 *230*	— —	— —	— —
S2	— —	— —	— —	39 *130*	50 *165*	60 *195*	48 *155*	65 *215*	75 *245*	39 *130*	50 *165*	60 *195*	35 *115*	47 *155*	55 *180*	— —	— —	— —
S3	— —	— —	— —	34 *110*	46 *150*	55 *180*	42 *140*	55 *180*	65 *215*	34 *110*	45 *150*	55 *180*	31 *100*	41 *135*	48 *155*	— —	— —	— —
S11	— —	— —	— —	70 *230*	90 *295*	105 *345*	85 *280*	110 *360*	130 *425*	65 *215*	90 *295*	105 *345*	60 *195*	80 *260*	95 *310*	— —	— —	— —
S12	— —	— —	— —	47 *155*	60 *195*	75 *245*	60 *195*	75 *245*	90 *295*	47 *155*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*	— —	— —	— —
S13	— —	— —	— —	27 *90*	36 *120*	43 *140*	33 *110*	44 *145*	50 *165*	27 *90*	36 *120*	42 *140*	25 *80*	33 *110*	38 *125*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	43 *140*	55 *180*	65 *215*	37 *120*	49 *160*	60 *195*	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	45 *150*	60 *195*	70 *230*	39 *130*	50 *165*	60 *195*	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	70 *230*	85 *280*	48 *155*	60 *195*	75 *245*	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	80 *260*	105 *345*	125 *410*	70 *230*	95 *310*	110 *360*	— —	— —	— —

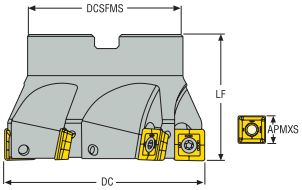
MINI AND MIDI SQUARE

The Mini and Midi Square family includes universal cutters for slotting, contouring and face milling operations in ordinary steel, easier stainless steels and cast iron.

- Square inserts that provide four usable edges, available in 12 and 15 insert size
- A special design on the square inserts enables a 90-degree setting angle
- Fixed pockets and include normal and close pitch versions

Mini-Midi Square – R220.99-09/12 – Metric



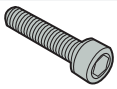


- For insert selection and cutting data recommendations, see page(s) 111-112
- For complete insert programme, see page(s) 768
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm	mm	mm	mm		kg	
R220.99-0040-09-4T	75069190	Arbor	40,0	4	8,0	1,7	35,0	40,0	16600	0,2	SONX09
R220.99-0050-09-6T	00023549	Arbor	50,0	6	8,0	1,7	47,0	40,0	14800	0,3	SONX09
R220.99-0063-09-7T	00023550	Arbor	63,0	7	8,0	1,7	47,0	40,0	13200	0,5	SONX09
R220.99-0050-12-4	00005593	Arbor	50,0	4	11,0	2,4	47,0	40,0	10800	0,3	SONX12
R220.99-0050-12-5T	00005594	Arbor	50,0	5	11,0	2,4	42,0	40,0	10800	0,3	SONX12
R220.99-0063-12-6T	00005598	Arbor	63,0	6	11,0	2,4	47,0	40,0	9600	0,5	SONX12
R220.99-0080-12-6	00005602	Arbor	80,0	6	11,0	2,4	62,0	50,0	8400	1,1	SONX12
R220.99-0100-12-8	00005604	Arbor	100,0	8	11,0	2,4	77,0	50,0	7600	1,5	SONX12

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.99-0040	MC6S8X30	C03006-T09P	T00-09P20	2.0NM
R220.99-0050-0063-09	220.17-692	C03006-T09P	T00-09P20	2.0NM
R220.99-0050-0063-12	220.17-692	C04011-T15P	T00-15P35	3.5NM
R220.99-0080	MC6S12X40	C04011-T15P	T00-15P35	3.5NM
R220.99-0100	–	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.99-09 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	SONX09T308TR-M10 F40M	4,0 *0.16*	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P2	SONX09T308TR-M10 F40M	4,0 *0.16*	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
P3	SONX09T308TR-M10 MP2501	4,0 *0.16*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
P4	SONX09T308TR-M10 MP2501	4,0 *0.16*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
P5	SONX09T308TR-M10 MP2501	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P6	SONX09T308TR-M10 MP2501	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P7	SONX09T308TR-M10 MP2501	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P8	SONX09T308TR-M10 MP2501	4,0 *0.16*	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
P11	SONX09T304TR-M10 T350M	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P12	SONX09T308TR-M10 MP2501	3,0 *0.12*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M1	SONX09T304TR-ME06 F40M	4,0 *0.16*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
M2	SONX09T304TR-ME06 F40M	4,0 *0.16*	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M3	SONX09T304TR-ME06 F40M	3,0 *0.12*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*
M4	SONX09T304TR-M10 F40M	2,5 *0.10*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M5	SONX09T304TR-M10 F40M	2,5 *0.10*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
K1	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K2	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K3	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K4	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K5	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K6	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K7	SONX09T308TR-M10 MK2050	4,0 *0.16*	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
N1	SONX09T304TR-ME06 F40M	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N2	SONX09T304TR-ME06 F40M	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N3	SONX09T304TR-ME06 F40M	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N11	SONX09T304TR-ME06 F40M	4,0 *0.16*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
S1	SONX09T304TR-M10 T350M	2,5 *0.10*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S2	SONX09T304TR-M10 T350M	2,5 *0.10*	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S3	SONX09T304TR-M10 T350M	2,5 *0.10*	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S11	SONX09T304TR-M10 T350M	2,5 *0.10*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*
S12	SONX09T304TR-ME06 F40M	2,5 *0.10*	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.99-09 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			MK1500			MK2050			T350M			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	300 *980*	390 *1275*	460 *1500*	— —	— —	— —	295 *970*	385 *1275*	450 *1475*	255 *840*	340 *1125*	395 *1300*	225 *740*	295 *970*	345 *1125*
P2	285 *940*	380 *1250*	445 *1450*	— —	— —	— —	280 *920*	370 *1225*	440 *1450*	245 *800*	325 *1075*	385 *1275*	215 *710*	285 *940*	340 *1125*
P3	250 *820*	330 *1075*	395 *1300*	— —	— —	— —	245 *800*	325 *1075*	385 *1275*	215 *710*	285 *940*	340 *1125*	190 *620*	250 *820*	300 *980*
P4	220 *720*	290 *950*	345 *1125*	— —	— —	— —	215 *710*	285 *940*	340 *1125*	190 *620*	250 *820*	295 *970*	165 *540*	220 *720*	260 *850*
P5	215 *710*	285 *940*	330 *1075*	— —	— —	— —	210 *690*	280 *920*	325 *1075*	185 *610*	240 *790*	285 *940*	160 *520*	215 *710*	250 *820*
P6	240 *790*	320 *1050*	370 *1225*	— —	— —	— —	235 *770*	315 *1025*	365 *1200*	205 *670*	270 *890*	320 *1050*	180 *590*	240 *790*	280 *920*
P7	225 *740*	300 *980*	350 *1150*	— —	— —	— —	225 *740*	295 *970*	345 *1125*	195 *640*	255 *840*	300 *980*	170 *560*	230 *750*	265 *870*
P8	210 *690*	280 *920*	330 *1075*	— —	— —	— —	205 *670*	275 *900*	325 *1075*	180 *590*	240 *790*	285 *940*	160 *520*	210 *690*	250 *820*
P11	220 *720*	290 *950*	340 *1125*	— —	— —	— —	215 *710*	290 *950*	335 *1100*	190 *620*	250 *820*	290 *950*	165 *540*	220 *720*	260 *850*
P12	145 *475*	190 *620*	220 *720*	— —	— —	— —	145 *475*	185 *610*	220 *720*	125 *410*	165 *540*	190 *620*	110 *360*	145 *475*	165 *540*
M1	205 *670*	270 *890*	320 *1050*	— —	— —	— —	— —	— —	— —	190 *620*	250 *820*	295 *970*	175 *570*	230 *750*	270 *890*
M2	170 *560*	230 *750*	265 *870*	— —	— —	— —	— —	— —	— —	155 *510*	210 *690*	245 *800*	145 *475*	195 *640*	225 *740*
M3	140 *460*	185 *610*	215 *710*	— —	— —	— —	— —	— —	— —	130 *425*	170 *560*	200 *660*	120 *395*	155 *510*	180 *590*
M4	110 *360*	145 *475*	165 *540*	— —	— —	— —	— —	— —	— —	100 *330*	130 *425*	155 *510*	95 *310*	125 *410*	140 *460*
M5	90 *295*	120 *395*	140 *460*	— —	— —	— —	— —	— —	— —	85 *280*	110 *360*	130 *425*	80 *260*	105 *345*	120 *395*
K1	225 *740*	300 *980*	355 *1175*	320 *1050*	425 *1400*	500 *1650*	300 *980*	400 *1300*	475 *1550*	195 *640*	255 *840*	305 *1000*	170 *560*	225 *740*	270 *890*
K2	205 *670*	270 *890*	315 *1025*	290 *950*	380 *1250*	445 *1450*	275 *900*	360 *1175*	420 *1375*	175 *570*	230 *750*	270 *890*	155 *510*	205 *670*	240 *790*
K3	170 *560*	230 *750*	265 *870*	245 *800*	325 *1075*	375 *1225*	230 *750*	305 *1000*	355 *1175*	145 *475*	195 *640*	230 *750*	130 *425*	175 *570*	200 *660*
K4	165 *540*	220 *720*	255 *840*	235 *770*	310 *1025*	360 *1175*	220 *720*	290 *950*	340 *1125*	140 *460*	185 *610*	220 *720*	125 *410*	165 *540*	190 *620*
K5	100 *330*	130 *425*	155 *510*	140 *460*	185 *610*	220 *720*	135 *445*	175 *570*	205 *670*	85 *280*	115 *375*	135 *445*	75 *245*	100 *330*	115 *375*
K6	145 *475*	190 *620*	225 *740*	205 *670*	270 *890*	315 *1025*	195 *640*	255 *840*	300 *980*	125 *410*	165 *540*	190 *620*	110 *360*	145 *475*	170 *560*
K7	130 *425*	170 *560*	200 *660*	180 *590*	240 *790*	280 *920*	170 *560*	225 *740*	265 *870*	110 *360*	145 *475*	170 *560*	95 *310*	130 *425*	150 *490*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1250 *4100*	1675 *5500*	2000 *6550*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	510 *1675*	680 *2225*	800 *2625*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	340 *1125*	455 *1500*	540 *1775*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	385 *1275*	520 *1700*	610 *2000*
S1	— —	— —	— —	— —	— —	— —	— —	— —	— —	47 *155*	60 *195*	70 *230*	43 *140*	60 *195*	65 *215*
S2	— —	— —	— —	— —	— —	— —	— —	— —	— —	38 *125*	50 *165*	60 *195*	35 *115*	47 *155*	55 *180*
S3	— —	— —	— —	— —	— —	— —	— —	— —	— —	33 *110*	43 *140*	50 *165*	31 *100*	41 *135*	47 *155*
S11	— —	— —	— —	— —	— —	— —	— —	— —	— —	65 *215*	85 *280*	100 *330*	60 *195*	80 *260*	90 *295*
S12	— —	— —	— —	— —	— —	— —	— —	— —	— —	45 *150*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*

R217/220.99-12 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	30%	10%
P1	SONX120508TR-ME08 F40M	5,0 *0.20*	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P2	SONX120508TR-ME08 F40M	5,0 *0.20*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
P3	SONX120508TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P4	SONX120508TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,18 *0.0070*	0,26 *0.010*
P5	SONX120508TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P6	SONX120508TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P7	SONX120508TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P8	SONX120508TR-M12 MP2501	5,0 *0.20*	0,16 *0.0065*	0,18 *0.0070*	0,28 *0.011*
P11	SONX120508TR-M12 T350M	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
P12	SONX120508TR-M12 MP2501	4,5 *0.18*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M1	SONX120508TR-ME08 F40M	5,0 *0.20*	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
M2	SONX120508TR-ME08 F40M	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,17 *0.0065*
M3	SONX120508TR-M12 F40M	4,5 *0.18*	0,13 *0.0050*	0,14 *0.0055*	0,20 *0.0080*
M4	SONX120508TR-M12 F40M	3,0 *0.12*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M5	SONX120508TR-M12 F40M	3,0 *0.12*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K1	SONX120508TR-M12 MK2050	5,0 *0.20*	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K2	SONX120508TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K3	SONX120508TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K4	SONX120508TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K5	SONX120508TR-M12 MK2050	5,0 *0.20*	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
K6	SONX120508TR-M12 MK2050	5,0 *0.20*	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K7	SONX120508TR-M12 MK2050	5,0 *0.20*	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
N1	SONX120508TR-ME08 F40M	5,0 *0.20*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N2	SONX120508TR-ME08 F40M	5,0 *0.20*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N3	SONX120508TR-ME08 F40M	5,0 *0.20*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
N11	SONX120508TR-ME08 F40M	5,0 *0.20*	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
S1	SONX120508TR-M12 T350M	3,0 *0.12*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
S2	SONX120508TR-M12 T350M	3,0 *0.12*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
S3	SONX120508TR-M12 T350M	3,0 *0.12*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
S11	SONX120508TR-M12 T350M	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,20 *0.0080*
S12	SONX120508TR-ME08 F40M	4,0 *0.16*	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.99-12 – Cutting data v_c = (m/min)/*(sf/min)*

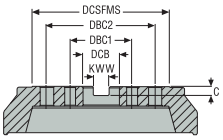
SMG	MP1501			MP2501			MK1500			MK2050			T350M			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	315	415	490	280	365	435	—	—	—	275	360	430	245	320	380	210	275	330
	1025	*1350*	*1600*	*920*	*1200*	*1425*	—	—	—	*900*	*1175*	*1400*	*800*	*1050*	*1250*	*690*	*900*	*1075*
P2	305	400	480	270	355	425	—	—	—	265	350	415	235	310	370	205	270	320
	1000	*1300*	*1575*	*890*	*1175*	*1400*	—	—	—	*870*	*1150*	*1350*	*770*	*1025*	*1225*	*670*	*890*	*1050*
P3	270	350	410	240	310	365	—	—	—	235	305	360	205	270	320	180	235	275
	890	*1150*	*1350*	*790*	*1025*	*1200*	—	—	—	*770*	*1000*	*1175*	*670*	*890*	*1050*	*590*	*770*	*900*
P4	235	310	370	210	275	330	—	—	—	205	270	325	180	240	285	160	210	250
	770	*1025*	*1225*	*690*	*900*	*1075*	—	—	—	*670*	*890*	*1075*	*590*	*790*	*940*	*520*	*690*	*820*
P5	225	300	355	200	265	315	—	—	—	195	260	310	175	230	275	150	200	235
	740	*980*	*1175*	*660*	*870*	*1025*	—	—	—	*640*	*850*	*1025*	*570*	*750*	*900*	*490*	*660*	*770*
P6	255	335	395	225	300	350	—	—	—	220	295	345	195	260	305	170	225	265
	840	*1100*	*1300*	*740*	*980*	*1150*	—	—	—	*720*	*970*	*1125*	*640*	*850*	*1000*	*560*	*740*	*870*
P7	240	320	375	210	280	330	—	—	—	210	280	325	185	245	290	160	215	250
	790	*1050*	*1225*	*690*	*920*	*1075*	—	—	—	*690*	*920*	*1075*	*610*	*800*	*950*	*520*	*710*	*820*
P8	225	295	345	200	260	305	—	—	—	195	260	300	175	230	265	150	200	230
	740	*970*	*1125*	*660*	*850*	*1000*	—	—	—	*640*	*850*	*980*	*570*	*750*	*870*	*490*	*660*	*750*
P11	230	310	365	205	275	320	—	—	—	205	270	315	180	240	280	155	205	245
	750	*1025*	*1200*	*670*	*900*	*1050*	—	—	—	*670*	*890*	*1025*	*590*	*790*	*920*	*510*	*670*	*800*
P12	155	200	235	135	180	210	—	—	—	135	175	205	120	155	185	105	135	160
	510	*660*	*770*	*445*	*590*	*690*	—	—	—	*445*	*570*	*670*	*395*	*510*	*610*	*345*	*445*	*520*
M1	—	—	—	195	255	305	—	—	—	—	—	—	180	240	285	165	215	260
	—	—	—	*640*	*840*	*1000*	—	—	—	—	—	—	*590*	*790*	*940*	*540*	*710*	*850*
M2	—	—	—	160	215	250	—	—	—	—	—	—	150	200	235	135	180	215
	—	—	—	*520*	*710*	*820*	—	—	—	—	—	—	*490*	*660*	*770*	*445*	*590*	*710*
M3	—	—	—	130	175	205	—	—	—	—	—	—	120	160	190	110	145	175
	—	—	—	*425*	*570*	*670*	—	—	—	—	—	—	*395*	*520*	*620*	*360*	*475*	*570*
M4	—	—	—	105	135	160	—	—	—	—	—	—	100	130	150	90	115	135
	—	—	—	*345*	*445*	*520*	—	—	—	—	—	—	*330*	*425*	*490*	*295*	*375*	*445*
M5	—	—	—	85	115	130	—	—	—	—	—	—	80	105	125	75	95	110
	—	—	—	*280*	*375*	*425*	—	—	—	—	—	—	*260*	*345*	*410*	*245*	*310*	*360*
K1	245	320	380	215	280	335	305	400	475	290	380	450	185	245	295	165	215	255
	800	*1050*	*1250*	*710*	*920*	*1100*	*1000*	*1300*	*1550*	*950*	*1250*	*1475*	*610*	*800*	*970*	*540*	*710*	*840*
K2	215	285	335	190	250	295	270	360	420	255	340	400	165	220	260	145	190	225
	710	*940*	*1100*	*620*	*820*	*970*	*890*	*1175*	*1375*	*840*	*1125*	*1300*	*540*	*720*	*850*	*475*	*620*	*740*
K3	180	240	285	160	215	250	225	305	355	215	285	335	140	185	220	120	160	190
	590	*790*	*940*	*520*	*710*	*820*	*740*	*1000*	*1175*	*710*	*940*	*1100*	*460*	*610*	*720*	*395*	*520*	*620*
K4	175	230	270	155	205	240	215	290	340	205	275	320	135	180	210	115	155	180
	570	*750*	*890*	*510*	*670*	*790*	*710*	*950*	*1125*	*670*	*900*	*1050*	*445*	*590*	*690*	*375*	*510*	*590*
K5	105	140	165	95	125	145	135	180	205	125	170	195	85	110	125	70	95	110
	345	*460*	*540*	*310*	*410*	*475*	*445*	*590*	*670*	*410*	*560*	*640*	*280*	*360*	*410*	*230*	*310*	*360*
K6	150	205	240	135	180	210	190	255	300	180	240	285	120	155	185	100	135	160
	490	*670*	*790*	*445*	*590*	*690*	*620*	*840*	*980*	*590*	*790*	*940*	*395*	*510*	*610*	*330*	*445*	*520*
K7	135	180	210	120	160	185	170	230	265	165	215	250	105	140	165	90	120	140
	445	*590*	*690*	*395*	*520*	*610*	*560*	*750*	*870*	*540*	*710*	*820*	*345*	*460*	*540*	*295*	*395*	*460*
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1200	1575	1875
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*3925*	*5175*	*6150*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	480	640	750
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1575*	*2100*	*2450*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	320	425	500
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1050*	*1400*	*1650*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	365	485	570
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1200*	*1600*	*1875*
S1	—	—	—	—	—	—	—	—	—	—	—	—	46	60	70	41	55	65
	—	—	—	—	—	—	—	—	—	—	—	—	*150*	*195*	*230*	*135*	*180*	*215*
S2	—	—	—	—	—	—	—	—	—	—	—	—	37	48	55	33	44	50
	—	—	—	—	—	—	—	—	—	—	—	—	*120*	*155*	*180*	*110*	*145*	*165*
S3	—	—	—	—	—	—	—	—	—	—	—	—	32	42	49	29	39	44
	—	—	—	—	—	—	—	—	—	—	—	—	*105*	*140*	*160*	*95*	*130*	*145*
S11	—	—	—	—	—	—	—	—	—	—	—	—	60	80	95	55	75	90
	—	—	—	—	—	—	—	—	—	—	—	—	*195*	*260*	*310*	*180*	*245*	*295*
S12	—	—	—	—	—	—	—	—	—	—	—	—	43	55	65	39	50	60
	—	—	—	—	—	—	—	—	—	—	—	—	*140*	*180*	*215*	*130*	*165*	*195*

Code keys metric and *inch*

R	217	.	69	-	25	32	.	3S	-	042	-	10	.	4	A
1	2		3		4	5		6		7		8		9	10

R	217	.	69	-	01.50	-	3	-	01.34	-	10	-	4	A
1	2		3		5		6		7		8		9	10

1.	2.	3.
Right hand rotation Cx = For Seco-Capto	215/217=With shank 220 = For Arbor 235 = Finishing	69 = Rectangular positive 2 cutting edges 94 = Tangential 4 cutting edges 59 = Square positive 4 cutting edges 15 = Finishing
4. (Not applicable for inch designation)	**5.**	**6.**
Shank diameter (except for Arbor type)	Cutter diameter	Shank type (except for Arbor type) 0 = Cylindrical 3 = Weldon 3S = Seco Weldon RE = Combimaster
7.	**8.**	**9.**
Max. axial cutting depht	Insert size xxS = short edge xxM = Medium edge xxL = Long edge xxH = Heavy duty	Effective No. of flutes (ZEFP)
10.		
A = With through coolant supply N = Coated S = Set H = Heavy Duty K = Full effective (for .59 only) R6 = Compatible with radius 6.3 mm (for .59 only)		



Dimensions in mm					
DCB	DCSFMS	DBC1	DBC2	KWW	C
16	30-35	–	–	8,4	5,6
22	42-47	–	–	10,4	6.3
27	48-62	–	–	12,4	7
32	60-90	–	–	14,4	8
40	90-130	66,7	–	16,4	9
60	130-270	101,6	177,8	25,7	14

Dimensions in inch					
DCB	DCSFMS	DBC1	DBC2	KWW	C
0.500	*1.181 - 1.378*			*0.258*	*0.165*
0.750	*1.378 - 1.850*	–	–	*0.321*	*0.193*
1.000	*1.803 - 2.441*	–	–	*0.382*	*0.224*
1.250	*2.250 - 3.031*	–	–	*0.508*	*0.287*
1.500	*2.750 - 3.543*	–	–	*0.630*	*0.382*
2.000	*4.331*	–	–	*0.756*	*0.445*
2.500	*5.118 - 6.299 (8.858)*	*4.000*	*(7.000)*	*1.000*	*0.551*

Selection – Metric

Cutter	Insert	Material suitability					Corner radius (mm)					
		P	M	K	N	S						
Turbo	XO..06	■	■	■	■	■	0,2/0,4/0,8/1,6	■	□	■	■	◪
	XO..10	■	■	■	■	■	0,2/0,4/0,8/1,2/ 1,6/2,0/2,4/3,1	■	◪	■	■	◪
	XO..12	■	■	■	■	■	0,2/0,4/0,8/1,2/ 1,6/2,0/2,4/3,1/ 4,0/5,0/6,3	◪	■	■	■	◪
	XO..18	■	■	■	■	■	0,4/0,8/1,2/1,6/2,0/ 2,4/3,1/4,0/5,0/6,3	□	■	■	■	◪
Helical T4	LO..08	■	□	■	–	◪	0,4/0,8/1,2/1,6	◪	◪	◪	–	□
	LO..12	■	◪	■	◪	◪	0,4/0,8/1,2/1,6/2,0/ 2,4/3,1/4,0/5,0/6,3	◪	◪	◪	–	□
R215/220.59 / R215/220.59K	AC15 SC12	◪	◪	◪	□	□	1,2/3,0/3,1/6,0	_	■	□	_	□
220.69-15	AC15	◪	◪	◪	□	□	1,2/3,0/3,1/6,0	_	■	□	_	□
Helical solution for side-finishing operation (small radial engagement)												
235.15	-	■	■	■	-	■	Chamfer	■	■	◪	-	-

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Metric

Cutter	No. of cutting edges	Application	Cutter diameter (mm)/available depth of cut and number of teeth															See page
			12	14	16	20	25	32	40	44	50	54	63	66	80	100	125	
Turbo 06	2		10 (2)	15 (2)	20 (2)	20 (3) / 25 (3)												121
					15 (3)													
Turbo 10	2					25 (1)	25 (2)	25 (3)	34 (4)		42 (5)							126
						17 (2)	17 (3) / 25 (3) / 34 (3) / 42 (2)	34 (4) / 42 (4) / 50 (3)	34 (5) / 58 (4)	58 (5)	42 (6)							
Turbo 12	2						22 (2) / 33 (2)	33 (2)	33 (3) / 55 (3)	33 (3)	33 (4) / 44 (4) / 55 (4) / 66 (4)	44 (4)	33 (5) / 55 (5)	44 (5)				132
								22 (3) / 33 (3) / 44 (3) / 55 (3)	44 (4) / 65.5 (3)		44 (5) / 86 (5) / 106 (5)		77 (4) / 107 (5)		64 (6)			
Turbo 18	2								47 (2)		47 (3) / 62 (3)	47 (3)	47 (4) / 62 (3)	47 (4)	47 (5) / 62 (5)	62 (6)		140
													62 (4) / 77 (4)		77 (4) / 93 (5)	77 (5)		
Helical T4 08	4						29 (2) / 36 (2)	36 (3)	36 (3)		43 (4)							148
							43 (2)	43 (3) / 50 (3)	43 (4) / 50 (4)	57 (4)	57 (5)	64 (5)						
Helical T4 12	4								35 (2)	35 (3)	35 (3) / 46 (3)		46 (4)					153
										58 (3)	46 (4) / 58 (4) / 81 (4)	69 (4)	58 (5) / 81 (4) / 92 (4)	81 (5)	69 (5) / 104 (5)	81 (6)		
215/220.59	2 & 4 half effective										50 (2) / 59 (2)		59 (2)		68 (2/3)	77 (3/4)		163
											77 (2) / 120 (2)		86 (2) / 120 (2) / 160 (2)		95 (2/3)			163
215/220.59K	2 & 4 full effective										63 (3) / 72 (3)		72 (4) / 110 (3)		72 (5)			163
220.69-15	2												38 (4)		38 (5) / 50 (5)	50 (6)	50 (7)	171
235.15	1							40 (2)			50 (3)				90 (3)			176

x(y)	Slotting and contouring operations : x indicates the maximum depth of cut (y indicates the number of teeth)
x(y)	For contouring operations only : x indicates the maximum depth of cut (y indicates the number of teeth)

Slotting and contouring

Contouring only

Selection – Inch

Cutter	Insert	Material suitability					Corner radius (inch)					
		P	M	K	N	S						
Turbo	XO..06	■	■	■	■	■	.007/.016 .031/.063	■	□	■	■	◪
	XO..10	■	■	■	■	■	.007/.016/.031 .047/.063 .079/.094 .122	■	◪	■	■	◪
	XO..12	■	■	■	■	■	.007/.016/.031 .047/.063 .079/.094 .122/.157 .197/.248	◪	■	■	■	◪
	XO..18	■	■	■	■	■	.016/.031 .047/.063 .079/.094 .122/.157 .197/.248	□	■	■	■	◪
Helical T4	LO..08	■	□	■	–	◪	.016/.031 .047/.063	◪	◪	◪	–	□
	LO..12	■	◪	■	◪	◪	.016/.031 .047/.063 .079/.094 .122/.157 .197/.248	◪	◪	◪	–	□
R215/220.59 / R215/220.59K	AC15 SC12	◪	◪	◪	□	□	.047/.122 .118/.236	–	■	□	–	□
220.69-15	AC15	◪	◪	◪	□	□	.047/.122 .118/.236	–	■	□	–	□
235.15		■	■	■	-	■	Chamfer	■	■	◪	-	-

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Inch

Cutter	No. of cutting edges	Application	Cutter diameter (inch)/available depth of cut and number of teeth								See page
			0.750	1.00	1.25	1.50	2.00	2.50	3.00	4.00	
Turbo 06	2		1.024 (3)								121
Turbo 10	2			1.024 (2)		1.378 (4)					126
				1.378 (3) / 1.693 (2)		1.339 (5)					
Turbo 12	2			0.870 (2) / 0.902 (2)	1.299 (2)	1.732 (3)	1.740 (4) / 2.591 (4)	2.953 (4)			132
					1.732 (3)	1.732 (4) / 2.165 (4) / 2.559 (3)	2.146 (5)				
Turbo 18	2					1.862 (2)	1.850 (3)	1.866 (4) / 2.409 (4) / 2.441 (4)	2.480 (5) / 3.024 (4)	3.024 (5)	140
							2.441 (3)	3.024 (4)			
Helical T4 08	4			1.417 (2)	1.417 (2)		1.693 (4)				148
				1.693 (2)		1.969 (4)					
Helical T4 12	4						1.406 (3) / 1.850 (3)				153
							2.283 (4) / 2.310 (4)	3.189 (4) / 3.211 (4)	3.189 (5) / 3.211 (5)		
215/220.59	2 & 4 half effective										163
							3.031 (2)				
215/220.59K	2 & 4 full effective										163
220.69-15	2						1.567 (3)				171
235.15	1						1.969 (3)		3.500 (3)		176

x(y)	Slotting and contouring operations : x indicates the maximum depth of cut (y indicates the number of teeth)
x(y)	For contouring operations only : x indicates the maximum depth of cut (y indicates the number of teeth)

Slotting and contouring

Contouring only

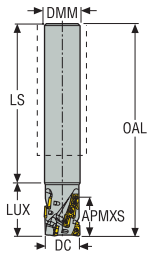
Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

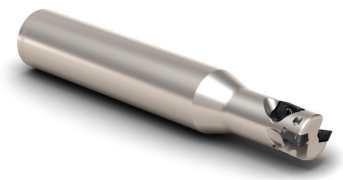
TURBO HELICAL

Seco's range of high-performance Turbo helical cutters offers high feeds, large depths of cut and high metal removal rates in contouring and profiling applications. These cutters provide a first choice for mixed production in all workpiece materials

- Insert size 06, cutter range 12-20mm (0.5 - .075 inch)
- Insert size 10, cutter range 20-54mm (0.75 - 2 inch)
- Insert size 12, cutter range 25-80mm (1 - 2.5 inch)
- Insert size 18, cutter range 40-100mm (1.5 - 4 inch)

Helical Turbo 06 – R217.69-06 – Metric





- For insert selection and cutting data recommendations, see page(s) 124-125
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
R217.69-1612.0-10-06.2N	02709311	Cylindrical	12,0	2	4	10,0	16,0	66,0	23,0	98,0	54400	0,2	XO.X06..
R217.69-1616.0-15-06.3N	02709314	Cylindrical	16,0	3	9	15,0	16,0	80,0	30,0	110,0	48000	0,2	XO.X06..
R217.69-1616.0-20-06.2N	02709316	Cylindrical	16,0	2	8	20,0	16,0	80,0	30,0	110,0	48000	0,2	XO.X06..
R217.69-2020.0-25-06.3N	02709317	Cylindrical	20,0	3	15	25,0	20,0	85,0	35,0	120,0	44000	0,3	XO.X06..

Modification of the cutter body needed for radii > 0,8 mm

Spare Parts

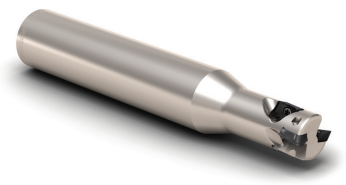
Accessories

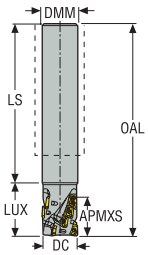
For cutter	Insert screw	Torque key	Torque value
R217.69-..	C01804-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Helical Turbo 06 – R217.69-06 – Inch





- For insert selection and cutting data recommendations, see page(s) 124-125
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.69-00.75-0-06M3N	02710568	Cylindrical	0.750	3	15	1.024	0.750	3.622	1.378	5.000	44000	0.880	XO.X06..

Modification of the cutter body needed for radii > 0.031 in

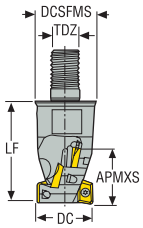
Spare Parts

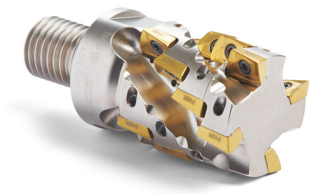
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..	C01804-T06P	T00-06P05	4.4IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 06 – R217.69-06– Metric





- For insert selection and cutting data recommendations, see page(s) 124-125
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
R217.69-0814.RE-15-06.2N	02709297	Combimaster	14,0	2	6	15,0	–	M8	13,2	25,0	–	51200	0,1	XO.X06..
R217.69-1020.RE-20-06.3AN	02709306	Combimaster	20,0	3	12	20,0	–	M10	18,5	35,0	–	44800	0,1	XO.X06..

Modification of the cutter body needed for radii > 0,8 mm

Spare Parts

For cutter	Insert screw
R217.69-..	C01804-T06P

Accessories

Torque key	Torque value
T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-06 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	XOMX060208R-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*
P2	XOMX060208R-M05 F40M	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P3	XOMX060208R-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
P4	XOMX060208R-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
P5	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
P6	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
P7	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
P8	XOMX060208R-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
P11	XOMX060208R-M05 MP3000	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
P12	XOMX060208R-M05 MP3000	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*
M1	XOMX060208R-M05 MS2050	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
M2	XOMX060208R-M05 MS2050	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
M3	XOMX060208R-M05 MS2050	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*
M4	XOMX060208R-M05 MS2050	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*
M5	XOMX060208R-M05 MS2050	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*
K1	XOMX060208R-M05 F40M	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
K2	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
K3	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
K4	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
K5	XOMX060208R-M05 F40M	0,046 *0.0018*	0,050 *0.0020*	0,080 *0.0032*
K6	XOMX060208R-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
K7	XOMX060208R-M05 F40M	0,046 *0.0018*	0,050 *0.0020*	0,080 *0.0032*
N1	XOEX060204FR-E03 H15	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
N2	XOEX060204FR-E03 H15	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
N3	XOEX060204FR-E03 H15	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
N11	XOEX060204FR-E03 H15	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
S1	XOMX060208R-M05 F40M	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*
S2	XOMX060208R-M05 F40M	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*
S3	XOMX060208R-M05 F40M	0,034 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
S11	XOMX060208R-M05 MS2050	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*
S12	XOMX060208R-M05 MS2050	0,042 *0.0017*	0,046 *0.0018*	0,070 *0.0028*
S13	XOMX060208R-M05 MS2050	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*
H5	XOMX060208R-M05 MP3000	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*
H8	XOMX060208R-M05 MP3000	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*
H11	XOMX060208R-M05 MP3000	0,036 *0.0014*	0,038 *0.0015*	0,060 *0.0024*
H12	XOMX060208R-M05 MP3000	0,028 *0.0011*	0,030 *0.0012*	0,046 *0.0018*

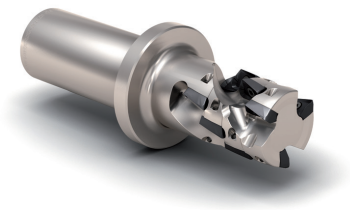
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

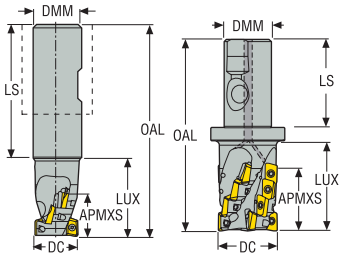
R217/220.69-06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			F30M			F15M			MP3000			MS2050			MM4500			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	160	180	190	165	180	190	170	190	200	175	195	205	165	185	195	145	165	175	—	—	—
	520	*590*	*620*	*540*	*590*	*620*	*560*	*620*	*660*	*570*	*640*	*670*	*540*	*610*	*640*	*475*	*540*	*570*	—	—	—
P2	160	175	185	160	180	190	170	190	200	175	190	200	165	180	195	145	160	175	—	—	—
	520	*570*	*610*	*520*	*590*	*620*	*560*	*620*	*660*	*570*	*620*	*660*	*540*	*590*	*640*	*475*	*520*	*570*	—	—	—
P3	150	165	180	150	170	180	160	180	190	165	180	195	155	175	185	135	155	165	—	—	—
	490	*540*	*590*	*490*	*560*	*590*	*520*	*590*	*620*	*540*	*590*	*640*	*510*	*570*	*610*	*445*	*510*	*540*	—	—	—
P4	140	160	170	145	160	170	150	170	180	155	175	185	145	165	175	125	145	155	—	—	—
	460	*520*	*560*	*475*	*520*	*560*	*490*	*560*	*590*	*510*	*570*	*610*	*475*	*540*	*570*	*410*	*475*	*510*	—	—	—
P5	140	155	165	140	160	170	150	170	180	155	170	180	145	165	175	125	140	155	—	—	—
	460	*510*	*540*	*460*	*520*	*560*	*490*	*560*	*590*	*510*	*560*	*590*	*475*	*540*	*570*	*410*	*460*	*510*	—	—	—
P6	145	165	175	150	165	180	160	175	185	160	180	190	150	170	180	130	150	160	—	—	—
	475	*540*	*570*	*490*	*540*	*590*	*520*	*570*	*610*	*520*	*590*	*620*	*490*	*560*	*590*	*425*	*490*	*520*	—	—	—
P7	140	160	170	145	165	175	155	170	185	155	175	185	150	165	175	130	145	155	—	—	—
	460	*520*	*560*	*475*	*540*	*570*	*510*	*560*	*610*	*510*	*570*	*610*	*490*	*540*	*570*	*425*	*475*	*510*	—	—	—
P8	135	155	165	140	160	170	150	165	180	150	170	180	145	160	170	125	140	150	—	—	—
	445	*510*	*540*	*460*	*520*	*560*	*490*	*540*	*590*	*490*	*560*	*590*	*475*	*520*	*560*	*410*	*460*	*490*	—	—	—
P11	140	160	170	145	160	170	150	170	180	155	175	185	145	165	175	125	145	155	—	—	—
	460	*520*	*560*	*475*	*520*	*560*	*490*	*560*	*590*	*510*	*570*	*610*	*475*	*540*	*570*	*410*	*475*	*510*	—	—	—
P12	110	130	140	115	130	140	120	140	150	125	145	155	115	135	145	95	115	125	—	—	—
	360	*425*	*460*	*375*	*425*	*460*	*395*	*460*	*490*	*410*	*475*	*510*	*375*	*445*	*475*	*310*	*375*	*410*	—	—	—
M1	145	160	175	145	165	175	155	175	185	155	170	185	150	170	180	135	150	165	—	—	—
	475	*520*	*570*	*475*	*540*	*570*	*510*	*570*	*610*	*510*	*560*	*610*	*490*	*560*	*590*	*445*	*490*	*540*	—	—	—
M2	130	150	160	135	155	165	145	160	170	140	160	170	140	155	165	120	140	150	—	—	—
	425	*490*	*520*	*445*	*510*	*540*	*475*	*520*	*560*	*460*	*520*	*560*	*460*	*510*	*540*	*395*	*460*	*490*	—	—	—
M3	115	135	145	120	135	145	130	145	155	125	145	155	120	140	150	105	125	135	—	—	—
	375	*445*	*475*	*395*	*445*	*475*	*425*	*475*	*510*	*410*	*475*	*510*	*395*	*460*	*490*	*345*	*410*	*445*	—	—	—
M4	100	115	125	100	120	130	110	130	140	110	125	135	105	125	135	90	105	115	—	—	—
	330	*375*	*410*	*330*	*395*	*425*	*360*	*425*	*460*	*360*	*410*	*445*	*345*	*410*	*445*	*295*	*345*	*375*	—	—	—
M5	85	105	115	90	105	120	100	115	125	95	115	125	95	110	120	75	95	105	—	—	—
	280	*345*	*375*	*295*	*345*	*395*	*330*	*375*	*410*	*310*	*375*	*410*	*310*	*360*	*395*	*245*	*310*	*345*	—	—	—
K1	145	160	170	145	165	175	155	170	185	—	—	—	—	—	—	—	—	—	—	—	—
	475	*520*	*560*	*475*	*540*	*570*	*510*	*560*	*610*	—	—	—	—	—	—	—	—	—	—	—	—
K2	135	155	165	140	155	165	145	165	175	—	—	—	—	—	—	—	—	—	—	—	—
	445	*510*	*540*	*460*	*510*	*540*	*475*	*540*	*570*	—	—	—	—	—	—	—	—	—	—	—	—
K3	125	140	150	125	145	155	135	155	165	—	—	—	—	—	—	—	—	—	—	—	—
	410	*460*	*490*	*410*	*475*	*510*	*445*	*510*	*540*	—	—	—	—	—	—	—	—	—	—	—	—
K4	120	140	150	125	140	150	135	150	160	—	—	—	—	—	—	—	—	—	—	—	—
	395	*460*	*490*	*410*	*460*	*490*	*445*	*490*	*520*	—	—	—	—	—	—	—	—	—	—	—	—
K5	85	105	115	90	110	120	100	115	130	—	—	—	—	—	—	—	—	—	—	—	—
	280	*345*	*375*	*295*	*360*	*395*	*330*	*375*	*425*	—	—	—	—	—	—	—	—	—	—	—	—
K6	110	130	140	115	135	145	125	140	155	—	—	—	—	—	—	—	—	—	—	—	—
	360	*425*	*460*	*375*	*445*	*475*	*410*	*460*	*510*	—	—	—	—	—	—	—	—	—	—	—	—
K7	105	120	130	105	125	135	115	135	145	—	—	—	—	—	—	—	—	—	—	—	—
	345	*395*	*425*	*345*	*410*	*445*	*375*	*445*	*475*	—	—	—	—	—	—	—	—	—	—	—	—
N1	275	295	305	280	300	310	290	305	320	—	—	—	—	—	—	—	—	—	280	300	310
	900	*970*	*1000*	*920*	*980*	*1025*	*950*	*1000*	*1050*	—	—	—	—	—	—	—	—	—	*920*	*980*	*1025*
N2	215	235	245	220	240	250	230	245	260	—	—	—	—	—	—	—	—	—	220	240	250
	710	*770*	*800*	*720*	*790*	*820*	*750*	*800*	*850*	—	—	—	—	—	—	—	—	—	*720*	*790*	*820*
N3	190	205	220	190	210	220	200	220	230	—	—	—	—	—	—	—	—	—	190	210	220
	620	*670*	*720*	*620*	*690*	*720*	*660*	*720*	*750*	—	—	—	—	—	—	—	—	—	*620*	*690*	*720*
N11	200	215	225	200	220	230	210	230	240	—	—	—	—	—	—	—	—	—	200	220	230
	660	*710*	*740*	*660*	*720*	*750*	*690*	*750*	*790*	—	—	—	—	—	—	—	—	—	*660*	*720*	*750*
S1	50	65	75	55	70	80	60	80	90	60	75	85	55	70	80	28	37	43	—	—	—
	165	*215*	*245*	*180*	*230*	*260*	*195*	*260*	*295*	*195*	*245*	*280*	*180*	*230*	*260*	*90*	*120*	*140*	—	—	—
S2	41	55	60	43	55	65	49	65	75	47	60	70	45	60	70	23	30	35	—	—	—
	135	*180*	*195*	*140*	*180*	*215*	*160*	*215*	*245*	*155*	*195*	*230*	*150*	*195*	*230*	*75*	*100*	*115*	—	—	—
S3	35	46	55	37	48	55	42	55	65	41	55	65	39	50	60	20	26	30	—	—	—
	115	*150*	*180*	*120*	*155*	*180*	*140*	*180*	*215*	*135*	*180*	*215*	*130*	*165*	*195*	*65*	*85*	*100*	—	—	—
S11	70	90	100	75	90	100	85	100	110	80	100	110	75	95	105	40	50	60	—	—	—
	230	*295*	*330*	*245*	*295*	*330*	*280*	*330*	*360*	*260*	*330*	*360*	*245*	*310*	*345*	*130*	*165*	*195*	—	—	—
S12	49	65	75	43	55	65	60	75	85	55	75	85	55	70	80	37	48	55	—	—	—
	160	*215*	*245*	*140*	*180*	*215*	*195*	*245*	*280*	*180*	*245*	*280*	*180*	*230*	*260*	*120*	*155*	*180*	—	—	—
S13	28	37	43	25	32	38	34	44	50	33	43	50	31	41	47	21	28	32	—	—	—
	90	*120*	*140*	*80*	*105*	*125*	*110*	*145*	*165*	*110*	*140*	*165*	*100*	*135*	*155*	*70*	*90*	*105*	—	—	—
H5	42	55	65	44	60	70	50	65	75	49	65	75	—	—	—	—	—	—	—	—	—
	140	*180*	*215*	*145*	*195*	*230*	*165*	*215*	*245*	*160*	*215*	*245*	—	—	—	—	—	—	—	—	—
H8	44	55	65	46	60	70	55	70	80	50	65	75	—	—	—	—	—	—	—	—	—
	145	*180*	*215*	*150*	*195*	*230*	*180*	*230*	*260*	*165*	*215*	*245*	—	—	—	—	—	—	—	—	—
H11	55	70	80	55	75	85	65	80	95	65	80	90	—	—	—	—	—	—	—	—	—
	180	*230*	*260*	*180*	*245*	*280*	*215*	*260*	*310*	*215*	*260*	*295*	—	—	—	—	—	—	—	—	—
H12	80	95	105	80	100	110	90	110	120	95	110	120	—	—	—	—	—	—	—	—	—
	260	*310*	*345*	*260*	*330*	*360*	*295*	*360*	*395*	*310*	*360*	*395*	—	—	—	—	—	—	—	—	—

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Helical Turbo 10 – R217.69-10 – Metric





- For insert selection and cutting data recommendations, see page(s) 129-131
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
R217.69-2020.3-017-10.2A	02827022	Weldon	20,0	2	4	17,0	20,0	50,0	35,0	85,0	26300	0,2	XO.X10..
R217.69-2020.3-025-10.1A	02827023	Weldon	20,0	1	3	25,0	20,0	50,0	45,0	95,0	26300	0,3	XO.X10..
R217.69-2525.3-025-10.2A	02827024	Weldon	25,0	2	6	25,0	25,0	50,0	44,0	100,0	23500	0,4	XO.X10..
R217.69-2025.3S-025-10.3A	02827025	Seco-Weldon	25,0	3	9	25,0	20,0	50,0	43,0	100,0	23500	0,4	XO.X10..*
R217.69-2025.3S-034-10.3A	02827026	Seco-Weldon	25,0	3	12	34,0	20,0	50,0	43,0	100,0	23500	0,4	XO.X10..*
R217.69-2525.3S-034-10.3A	02827027	Seco-Weldon	25,0	3	12	34,0	25,0	56,0	43,0	110,0	23500	0,4	XO.X10..*
R217.69-2525.3S-042-10.2A	02827028	Seco-Weldon	25,0	2	10	42,0	25,0	56,0	53,0	120,0	23500	0,5	XO.X10..
R217.69-2532.3S-034-10.4A	02827029	Seco-Weldon	32,0	4	16	34,0	25,0	56,0	43,0	110,0	20800	0,5	XO.X10..*
R217.69-2532.3S-042-10.4A	02827030	Seco-Weldon	32,0	4	20	42,0	25,0	56,0	53,0	120,0	20800	0,4	XO.X10..*
R217.69-2532.3S-050-10.3A	02827031	Seco-Weldon	32,0	3	18	50,0	25,0	56,0	63,0	130,0	20800	0,5	XO.X10..
R217.69-3240.3S-058-10.4A	02827032	Seco-Weldon	40,0	4	28	58,0	32,0	60,0	72,0	144,0	18600	0,9	XO.X10..

Modification of the cutter body needed for radii > 2,0 mm
* No axial support in the front row for radii > 1,6 mm

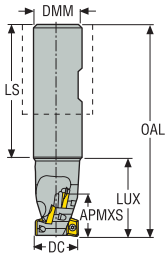
Spare Parts

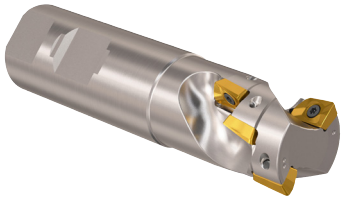
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 10 – R217.69-10 – Inch





- For insert selection and cutting data recommendations, see page(s) 129-131
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.69-01.00-3-01.00-10-2A	02829883	Weldon	1.000	2	6	1.024	1.000	2.282	1.874	4.000	23500	0.880	XO.X10..
R217.69-01.00-3-01.34-10-3A	02865301	Weldon	1.000	3	12	1.378	1.000	2.282	1.969	4.250	23500	0.880	XO.X10..*
R217.69-01.00-3-01.65-10-2A	02865304	Weldon	1.000	2	10	1.693	1.000	2.422	2.078	4.500	23500	0.880	XO.X10..

Modification of the cutter body needed for radii > 0.079 in
* No axial support in the front row for radii > 0.063

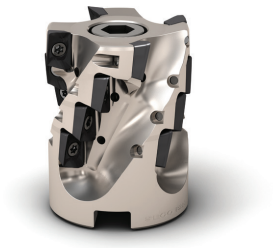
Spare Parts

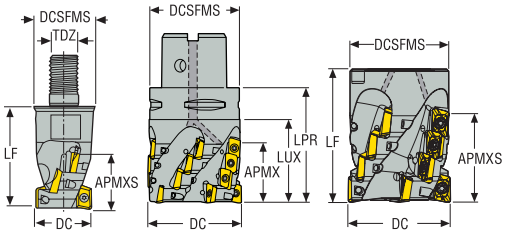
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..	C02506-T07P	T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 10 – R217/220.69-10 – Metric





- For insert selection and cutting data recommendations, see page(s) 129-131
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
R217.69-1020.RE-017-10.2A	02827017	Combimaster	20,0	2	4	17,0	–	M10	18,5	28,0	–	26300	0,1	XO.X10..
R217.69-1225.RE-017-10.3A	02827018	Combimaster	25,0	3	6	17,0	–	M12	23,0	35,0	–	23500	0,1	XO.X10..*
R217.69-1225.RE-025-10.2A	02827019	Combimaster	25,0	2	6	25,0	–	M12	23,0	40,0	–	23500	0,1	XO.X10..
R217.69-1632.RE-025-10.3A	02827020	Combimaster	32,0	3	9	25,0	–	M16	30,0	45,0	–	20800	0,2	XO.X10..
R217.69-1632.RE-034-10.4A	02827021	Combimaster	32,0	4	16	34,0	–	M16	30,0	50,0	–	20800	0,3	XO.X10..*
R217.69-2040.RE-034-10.5A	02972760	Combimaster	40,0	5	20	34,0	–	M20	36,5	55,0	–	18600	0,4	XO.X10..*
C4-R217.69-044-058-10.5A	02827033	Seco-Capto	44,0	5	35	58,0	–	–	40,0	90,0	–	16600	0,7	XO.X10..*
R220.69-00040-034-10.4A	02865893	Arbor	40,0	4	16	34,0	16,0	–	35,0	55,0	–	18600	0,3	XO.X10..
R220.69-00040-034-10.5A	02827038	Arbor	40,0	5	20	34,0	16,0	–	38,0	55,0	–	18600	0,3	XO.X10..*
R220.69-00050-042-10.5A	02865895	Arbor	50,0	5	25	42,0	27,0	–	48,0	65,0	–	16600	0,5	XO.X10..
R220.69-00050-042-10.6A	02827039	Arbor	50,0	6	30	42,0	27,0	–	48,0	65,0	–	16600	0,5	XO.X10..*

For Combimaster Shanks, see Machining Navigator Tooling System

Modification of the cutter body needed for radii > 2,0 mm
* No axial support in the front row for radii > 1,6 mm

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.69-../Cx-R217.69-..	–	C02506-T07P	T00-07P09	0.9NM
R220.69-00040	950D0850	C02506-T07P	T00-07P09	0.9NM
R220.69-00050	MC6S12X60	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-10 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	XOMX10T308TR-ME07 MP2501	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
P2	XOMX10T308TR-ME07 MP2501	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
P3	XOMX10T308TR-ME07 MP2501	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
P4	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P5	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P6	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P7	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P8	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
P11	XOMX10T308TR-M09 T350M	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
P12	XOMX10T308TR-M09 T350M	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
M1	XOEX10T308R-M06 MS2050	0,070 *0.0028*	0,075 *0.0030*	0,12 *0.0048*
M2	XOEX10T308R-M06 MS2050	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
M3	XOEX10T308R-M06 MS2050	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
M4	XOMX10T308TR-ME07 MS2050	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
M5	XOMX10T304TR-ME07 MS2050	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
K1	XOMX10T308TR-M09 MK2050	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
K2	XOMX10T308TR-M09 MK2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K3	XOMX10T308TR-M09 MK2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K4	XOMX10T308TR-M09 MK2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K5	XOMX10T308TR-M09 MK2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
K6	XOMX10T308TR-M09 MK2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K7	XOMX10T308TR-M09 MK2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
N1	XOEX10T308FR-E05 H15	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
N2	XOEX10T308FR-E05 H15	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
N3	XOEX10T308FR-E05 H15	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
N11	XOEX10T308FR-E05 H15	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S1	XOMX10T308TR-ME07 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
S2	XOMX10T308TR-ME07 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
S3	XOMX10T308TR-ME07 F40M	0,048 *0.0019*	0,050 *0.0020*	0,080 *0.0032*
S11	XOEX10T308R-M06 MS2050	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
S12	XOEX10T308R-M06 MS2050	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
S13	XOEX10T308R-M06 MS2050	0,044 *0.0017*	0,048 *0.0019*	0,075 *0.0030*
H5	XOMX10T308TR-M09 MP3000	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
H8	XOMX10T308TR-M09 MP3000	0,048 *0.0019*	0,055 *0.0022*	0,080 *0.0032*
H11	XOMX10T308TR-M09 MP3000	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
H12	XOMX10T308TR-M09 MP3000	0,048 *0.0019*	0,055 *0.0022*	0,080 *0.0032*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

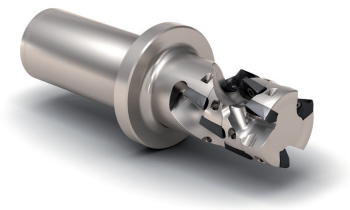
R217/220.69-10 – Cutting data v_c = (m/min)/*(sf/min)*

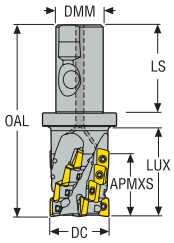
SMG	MP1501			MP2501			MP3000			T350M			F40M			MP2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	155 *510*	170 *560*	180 *590*	145 *475*	165 *540*	175 *570*	145 *475*	160 *520*	170 *560*	140 *460*	155 *510*	165 *540*	135 *445*	155 *510*	165 *540*	155 *510*	170 *560*	180 *590*
P2	150 *490*	170 *560*	180 *590*	145 *475*	160 *520*	170 *560*	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	135 *445*	155 *510*	165 *540*	150 *490*	170 *560*	180 *590*
P3	145 *475*	160 *520*	170 *560*	135 *445*	150 *490*	165 *540*	135 *445*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	130 *425*	145 *475*	155 *510*	145 *475*	160 *520*	170 *560*
P4	135 *445*	155 *510*	165 *540*	130 *425*	145 *475*	155 *510*	125 *410*	145 *475*	150 *490*	120 *395*	140 *460*	145 *475*	120 *395*	135 *445*	145 *475*	135 *445*	150 *490*	165 *540*
P5	135 *445*	150 *490*	160 *520*	125 *410*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	135 *445*	145 *475*	135 *445*	150 *490*	160 *520*
P6	140 *460*	160 *520*	165 *540*	135 *445*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*
P7	135 *445*	155 *510*	165 *540*	130 *425*	145 *475*	155 *510*	125 *410*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	135 *445*	155 *510*	165 *540*
P8	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	135 *445*	145 *475*	135 *445*	150 *490*	160 *520*
P11	135 *445*	155 *510*	160 *520*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	120 *395*	135 *445*	145 *475*	135 *445*	150 *490*	160 *520*
P12	110 *360*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	95 *310*	110 *360*	120 *395*	110 *360*	125 *410*	135 *445*
M1	— —	— —	— —	125 *410*	140 *460*	150 *490*	125 *410*	140 *460*	150 *490*	120 *395*	140 *460*	145 *475*	125 *410*	140 *460*	150 *490*	130 *425*	150 *490*	160 *520*
M2	— —	— —	— —	115 *375*	130 *425*	140 *460*	110 *360*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*	110 *360*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*
M3	— —	— —	— —	100 *330*	115 *375*	125 *410*	100 *330*	115 *375*	125 *410*	95 *310*	115 *375*	120 *395*	100 *330*	115 *375*	125 *410*	105 *345*	125 *410*	135 *445*
M4	— —	— —	— —	85 *280*	100 *330*	110 *360*	85 *280*	100 *330*	110 *360*	80 *260*	100 *330*	105 *345*	85 *280*	100 *330*	110 *360*	90 *295*	110 *360*	115 *375*
M5	— —	— —	— —	75 *245*	90 *295*	100 *330*	75 *245*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	70 *230*	90 *295*	100 *330*	80 *260*	95 *310*	105 *345*
K1	140 *460*	155 *510*	165 *540*	130 *425*	150 *490*	155 *510*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	135 *445*	155 *510*	165 *540*
K2	130 *425*	150 *490*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	115 *375*	130 *425*	140 *460*	130 *425*	145 *475*	155 *510*
K3	120 *395*	140 *460*	145 *475*	115 *375*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	105 *345*	120 *395*	130 *425*	120 *395*	135 *445*	145 *475*
K4	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	135 *445*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	100 *330*	120 *395*	130 *425*	115 *375*	135 *445*	145 *475*
K5	90 *295*	105 *345*	115 *375*	80 *260*	100 *330*	110 *360*	75 *245*	95 *310*	105 *345*	70 *230*	90 *295*	100 *330*	70 *230*	90 *295*	100 *330*	90 *295*	105 *345*	115 *375*
K6	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	95 *310*	110 *360*	120 *395*	110 *360*	125 *410*	135 *445*
K7	105 *345*	120 *395*	130 *425*	95 *310*	115 *375*	120 *395*	90 *295*	110 *360*	120 *395*	85 *280*	105 *345*	115 *375*	85 *280*	105 *345*	115 *375*	100 *330*	120 *395*	130 *425*
N1	— —	— —	— —	— —	— —	— —	245 *800*	265 *870*	275 *900*	— —	— —	— —	245 *800*	260 *850*	270 *890*	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	195 *640*	210 *690*	220 *720*	— —	— —	— —	190 *620*	205 *670*	215 *710*	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	170 *560*	185 *610*	195 *640*	— —	— —	— —	165 *540*	180 *590*	190 *620*	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	175 *570*	195 *640*	205 *670*	— —	— —	— —	170 *560*	190 *620*	200 *660*	— —	— —	— —
S1	— —	— —	— —	45 *150*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*	40 *130*	55 *180*	60 *195*	41 *135*	55 *180*	65 *215*	49 *160*	65 *215*	75 *245*
S2	— —	— —	— —	36 *120*	47 *155*	55 *180*	34 *110*	45 *150*	50 *165*	32 *105*	42 *140*	49 *160*	33 *110*	43 *140*	50 *165*	40 *130*	50 *165*	60 *195*
S3	— —	— —	— —	31 *100*	41 *135*	49 *160*	30 *100*	39 *130*	46 *150*	28 *90*	37 *120*	43 *140*	29 *95*	38 *125*	44 *145*	35 *115*	46 *150*	55 *180*
S11	— —	— —	— —	60 *195*	80 *260*	90 *295*	60 *195*	75 *245*	85 *280*	55 *180*	70 *230*	80 *260*	55 *180*	75 *245*	85 *280*	70 *230*	85 *280*	95 *310*
S12	— —	— —	— —	43 *140*	55 *180*	65 *215*	41 *135*	55 *180*	60 *195*	38 *125*	50 *165*	60 *195*	39 *130*	50 *165*	60 *195*	47 *155*	60 *195*	75 *245*
S13	— —	— —	— —	25 *80*	33 *110*	39 *130*	24 *80*	31 *100*	36 *120*	22 *70*	30 *100*	34 *110*	23 *75*	30 *100*	35 *115*	28 *90*	36 *120*	43 *140*
H5	45 *150*	60 *195*	70 *230*	36 *120*	48 *155*	55 *180*	35 *115*	47 *155*	55 *180*	35 *115*	46 *150*	55 *180*	34 *110*	45 *150*	55 *180*	40 *130*	55 *180*	60 *195*
H8	48 *155*	65 *215*	75 *245*	39 *130*	50 *165*	60 *195*	38 *125*	49 *160*	60 *195*	37 *120*	48 *155*	55 *180*	36 *120*	48 *155*	55 *180*	42 *140*	55 *180*	65 *215*
H11	60 *195*	75 *245*	85 *280*	46 *150*	60 *195*	70 *230*	45 *150*	60 *195*	70 *230*	44 *145*	60 *195*	70 *230*	44 *145*	55 *180*	65 *215*	50 *165*	65 *215*	75 *245*
H12	80 *260*	100 *330*	110 *360*	75 *245*	90 *295*	100 *330*	70 *230*	85 *280*	100 *330*	65 *215*	80 *260*	95 *310*	65 *215*	80 *260*	90 *295*	80 *260*	95 *310*	105 *345*

R217/220.69-10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			MS2050			MS2500			MM4500			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	—	—	—	145	160	170	145	160	170	160	175	185	125	140	150	—	—	—
	—	—	—	*475*	*520*	*560*	*475*	*520*	*560*	*520*	*570*	*610*	*410*	*460*	*490*	—	—	—
P2	—	—	—	145	160	170	140	160	170	155	170	185	125	140	150	—	—	—
	—	—	—	*475*	*520*	*560*	*460*	*520*	*560*	*510*	*560*	*610*	*410*	*460*	*490*	—	—	—
P3	—	—	—	135	150	160	135	150	160	150	165	175	115	130	140	—	—	—
	—	—	—	*445*	*490*	*520*	*445*	*490*	*520*	*490*	*540*	*570*	*375*	*425*	*460*	—	—	—
P4	—	—	—	130	145	155	125	140	150	140	155	165	105	125	135	—	—	—
	—	—	—	*425*	*475*	*510*	*410*	*460*	*490*	*460*	*510*	*540*	*345*	*410*	*445*	—	—	—
P5	—	—	—	125	145	150	125	140	150	135	155	165	105	120	130	—	—	—
	—	—	—	*410*	*475*	*490*	*410*	*460*	*490*	*445*	*510*	*540*	*345*	*395*	*425*	—	—	—
P6	—	—	—	130	150	160	130	145	155	145	160	170	115	130	140	—	—	—
	—	—	—	*425*	*490*	*520*	*425*	*475*	*510*	*475*	*520*	*560*	*375*	*425*	*460*	—	—	—
P7	—	—	—	130	145	155	125	145	155	140	160	170	110	125	135	—	—	—
	—	—	—	*425*	*475*	*510*	*410*	*475*	*510*	*460*	*520*	*560*	*360*	*410*	*445*	—	—	—
P8	—	—	—	125	140	150	125	140	150	135	155	165	105	120	130	—	—	—
	—	—	—	*410*	*460*	*490*	*410*	*460*	*490*	*445*	*510*	*540*	*345*	*395*	*425*	—	—	—
P11	—	—	—	125	145	155	125	140	150	140	155	165	105	125	135	—	—	—
	—	—	—	*410*	*475*	*510*	*410*	*460*	*490*	*460*	*510*	*540*	*345*	*410*	*445*	—	—	—
P12	—	—	—	100	120	125	100	115	125	115	130	140	80	95	105	—	—	—
	—	—	—	*330*	*395*	*410*	*330*	*375*	*410*	*375*	*425*	*460*	*260*	*310*	*345*	—	—	—
M1	—	—	—	—	—	—	130	145	155	135	150	165	115	130	140	—	—	—
	—	—	—	—	—	—	*425*	*475*	*510*	*445*	*490*	*540*	*375*	*425*	*460*	—	—	—
M2	—	—	—	—	—	—	120	135	145	125	140	150	100	120	130	—	—	—
	—	—	—	—	—	—	*395*	*445*	*475*	*410*	*460*	*490*	*330*	*395*	*425*	—	—	—
M3	—	—	—	—	—	—	105	120	130	110	125	140	90	105	115	—	—	—
	—	—	—	—	—	—	*345*	*395*	*425*	*360*	*410*	*460*	*295*	*345*	*375*	—	—	—
M4	—	—	—	—	—	—	90	105	115	95	110	120	75	90	100	—	—	—
	—	—	—	—	—	—	*295*	*345*	*375*	*310*	*360*	*395*	*245*	*295*	*330*	—	—	—
M5	—	—	—	—	—	—	75	95	105	85	100	110	65	80	90	—	—	—
	—	—	—	—	—	—	*245*	*310*	*345*	*280*	*330*	*360*	*215*	*260*	*295*	—	—	—
K1	150	170	180	150	165	175	—	—	—	—	—	—	—	—	—	—	—	—
	490	*560*	*590*	*490*	*540*	*570*	—	—	—	—	—	—	—	—	—	—	—	—
K2	145	160	170	140	160	165	—	—	—	—	—	—	—	—	—	—	—	—
	475	*520*	*560*	*460*	*520*	*540*	—	—	—	—	—	—	—	—	—	—	—	—
K3	135	150	160	130	150	155	—	—	—	—	—	—	—	—	—	—	—	—
	445	*490*	*520*	*425*	*490*	*510*	—	—	—	—	—	—	—	—	—	—	—	—
K4	130	150	160	130	145	155	—	—	—	—	—	—	—	—	—	—	—	—
	425	*490*	*520*	*425*	*475*	*510*	—	—	—	—	—	—	—	—	—	—	—	—
K5	100	120	130	100	115	125	—	—	—	—	—	—	—	—	—	—	—	—
	330	*395*	*425*	*330*	*375*	*410*	—	—	—	—	—	—	—	—	—	—	—	—
K6	125	140	150	120	140	145	—	—	—	—	—	—	—	—	—	—	—	—
	410	*460*	*490*	*395*	*460*	*475*	—	—	—	—	—	—	—	—	—	—	—	—
K7	115	135	145	115	130	140	—	—	—	—	—	—	—	—	—	—	—	—
	375	*445*	*475*	*375*	*425*	*460*	—	—	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	245	260	270
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*800*	*850*	*890*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	190	205	215
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*620*	*670*	*710*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	165	185	195
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*540*	*610*	*640*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	175	190	200
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*570*	*620*	*660*
S1	—	—	—	—	—	—	45	60	70	55	70	80	23	30	36	—	—	—
	—	—	—	—	—	—	*150*	*195*	*230*	*180*	*230*	*260*	*75*	*100*	*120*	—	—	—
S2	—	—	—	—	—	—	36	47	55	43	55	65	19	25	29	—	—	—
	—	—	—	—	—	—	*120*	*155*	*180*	*140*	*180*	*215*	*60*	*80*	*95*	—	—	—
S3	—	—	—	—	—	—	32	41	48	37	49	60	16	22	25	—	—	—
	—	—	—	—	—	—	*105*	*135*	*155*	*120*	*160*	*195*	*50*	*70*	*80*	—	—	—
S11	—	—	—	—	—	—	65	80	90	75	90	100	32	42	50	—	—	—
	—	—	—	—	—	—	*215*	*260*	*295*	*245*	*295*	*330*	*105*	*140*	*165*	—	—	—
S12	—	—	—	—	—	—	43	55	65	50	65	75	30	39	46	—	—	—
	—	—	—	—	—	—	*140*	*180*	*215*	*165*	*215*	*245*	*100*	*130*	*150*	—	—	—
S13	—	—	—	—	—	—	25	33	38	30	39	46	17	23	27	—	—	—
	—	—	—	—	—	—	*80*	*110*	*125*	*100*	*130*	*150*	*55*	*75*	*90*	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

Helical Turbo 12 – R217.69-12 – Metric





- For insert selection and cutting data recommendations, see page(s) 137-139
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
R217.69-2025.3S-022-12.2AN	02709523	Seco-Weldon	25,0	2	4	22,0	20,0	50,0	38,0	99,5	20800	0,3	XO.X12..*
R217.69-2525.3S-033-12.2AN	02709526	Seco-Weldon	25,0	2	6	33,0	25,0	56,0	43,0	115,5	20800	0,4	XO.X12..*
R217.69-2532.3S-033-12.2AN	02709528	Seco-Weldon	32,0	2	6	33,0	25,0	56,0	47,0	115,5	18400	0,5	XO.X12..
R217.69-2532.3S-033-12.3AN	02709530	Seco-Weldon	32,0	3	9	33,0	25,0	56,0	48,0	115,5	18400	0,5	XO.X12..*
R217.69-2532.3S-044-12.3AN	02629796	Seco-Weldon	32,0	3	12	44,0	25,0	56,0	58,0	125,5	18400	0,5	XO.X12..*
R217.69-3240.3S-033-12.3AN	02709540	Seco-Weldon	40,0	3	9	33,0	32,0	60,0	49,0	119,5	16400	0,8	XO.X12..
R217.69-3240.3S-044-12.4AN	02709541	Seco-Weldon	40,0	4	16	44,0	32,0	60,0	57,0	129,5	16400	0,8	XO.X12..*
R217.69-3240.3S-055-12.3AN	02709543	Seco-Weldon	40,0	3	15	55,0	32,0	60,0	69,0	139,5	16400	0,9	XO.X12..
R217.69-3250.3S-055-12.4AN	02709546	Seco-Weldon	50,0	4	20	55,0	32,0	60,0	67,0	139,5	14800	1,1	XO.X12..

Modification of the cutter body needed for radii > 3,1 mm
* No axial support in the front row for radii > 1,6 mm

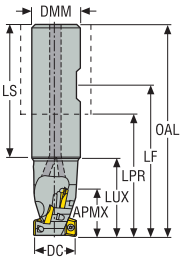
Spare Parts

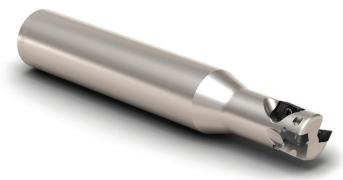
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..Ø25/R217.69-HSK	C03507-T10P	T00-10P30	3.0NM
R217.69-..Ø32	C03508-T10P	T00-10P30	3.0NM
R217.69-..Ø40-50	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 12 – R217.69-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 137-139
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Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.69-01.25-3-12S2AN	02710791	Weldon	1.250	2	6	1.299	1.250	2.278	2.220	4.499	18400	1.320	XO.X12..
R217.69-01.25-3-12M3AN	02710789	Weldon	1.250	3	12	1.732	1.250	2.280	2.695	5.000	18400	1.320	XO.X12..*
R217.69-01.50-3-12S3AN	02710800	Weldon	1.500	3	12	1.732	1.500	2.742	2.510	5.252	16400	2.200	XO.X12..*
R217.69-01.50-3-12M4AN	02710799	Weldon	1.500	4	20	2.165	1.500	2.689	3.010	5.750	16400	2.430	XO.X12..*
R217.69-01.50-3-12L3AN	02710795	Weldon	1.500	3	18	2.559	1.500	2.689	3.262	5.998	16400	2.200	XO.X12..
R217.69-02.00-3-12M4AN	02710802	Weldon	2.000	4	24	2.591	1.500	2.687	3.311	5.998	14800	3.090	XO.X12..

Modification of the cutter body needed for radii > 0.122 in
* No axial support in the front row for radii > 0.063

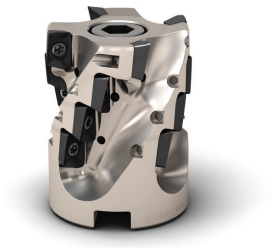
Spare Parts

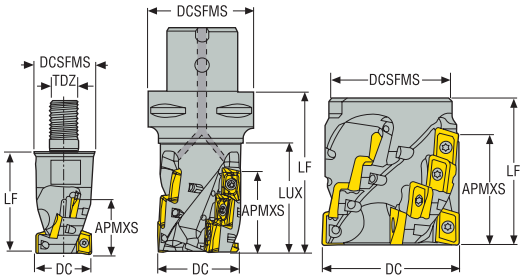
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-01.00-01.25	C03507-T10P	T00-10P30	26.6IN.LBS
R217.69-01.50-02.00	C03509-T10P	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 12 – R217/220.69-12 – Metric





- For insert selection and cutting data recommendations, see page(s) 137-139
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

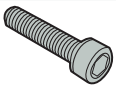
Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
R217.69-1225.RE-022-12.2AN	02709506	Combimaster	25,0	2	4	22,0	–	M12	23,0	40,0	–	20800	0,1	XO.X12..*
R217.69-1632.RE-022-12.3AN	02709508	Combimaster	32,0	3	6	22,0	–	M16	30,0	40,0	–	18400	0,2	XO.X12..*
R217.69-2040.RE-033-12.3AN	02972763	Combimaster	40,0	3	9	33,0	–	M20	36,5	50,0	–	16400	0,4	XO.X12..
R217.69-2040.RE-044-12.4AN	02972764	Combimaster	40,0	4	16	44,0	–	M20	36,5	61,0	–	16400	0,4	XO.X12..*
R220.69-00050-033-12.4AN	02709941	Arbor	50,0	4	12	33,0	27,0	–	48,0	55,0	–	14800	0,4	XO.X12..
R220.69-00050-044-12.4AN	02709947	Arbor	50,0	4	16	44,0	27,0	–	48,0	65,0	–	14800	0,5	XO.X12..
R220.69-00050-044-12.5AN	02709951	Arbor	50,0	5	20	44,0	27,0	–	48,0	65,0	–	14800	0,5	XO.X12..*
R220.69-00063-033-12.5AN	02709956	Arbor	63,0	5	15	33,0	27,0	–	62,0	63,0	–	13200	1,0	XO.X12..
R220.69-00063-055-12.5AN	02709965	Arbor	63,0	5	25	55,0	27,0	–	60,0	75,0	–	13200	1,0	XO.X12..
R220.69-00063-077-12.4SAN	02717797	Arbor	63,0	4	28	77,0	27,0	–	60,0	100,0	–	13200	1,5	XO.X12..
R217.69-HSK63A.32-044-12.3AN	02717942	HSK	32,0	3	12	44,0	–	–	63,0	90,0	52,0	18400	1,0	XO.X12..*

For Combimaster Shanks, see Machining Navigator Tooling System

Modification of the cutter body needed for radii > 3,1 mm
* No axial support in the front row for radii > 1,6 mm

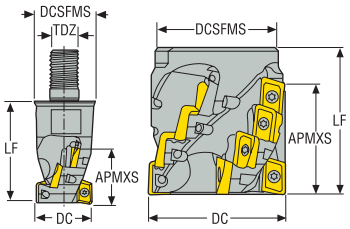
Spare Parts

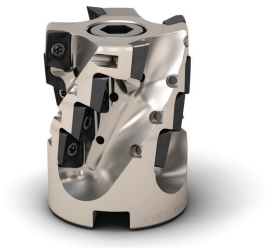
Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
						
R217.69-..Ø25	–	–	C03507-T10P	–	T00-10P30	26.6IN.LBS
R217.69-../C5-R217.69-Ø32	–	–	C03508-T10P	–	T00-10P30	26.6IN.LBS
R217.69-../Cx-R217.69-Ø40-66	–	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-Ø50-033	MC6S12X40	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-Ø50/Ø63-033-044	MC6S12X50	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-Ø50/Ø63-044-055	MC6S12X60	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-00063	MP6S12X80	R220.69-00063044-12.4BAN	C03509-T10P	R220.69-RE063033-12.4AN	T00-10P30	26.6IN.LBS
R217.69-..Ø25/R217.69-HSK	–	–	C03507-T10P	–	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 12 – R217/220.69-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 137-139
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			Inch			Inch	Inch		Inch	Inch	Inch		lbs	
R217.69-1.00-12RE-12S2AN	02710788	Combimaster	1.000	2	4	0.870	–	M12	0.906	1.378	–	14800	0.440	XO.X12..*
R217.69-01.50-20RE-01.73-12-4A	03003976	Combimaster	1.500	4	16	1.732	–	M20	1.437	2.165	–	16400	0.880	XO.X12..*
R220.69-02.00-12S4AN	02710915	Arbor	2.000	4	16	1.740	1.000	–	2.047	2.750	–	14800	1.320	XO.X12..
R220.69-02.00-12M5AN	02710895	Arbor	2.000	5	25	2.146	1.000	–	2.047	3.250	–	14800	1.540	XO.X12..*
R220.69-02.50-12L4SAN	02722266	Arbor	2.500	4	24	2.953	1.000	–	2.441	2.992	–	13200	4.630	XO.X12..

For Combimaster Shanks, see Machining Navigator Tooling System

Modification of the cutter body needed for radii > 0.122 in
* No axial support in the front row for radii > 0.063

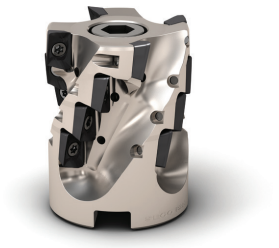
Spare Parts

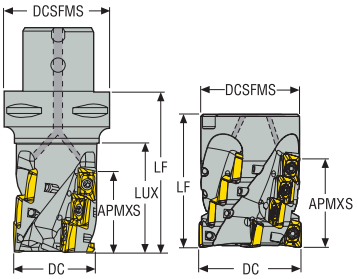
Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
R217.69-01.00-01.25	–	–	C03507-T10P	–	T00-10P30	26.6IN.LBS
R217.69-01.50	–	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-..M5	UC6S1/2UNFX2-1/2	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-..S4	UC6S1/2UNFX3	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
R220.69-..L4	UP6S1/2UNFX3-1/4	R220.69-02.50-12L4BAN	C03509-T10P	R220.69-02.50-RE-12.4AN	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 12 – R217/220.69-12 – Metric





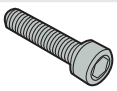
- For insert selection and cutting data recommendations, see page(s) 137-139
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
C5-R217.69-032-044-12.3AN	02717844	Seco-Capto	32,0	3	12	44,0	–	50,0	79,0	56,0	18400	0,7	XO.X12..*
C5-R217.69-032-055-12.3AN	02829929	Seco-Capto	32,0	3	15	55,0	–	50,0	90,0	67,0	18400	0,7	XO.X12..*
C6-R217.69-040-055-12.3AN	02717917	Seco-Capto	40,0	3	15	55,0	–	63,0	92,0	67,0	16400	1,1	XO.X12..
C6-R217.69-040-066-12.3AN	02829930	Seco-Capto	40,0	3	18	65,5	–	63,0	103,0	79,9	16400	1,2	XO.X12..
C4-R217.69-044-033-12.3AN	02717838	Seco-Capto	44,0	3	9	33,0	–	40,0	68,0	48,0	15500	0,6	XO.X12..
C6-R217.69-050-055-12.4AN	02717918	Seco-Capto	50,0	4	20	55,0	–	63,0	92,0	67,0	14800	1,4	XO.X12..
C5-R217.69-054-044-12.4AN	02717852	Seco-Capto	54,0	4	16	44,0	–	50,0	79,0	59,0	13900	1,2	XO.X12..
C6-R217.69-066-044-12.5AN	02717924	Seco-Capto	66,0	5	20	44,0	–	63,0	81,0	59,0	12000	1,9	XO.X12..
C6-R217.69-050-066-12.4SAN	02717991	Seco-Capto	50,0	4	24	66,0	–	63,0	101,0	76,0	14800	1,4	XO.X12..
C6-R217.69-050-086-12.5SAN	02829935	Seco-Capto	50,0	5	40	86,0	–	63,0	119,0	97,0	14800	1,7	XO.X12..
C6-R217.69-050-106-12.5SAN	02829936	Seco-Capto	50,0	5	50	106,0	–	63,0	140,0	118,0	12000	1,7	XO.X12..
C6-R217.69-063-107-12.5SAN	02829940	Seco-Capto	63,0	5	50	107,0	–	63,0	140,0	118,0	12000	2,4	XO.X12..

Modification of the cutter body needed for radii > 3,1 mm
* No axial support in the front row for radii > 1,6 mm

Spare Parts

Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
						
R217.69-../C5-R217.69-Ø32	–	–	C03508-T10P	–	T00-10P30	26.6IN.LBS
R217.69-../Cx-R217.69-Ø40-66	–	–	C03509-T10P	–	T00-10P30	26.6IN.LBS
C6-R217.69-050-066-4SAN	MC6S10X40	C6-R217.69-050-044-12.4BAN	C03509-T10P	R220.69-RE050022-12.4AN	T00-10P30	26.6IN.LBS
C6-R217.69-050-086-5SAN	MC6S10X40	C6-R217.69-050-064-12.5BAN	C03509-T10P	R220.69-RE050022-12.5AN	T00-10P30	26.6IN.LBS
C6-R217.69-050-106-5SAN	MC6S10X40	C6-R217.69-050-084-12.5BAN	C03509-T10P	R220.69-RE050022-12.5AN	T00-10P30	26.6IN.LBS
C6-R217.69-063-5SAN	MC6S10X40	C6-R217.69-063-074-12.5BAN	C03509-T10P	R220.69-RE063033-12.5AN	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-12 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	XOMX120408TR-ME08 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P2	XOMX120408TR-ME08 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P3	XOMX120408TR-ME08 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,19 *0.0075*
P4	XOMX120408TR-M12 MP2501	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
P5	XOMX120408TR-M12 MP2501	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
P6	XOMX120408TR-M12 MP2501	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
P7	XOMX120408TR-M12 MP2501	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
P8	XOMX120408TR-M12 MP2501	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
P11	XOMX120408TR-M12 T350M	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
P12	XOMX120408TR-M12 T350M	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M1	XOEX120408R-M07 MS2050	0,10 *0.0040*	0,11 *0.0044*	0,16 *0.0065*
M2	XOEX120408R-M07 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M3	XOEX120408R-M07 MS2050	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
M4	XOMX120408TR-ME08 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M5	XOMX120408TR-ME08 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
K1	XOMX120408TR-MD13 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K2	XOMX120408TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K3	XOMX120408TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K4	XOMX120408TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K5	XOMX120408TR-MD13 MK2050	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K6	XOMX120408TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K7	XOMX120408TR-MD13 MK2050	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N1	XOEX120408FR-E06 H15	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N2	XOEX120408FR-E06 H15	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N3	XOEX120408FR-E06 H15	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
N11	XOEX120408FR-E06 H15	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
S1	XOEX120408R-M07 F40M	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*
S2	XOEX120408R-M07 F40M	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*
S3	XOEX120408R-M07 F40M	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*
S11	XOEX120408R-M07 MS2050	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
S12	XOEX120408R-M07 MS2050	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
S13	XOEX120408R-M07 MS2050	0,065 *0.0026*	0,070 *0.0028*	0,10 *0.0040*
H5	XOMX120408TR-MD13 MP3000	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
H8	XOMX120408TR-MD13 MP3000	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
H11	XOMX120412TR-MD13 MP3000	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
H12	XOMX120408TR-MD13 MP3000	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

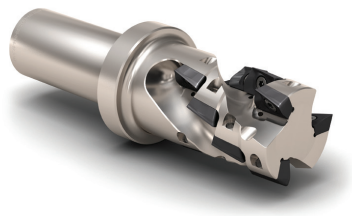
R217/220.69-12 – Cutting data v_c = (m/min)/*(sf/min)*

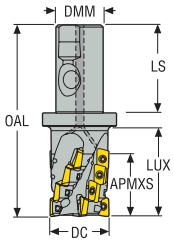
SMG	MP1501			MP2501			MP3000			T350M			F40M			MP2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	150 *490*	165 *540*	175 *570*	140 *460*	160 *520*	170 *560*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	150 *490*	170 *560*	180 *590*
P2	145 *475*	165 *540*	175 *570*	140 *460*	155 *510*	165 *540*	135 *445*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	150 *490*	165 *540*	175 *570*
P3	140 *460*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	140 *460*	160 *520*	170 *560*
P4	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	115 *375*	135 *445*	140 *460*	105 *345*	125 *410*	135 *445*	135 *445*	150 *490*	160 *520*
P5	130 *425*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	105 *345*	120 *395*	135 *445*	130 *425*	150 *490*	160 *520*
P6	135 *445*	155 *510*	165 *540*	130 *425*	145 *475*	155 *510*	125 *410*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	140 *460*	155 *510*	165 *540*
P7	135 *445*	150 *490*	160 *520*	125 *410*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	135 *445*	150 *490*	160 *520*
P8	130 *425*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	105 *345*	120 *395*	130 *425*	130 *425*	145 *475*	160 *520*
P11	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	150 *490*	115 *375*	135 *445*	145 *475*	105 *345*	125 *410*	135 *445*	135 *445*	150 *490*	160 *520*
P12	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	115 *375*	80 *260*	100 *330*	110 *360*	105 *345*	125 *410*	135 *445*
M1	— —	— —	— —	120 *395*	135 *445*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	135 *445*	145 *475*	110 *360*	125 *410*	140 *460*	130 *425*	145 *475*	155 *510*
M2	— —	— —	— —	110 *360*	125 *410*	135 *445*	105 *345*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	120 *395*	135 *445*	145 *475*
M3	— —	— —	— —	95 *310*	115 *375*	125 *410*	95 *310*	110 *360*	125 *410*	90 *295*	110 *360*	120 *395*	85 *280*	105 *345*	115 *375*	105 *345*	120 *395*	130 *425*
M4	— —	— —	— —	80 *260*	100 *330*	105 *345*	80 *260*	100 *330*	105 *345*	75 *245*	95 *310*	105 *345*	70 *230*	90 *295*	95 *310*	90 *295*	105 *345*	115 *375*
M5	— —	— —	— —	70 *230*	85 *280*	95 *310*	70 *230*	85 *280*	95 *310*	65 *215*	85 *280*	90 *295*	60 *195*	75 *245*	85 *280*	80 *260*	95 *310*	105 *345*
K1	130 *425*	150 *490*	160 *520*	125 *410*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	135 *445*	150 *490*	160 *520*
K2	125 *410*	140 *460*	155 *510*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	145 *475*	110 *360*	125 *410*	140 *460*	105 *345*	120 *395*	130 *425*	130 *425*	145 *475*	155 *510*
K3	115 *375*	130 *425*	145 *475*	110 *360*	125 *410*	135 *445*	105 *345*	120 *395*	135 *445*	100 *330*	115 *375*	130 *425*	95 *310*	110 *360*	120 *395*	120 *395*	135 *445*	145 *475*
K4	115 *375*	130 *425*	140 *460*	105 *345*	120 *395*	135 *445*	100 *330*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*	90 *295*	105 *345*	115 *375*	115 *375*	130 *425*	140 *460*
K5	85 *280*	100 *330*	110 *360*	75 *245*	95 *310*	105 *345*	75 *245*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	60 *195*	75 *245*	85 *280*	85 *280*	105 *345*	110 *360*
K6	105 *345*	120 *395*	135 *445*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	120 *395*	80 *260*	100 *330*	110 *360*	105 *345*	125 *410*	135 *445*
K7	100 *330*	115 *375*	125 *410*	90 *295*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	85 *280*	100 *330*	110 *360*	75 *245*	90 *295*	100 *330*	100 *330*	120 *395*	125 *410*
N1	— —	— —	— —	— —	— —	— —	240 *790*	260 *850*	270 *890*	— —	— —	— —	230 *750*	245 *800*	255 *840*	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	190 *620*	205 *670*	215 *710*	— —	— —	— —	175 *570*	190 *620*	200 *660*	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	165 *540*	180 *590*	190 *620*	— —	— —	— —	150 *490*	165 *540*	175 *570*	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	170 *560*	190 *620*	200 *660*	— —	— —	— —	160 *520*	175 *570*	185 *610*	— —	— —	— —
S1	— —	— —	— —	42 *140*	55 *180*	65 *215*	39 *130*	55 *180*	60 *195*	37 *120*	49 *160*	55 *180*	34 *110*	45 *150*	50 *165*	48 *155*	65 *215*	75 *245*
S2	— —	— —	— —	34 *110*	44 *145*	50 *165*	32 *105*	42 *140*	49 *160*	30 *100*	39 *130*	46 *150*	27 *90*	36 *120*	42 *140*	38 *125*	50 *165*	60 *195*
S3	— —	— —	— —	29 *95*	39 *130*	45 *150*	28 *90*	37 *120*	43 *140*	26 *85*	34 *110*	40 *130*	24 *80*	31 *100*	37 *120*	34 *110*	44 *145*	50 *165*
S11	— —	— —	— —	60 *195*	75 *245*	85 *280*	55 *180*	70 *230*	80 *260*	50 *165*	70 *230*	75 *245*	47 *155*	60 *195*	70 *230*	65 *215*	85 *280*	95 *310*
S12	— —	— —	— —	40 *130*	55 *180*	60 *195*	38 *125*	50 *165*	60 *195*	36 *120*	47 *155*	55 *180*	32 *105*	43 *140*	50 *165*	47 *155*	60 *195*	70 *230*
S13	— —	— —	— —	23 *75*	31 *100*	36 *120*	22 *70*	30 *100*	34 *110*	21 *70*	28 *90*	32 *105*	19 *60*	25 *80*	29 *95*	27 *90*	35 *115*	42 *140*
H5	42 *140*	55 *180*	65 *215*	34 *110*	45 *150*	55 *180*	34 *110*	44 *145*	55 *180*	33 *110*	43 *140*	50 *165*	28 *90*	37 *120*	44 *145*	39 *130*	50 *165*	60 *195*
H8	45 *150*	60 *195*	70 *230*	36 *120*	48 *155*	55 *180*	36 *120*	48 *155*	55 *180*	35 *115*	46 *150*	55 *180*	30 *100*	40 *130*	47 *155*	41 *135*	55 *180*	65 *215*
H11	55 *180*	70 *230*	80 *260*	43 *140*	55 *180*	65 *215*	43 *140*	55 *180*	65 *215*	42 *140*	55 *180*	65 *215*	36 *120*	48 *155*	55 *180*	50 *165*	65 *215*	75 *245*
H12	80 *260*	95 *310*	105 *345*	70 *230*	90 *295*	95 *310*	70 *230*	85 *280*	95 *310*	65 *215*	80 *260*	90 *295*	55 *180*	70 *230*	80 *260*	80 *260*	95 *310*	105 *345*

R217/220.69-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			MS2500			MS2050			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	—	—	—	155	175	185	170	185	195	150	170	180	—	—	—
	—	—	—	*510*	*570*	*610*	*560*	*610*	*640*	*490*	*560*	*590*	—	—	—
P2	—	—	—	155	175	185	165	185	195	150	165	180	—	—	—
	—	—	—	*510*	*570*	*610*	*540*	*610*	*640*	*490*	*540*	*590*	—	—	—
P3	—	—	—	145	165	175	155	175	185	140	155	170	—	—	—
	—	—	—	*475*	*540*	*570*	*510*	*570*	*610*	*460*	*510*	*560*	—	—	—
P4	—	—	—	135	155	165	150	165	180	130	150	160	—	—	—
	—	—	—	*445*	*510*	*540*	*490*	*540*	*590*	*425*	*490*	*520*	—	—	—
P5	—	—	—	135	155	165	145	165	175	125	145	155	—	—	—
	—	—	—	*445*	*510*	*540*	*475*	*540*	*570*	*410*	*475*	*510*	—	—	—
P6	—	—	—	145	160	175	155	170	185	135	155	165	—	—	—
	—	—	—	*475*	*520*	*570*	*510*	*560*	*610*	*445*	*510*	*540*	—	—	—
P7	—	—	—	140	160	170	150	170	180	130	150	160	—	—	—
	—	—	—	*460*	*520*	*560*	*490*	*560*	*590*	*425*	*490*	*520*	—	—	—
P8	—	—	—	135	155	165	145	165	175	125	145	155	—	—	—
	—	—	—	*445*	*510*	*540*	*475*	*540*	*570*	*410*	*475*	*510*	—	—	—
P11	—	—	—	140	155	165	150	165	175	130	150	160	—	—	—
	—	—	—	*460*	*510*	*540*	*490*	*540*	*570*	*425*	*490*	*520*	—	—	—
P12	—	—	—	110	125	140	120	135	150	100	120	130	—	—	—
	—	—	—	*360*	*410*	*460*	*395*	*445*	*490*	*330*	*395*	*425*	—	—	—
M1	—	—	—	—	—	—	145	160	175	135	150	165	—	—	—
	—	—	—	—	—	—	*475*	*520*	*570*	*445*	*490*	*540*	—	—	—
M2	—	—	—	—	—	—	130	150	160	120	140	150	—	—	—
	—	—	—	—	—	—	*425*	*490*	*520*	*395*	*460*	*490*	—	—	—
M3	—	—	—	—	—	—	115	135	145	105	125	135	—	—	—
	—	—	—	—	—	—	*375*	*445*	*475*	*345*	*410*	*445*	—	—	—
M4	—	—	—	—	—	—	100	115	130	90	105	120	—	—	—
	—	—	—	—	—	—	*330*	*375*	*425*	*295*	*345*	*395*	—	—	—
M5	—	—	—	—	—	—	85	105	115	75	95	105	—	—	—
	—	—	—	—	—	—	*280*	*345*	*375*	*245*	*310*	*345*	—	—	—
K1	155	175	185	160	180	190	—	—	—	—	—	—	—	—	—
	510	*570*	*610*	*520*	*590*	*620*	—	—	—	—	—	—	—	—	—
K2	150	165	180	155	170	180	—	—	—	—	—	—	—	—	—
	490	*540*	*590*	*510*	*560*	*590*	—	—	—	—	—	—	—	—	—
K3	135	155	170	140	160	170	—	—	—	—	—	—	—	—	—
	445	*510*	*560*	*460*	*520*	*560*	—	—	—	—	—	—	—	—	—
K4	135	155	165	140	155	170	—	—	—	—	—	—	—	—	—
	445	*510*	*540*	*460*	*510*	*560*	—	—	—	—	—	—	—	—	—
K5	100	120	130	105	125	135	—	—	—	—	—	—	—	—	—
	330	*395*	*425*	*345*	*410*	*445*	—	—	—	—	—	—	—	—	—
K6	125	145	155	130	150	160	—	—	—	—	—	—	—	—	—
	410	*475*	*510*	*425*	*490*	*520*	—	—	—	—	—	—	—	—	—
K7	120	135	150	120	140	150	—	—	—	—	—	—	—	—	—
	395	*445*	*490*	*395*	*460*	*490*	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	260	280	290
	—	—	—	—	—	—	—	—	—	—	—	—	*850*	*920*	*950*
N2	—	—	—	—	—	—	—	—	—	—	—	—	200	220	230
	—	—	—	—	—	—	—	—	—	—	—	—	*660*	*720*	*750*
N3	—	—	—	—	—	—	—	—	—	—	—	—	175	195	205
	—	—	—	—	—	—	—	—	—	—	—	—	*570*	*640*	*670*
N11	—	—	—	—	—	—	—	—	—	—	—	—	185	200	215
	—	—	—	—	—	—	—	—	—	—	—	—	*610*	*660*	*710*
S1	—	—	—	—	—	—	55	70	80	44	55	70	—	—	—
	—	—	—	—	—	—	*180*	*230*	*260*	*145*	*180*	*230*	—	—	—
S2	—	—	—	—	—	—	43	55	65	35	46	55	—	—	—
	—	—	—	—	—	—	*140*	*180*	*215*	*115*	*150*	*180*	—	—	—
S3	—	—	—	—	—	—	38	49	60	31	40	48	—	—	—
	—	—	—	—	—	—	*125*	*160*	*195*	*100*	*130*	*155*	—	—	—
S11	—	—	—	—	—	—	75	90	105	60	80	90	—	—	—
	—	—	—	—	—	—	*245*	*295*	*345*	*195*	*260*	*295*	—	—	—
S12	—	—	—	—	—	—	50	70	80	43	55	65	—	—	—
	—	—	—	—	—	—	*165*	*230*	*260*	*140*	*180*	*215*	—	—	—
S13	—	—	—	—	—	—	30	39	47	24	32	38	—	—	—
	—	—	—	—	—	—	*100*	*130*	*155*	*80*	*105*	*125*	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

Helical Turbo 18 – R217.69-18 – Metric





- For insert selection and cutting data recommendations, see page(s) 144-146
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
R217.69-3240.3S-047-18.2AN	02710003	Seco-Weldon	40,0	2	6	47,0	32,0	60,0	57,0	130,0	9900	0,8	XO.X18..
R217.69-3250.3S-047-18.3AN	02710010	Seco-Weldon	50,0	3	9	47,0	32,0	60,0	65,0	134,5	8900	1,1	XO.X18..

Modification of the cutter body needed for radii > 3,1 mm

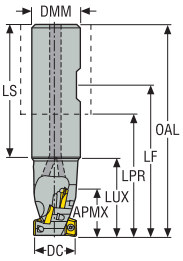
Spare Parts

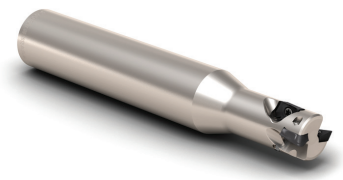
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..	C04510-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 18 – R217.69-18 – Inch





- For insert selection and cutting data recommendations, see page(s) 144-146
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.69-01.50-3-18S2AN	02710923	Weldon	1.500	2	6	1.862	1.500	2.689	2.618	5.439	9900	2.200	XO.X18
R217.69-02.00-3-18S3AN	02710934	Weldon	2.000	3	9	1.850	1.500	2.689	2.802	5.491	8900	2.870	XO.X18

Modification of the cutter body needed for radii > 0.122 in

Spare Parts

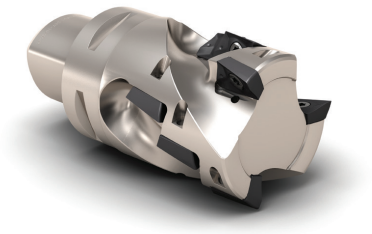
For cutter	Insert screw
R217.69-..	C04510-T20P

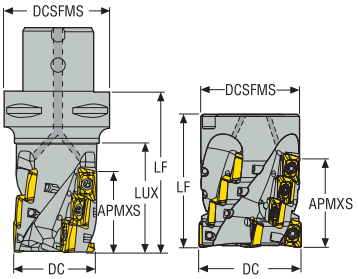
Accessories

Torque key	Torque value
T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 18 – R217/220.69-18 – Metric





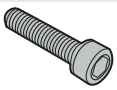
- For insert selection and cutting data recommendations, see page(s) 144-146
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
C5-R217.69-040-047-18.2AN	02717849	Seco-Capto	40,0	2	6	47,0	–	–	50,0	82,0	58,0	9900	0,8	XO.X18..
C6-R217.69-050-062-18.3AN	02717919	Seco-Capto	50,0	3	12	62,0	–	–	63,0	99,0	73,0	8900	1,5	XO.X18..
C5-R217.69-054-047-18.3AN	02717916	Seco-Capto	54,0	3	9	47,0	–	–	50,0	82,0	62,0	8600	1,1	XO.X18..
C6-R217.69-066-047-18.4AN	02717933	Seco-Capto	66,0	4	12	47,0	–	–	63,0	84,0	62,0	7700	1,7	XO.X18..
C8-R217.69-080-093-18.5SAN	02829948	Seco-Capto	80,0	5	30	93,0	–	–	80,0	140,0	110,0	7000	4,2	XO.X18..
R220.69-00063-047-18.4AN	02710017	Arbor	63,0	4	12	47,0	27,0	–	60,0	70,0	–	7900	0,8	XO.X18..
R220.69-00063-062-18.3AN	02710032	Arbor	63,0	3	12	62,0	27,0	–	60,0	85,0	–	7900	1,1	XO.X18..
R220.69-00063-062-18.4AN	02710034	Arbor	63,0	4	16	62,0	27,0	–	60,0	85,0	–	7900	1,0	XO.X18..
R220.69-00063-077-18.4SAN	02717825	Arbor	63,0	4	20	77,0	27,0	–	60,0	100,0	–	7900	1,3	XO.X18..
R220.69-00080-047-18.5AN	02710037	Arbor	80,0	5	15	47,0	32,0	–	77,0	70,0	–	7000	1,6	XO.X18..
R220.69-00080-062-18.5AN	02710039	Arbor	80,0	5	20	62,0	32,0	–	77,0	85,0	–	7000	1,9	XO.X18..
R220.69-00080-077-18.4SAN	02717831	Arbor	80,0	4	20	77,0	32,0	–	77,0	100,0	–	7000	2,4	XO.X18..
R220.69-00100-062-18.6AN	02710042	Arbor	100,0	6	24	62,0	40,0	–	90,0	85,0	–	6300	3,1	XO.X18..
R220.69-00100-077-18.5SAN	02717833	Arbor	100,0	5	25	77,0	40,0	–	90,0	100,0	–	6300	4,0	XO.X18..

Modification of the cutter body needed for radii > 3,1 mm

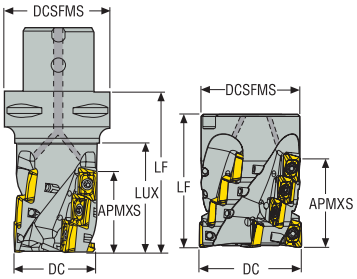
Spare Parts

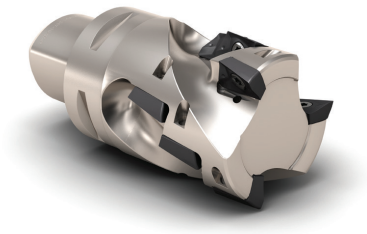
Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
						
Cx-R217.69-..	–	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
C8-R217.69-080	MC6S16X40	C8-R217.69-080-062-18.5BAN	C04510-T20P	R220.69-RE080031-18.5AN	T00-20P50	44.3IN.LBS
R220.69-00063	MC6S12X60	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-00063-SAN	MP6S12X80	R220.69-00063046-18.4BAN	C04510-T20P	R220.69-RE063031-18.4AN	T00-20P50	44.3IN.LBS
R220.69-00080	MC6S16X70	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-00080-SAN	MP6S16X80	R220.69-00080046-18.4BAN	C04510-T20P	R220.69-RE080031-18.4AN	T00-20P50	44.3IN.LBS
R220.69-00100	MC6S20X70	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-00100-SAN	MP6S20X80	R220.69-00100046-18.5BAN	C04510-T20P	R220.69-RE100031-18.5AN	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical Turbo 18 – R217/220.69-18 – Inch





- For insert selection and cutting data recommendations, see page(s) 144-146
- For complete insert programme, see page(s) 782, 783
- For ISO attribute explanation, see page 16
- KAPRS 90°

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			Inch			Inch	Inch		Inch	Inch	Inch		lbs	
C5-R217.69-02.00-18S3AN	02721714	Seco-Capto	2.000	3	6	1.854	–	–	1.969	3.228	2.441	8900	2.200	XO.X18
C6-R217.69-02.00-18M3AN	02721715	Seco-Capto	2.000	3	12	2.441	–	–	2.480	3.898	3.031	8900	2.430	XO.X18
C6-R217.69-02.50-18M4AN	02721716	Seco-Capto	2.500	4	16	2.409	–	–	2.480	3.898	3.898	7900	3.090	XO.X18
R220.69-02.50-18S4AN	02710940	Arbor	2.500	4	12	1.866	1.000	–	2.441	2.750	–	7900	2.200	XO.X18
R220.69-02.50-18M4AN	02710937	Arbor	2.500	4	16	2.441	1.000	–	2.441	3.346	–	7900	2.200	XO.X18
R220.69-02.50-18L4SAN	02722279	Arbor	2.500	4	20	3.024	1.000	–	2.441	3.937	–	7900	7.720	XO.X18
R220.69-03.00-18M5AN	02710942	Arbor	3.000	5	20	2.480	1.250	–	2.890	3.500	–	7000	3.970	XO.X18
R220.69-03.00-18L4SAN	02722281	Arbor	3.000	4	20	3.024	1.250	–	2.890	3.937	–	7000	6.610	XO.X18
R220.69-04.00-18L5SAN	02722282	Arbor	4.000	5	25	3.024	1.500	–	3.543	3.937	–	6300	8.820	XO.X18

Modification of the cutter body needed for radii > 0.122 in

Spare Parts

Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
Cx-R217.69-..	–	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-02.50S	UC6S1/2UNFX2-1/2	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-02.50M	UC6S1/2UNFX3	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-02.50L	UP6S1/2UNFX3-1/4	R220.69-02.50-18L4BAN	C04510-T20P	R220.69-02.50-RE-18.4AN	T00-20P50	44.3IN.LBS
R220.69-03.00M	UC6S5/8UNFX3	–	C04510-T20P	–	T00-20P50	44.3IN.LBS
R220.69-03.00S	UP6S5/8UNFX3-1/4	R220.69-03.00-18L4BAN	C04510-T20P	R220.69-03.00-RE-18.4AN	T00-20P50	44.3IN.LBS
R220.69-04.00S	UP6S3/4UNFX3-1/4	R220.69-04.00-18L5BAN	C04510-T20P	R220.69-04.00-RE-18.5AN	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.69-18 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	XOMX180608TR-ME13 MP2501	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
P2	XOMX180608TR-ME13 MP2501	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
P3	XOMX180608TR-ME13 MP2501	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
P4	XOMX180608TR-M14 MP2501	0,15 *0.0060*	0,16 *0.0065*	0,25 *0.010*
P5	XOMX180608TR-M14 MP2501	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
P6	XOMX180608TR-M14 MP2501	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P7	XOMX180608TR-M14 MP2501	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P8	XOMX180608TR-M14 MP2501	0,15 *0.0060*	0,17 *0.0065*	0,25 *0.010*
P11	XOMX180608TR-M14 T350M	0,14 *0.0055*	0,16 *0.0065*	0,24 *0.0095*
P12	XOMX180608TR-M14 T350M	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M1	XOMX180608R-M10 MS2050	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
M2	XOMX180608R-M10 MS2050	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M3	XOMX180608R-M10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M4	XOMX180608TR-M14 T350M	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M5	XOMX180608TR-M14 T350M	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
K1	XOMX180608TR-MD15 MK2050	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K2	XOMX180608TR-MD15 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K3	XOMX180608TR-MD15 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K4	XOMX180608TR-MD15 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K5	XOMX180608TR-MD15 MK2050	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
K6	XOMX180608TR-MD15 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K7	XOMX180608TR-MD15 MK2050	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
N1	XOEX180608FR-E10 H25	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
N2	XOEX180608FR-E10 H25	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
N3	XOEX180608FR-E10 H25	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
N11	XOEX180608FR-E10 H25	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
S1	XOMX180608R-M10 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S2	XOMX180608R-M10 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S3	XOMX180608R-M10 F40M	0,070 *0.0028*	0,075 *0.0030*	0,11 *0.0044*
S11	XOMX180608R-M10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S12	XOMX180608R-M10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S13	XOMX180608R-M10 MS2050	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H5	XOMX180608TR-MD15 MP3000	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
H8	XOMX180608TR-MD15 MP3000	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*
H11	XOMX180608TR-MD15 MP3000	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
H12	XOMX180608TR-MD15 MP3000	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*

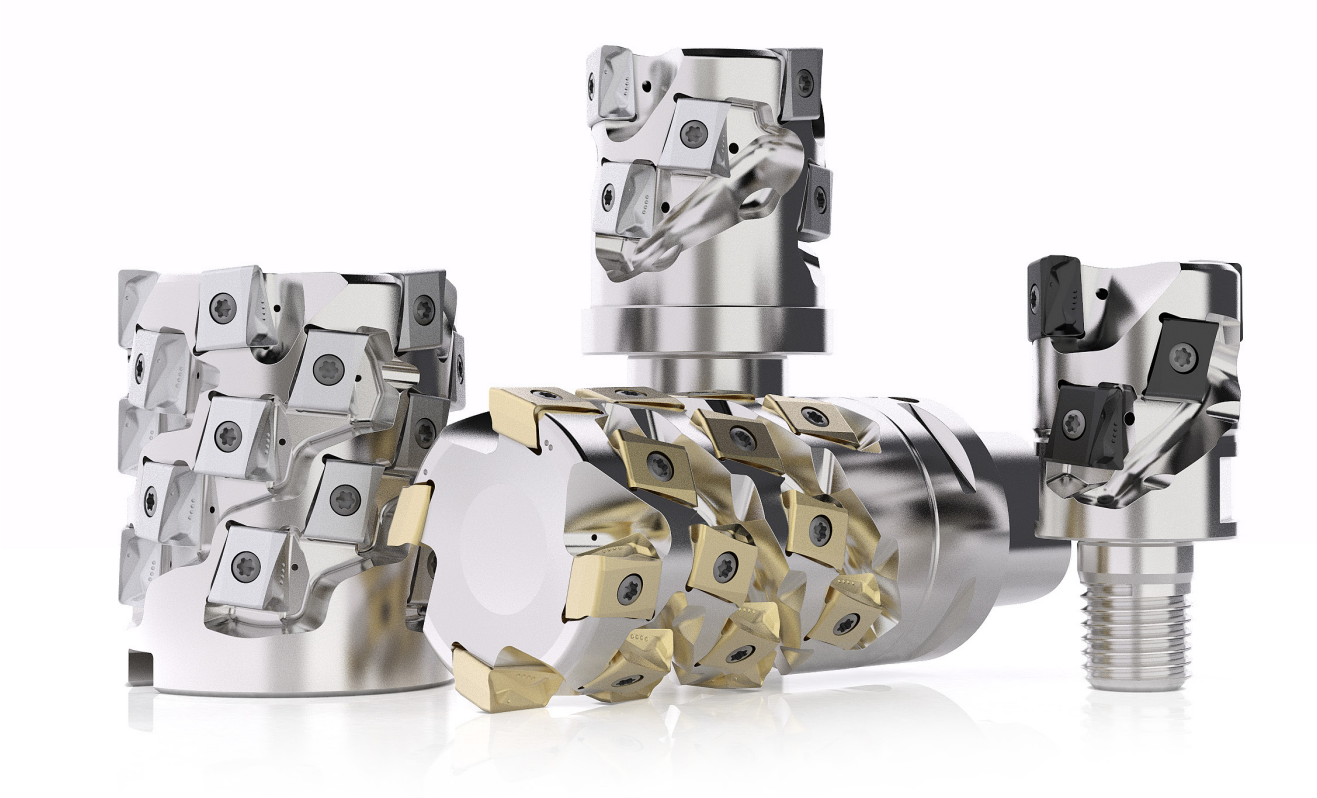
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.69-18 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			T350M			F40M		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	150 *490*	165 *540*	175 *570*	140 *460*	160 *520*	170 *560*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	160 *520*	125 *410*	140 *460*	155 *510*
P2	145 *475*	165 *540*	175 *570*	140 *460*	155 *510*	170 *560*	135 *445*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*
P3	140 *460*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	145 *475*
P4	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	115 *375*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*
P5	130 *425*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	105 *345*	120 *395*	135 *445*
P6	135 *445*	155 *510*	165 *540*	130 *425*	145 *475*	155 *510*	125 *410*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*
P7	135 *445*	150 *490*	160 *520*	125 *410*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*
P8	130 *425*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	105 *345*	120 *395*	130 *425*
P11	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	115 *375*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*
P12	105 *345*	125 *410*	135 *445*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	80 *260*	100 *330*	110 *360*
M1	— —	— —	— —	120 *395*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	140 *460*
M2	— —	— —	— —	110 *360*	125 *410*	135 *445*	105 *345*	125 *410*	135 *445*	105 *345*	120 *395*	130 *425*	100 *330*	115 *375*	125 *410*
M3	— —	— —	— —	95 *310*	115 *375*	125 *410*	95 *310*	110 *360*	125 *410*	90 *295*	110 *360*	120 *395*	85 *280*	105 *345*	115 *375*
M4	— —	— —	— —	80 *260*	100 *330*	110 *360*	80 *260*	100 *330*	105 *345*	80 *260*	95 *310*	105 *345*	70 *230*	90 *295*	100 *330*
M5	— —	— —	— —	70 *230*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	65 *215*	85 *280*	95 *310*	60 *195*	80 *260*	90 *295*
K1	135 *445*	150 *490*	160 *520*	125 *410*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*
K2	125 *410*	145 *475*	155 *510*	120 *395*	135 *445*	145 *475*	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	140 *460*	100 *330*	120 *395*	130 *425*
K3	115 *375*	135 *445*	145 *475*	110 *360*	125 *410*	135 *445*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	90 *295*	110 *360*	120 *395*
K4	115 *375*	130 *425*	140 *460*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	95 *310*	115 *375*	125 *410*	90 *295*	105 *345*	115 *375*
K5	85 *280*	100 *330*	110 *360*	75 *245*	95 *310*	105 *345*	75 *245*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	60 *195*	80 *260*	85 *280*
K6	105 *345*	125 *410*	135 *445*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	120 *395*	80 *260*	100 *330*	110 *360*
K7	100 *330*	115 *375*	125 *410*	90 *295*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	85 *280*	100 *330*	110 *360*	75 *245*	90 *295*	100 *330*
N1	— —	— —	— —	— —	— —	— —	245 *800*	260 *850*	270 *890*	— —	— —	— —	230 *750*	245 *800*	255 *840*
N2	— —	— —	— —	— —	— —	— —	190 *620*	205 *670*	215 *710*	— —	— —	— —	175 *570*	190 *620*	200 *660*
N3	— —	— —	— —	— —	— —	— —	165 *540*	180 *590*	190 *620*	— —	— —	— —	150 *490*	165 *540*	180 *590*
N11	— —	— —	— —	— —	— —	— —	170 *560*	190 *620*	200 *660*	— —	— —	— —	160 *520*	175 *570*	185 *610*
S1	— —	— —	— —	42 *140*	55 *180*	65 *215*	40 *130*	50 *165*	60 *195*	38 *125*	50 *165*	60 *195*	34 *110*	45 *150*	55 *180*
S2	— —	— —	— —	34 *110*	45 *150*	55 *180*	32 *105*	42 *140*	50 *165*	30 *100*	40 *130*	47 *155*	28 *90*	36 *120*	43 *140*
S3	— —	— —	— —	30 *100*	40 *130*	46 *150*	28 *90*	37 *120*	44 *145*	27 *90*	35 *115*	41 *135*	24 *80*	32 *105*	38 *125*
S11	— —	— —	— —	60 *195*	75 *245*	85 *280*	55 *180*	70 *230*	80 *260*	50 *165*	70 *230*	80 *260*	47 *155*	60 *195*	75 *245*
S12	— —	— —	— —	40 *130*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*	36 *120*	48 *155*	55 *180*	33 *110*	43 *140*	50 *165*
S13	— —	— —	— —	24 *80*	31 *100*	37 *120*	22 *70*	29 *95*	35 *115*	21 *70*	28 *90*	33 *110*	19 *60*	25 *80*	30 *100*
H5	43 *140*	55 *180*	65 *215*	34 *110*	46 *150*	55 *180*	34 *110*	44 *145*	50 *165*	33 *110*	44 *145*	50 *165*	29 *95*	38 *125*	45 *150*
H8	46 *150*	60 *195*	70 *230*	37 *120*	49 *160*	55 *180*	36 *120*	47 *155*	55 *180*	36 *120*	47 *155*	55 *180*	31 *100*	40 *130*	48 *155*
H11	55 *180*	70 *230*	80 *260*	44 *145*	60 *195*	70 *230*	43 *140*	55 *180*	65 *215*	42 *140*	55 *180*	65 *215*	37 *120*	48 *155*	55 *180*
H12	80 *260*	95 *310*	105 *345*	70 *230*	90 *295*	100 *330*	70 *230*	85 *280*	95 *310*	65 *215*	80 *260*	90 *295*	55 *180*	70 *230*	80 *260*

R217/220.69-18 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M			MK1500			MK2050			MS2050			H25		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	130 *425*	145 *475*	155 *510*	— —	— —	— —	140 *460*	155 *510*	165 *540*	140 *460*	155 *510*	165 *540*	— —	— —	— —
P2	125 *410*	145 *475*	155 *510*	— —	— —	— —	140 *460*	155 *510*	165 *540*	135 *445*	155 *510*	165 *540*	— —	— —	— —
P3	120 *395*	135 *445*	145 *475*	— —	— —	— —	130 *425*	145 *475*	155 *510*	130 *425*	145 *475*	155 *510*	— —	— —	— —
P4	110 *360*	130 *425*	140 *460*	— —	— —	— —	120 *395*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	— —	— —	— —
P5	110 *360*	125 *410*	135 *445*	— —	— —	— —	120 *395*	135 *445*	145 *475*	120 *395*	135 *445*	145 *475*	— —	— —	— —
P6	115 *375*	130 *425*	145 *475*	— —	— —	— —	125 *410*	145 *475*	155 *510*	125 *410*	145 *475*	155 *510*	— —	— —	— —
P7	115 *375*	130 *425*	140 *460*	— —	— —	— —	125 *410*	140 *460*	150 *490*	125 *410*	140 *460*	150 *490*	— —	— —	— —
P8	110 *360*	125 *410*	135 *445*	— —	— —	— —	120 *395*	135 *445*	145 *475*	120 *395*	135 *445*	145 *475*	— —	— —	— —
P11	110 *360*	125 *410*	140 *460*	— —	— —	— —	120 *395*	140 *460*	150 *490*	120 *395*	140 *460*	150 *490*	— —	— —	— —
P12	85 *280*	100 *330*	110 *360*	— —	— —	— —	95 *310*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	— —	— —	— —
M1	115 *375*	130 *425*	140 *460*	— —	— —	— —	— —	— —	— —	125 *410*	140 *460*	150 *490*	— —	— —	— —
M2	100 *330*	120 *395*	130 *425*	— —	— —	— —	— —	— —	— —	115 *375*	130 *425*	140 *460*	— —	— —	— —
M3	90 *295*	105 *345*	115 *375*	— —	— —	— —	— —	— —	— —	100 *330*	115 *375*	125 *410*	— —	— —	— —
M4	75 *245*	90 *295*	100 *330*	— —	— —	— —	— —	— —	— —	85 *280*	100 *330*	110 *360*	— —	— —	— —
M5	65 *215*	80 *260*	90 *295*	— —	— —	— —	— —	— —	— —	75 *245*	90 *295*	100 *330*	— —	— —	— —
K1	110 *360*	130 *425*	140 *460*	145 *475*	160 *520*	175 *570*	140 *460*	160 *520*	170 *560*	— —	— —	— —	— —	— —	— —
K2	105 *345*	120 *395*	135 *445*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	165 *540*	— —	— —	— —	— —	— —	— —
K3	95 *310*	110 *360*	125 *410*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	155 *510*	— —	— —	— —	— —	— —	— —
K4	90 *295*	110 *360*	120 *395*	125 *410*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	— —	— —	— —	— —	— —	— —
K5	65 *215*	80 *260*	90 *295*	95 *310*	115 *375*	125 *410*	95 *310*	110 *360*	120 *395*	— —	— —	— —	— —	— —	— —
K6	85 *280*	100 *330*	110 *360*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	— —	— —	— —	— —	— —	— —
K7	80 *260*	95 *310*	105 *345*	110 *360*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*	— —	— —	— —	— —	— —	— —
N1	230 *750*	250 *820*	260 *850*	— —	— —	— —	— —	— —	— —	— —	— —	— —	235 *770*	255 *840*	265 *870*
N2	180 *590*	195 *640*	205 *670*	— —	— —	— —	— —	— —	— —	— —	— —	— —	185 *610*	200 *660*	210 *690*
N3	155 *510*	170 *560*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —	160 *520*	175 *570*	185 *610*
N11	160 *520*	180 *590*	190 *620*	— —	— —	— —	— —	— —	— —	— —	— —	— —	165 *540*	185 *610*	195 *640*
S1	36 *120*	47 *155*	55 *180*	— —	— —	— —	— —	— —	— —	42 *140*	55 *180*	65 *215*	— —	— —	— —
S2	29 *95*	38 *125*	45 *150*	— —	— —	— —	— —	— —	— —	34 *110*	45 *150*	55 *180*	— —	— —	— —
S3	25 *80*	34 *110*	39 *130*	— —	— —	— —	— —	— —	— —	30 *100*	39 *130*	46 *150*	— —	— —	— —
S11	49 *160*	65 *215*	75 *245*	— —	— —	— —	— —	— —	— —	60 *195*	75 *245*	85 *280*	— —	— —	— —
S12	28 *90*	38 *125*	45 *150*	— —	— —	— —	— —	— —	— —	40 *130*	55 *180*	65 *215*	— —	— —	— —
S13	17 *55*	22 *70*	26 *85*	— —	— —	— —	— —	— —	— —	24 *80*	31 *100*	37 *120*	— —	— —	— —
H5	30 *100*	40 *130*	47 *155*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	32 *105*	42 *140*	50 *165*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	38 *125*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	60 *195*	75 *245*	85 *280*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —



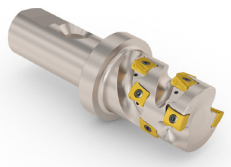
SQUARE T4 HELICAL

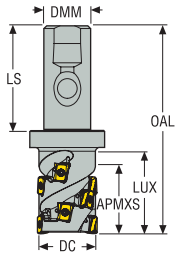
The Square T4 Helical cutter range takes our diverse milling portfolio to the next level with tools that features tangentially mounted inserts, each having 4 cutting edges.

- T4 Helical Insert size 08, cutter range 25-54mm (1 - 2 inch)
- T4 Helical Insert size 12, cutter range 50-100mm (2 - 4 inch)

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Helical T4 08 – R217.94-08 – Metric





- For insert selection and cutting data recommendations, see page(s) 151-152
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
R217.94-2025.3S-029-08.2A	02926806	Seco-Weldon	25,0	2	8	29,0	20,0	50,0	44,0	100,0	20800	0,3	LOEX08..
R217.94-2025.3S-036-08.2A	02926807	Seco-Weldon	25,0	2	10	36,0	20,0	50,0	44,0	100,0	20800	0,3	LOEX08..
R217.94-2025.3S-043-08.2A	02926809	Seco-Weldon	25,0	2	12	43,0	20,0	50,0	49,0	105,0	20800	0,3	LOEX08..
R217.94-2532.3S-043-08.3A	02926813	Seco-Weldon	32,0	3	18	43,0	25,0	56,0	55,0	121,0	18400	0,5	LOEX08..
R217.94-2532.3S-050-08.3A	02926814	Seco-Weldon	32,0	3	21	50,0	25,0	56,0	59,0	125,0	18400	0,5	LOEX08..
R217.94-3240.3S-036-08.3A	02926815	Seco-Weldon	40,0	3	15	36,0	32,0	60,0	45,0	115,0	16400	0,8	LOEX08..
R217.94-3240.3S-050-08.4A	02926816	Seco-Weldon	40,0	4	28	50,0	32,0	60,0	60,0	130,0	16400	0,9	LOEX08..

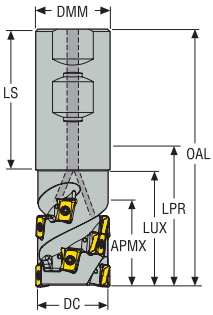
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.94-..	C02708B-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical T4 08 – R217.94-08 – Inch



- For insert selection and cutting data recommendations, see page(s) 151-152
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.94-01.00-3-01.40-08-2A	02941522	Weldon	0.996	2	10	1.417	1.000	2.382	1.870	4.252	20800	0.880	LOEX08..
R217.94-01.00-3-01.70-08-2A	02941527	Weldon	0.996	2	12	1.693	1.000	2.382	2.106	4.488	20800	0.880	LOEX08..
R217.94-01.25-3-01.40-08-2A	02941523	Weldon	1.246	2	10	1.417	1.250	2.382	1.949	4.331	18400	1.320	LOEX08..
R217.94-01.50-3-02.00-08-4A	02941529	Weldon	1.496	4	28	1.969	1.250	2.323	2.677	5.000	16400	1.540	LOEX08..

Spare Parts

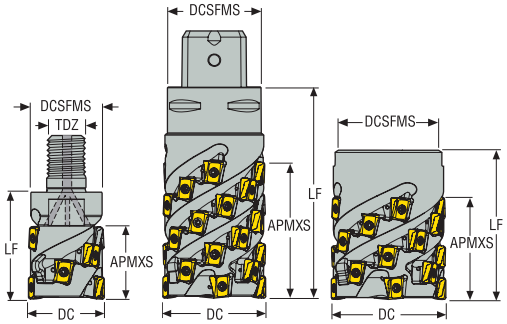
Accessories

For cutter	Insert screw	Torque key	Torque value
R127.94-..	C02708B-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Helical T4 08 – R217/220.94-08 – Metric



- For insert selection and cutting data recommendations, see page(s) 151-152
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
R217.94-1225.RE-029-08.2A	02926803	Combimaster	25,0	2	8	29,0	–	M12	23,0	40,0	–	20800	0,1	LOEX08..
R217.94-1632.RE-036-08.3A	02926805	Combimaster	32,0	3	15	36,0	–	M16	30,0	55,0	–	18400	0,3	LOEX08..
R217.94-2040.RE-043-08.4A	02972768	Combimaster	40,0	4	24	43,0	–	M20	36,5	60,0	–	16400	0,45	LOEX08..
C4-R217.94-044-057-08.4A	02926819	Seco-Capto	44,0	4	32	57,0	–	–	40,0	90,0	70,0	15500	0,8	LOEX08..
C5-R217.94-054-064-08.5A	02926820	Seco-Capto	54,0	5	45	64,0	–	–	50,0	98,0	78,0	14800	1,4	LOEX08..
R220.94-00050-043-08.4A	02926817	Arbor	50,0	4	24	43,0	27,0	–	48,0	65,0	–	14800	0,6	LOEX08..
R220.94-00050-057-08.5A	02926818	Arbor	50,0	5	40	57,0	27,0	–	48,0	70,0	–	14800	0,6	LOEX08..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.94-../Cx-217.94-..	–	C02708B-T08P	T00-08P12	1.2NM
R220.94-..	MC6S12X60	C02708B-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.94-08 – Insert selection – mm/*Inch*

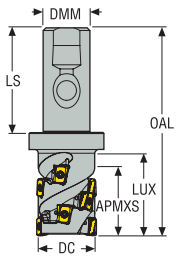
SMG		f_z		
		100%	30%	10%
P1	LOEX080408TR-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
P2	LOEX080408TR-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
P3	LOEX080408TR-M08 F40M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
P4	LOEX080408TR-M08 F40M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
P5	LOEX080408TR-M08 F40M	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
P6	LOEX080408TR-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*
P7	LOEX080408TR-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*
P8	LOEX080408TR-M08 F40M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
P11	LOEX080408TR-M08 MS2050	0,080 *0.0032*	0,090 *0.0036*	0,14 *0.0055*
P12	LOEX080408TR-M08 MS2050	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*
M1	LOEX080408TR-M08 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M2	LOEX080408TR-M08 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M3	LOEX080408TR-M08 MS2050	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
M4	LOEX080408TR-M08 MS2050	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*
M5	LOEX080408TR-M08 MS2050	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*
K1	LOEX080408TR-MD08 MK2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
K2	LOEX080408TR-MD08 MK2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
K3	LOEX080408TR-MD08 MK2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
K4	LOEX080408TR-MD08 MK2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
K5	LOEX080408TR-MD08 MK2050	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*
K6	LOEX080408TR-MD08 MK2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
K7	LOEX080408TR-MD08 MK2050	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*
N1	LOEX080408TR-M08 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
N2	LOEX080408TR-M08 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
N3	LOEX080408TR-M08 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
N11	LOEX080408TR-M08 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
S1	LOEX080408TR-M08 F40M	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*
S2	LOEX080408TR-M08 F40M	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*
S3	LOEX080408TR-M08 F40M	0,055 *0.0022*	0,060 *0.0024*	0,090 *0.0036*
S11	LOEX080408TR-M08 MS2050	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
S12	LOEX080408TR-M08 MS2050	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
S13	LOEX080408TR-M08 MS2050	0,060 *0.0024*	0,065 *0.0026*	0,095 *0.0038*
H5	LOEX080408TR-M08 MP3000	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*
H8	LOEX080408TR-M08 MP3000	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*
H11	LOEX080408TR-M08 MP3000	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*
H12	LOEX080408TR-M08 MP3000	0,044 *0.0017*	0,048 *0.0019*	0,070 *0.0028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.94-08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP3000			MK2050			MS2050			MP2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*	140 *460*	155 *510*	165 *540*	135 *445*	150 *490*	155 *510*	140 *460*	155 *510*	165 *540*
P2	125 *410*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*	140 *460*	155 *510*	165 *540*	130 *425*	145 *475*	155 *510*	140 *460*	155 *510*	165 *540*
P3	120 *395*	135 *445*	145 *475*	130 *425*	145 *475*	155 *510*	130 *425*	145 *475*	155 *510*	125 *410*	140 *460*	150 *490*	130 *425*	145 *475*	155 *510*
P4	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	125 *410*	140 *460*	150 *490*
P5	110 *360*	125 *410*	135 *445*	120 *395*	135 *445*	145 *475*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*
P6	115 *375*	130 *425*	140 *460*	130 *425*	145 *475*	150 *490*	130 *425*	145 *475*	150 *490*	120 *395*	135 *445*	145 *475*	130 *425*	145 *475*	150 *490*
P7	115 *375*	130 *425*	135 *445*	125 *410*	140 *460*	150 *490*	125 *410*	140 *460*	150 *490*	120 *395*	135 *445*	140 *460*	125 *410*	140 *460*	150 *490*
P8	110 *360*	125 *410*	135 *445*	120 *395*	135 *445*	145 *475*	120 *395*	135 *445*	145 *475*	115 *375*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*
P11	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	145 *475*	125 *410*	140 *460*	150 *490*	115 *375*	130 *425*	140 *460*	125 *410*	140 *460*	150 *490*
P12	85 *280*	100 *330*	110 *360*	100 *330*	115 *375*	125 *410*	100 *330*	115 *375*	125 *410*	95 *310*	110 *360*	115 *375*	100 *330*	115 *375*	125 *410*
M1	115 *375*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*	— —	— —	— —	120 *395*	135 *445*	145 *475*	120 *395*	135 *445*	145 *475*
M2	105 *345*	120 *395*	130 *425*	110 *360*	125 *410*	135 *445*	— —	— —	— —	110 *360*	125 *410*	135 *445*	110 *360*	125 *410*	135 *445*
M3	90 *295*	105 *345*	115 *375*	100 *330*	115 *375*	125 *410*	— —	— —	— —	95 *310*	110 *360*	120 *395*	100 *330*	115 *375*	120 *395*
M4	75 *245*	90 *295*	100 *330*	85 *280*	100 *330*	110 *360*	— —	— —	— —	80 *260*	100 *330*	105 *345*	85 *280*	100 *330*	110 *360*
M5	65 *215*	80 *260*	90 *295*	75 *245*	90 *295*	100 *330*	— —	— —	— —	75 *245*	90 *295*	95 *310*	75 *245*	90 *295*	100 *330*
K1	115 *375*	130 *425*	140 *460*	125 *410*	140 *460*	150 *490*	145 *475*	160 *520*	165 *540*	— —	— —	— —	125 *410*	140 *460*	150 *490*
K2	105 *345*	120 *395*	130 *425*	120 *395*	135 *445*	145 *475*	135 *445*	150 *490*	160 *520*	— —	— —	— —	120 *395*	135 *445*	145 *475*
K3	95 *310*	115 *375*	120 *395*	110 *360*	125 *410*	135 *445*	125 *410*	140 *460*	150 *490*	— —	— —	— —	110 *360*	125 *410*	135 *445*
K4	95 *310*	110 *360*	120 *395*	105 *345*	120 *395*	130 *425*	125 *410*	140 *460*	150 *490*	— —	— —	— —	105 *345*	125 *410*	130 *425*
K5	70 *230*	85 *280*	90 *295*	80 *260*	95 *310*	105 *345*	95 *310*	115 *375*	120 *395*	— —	— —	— —	80 *260*	95 *310*	105 *345*
K6	85 *280*	105 *345*	110 *360*	100 *330*	115 *375*	125 *410*	115 *375*	135 *445*	140 *460*	— —	— —	— —	100 *330*	115 *375*	125 *410*
K7	80 *260*	95 *310*	105 *345*	95 *310*	110 *360*	115 *375*	110 *360*	125 *410*	135 *445*	— —	— —	— —	95 *310*	110 *360*	120 *395*
N1	220 *720*	240 *790*	245 *800*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	175 *570*	190 *620*	195 *640*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	150 *490*	165 *540*	175 *570*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	160 *520*	175 *570*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	39 *130*	50 *165*	60 *195*	45 *150*	60 *195*	70 *230*	— —	— —	— —	42 *140*	55 *180*	65 *215*	46 *150*	60 *195*	70 *230*
S2	31 *100*	41 *135*	48 *155*	36 *120*	47 *155*	55 *180*	— —	— —	— —	34 *110*	45 *150*	55 *180*	37 *120*	49 *160*	55 *180*
S3	27 *90*	36 *120*	42 *140*	32 *105*	42 *140*	49 *160*	— —	— —	— —	30 *100*	39 *130*	46 *150*	32 *105*	43 *140*	50 *165*
S11	55 *180*	70 *230*	80 *260*	65 *215*	75 *245*	85 *280*	— —	— —	— —	60 *195*	75 *245*	85 *280*	65 *215*	80 *260*	85 *280*
S12	38 *125*	49 *160*	60 *195*	44 *145*	55 *180*	65 *215*	— —	— —	— —	42 *140*	55 *180*	65 *215*	44 *145*	60 *195*	65 *215*
S13	22 *70*	29 *95*	34 *110*	25 *80*	33 *110*	39 *130*	— —	— —	— —	24 *80*	31 *100*	37 *120*	26 *85*	34 *110*	40 *130*
H5	33 *110*	43 *140*	50 *165*	39 *130*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —	37 *120*	49 *160*	55 *180*
H8	35 *115*	45 *150*	55 *180*	40 *130*	55 *180*	60 *195*	— —	— —	— —	— —	— —	— —	40 *130*	50 *165*	60 *195*
H11	42 *140*	55 *180*	65 *215*	49 *160*	65 *215*	70 *230*	— —	— —	— —	— —	— —	— —	47 *155*	60 *195*	70 *230*
H12	60 *195*	75 *245*	85 *280*	75 *245*	90 *295*	100 *330*	— —	— —	— —	— —	— —	— —	75 *245*	90 *295*	100 *330*

Helical T4 12 – R217/220.94-12 – Metric



- For insert selection and cutting data recommendations, see page(s) 158-160
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm		kg	
R217.94-3250.3S-035-12.3A	02998573	Seco-Weldon	50,0	3	9	35,0	32,0	60,0	51,0	120,0	9900	1,0	LOEX12..
R217.94-3250.3S-058-12.4A	02998574	Seco-Weldon	50,0	4	20	58,0	32,0	60,0	66,0	135,0	9900	1,1	LOEX12..

Spare Parts

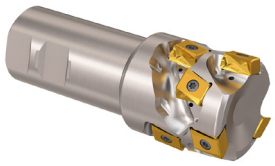
Accessories

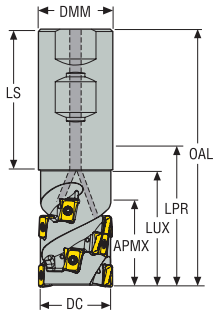
For cutter	Insert screw	Torque key	Torque value
R217.94-..	C04012B-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Helical T4 12 – R217/220.94-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 158-160
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.94-02.00-3-1.37-12-3A	02998584	Weldon	2.000	3	9	1.406	1.500	2.699	2.205	4.928	9800	2.650	LOEX12..
R217.94-02.00-3-2.28-12-4A	02998585	Weldon	2.000	4	20	2.310	1.500	2.699	3.106	5.715	9800	2.870	LOEX12..

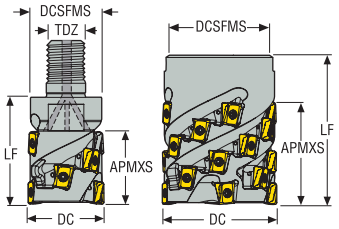
Spare Parts

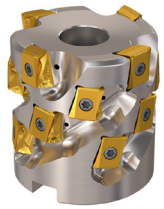
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.94-..	C04012B-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical T4 12 – R217/220.94-12 – Metric





- For insert selection and cutting data recommendations, see page(s) 158-160
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
R217.94-2040.RE-035-12.2A	03135367	Combimaster	40,0	2	6	35,0	–	M20	36,5	50,0	–	11000	0,4	LOEX12..
R220.94-00050-046-12.3A	02998575	Arbor	50,0	3	12	46,0	27,0	–	46,4	70,0	–	9900	0,5	LOEX12..
R220.94-00050-046-12.4A	02998576	Arbor	50,0	4	16	46,0	27,0	–	46,4	65,0	–	9900	0,5	LOEX12..
R220.94-00050-058-12.4A	02998577	Arbor	50,0	4	20	58,0	27,0	–	46,4	80,0	–	9900	0,6	LOEX12..
R220.94-00063-046-12.4A	02998578	Arbor	63,0	4	16	46,0	27,0	–	59,6	65,0	–	8800	0,9	LOEX12..
R220.94-00063-058-12.5A	02998579	Arbor	63,0	5	25	58,0	27,0	–	59,6	75,0	–	8800	1,1	LOEX12..
R220.94-00063-081-12.4A	02998580	Arbor	63,0	4	28	81,0	27,0	–	59,6	93,0	–	8800	1,3	LOEX12..
R220.94-00080-069-12.5A	02998581	Arbor	80,0	5	30	69,0	32,0	–	76,6	90,0	–	7800	2,2	LOEX12..
R220.94-00100-081-12.6A	02998583	Arbor	100,0	6	42	81,0	40,0	–	96,7	93,0	–	7000	3,7	LOEX12..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

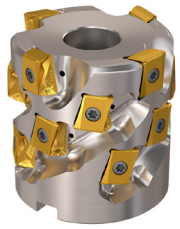
Accessories

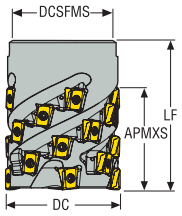
For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.94-..	–	C04012B-T15P	T00-15P35	3.5NM
R220.94-..Ø50-63	MC6S12X60	C04012B-T15P	T00-15P35	3.5NM
R220.94-..Ø50-63-058	MC6S12X70	C04012B-T15P	T00-15P35	3.5NM
R220.94-..Ø63-081	MP6S12X80	C04012B-T15P	T00-15P35	3.5NM
R220.94-..Ø80	MP6S16X80	C04012B-T15P	T00-15P35	3.5NM
R220.94-..Ø100	MP6S20X80	C04012B-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Helical T4 12 – R217/220.94-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 158-160
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			Inch			Inch	Inch		Inch	Inch	Inch		lbs	
R220.94-02.00-1.81-12-3A	02998586	Arbor	2.000	3	12	1.850	1.000	–	1.862	2.756	–	9800	1.320	LOEX12..
R220.94-02.00-2.28-12-4A	02998587	Arbor	2.000	4	20	2.283	1.000	–	1.862	3.150	–	9800	1.540	LOEX12..
R220.94-02.50-3.18-12-4A	02998589	Arbor	2.500	4	28	3.189	1.000	–	2.366	3.661	–	8800	2.870	LOEX12..
R220.94-02.50-3.18-12.4SA	03169706	Arbor	2.500	4	28	3.211	1.000	–	2.358	3.937	–	8800	3.090	LOEX12..
R220.94-03.00-3.18-12-5A	02998590	Arbor	3.000	5	35	3.189	1.250	–	2.870	3.740	–	8000	4.410	LOEX12..
R220.94-03.00-3.18-12.5SA	03169707	Arbor	3.000	5	35	3.211	1.250	–	2.858	3.937	–	7800	5.510	LOEX12..

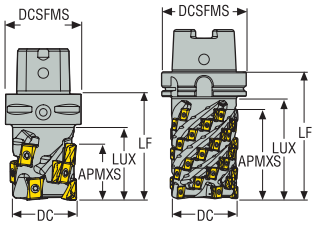
Spare Parts

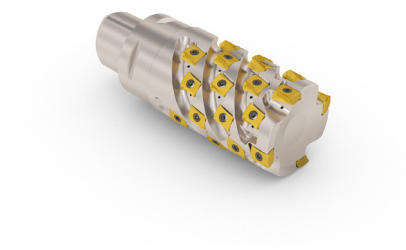
Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
R217.94-02.00-3A	UC6S1/2UNFX2-1/4	–	C04012B-T15P	–	T00-15P35	31.0IN.LBS
R217.94-02.00-4A	UC6S1/2UNFX2-1/2	–	C04012B-T15P	–	T00-15P35	31.0IN.LBS
R217.94-02.50	UP6S1/2UNFX3-1/4	–	C04012B-T15P	–	T00-15P35	31.0IN.LBS
R217.94-02.50S	UP6S1/2UNFX3-1/4	R220.94-02.50-1.76-12.4BA	C04012B-T15P	R220.94-RE2.50-1.42-12.4A	T00-15P35	31.0IN.LBS
R220.94-03.00	UP6S5/8UNFX3-1/4	–	C04012B-T15P	–	T00-15P35	31.0IN.LBS
R220.94-03.00S	UP6S5/8UNFX3-1/4	R220.94-03.00-1.76-12.5BA	C04012B-T15P	R220.94-RE3.00-1.42-12.5A	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Helical T4 12 – R217/220.94-12 – Metric



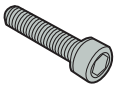


- For insert selection and cutting data recommendations, see page(s) 158-160
- For complete insert programme, see page(s) 737, 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	TDZ	DCSFMS	LF	LUX	RPMX	Weight	Insert
			mm			mm	mm		mm	mm	mm		kg	
C5-R217.94-044-035-12.3A	03134235	Seco-Capto	44,0	3	9	35,0	–	–	50,0	70,0	48,0	10600	0,8	LOEX12..
C5-R217.94-044-058-12.3A	03134236	Seco-Capto	44,0	3	15	58,0	–	–	50,0	95,0	73,0	10600	0,9	LOEX12..
C6-R217.94-050-081-12.4SA	03169703	Seco-Capto	50,0	4	28	81,0	–	–	63,0	115,0	91,0	10000	1,4	LOEX12..
C5-R217.94-054-069-12.4A	03134237	Seco-Capto	54,0	4	24	70,0	–	–	50,0	105,0	–	9700	1,3	LOEX12..
C6-R217.94-063-092-12.4SA	03169704	Seco-Capto	63,0	4	32	92,0	–	–	63,0	125,0	101,5	9000	2,3	LOEX12..
C6-R217.94-066-081-12.5A	03134238	Seco-Capto	66,0	5	35	81,0	–	–	63,0	115,0		8700	2,3	LOEX12..
R217.94-HSK100A-080-104-12.5SA	03169705	HSK	80,0	5	45	104,0	–	–	100,0	150,0	118,5	7800	5,4	LOEX12..

Spare Parts

Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
						
Cx-R217.94-..	–	–	C04012B-T15P	–	T00-15P35	31.0IN.LBS
C6-R217.94-..050	220.17-692M	C6-R217.94-050-058-12.4BA	C04012B-T15P	R220.94-RE050023-12.4A	T00-15P35	31.0IN.LBS
C6-R217.94-..063	MC6S12X35	C6-R217.94-063-056-12.4BA	C04012B-T15P	R220.94-RE063036-12.4A	T00-15P35	31.0IN.LBS
R220.94-HSK100	MC6S16X40	R217.94-HSK100A-080-68-12.5BA	C04012B-T15P	R220.94-RE080036-12.5A	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.94-12 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	LOEX120708R-M09 MP2501	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P2	LOEX120708R-M09 MP2501	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
P3	LOEX120708R-M09 MP2501	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
P4	LOEX120708TR-M12 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P5	LOEX120708TR-M12 MP2501	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
P6	LOEX120708TR-M12 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P7	LOEX120708TR-M12 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P8	LOEX120708TR-M12 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P11	LOEX120708TR-M12 T350M	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
P12	LOEX120708TR-M12 T350M	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M1	LOEX120708R-M09 MS2050	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
M2	LOEX120708R-M09 MS2050	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M3	LOEX120708R-M09 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M4	LOEX120708TR-M12 MS2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
M5	LOEX120708TR-M12 MS2050	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
K1	LOEX120708TR-MD13 MK2050	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K2	LOEX120708TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K3	LOEX120708TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K4	LOEX120708TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K5	LOEX120708TR-MD13 MK2050	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K6	LOEX120708TR-MD13 MK2050	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K7	LOEX120708TR-MD13 MK2050	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
N1	LOEX120708R-M09 F40M	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
N2	LOEX120708R-M09 F40M	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
N3	LOEX120708R-M09 F40M	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
N11	LOEX120708R-M09 F40M	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
S1	LOEX120708TR-M12 F40M	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
S2	LOEX120708TR-M12 F40M	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*
S3	LOEX120708TR-M12 F40M	0,090 *0.0036*	0,095 *0.0038*	0,15 *0.0060*
S11	LOEX120716R-M09 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S12	LOEX120708R-M09 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S13	LOEX120708R-M09 MS2050	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.94-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			T350M			F40M			MP2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	165 *540*	180 *590*	195 *640*	160 *520*	180 *590*	190 *620*	155 *510*	175 *570*	185 *610*	150 *490*	165 *540*	180 *590*	140 *460*	160 *520*	170 *560*	155 *510*	175 *570*	185 *610*
P2	160 *520*	180 *590*	190 *620*	155 *510*	175 *570*	185 *610*	150 *490*	170 *560*	180 *590*	145 *475*	165 *540*	175 *570*	135 *445*	155 *510*	165 *540*	155 *510*	175 *570*	185 *610*
P3	155 *510*	170 *560*	180 *590*	150 *490*	165 *540*	180 *590*	145 *475*	160 *520*	175 *570*	140 *460*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	145 *475*	165 *540*	175 *570*
P4	145 *475*	165 *540*	175 *570*	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	120 *395*	140 *460*	150 *490*	135 *445*	155 *510*	165 *540*
P5	140 *460*	160 *520*	170 *560*	140 *460*	155 *510*	170 *560*	130 *425*	150 *490*	165 *540*	125 *410*	145 *475*	155 *510*	115 *375*	135 *445*	150 *490*	135 *445*	155 *510*	165 *540*
P6	150 *490*	170 *560*	180 *590*	145 *475*	165 *540*	175 *570*	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	125 *410*	145 *475*	155 *510*	145 *475*	160 *520*	175 *570*
P7	145 *475*	165 *540*	175 *570*	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	120 *395*	140 *460*	150 *490*	140 *460*	155 *510*	170 *560*
P8	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	125 *410*	145 *475*	155 *510*	115 *375*	135 *445*	145 *475*	135 *445*	155 *510*	165 *540*
P11	145 *475*	160 *520*	175 *570*	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	130 *425*	145 *475*	160 *520*	120 *395*	140 *460*	150 *490*	135 *445*	155 *510*	165 *540*
P12	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	140 *460*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	90 *295*	110 *360*	120 *395*	110 *360*	125 *410*	140 *460*
M1	— —	— —	— —	135 *445*	155 *510*	165 *540*	135 *445*	150 *490*	165 *540*	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	155 *510*	130 *425*	150 *490*	160 *520*
M2	— —	— —	— —	125 *410*	140 *460*	155 *510*	120 *395*	140 *460*	150 *490*	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	140 *460*	120 *395*	140 *460*	150 *490*
M3	— —	— —	— —	110 *360*	130 *425*	140 *460*	105 *345*	125 *410*	135 *445*	105 *345*	120 *395*	135 *445*	95 *310*	115 *375*	125 *410*	105 *345*	125 *410*	135 *445*
M4	— —	— —	— —	90 *295*	110 *360*	120 *395*	90 *295*	110 *360*	120 *395*	85 *280*	105 *345*	115 *375*	80 *260*	100 *330*	110 *360*	90 *295*	110 *360*	120 *395*
M5	— —	— —	— —	80 *260*	100 *330*	110 *360*	80 *260*	95 *310*	105 *345*	75 *245*	95 *310*	105 *345*	70 *230*	85 *280*	95 *310*	75 *245*	95 *310*	105 *345*
K1	145 *475*	165 *540*	175 *570*	140 *460*	160 *520*	170 *560*	135 *445*	155 *510*	165 *540*	130 *425*	150 *490*	160 *520*	120 *395*	140 *460*	150 *490*	140 *460*	160 *520*	170 *560*
K2	140 *460*	155 *510*	170 *560*	135 *445*	150 *490*	165 *540*	130 *425*	145 *475*	160 *520*	125 *410*	140 *460*	155 *510*	115 *375*	135 *445*	145 *475*	130 *425*	150 *490*	160 *520*
K3	125 *410*	145 *475*	160 *520*	125 *410*	140 *460*	155 *510*	115 *375*	135 *445*	150 *490*	110 *360*	130 *425*	145 *475*	100 *330*	120 *395*	135 *445*	120 *395*	140 *460*	150 *490*
K4	125 *410*	145 *475*	155 *510*	120 *395*	140 *460*	150 *490*	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	140 *460*	100 *330*	120 *395*	130 *425*	115 *375*	135 *445*	150 *490*
K5	90 *295*	110 *360*	120 *395*	90 *295*	105 *345*	115 *375*	80 *260*	100 *330*	110 *360*	75 *245*	95 *310*	105 *345*	70 *230*	85 *280*	100 *330*	85 *280*	105 *345*	115 *375*
K6	115 *375*	135 *445*	145 *475*	110 *360*	130 *425*	140 *460*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	90 *295*	110 *360*	120 *395*	110 *360*	125 *410*	140 *460*
K7	110 *360*	125 *410*	140 *460*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	130 *425*	95 *310*	110 *360*	125 *410*	85 *280*	105 *345*	115 *375*	100 *330*	120 *395*	130 *425*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	255 *840*	275 *900*	285 *940*	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	195 *640*	215 *710*	225 *740*	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	165 *540*	185 *610*	195 *640*	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	175 *570*	195 *640*	205 *670*	— —	— —	— —
S1	— —	— —	— —	47 *155*	65 *215*	75 *245*	44 *145*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*	38 *125*	50 *165*	60 *195*	46 *150*	60 *195*	70 *230*
S2	— —	— —	— —	38 *125*	50 *165*	60 *195*	35 *115*	47 *155*	55 *180*	34 *110*	45 *150*	50 *165*	31 *100*	41 *135*	48 *155*	37 *120*	49 *160*	55 *180*
S3	— —	— —	— —	34 *110*	44 *145*	50 *165*	31 *100*	41 *135*	48 *155*	29 *95*	39 *130*	46 *150*	27 *90*	36 *120*	42 *140*	32 *105*	43 *140*	50 *165*
S11	— —	— —	— —	65 *215*	85 *280*	95 *310*	60 *195*	80 *260*	90 *295*	60 *195*	75 *245*	90 *295*	55 *180*	70 *230*	80 *260*	65 *215*	80 *260*	95 *310*
S12	— —	— —	— —	46 *150*	60 *195*	70 *230*	42 *140*	55 *180*	65 *215*	40 *130*	55 *180*	65 *215*	36 *120*	48 *155*	55 *180*	44 *145*	60 *195*	70 *230*
S13	— —	— —	— —	27 *90*	36 *120*	42 *140*	25 *80*	33 *110*	39 *130*	24 *80*	31 *100*	37 *120*	21 *70*	29 *95*	33 *110*	26 *85*	34 *110*	40 *130*
H5	46 *150*	60 *195*	70 *230*	39 *130*	50 *165*	60 *195*	38 *125*	50 *165*	60 *195*	37 *120*	49 *160*	60 *195*	32 *105*	43 *140*	50 *165*	38 *125*	50 *165*	60 *195*
H8	49 *160*	65 *215*	75 *245*	42 *140*	55 *180*	65 *215*	40 *130*	55 *180*	60 *195*	40 *130*	50 *165*	60 *195*	34 *110*	46 *150*	55 *180*	40 *130*	55 *180*	60 *195*
H11	60 *195*	75 *245*	90 *295*	50 *165*	65 *215*	75 *245*	48 *155*	65 *215*	75 *245*	47 *155*	60 *195*	75 *245*	41 *135*	55 *180*	65 *215*	48 *155*	65 *215*	75 *245*
H12	85 *280*	105 *345*	115 *375*	80 *260*	100 *330*	110 *360*	75 *245*	95 *310*	105 *345*	70 *230*	90 *295*	100 *330*	60 *195*	80 *260*	90 *295*	80 *260*	100 *330*	110 *360*

R217/220.94-12 – Cutting data v_c = (m/min)/*(sf/min)*

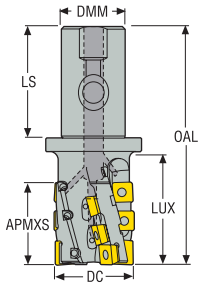
SMG	MK1500			MK2050			MS2050			MS2500			MM4500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	—	—	—	155	170	185	150	170	180	165	185	195	130	150	160
	—	—	—	*510*	*560*	*610*	*490*	*560*	*590*	*540*	*610*	*640*	*425*	*490*	*520*
P2	—	—	—	150	170	180	150	170	180	165	180	190	130	150	160
	—	—	—	*490*	*560*	*590*	*490*	*560*	*590*	*540*	*590*	*620*	*425*	*490*	*520*
P3	—	—	—	140	160	170	140	160	170	155	175	185	120	140	150
	—	—	—	*460*	*520*	*560*	*460*	*520*	*560*	*510*	*570*	*610*	*395*	*460*	*490*
P4	—	—	—	135	155	165	130	150	160	145	165	175	110	130	140
	—	—	—	*445*	*510*	*540*	*425*	*490*	*520*	*475*	*540*	*570*	*360*	*425*	*460*
P5	—	—	—	130	150	160	130	150	160	145	160	175	110	130	140
	—	—	—	*425*	*490*	*520*	*425*	*490*	*520*	*475*	*520*	*570*	*360*	*425*	*460*
P6	—	—	—	140	160	170	140	155	165	150	170	180	115	135	145
	—	—	—	*460*	*520*	*560*	*460*	*510*	*540*	*490*	*560*	*590*	*375*	*445*	*475*
P7	—	—	—	135	155	165	135	150	165	150	165	180	115	130	145
	—	—	—	*445*	*510*	*540*	*445*	*490*	*540*	*490*	*540*	*590*	*375*	*425*	*475*
P8	—	—	—	130	150	160	130	145	160	145	160	170	110	125	140
	—	—	—	*425*	*490*	*520*	*425*	*475*	*520*	*475*	*520*	*560*	*360*	*410*	*460*
P11	—	—	—	135	150	165	130	150	160	145	165	175	110	130	140
	—	—	—	*445*	*490*	*540*	*425*	*490*	*520*	*475*	*540*	*570*	*360*	*425*	*460*
P12	—	—	—	105	125	135	105	120	130	115	135	145	80	100	110
	—	—	—	*345*	*410*	*445*	*345*	*395*	*425*	*375*	*445*	*475*	*260*	*330*	*360*
M1	—	—	—	—	—	—	135	155	165	140	160	170	120	140	150
	—	—	—	—	—	—	*445*	*510*	*540*	*460*	*520*	*560*	*395*	*460*	*490*
M2	—	—	—	—	—	—	125	140	150	130	145	160	105	125	135
	—	—	—	—	—	—	*410*	*460*	*490*	*425*	*475*	*520*	*345*	*410*	*445*
M3	—	—	—	—	—	—	110	125	135	115	135	145	90	110	120
	—	—	—	—	—	—	*360*	*410*	*445*	*375*	*445*	*475*	*295*	*360*	*395*
M4	—	—	—	—	—	—	90	110	120	95	115	125	75	95	105
	—	—	—	—	—	—	*295*	*360*	*395*	*310*	*375*	*410*	*245*	*310*	*345*
M5	—	—	—	—	—	—	80	95	110	85	105	115	65	80	90
	—	—	—	—	—	—	*260*	*310*	*360*	*280*	*345*	*375*	*215*	*260*	*295*
K1	160	180	190	155	175	185	—	—	—	—	—	—	—	—	—
	520	*590*	*620*	*510*	*570*	*610*	—	—	—	—	—	—	—	—	—
K2	150	170	180	150	165	180	—	—	—	—	—	—	—	—	—
	490	*560*	*590*	*490*	*540*	*590*	—	—	—	—	—	—	—	—	—
K3	140	160	170	135	155	170	—	—	—	—	—	—	—	—	—
	460	*520*	*560*	*445*	*510*	*560*	—	—	—	—	—	—	—	—	—
K4	135	155	170	135	155	165	—	—	—	—	—	—	—	—	—
	445	*510*	*560*	*445*	*510*	*540*	—	—	—	—	—	—	—	—	—
K5	105	125	135	100	120	130	—	—	—	—	—	—	—	—	—
	345	*410*	*445*	*330*	*395*	*425*	—	—	—	—	—	—	—	—	—
K6	130	150	160	125	145	155	—	—	—	—	—	—	—	—	—
	425	*490*	*520*	*410*	*475*	*510*	—	—	—	—	—	—	—	—	—
K7	120	140	150	120	135	150	—	—	—	—	—	—	—	—	—
	395	*460*	*490*	*395*	*445*	*490*	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
S1	—	—	—	—	—	—	45	60	70	50	70	80	23	30	36
	—	—	—	—	—	—	*150*	*195*	*230*	*165*	*230*	*260*	*75*	*100*	*120*
S2	—	—	—	—	—	—	36	48	55	42	55	65	18	25	29
	—	—	—	—	—	—	*120*	*155*	*180*	*140*	*180*	*215*	*60*	*80*	*95*
S3	—	—	—	—	—	—	32	42	50	37	48	55	16	21	25
	—	—	—	—	—	—	*105*	*140*	*165*	*120*	*155*	*180*	*50*	*70*	*80*
S11	—	—	—	—	—	—	60	80	90	70	90	100	32	43	50
	—	—	—	—	—	—	*195*	*260*	*295*	*230*	*295*	*330*	*105*	*140*	*165*
S12	—	—	—	—	—	—	43	60	70	50	65	75	30	39	46
	—	—	—	—	—	—	*140*	*195*	*230*	*165*	*215*	*245*	*100*	*130*	*150*
S13	—	—	—	—	—	—	25	33	39	29	39	45	17	23	27
	—	—	—	—	—	—	*80*	*110*	*130*	*95*	*130*	*150*	*55*	*75*	*90*
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

R215/220.59 HELICAL

Our comprehensive selection of high-performance helical milling cutters incorporate the latest geometries and grades to achieve high feed rates, large depths of cut and aggressive metal removal in contouring and profiling operations. The helix angle allows the cutter to absorb most of the end load so it smoothly enter and exit the workpiece.

- Cutter range 50-100 mm (2 - 4 inch)
- Many options for different types of mounting

R215.59-12.4..K – Half effective – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 735,751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	SC.T	AC.T
			mm			mm	mm	mm	mm	mm		kg		
R215.59-4050.3S-050-12.4A	75066227	Seco-Weldon	50,0	2	12	50,0	40,0	70,0	67,0	150,0	8300	1,4	10	2

Modification of the cutter body needed for radii > 3,0 mm

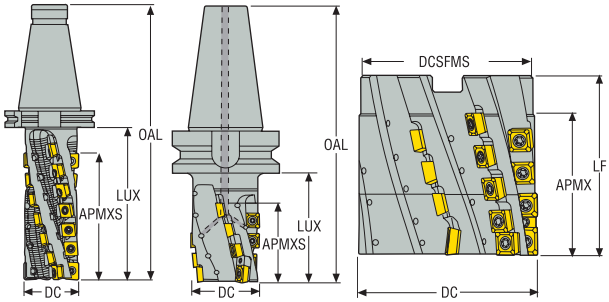
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R215.59-..	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R215.59-12.4 – Half effective – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 735,751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	LUX	RPMX	Weight	SC.T	AC.T
			mm			mm	mm	mm	mm	mm		kg		
R215.59-BT50.050.059-12.4A	75066230	BT50	50,0	2	14	59,0	–	100,0	135,0	92,0	8300	4,5	12	2
R215.59-BT50.050.077-12.4A	75066231	BT50	50,0	2	18	77,0	–	100,0	148,0	110,0	8300	4,5	18	2
R215.59-BT50.063.086-12.4S	75034445	BT50	63,0	2	18	86,0	–	100,0	162,9	125,0	7400	6,8	18	2
R215.59-BT50.080.095-12.4S	75034446	BT50	80,0	2	22	96,0	–	100,0	173,0	135,0	6500	6,6	20	2
R215.59-50063120-12.4S	00026979	DIN2080	63,0	2	28	122,8	–	97,45	200,0	165,0	7400	5,6	26	2
R220.59-00063.059-12.4	75001999	Arbor	63,0	2	14	59,0	27,0	62,0	70,0	–	7400	0,9	12	2
R220.59-00080.068-12.4	75000111	Arbor	80,0	2	16	68,0	32,0	77,0	85,0	–	6500	1,5	14	2
R220.59-00080.068-12.6	75000109	Arbor	80,0	3	24	68,0	32,0	77,0	85,0	–	6500	2,2	21	3
R220.59-00100077-12.6S	75000112	Arbor	100,0	3	27	77,0	40,0	90,0	100,0	–	5800	3,7	24	3
R220.59-00100077-12.6SR6	75000247	Arbor	100,0	3	24	77,0	40,0	90,0	100,0	–	5800	4,4	21*	3*
R220.59-00100077-12.8S	75000113	Arbor	100,0	4	36	77,0	40,0	90,0	100,0	–	5800	3,9	32	3
R220.59-00100077-12.8SR6	75000248	Arbor	100,0	4	32	77,0	40,0	90,0	100,0	–	5800	4,5	28*	4*

Modification of the cutter body needed for radii > 3,0 mm
*Compatible with radii 6.0 mm only

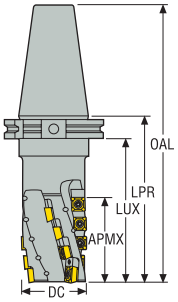
Spare Parts

Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
R215.59-..	–	–	C45011-T20P	–	T00-20P50	5.0NM
R215.59-050	–	–	C45011-T20P	–	T00-20P50	5.0NM
R215.59-060	215.59-691	R215.59-BT50.063.062-12.4B	C45011-T20P	R220.59-RE063024-12.4	T00-20P50	5.0NM
R220.59-080	215.59-692S	R215.59-BT50.080.061-12.4B	C45011-T20P	R220.59-RE080034-12.4	T00-20P50	5.0NM
R215.59-50-4S	215.59-691	R215.59-CV50/50063096-12.4B	C45011-T20P	R220.59-RE063024-12.4	T00-20P50	5.0NM
R220.59-00063	MC6S12X50	–	C45011-T20P	–	T00-20P50	5.0NM
R220.59-00080	MC6S16X70	–	C45011-T20P	–	T00-20P50	5.0NM
R220.59-00100..6S	215.59-693S	R220.59-00100043-12.6B	C45011-T20P	R220.59-RE100034-12.6	T00-20P50	5.0NM
R220.59-00100..6SR	215.59-693S	R220.59-00100043-12.6B	C45011-T20P	R220.59-RE100034-12.6R6	T00-20P50	5.0NM
R220.59-00100..8S	215.59-693S	R220.59-00100043-12.8B	C45011-T20P	R220.59-RE100034-12.8	T00-20P50	5.0NM
R220.59-00100..8SR	215.59-693S	R220.59-00100043-12.8B	C45011-T20P	R220.59-RE100034-12.8R6	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R215.59-12.4 – Half effective – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 735,751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	LUX	RPMX	Weight	SC.T	AC.T
			mm			mm	mm	mm	mm	mm		kg		
R215.59-CV50050.077-12.4A	75066136	CV50	50,0	2	18	77,0	–	97,45	150,0	100,0	8300	4,2	16	2
R215.59-CV50050120-12.4	00026978	CV50	50,0	2	28	122,9	–	97,45	180,0	145,0	8300	4,5	26	2
R215.59-CV50063086-12.4S	75003346	CV50	63,0	2	20	86,0	–	97,45	160,0	120,0	7400	5,0	18	2
R215.59-CV50063086-12.4SR6	75000244	CV50	63,0	2	20	86,0	–	97,45	160,0	120,0	7400	5,1	16*	2*
R215.59-CV50063120-12.4S	00026980	CV50	63,0	2	28	122,8	–	97,45	200,0	165,0	7400	5,6	26	2
R215.59-CV50063120-12.4SR6	00027074	CV50	63,0	2	28	122,8	–	97,45	199,9	165,0	7400	5,8	24*	2*
R215.59-CV50063160-12.4S	00095805	CV50	63,0	2	36	158,7	–	97,45	234,9	200,0	7400	6,2	34	2
R215.59-CV50063160-12.4SR6	00095807	CV50	63,0	2	36	158,7	–	97,45	234,9	200,0	7400	6,2	32*	2*
R215.59-CV50080095-12.4S	75007713	CV50	80,0	2	22	96,0	–	97,45	150,0	131,0	6500	5,5	20	2
R215.59-CV50080095-12.6S	75003347	CV50	80,0	3	33	96,0	–	97,45	150,0	131,0	6500	5,9	30	3

Modification of the cutter body needed for radii > 3,0 mm
*Compatible with radii 6.0 mm only

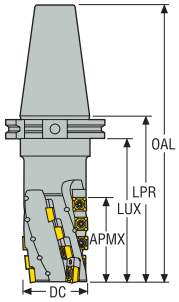
Spare Parts

Accessories

For cutter	Arbor screw	Basic body	Insert screw	Replaceable end	Torque key	Torque value
R215.59-CV50-12.4	–	–	C45011-T20P	–	T00-20P50	5.0NM
R215.59-CV5006-12.4S	215.59-691	R215.59-CV50063062-12.4B	C45011-T20P	R220.59-RE063024-12.4	T00-20P50	5.0NM
R215.59-CV50-12.4SR	215.59-691	R215.59-CV50063062-12.4B	C45011-T20P	R220.59-RE063024-12.4R6	T00-20P50	5.0NM
R215.59-63-120-12.4S	215.59-691	R215.59-CV50/50063096-12.4B	C45011-T20P	R220.59-RE063024-12.4	T00-20P50	5.0NM
R215.59-63-120-12.4SR	215.59-691	R215.59-CV50/50063096-12.4B	C45011-T20P	R220.59-RE063024-12.4R6	T00-20P50	5.0NM
R215.59-63-160-12.4S	215.59-691	R215.59-CV50/50063134-12.4B	C45011-T20P	R220.59-RE063024-12.4	T00-20P50	5.0NM
R215.59-63-160-12.4SR	215.59-691	R215.59-CV50/50063134-12.4B	C45011-T20P	R220.59-RE063024-12.4R6	T00-20P50	5.0NM
R215.59-CV5008-12.4S	215.59-692S	–	C45011-T20P	R220.59-RE080034-12.4	T00-20P50	5.0NM
R220.59-080-12.6S	215.59-692S	R215.59-CV50080061-12.6B	C45011-T20P	R220.59-RE080034-12.6	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R215.59-12.4 – Half effective – Inch



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 735,751
- For ISO attribute explanation, see page 16, 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	LUX	RPMX	Weight	SC.T	AC.T
			Inch			Inch	Inch	Inch	Inch	Inch		lbs		
R215.59-02.00-CV5-12.4	00087668	CV50	2.000	2	18	3.031	–	3.837	5.540	3.965	8300	8.820	2	16

Modification of the cutter body needed for radii > 3,0 mm

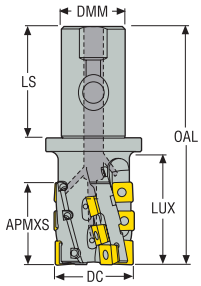
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R215.59-..	C45011-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829

R215.59-12.4..K – Full effective – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 735,751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	SC.T	AC.T
			mm			mm	mm	mm	mm	mm		kg		
R215.59-4050.3S-063-12.3K	00092248	Seco-Weldon	50,0	3	18	63,0	40,0	70,0	78,0	160,0	8300	1,5	15	3

Modification of the cutter body needed for radii > 3,0 mm

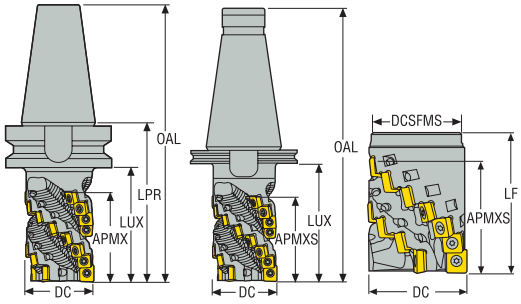
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R215.59-..	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R215/220.59-12.4 – Full effective – Metric



- For insert selection and cutting data recommendations, see page(s) 168-169
- For complete insert programme, see page(s) 735,751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	LUX	RPMX	Weight	SC.T	AC.T
			mm			mm	mm	mm	mm	mm		kg		
R215.59-BT50050072-12.3K	00008459	BT50	50,0	3	21	73,0	–	100,0	145,0	103,0	8300	4,9	18	3
R215.59-BT50063110-12.3K	00008466	BT50	63,0	3	33	111,8	–	100,0	180,0	137,0	7400	5,7	30	3
R215.59-CV50063110-12.3K	00026532	CV50-DIN	63,0	3	33	111,8	–	97,45	165,0	126,0	7400	4,7	30	3
R215.59-50063110-12.3K	00026533	DIN2080	63,0	3	33	111,8	–	97,45	165,0	126,0	7400	5,2	30	3
R220.59-00063.072-12.4K	00008461	Arbor	63,0	4	28	72,0	27,0	62,0	90,0	–	7400	1,2	24	4
R220.59-00080.072-12.5K	00008462	Arbor	80,0	5	35	72,0	32,0	74,7	100,0	–	6500	2,3	30	5

Modification of the cutter body needed for radii > 3,0 mm

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R215.59-..	–	C45011-T20P	T00-20P50	5.0NM
R220.59-00063	MC6S12X80	C45011-T20P	T00-20P50	5.0NM
R220.59-00080	MC6S16X80	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R215/220.59-12 – Insert selection – mm/*Inch*

SMG			f_z		
			100%	30%	10%
P1	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P2	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P3	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P4	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P5	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P6	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P7	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P8	ACET150612TR-M11 MP2501	SCET120612T-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P11	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P12	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
M1	ACET150612TR-ME10 MS2050	SCET120612R-M10 MS2050	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
M2	ACET150612TR-ME10 MS2050	SCET120612R-M10 MS2050	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*
M3	ACET150612TR-ME10 MS2050	SCET120612R-M10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M4	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
M5	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
K1	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K2	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K3	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K4	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K5	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
K6	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,15 *0.0060*	0,16 *0.0065*	0,24 *0.0095*
K7	ACET150612TR-M14 MK1500	SCET120612T-M14 MK1500	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
S1	ACET150612TR-M11 F40M	SCET120612T-M11 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
S2	ACET150612TR-M11 F40M	SCET120612T-M11 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
S3	ACET150612TR-M11 F40M	SCET120612T-M11 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
S11	ACET150612TR-ME10 MS2050	SCET120612R-M10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S12	ACET150612TR-ME10 MS2050	SCET120612R-M10 MS2050	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
S13	ACET150612TR-ME10 MS2050	SCET120612R-M10 MS2050	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
H5	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
H8	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
H11	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
H12	ACET150612TR-M11 T350M	SCET120612T-M11 T350M	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R215/220.59-12 – Cutting data v_c = (m/min)/*(sf/min)*

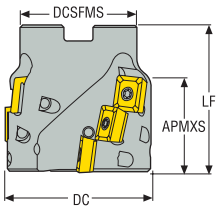
SMG	MP1501			MP2501			MP3000			T350M			MK1500			F40M			MS2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	135	145	155	125	140	150	120	135	140	120	135	140	—	—	—	115	125	135	120	135	140
	445	*475*	*510*	*410*	*460*	*490*	*395*	*445*	*460*	*395*	*445*	*460*	—	—	—	*375*	*410*	*445*	*395*	*445*	*460*
P2	130	145	150	125	140	145	120	130	140	120	130	140	—	—	—	110	125	135	120	135	140
	425	*475*	*490*	*410*	*460*	*475*	*395*	*425*	*460*	*395*	*425*	*460*	—	—	—	*360*	*410*	*445*	*395*	*445*	*460*
P3	125	140	145	120	130	140	115	125	135	110	125	135	—	—	—	105	120	125	115	125	135
	410	*460*	*475*	*395*	*425*	*460*	*375*	*410*	*445*	*360*	*410*	*445*	—	—	—	*345*	*395*	*410*	*375*	*410*	*445*
P4	120	130	140	115	125	135	105	120	130	105	120	125	—	—	—	100	115	120	105	120	130
	395	*425*	*460*	*375*	*410*	*445*	*345*	*395*	*425*	*345*	*395*	*410*	—	—	—	*330*	*375*	*395*	*345*	*395*	*425*
P5	115	130	140	110	125	130	105	120	125	105	120	125	—	—	—	100	110	120	105	120	125
	375	*425*	*460*	*360*	*410*	*425*	*345*	*395*	*410*	*345*	*395*	*410*	—	—	—	*330*	*360*	*395*	*345*	*395*	*410*
P6	125	135	145	115	130	140	110	125	130	110	125	130	—	—	—	105	115	125	110	125	130
	410	*445*	*475*	*375*	*425*	*460*	*360*	*410*	*425*	*360*	*410*	*425*	—	—	—	*345*	*375*	*410*	*360*	*410*	*425*
P7	120	135	140	115	130	135	110	120	130	110	120	130	—	—	—	100	115	120	110	120	130
	395	*445*	*460*	*375*	*425*	*445*	*360*	*395*	*425*	*360*	*395*	*425*	—	—	—	*330*	*375*	*395*	*360*	*395*	*425*
P8	115	130	135	110	125	130	105	115	125	105	115	125	—	—	—	100	110	120	105	120	125
	375	*425*	*445*	*360*	*410*	*425*	*345*	*375*	*410*	*345*	*375*	*410*	—	—	—	*330*	*360*	*395*	*345*	*395*	*410*
P11	120	130	140	115	125	135	105	120	125	105	120	125	—	—	—	100	115	120	110	120	130
	395	*425*	*460*	*375*	*410*	*445*	*345*	*395*	*410*	*345*	*395*	*410*	—	—	—	*330*	*375*	*395*	*360*	*395*	*425*
P12	100	110	120	95	105	115	85	100	110	85	100	105	—	—	—	80	95	100	90	100	110
	330	*360*	*395*	*310*	*345*	*375*	*280*	*330*	*360*	*280*	*330*	*345*	—	—	—	*260*	*310*	*330*	*295*	*330*	*360*
M1	—	—	—	110	125	130	105	120	125	105	120	125	—	—	—	100	115	125	110	125	130
	—	—	—	*360*	*410*	*425*	*345*	*395*	*410*	*345*	*395*	*410*	—	—	—	*330*	*375*	*410*	*360*	*410*	*425*
M2	—	—	—	100	115	120	95	110	120	100	110	120	—	—	—	95	105	115	100	115	120
	—	—	—	*330*	*375*	*395*	*310*	*360*	*395*	*330*	*360*	*395*	—	—	—	*310*	*345*	*375*	*330*	*375*	*395*
M3	—	—	—	90	105	110	90	100	110	90	100	110	—	—	—	85	95	105	90	105	110
	—	—	—	*295*	*345*	*360*	*295*	*330*	*360*	*295*	*330*	*360*	—	—	—	*280*	*310*	*345*	*295*	*345*	*360*
M4	—	—	—	80	90	100	75	90	95	75	90	95	—	—	—	70	85	95	80	90	100
	—	—	—	*260*	*295*	*330*	*245*	*295*	*310*	*245*	*295*	*310*	—	—	—	*230*	*280*	*310*	*260*	*295*	*330*
M5	—	—	—	70	85	90	65	80	90	70	80	90	—	—	—	65	75	85	70	85	90
	—	—	—	*230*	*280*	*295*	*215*	*260*	*295*	*230*	*260*	*295*	—	—	—	*215*	*245*	*280*	*230*	*280*	*295*
K1	120	135	140	115	125	135	110	120	130	105	120	130	125	140	150	100	115	120	—	—	—
	395	*445*	*460*	*375*	*410*	*445*	*360*	*395*	*425*	*345*	*395*	*425*	*410*	*460*	*490*	*330*	*375*	*395*	—	—	—
K2	115	130	135	110	120	130	100	115	125	105	115	125	120	135	145	95	110	115	—	—	—
	375	*425*	*445*	*360*	*395*	*425*	*330*	*375*	*410*	*345*	*375*	*410*	*395*	*445*	*475*	*310*	*360*	*375*	—	—	—
K3	105	120	130	100	115	120	95	110	115	95	110	115	115	125	135	90	100	110	—	—	—
	345	*395*	*425*	*330*	*375*	*395*	*310*	*360*	*375*	*310*	*360*	*375*	*375*	*410*	*445*	*295*	*330*	*360*	—	—	—
K4	105	120	125	100	110	120	90	105	115	95	105	115	110	125	135	85	100	105	—	—	—
	345	*395*	*410*	*330*	*360*	*395*	*295*	*345*	*375*	*310*	*345*	*375*	*360*	*410*	*445*	*280*	*330*	*345*	—	—	—
K5	80	95	105	75	90	95	70	85	90	70	85	90	90	105	110	65	75	85	—	—	—
	260	*310*	*345*	*245*	*295*	*310*	*230*	*280*	*295*	*230*	*280*	*295*	*295*	*345*	*360*	*215*	*245*	*280*	—	—	—
K6	100	110	120	95	105	115	85	100	110	85	100	110	105	120	130	80	95	100	—	—	—
	330	*360*	*395*	*310*	*345*	*375*	*280*	*330*	*360*	*280*	*330*	*360*	*345*	*395*	*425*	*260*	*310*	*330*	—	—	—
K7	95	105	115	90	100	110	80	95	100	80	95	100	100	115	120	75	90	95	—	—	—
	310	*345*	*375*	*295*	*330*	*360*	*260*	*310*	*330*	*260*	*310*	*330*	*330*	*375*	*395*	*245*	*295*	*310*	—	—	—
S1	—	—	—	46	60	65	40	55	60	41	55	60	—	—	—	38	49	55	44	55	65
	—	—	—	*150*	*195*	*215*	*130*	*180*	*195*	*135*	*180*	*195*	—	—	—	*125*	*160*	*180*	*145*	*180*	*215*
S2	—	—	—	37	49	55	33	43	50	33	44	50	—	—	—	30	40	47	35	47	55
	—	—	—	*120*	*160*	*180*	*110*	*140*	*165*	*110*	*145*	*165*	—	—	—	*100*	*130*	*155*	*115*	*155*	*180*
S3	—	—	—	33	43	50	29	38	45	29	39	46	—	—	—	27	35	42	31	41	49
	—	—	—	*110*	*140*	*165*	*95*	*125*	*150*	*95*	*130*	*150*	—	—	—	*90*	*115*	*140*	*100*	*135*	*160*
S11	—	—	—	60	75	85	55	70	75	55	70	75	—	—	—	50	65	75	60	75	80
	—	—	—	*195*	*245*	*280*	*180*	*230*	*245*	*180*	*230*	*245*	—	—	—	*165*	*215*	*245*	*195*	*245*	*260*
S12	—	—	—	45	60	65	39	50	60	40	50	60	—	—	—	36	48	55	42	55	65
	—	—	—	*150*	*195*	*215*	*130*	*165*	*195*	*130*	*165*	*195*	—	—	—	*120*	*155*	*180*	*140*	*180*	*215*
S13	—	—	—	26	34	41	23	30	36	23	30	36	—	—	—	21	28	33	25	33	39
	—	—	—	*85*	*110*	*135*	*75*	*100*	*120*	*75*	*100*	*120*	—	—	—	*70*	*90*	*110*	*80*	*110*	*130*
H5	47	60	70	38	50	60	34	45	55	36	48	55	—	—	—	32	42	49	—	—	—
	155	*195*	*230*	*125*	*165*	*195*	*110*	*150*	*180*	*120*	*155*	*180*	—	—	—	*105*	*140*	*160*	—	—	—
H8	50	65	70	41	55	60	37	49	55	39	50	60	—	—	—	34	44	50	—	—	—
	165	*215*	*230*	*135*	*180*	*195*	*120*	*160*	*180*	*130*	*165*	*195*	—	—	—	*110*	*145*	*165*	—	—	—
H11	60	70	80	48	60	70	44	55	65	46	60	65	—	—	—	40	55	60	—	—	—
	195	*230*	*260*	*155*	*195*	*230*	*145*	*180*	*215*	*150*	*195*	*215*	—	—	—	*130*	*180*	*195*	—	—	—
H12	75	90	100	70	85	90	65	80	85	65	80	85	—	—	—	60	70	80	—	—	—
	245	*295*	*330*	*230*	*280*	*295*	*215*	*260*	*280*	*215*	*260*	*280*	—	—	—	*195*	*230*	*260*	—	—	—

R215/220.69-15XH HELICAL

Helical mills for heavy duty, inserts with 4-cutting edges, single-sided inserts.

- Cutter range 50-100 mm (2 - 4 inch)
- Depth of cut <=160 mm (6.3 inch), max 30% ae
- Slotting depth max 50% DC
- Insert corner radii range 1.2-6.3 mm (.047 - .248 inch)

R220.69-15H – High feed rates – Metric



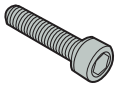
- For insert selection and cutting data recommendations, see page(s) 173-174
- For complete insert programme, see page(s) 735
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm			mm	mm	mm	mm		kg	
R220.69-0063038-15.4H	75068039	Arbor	63,0	4	12	38,0	27,0	62,0	63,0	7400	0,7	AC.T15..
R220.69-0080038-15.5H	75066129	Arbor	80,0	5	15	38,0	32,0	77,0	63,0	6500	1,2	AC.T15..
R220.69-0080050-15.5H	75066350	Arbor	80,0	5	20	50,0	32,0	77,0	75,0	6500	1,5	AC.T15..
R220.69-0100050-15.6H	75068040	Arbor	100,0	6	24	50,0	40,0	90,0	75,0	5800	2,6	AC.T15..
R220.69-00125050-15.7H	00094725	Arbor	125,0	7	28	50,0	40,0	90,0	75,0	5200	3,5	AC.T15..

Modification of the cutter body needed for radii > 3,0 mm

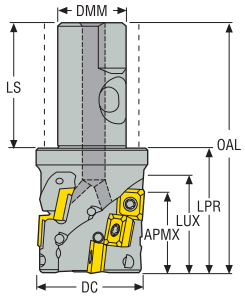
Spare Parts

Accessories

For cutter	Arbor screw	Axial support	Insert screw	Setting key	Torque key	Torque value
						
R220.69-0063	MC6S12X50	CH9411-T09P	C45011-T20P	H4B-T09P	T00-20P50	5.0NM
R220.69-0080	MC6S16X50	CH9411-T09P	C45011-T20P	H4B-T09P	T00-20P50	5.0NM
R220.69-0100	MC6S20X50	CH9411-T09P	C45011-T20P	H4B-T09P	T00-20P50	5.0NM
R220.69-00125	–	CH9411-T09P	C45011-T20P	H4B-T09P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.69-15H – High feed rates – Inch



- For insert selection and cutting data recommendations, see page(s) 173-174
- For complete insert programme, see page(s) 735
- For ISO attribute explanation, see page 16, 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DMM	LS	LUX	OAL	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R217.69-02.00-3-15HS3A	75072956	Weldon	2.000	3	9	1.567	1.500	2.689	24.554	5.195	7900	2.870	AC.T15..

Modification of the cutter body needed for radii > 0.118 in

Spare Parts

Accessories

For cutter	Axial support	Insert screw	Setting key	Torque key	Torque value
R217.69-..	CH9411-T09P	C45011-T20P	H4B-T09P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829

R215/220.69-15 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	ACET150612TR-M11 MP2501	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
P2	ACET150612TR-M11 MP2501	0,14 *0.0055*	0,15 *0.0060*	0,22 *0.0085*
P3	ACET150612TR-M11 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P4	ACET150612TR-M11 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,20 *0.0080*
P5	ACET150612TR-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P6	ACET150612TR-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P7	ACET150612TR-M11 MP2501	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P8	ACET150612TR-M11 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*
P11	ACET150612TR-M11 T350M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P12	ACET150612TR-M11 T350M	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
M1	ACET150612TR-ME10 MS2050	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
M2	ACET150612TR-ME10 MS2050	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
M3	ACET150612TR-ME10 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
M4	ACET150612TR-M11 T350M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
M5	ACET150612TR-M11 T350M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
K1	ACET150612TR-M14 MK1500	0,17 *0.0065*	0,19 *0.0075*	0,28 *0.011*
K2	ACET150612TR-M14 MK1500	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K3	ACET150612TR-M14 MK1500	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K4	ACET150612TR-M14 MK1500	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K5	ACET150612TR-M14 MK1500	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
K6	ACET150612TR-M14 MK1500	0,16 *0.0065*	0,17 *0.0065*	0,26 *0.010*
K7	ACET150612TR-M14 MK1500	0,14 *0.0055*	0,15 *0.0060*	0,24 *0.0095*
S1	ACET150612TR-M11 F40M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S2	ACET150612TR-M11 F40M	0,085 *0.0034*	0,095 *0.0038*	0,14 *0.0055*
S3	ACET150612TR-M11 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
S11	ACET150612TR-ME10 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S12	ACET150612TR-ME10 MS2050	0,090 *0.0036*	0,10 *0.0040*	0,15 *0.0060*
S13	ACET150612TR-ME10 MS2050	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
H5	ACET150612TR-M11 T350M	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
H8	ACET150612TR-M11 T350M	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
H11	ACET150612TR-M11 T350M	0,085 *0.0034*	0,090 *0.0036*	0,14 *0.0055*
H12	ACET150612TR-M11 T350M	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R215/220.69-15 – Cutting data v_c = (m/min)/*(sf/min)*

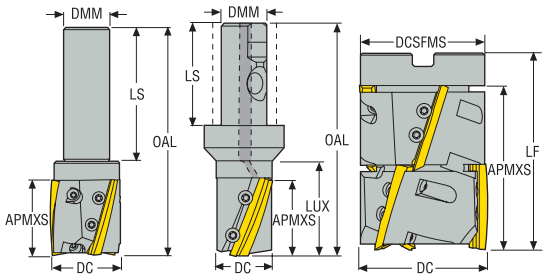
SMG	MP1501			MP2501			MP3000			T350M			MK1500			F40M			MS2050		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	175 *570*	195 *640*	210 *690*	165 *540*	185 *610*	200 *660*	155 *510*	175 *570*	190 *620*	155 *510*	175 *570*	190 *620*	— —	— —	— —	145 *475*	165 *540*	180 *590*	160 *520*	180 *590*	190 *620*
P2	170 *560*	195 *640*	205 *670*	165 *540*	185 *610*	200 *660*	155 *510*	175 *570*	190 *620*	150 *490*	175 *570*	185 *610*	— —	— —	— —	140 *460*	165 *540*	175 *570*	155 *510*	180 *590*	190 *620*
P3	160 *520*	185 *610*	195 *640*	155 *510*	175 *570*	185 *610*	145 *475*	165 *540*	175 *570*	145 *475*	165 *540*	175 *570*	— —	— —	— —	130 *425*	155 *510*	165 *540*	145 *475*	165 *540*	180 *590*
P4	155 *510*	175 *570*	190 *620*	145 *475*	165 *540*	180 *590*	135 *445*	155 *510*	170 *560*	135 *445*	155 *510*	170 *560*	— —	— —	— —	125 *410*	145 *475*	160 *520*	140 *460*	160 *520*	170 *560*
P5	150 *490*	170 *560*	185 *610*	140 *460*	165 *540*	175 *570*	130 *425*	150 *490*	165 *540*	130 *425*	155 *510*	165 *540*	— —	— —	— —	120 *395*	140 *460*	155 *510*	135 *445*	155 *510*	165 *540*
P6	160 *520*	180 *590*	195 *640*	150 *490*	170 *560*	185 *610*	140 *460*	160 *520*	175 *570*	140 *460*	160 *520*	175 *570*	— —	— —	— —	130 *425*	150 *490*	165 *540*	145 *475*	165 *540*	175 *570*
P7	155 *510*	175 *570*	190 *620*	145 *475*	165 *540*	180 *590*	135 *445*	155 *510*	170 *560*	135 *445*	155 *510*	170 *560*	— —	— —	— —	125 *410*	145 *475*	160 *520*	140 *460*	160 *520*	170 *560*
P8	150 *490*	170 *560*	185 *610*	140 *460*	160 *520*	175 *570*	130 *425*	150 *490*	165 *540*	130 *425*	150 *490*	165 *540*	— —	— —	— —	120 *395*	140 *460*	155 *510*	130 *425*	155 *510*	165 *540*
P11	155 *510*	175 *570*	185 *610*	145 *475*	165 *540*	180 *590*	135 *445*	155 *510*	165 *540*	135 *445*	155 *510*	165 *540*	— —	— —	— —	125 *410*	145 *475*	155 *510*	135 *445*	155 *510*	170 *560*
P12	120 *395*	140 *460*	155 *510*	110 *360*	135 *445*	145 *475*	105 *345*	125 *410*	135 *445*	100 *330*	120 *395*	135 *445*	— —	— —	— —	90 *295*	110 *360*	125 *410*	105 *345*	125 *410*	135 *445*
M1	— —	— —	— —	140 *460*	160 *520*	175 *570*	130 *425*	155 *510*	165 *540*	135 *445*	155 *510*	170 *560*	— —	— —	— —	125 *410*	145 *475*	160 *520*	140 *460*	160 *520*	175 *570*
M2	— —	— —	— —	125 *410*	145 *475*	160 *520*	115 *375*	140 *460*	150 *490*	120 *395*	140 *460*	155 *510*	— —	— —	— —	115 *375*	135 *445*	145 *475*	125 *410*	145 *475*	160 *520*
M3	— —	— —	— —	110 *360*	130 *425*	145 *475*	105 *345*	125 *410*	135 *445*	105 *345*	125 *410*	140 *460*	— —	— —	— —	95 *310*	115 *375*	130 *425*	110 *360*	130 *425*	145 *475*
M4	— —	— —	— —	90 *295*	110 *360*	125 *410*	85 *280*	105 *345*	115 *375*	85 *280*	105 *345*	120 *395*	— —	— —	— —	80 *260*	100 *330*	110 *360*	90 *295*	110 *360*	125 *410*
M5	— —	— —	— —	75 *245*	100 *330*	110 *360*	70 *230*	90 *295*	105 *345*	70 *230*	90 *295*	105 *345*	— —	— —	— —	65 *215*	85 *280*	100 *330*	80 *260*	100 *330*	110 *360*
K1	155 *510*	175 *570*	190 *620*	145 *475*	165 *540*	180 *590*	135 *445*	155 *510*	170 *560*	135 *445*	155 *510*	170 *560*	165 *540*	190 *620*	200 *660*	125 *410*	145 *475*	160 *520*	— —	— —	— —
K2	145 *475*	170 *560*	180 *590*	140 *460*	160 *520*	170 *560*	125 *410*	150 *490*	160 *520*	130 *425*	150 *490*	160 *520*	160 *520*	180 *590*	195 *640*	115 *375*	140 *460*	150 *490*	— —	— —	— —
K3	135 *445*	155 *510*	170 *560*	125 *410*	145 *475*	160 *520*	115 *375*	135 *445*	150 *490*	115 *375*	135 *445*	150 *490*	145 *475*	165 *540*	180 *590*	105 *345*	125 *410*	140 *460*	— —	— —	— —
K4	130 *425*	150 *490*	165 *540*	120 *395*	145 *475*	155 *510*	110 *360*	135 *445*	145 *475*	110 *360*	135 *445*	145 *475*	140 *460*	165 *540*	175 *570*	100 *330*	120 *395*	135 *445*	— —	— —	— —
K5	95 *310*	115 *375*	125 *410*	85 *280*	105 *345*	120 *395*	75 *245*	95 *310*	110 *360*	75 *245*	95 *310*	105 *345*	105 *345*	130 *425*	140 *460*	65 *215*	85 *280*	95 *310*	— —	— —	— —
K6	120 *395*	145 *475*	155 *510*	110 *360*	135 *445*	145 *475*	100 *330*	125 *410*	135 *445*	100 *330*	125 *410*	135 *445*	135 *445*	155 *510*	165 *540*	90 *295*	115 *375*	125 *410*	— —	— —	— —
K7	110 *360*	135 *445*	145 *475*	105 *345*	125 *410*	135 *445*	95 *310*	115 *375*	125 *410*	95 *310*	115 *375*	125 *410*	125 *410*	145 *475*	160 *520*	80 *260*	105 *345*	115 *375*	— —	— —	— —
S1	— —	— —	— —	45 *150*	60 *195*	70 *230*	39 *130*	50 *165*	60 *195*	40 *130*	55 *180*	65 *215*	— —	— —	— —	37 *120*	48 *155*	55 *180*	43 *140*	60 *195*	65 *215*
S2	— —	— —	— —	36 *120*	48 *155*	55 *180*	32 *105*	42 *140*	49 *160*	33 *110*	43 *140*	50 *165*	— —	— —	— —	30 *100*	39 *130*	46 *150*	35 *115*	46 *150*	55 *180*
S3	— —	— —	— —	32 *105*	42 *140*	49 *160*	28 *90*	37 *120*	43 *140*	29 *95*	37 *120*	44 *145*	— —	— —	— —	26 *85*	34 *110*	40 *130*	31 *100*	41 *135*	48 *155*
S11	— —	— —	— —	60 *195*	80 *260*	95 *310*	55 *180*	70 *230*	85 *280*	55 *180*	75 *245*	85 *280*	— —	— —	— —	50 *165*	65 *215*	80 *260*	60 *195*	80 *260*	90 *295*
S12	— —	— —	— —	43 *140*	55 *180*	70 *230*	38 *125*	50 *165*	60 *195*	39 *130*	50 *165*	60 *195*	— —	— —	— —	35 *115*	46 *150*	55 *180*	42 *140*	55 *180*	65 *215*
S13	— —	— —	— —	25 *80*	33 *110*	39 *130*	22 *70*	29 *95*	34 *110*	23 *75*	30 *100*	35 *115*	— —	— —	— —	21 *70*	27 *90*	32 *105*	24 *80*	32 *105*	38 *125*
H5	46 *150*	60 *195*	70 *230*	37 *120*	49 *160*	55 *180*	34 *110*	45 *150*	50 *165*	35 *115*	47 *155*	55 *180*	— —	— —	— —	31 *100*	41 *135*	48 *155*	— —	— —	— —
H8	49 *160*	65 *215*	75 *245*	39 *130*	50 *165*	60 *195*	36 *120*	48 *155*	55 *180*	38 *125*	50 *165*	60 *195*	— —	— —	— —	33 *110*	43 *140*	50 *165*	— —	— —	— —
H11	60 *195*	75 *245*	90 *295*	47 *155*	60 *195*	75 *245*	43 *140*	55 *180*	65 *215*	45 *150*	60 *195*	70 *230*	— —	— —	— —	39 *130*	50 *165*	60 *195*	— —	— —	— —
H12	85 *280*	110 *360*	120 *395*	80 *260*	100 *330*	110 *360*	70 *230*	90 *295*	100 *330*	70 *230*	90 *295*	100 *330*	— —	— —	— —	60 *195*	80 *260*	90 *295*	— —	— —	— —

R235.15 HELICAL

Helical mills for high surface finish in square shoulder and contouring operations.
Suitable for finishing operations.

- Cutter range 32-80mm, (1.25 - 3 inch)
- Depth of cut <=90 mm (3.5 inch)
- Max a_e = 1 mm

R235.15 – Finishing operations – Metric

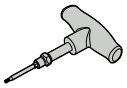


- For insert selection and cutting data recommendations, see page(s) 178-179
- For complete insert programme, see page(s) 789
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DMM	DCSFMS	LS	LF	OAL	LUX	RPMX	Weight	Insert
			mm			mm	mm	mm	mm	mm	mm	mm	mm		kg	
R235.15-2532.0-40	75036949	Cylindrical	32,0	2	2	40,0	–	25,0	–	71,0	–	140,0	40,0	8000	0,7	R235.15-032
R235.15A-3250.0-50	75036947	Cylindrical	50,0	3	3	50,0	–	32,0	–	95,0	–	155,0	50,0	5500	1,2	R235.15-050
R235.15-2532.3S-40A	75036948	Seco-Weldon	32,0	2	2	40,0	–	25,0	40,0	56,0	69,3	125,0	50,0	8000	0,7	R235.15-032
R235.15A-3250.3S-50A	75036946	Seco-Weldon	50,0	3	3	50,0	–	32,0	50,0	70,0	61,4	120,0	61,4	5500	0,9	R235.15-050
R235.15A-0080-90	75037122	Arbor	80,0	3	6	90,0	32,0	–	75,0	–	120,0	–	–	4400	3,2	R235.15-080

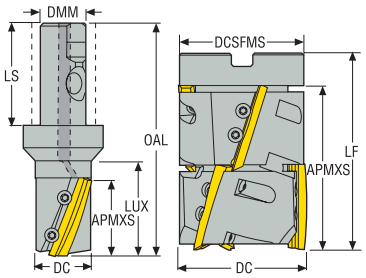
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Setting gauge	Setting key	Torque key	Torque value
						
R235.15-2532	–	CL85012-T25P	–	–	T00T-25P60	6.0NM
R235.15-3250	–	CL85012-T25P	AU8019-T15P	H4B-T15P	T00T-25P60	6.0NM
R235.15A-0080	MC6S16X100	CL85012-T25P	AU8019-T15P	H4B-T15P	T00T-25P60	6.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R235.15 – Finishing operations – Inch

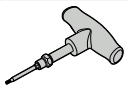


- For insert selection and cutting data recommendations, see page(s) 178-179
- For complete insert programme, see page(s) 789
- For ISO attribute explanation, see page 16, 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	DCB	DMM	DCSFMS	LS	LF	OAL	LUX	RPMX	Weight	Insert
			Inch			Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch		lbs	
R235.15A-02.00-3S-50A	75056423	Seco-Weldon	2.000	3	3	1.969	–	1.250	1.772	2.441	1.969	4.724	1.969	5500	2.200	R235.15-050
R235.15A-03.00-90	75056424	Shell mill	3.000	3	6	3.500	1.000	–	2.866	–	4.724	–	–	4400	7.280	R235.15-080

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Setting gauge	Setting key	Torque key	Torque value
						
R235.15A-02.00	–	CL85012-T25P	AU8019-T15P	H4B-T15P	T00T-25P60	53.1IN.LBS
R235.15A-03.00	UC6S1/2UNFX4	CL85012-T25P	AU8019-T15P	H4B-T15P	T00T-25P60	53.1IN.LBS

Torque and fixed keys, see page 829

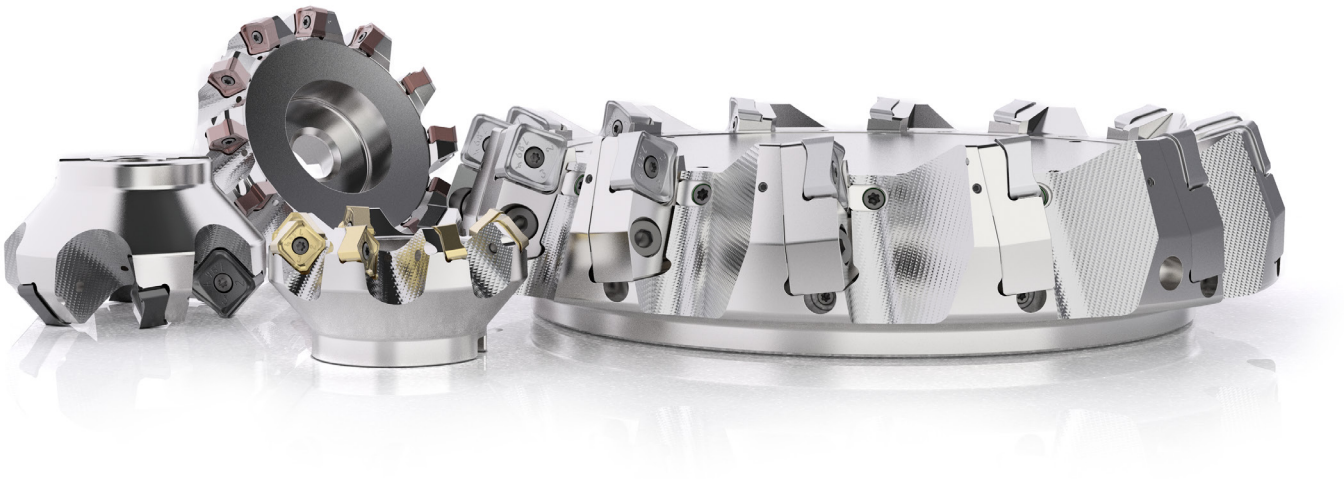
R235.15 – Insert selection – mm/*Inch*

SMG		f_z
		3%
P1	R235.15-xxx-E05 F30M	0,20 *0.0080*
P2	R235.15-xxx-E05 F30M	0,22 *0.0085*
P3	R235.15-xxx-E05 F30M	0,20 *0.0080*
P4	R235.15-xxx-E05 F30M	0,20 *0.0080*
P5	R235.15-xxx-E05 F30M	0,19 *0.0075*
P6	R235.15-xxx-E05 F30M	0,19 *0.0075*
P7	R235.15-xxx-E05 F30M	0,19 *0.0075*
P8	R235.15-xxx-E05 F30M	0,20 *0.0080*
P11	R235.15-xxx-E05 F30M	0,19 *0.0075*
P12	R235.15-xxx-E05 F30M	0,13 *0.0050*
M1	R235.15-xxx-E05 F30M	0,22 *0.0085*
M2	R235.15-xxx-E05 F30M	0,19 *0.0075*
M3	R235.15-xxx-E05 F30M	0,15 *0.0060*
M4	R235.15-xxx-E05 F30M	0,13 *0.0050*
M5	R235.15-xxx-E05 F30M	0,13 *0.0050*
K1	R235.15-xxx-E05 F30M	0,22 *0.0085*
K2	R235.15-xxx-E05 F30M	0,19 *0.0075*
K3	R235.15-xxx-E05 F30M	0,19 *0.0075*
K4	R235.15-xxx-E05 F30M	0,19 *0.0075*
K5	R235.15-xxx-E05 F30M	0,17 *0.0065*
K6	R235.15-xxx-E05 F30M	0,19 *0.0075*
K7	R235.15-xxx-E05 F30M	0,17 *0.0065*
N1	R235.15-xxx-E05 F30M	0,28 *0.011*
N2	R235.15-xxx-E05 F30M	0,28 *0.011*
N3	R235.15-xxx-E05 F30M	0,28 *0.011*
N11	R235.15-xxx-E05 F30M	0,28 *0.011*
S1	R235.15-xxx-E05 F30M	0,13 *0.0050*
S2	R235.15-xxx-E05 F30M	0,13 *0.0050*
S3	R235.15-xxx-E05 F30M	0,13 *0.0050*
S11	R235.15-xxx-E05 F30M	0,15 *0.0060*
S12	R235.15-xxx-E05 F30M	0,15 *0.0060*
S13	R235.15-xxx-E05 F30M	0,13 *0.0050*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R235.15 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F30M
	3%
P1	310 *1025*
P2	295 *970*
P3	260 *850*
P4	230 *750*
P5	220 *720*
P6	245 *800*
P7	235 *770*
P8	215 *710*
P11	225 *740*
P12	145 *475*
M1	200 *660*
M2	165 *540*
M3	130 *425*
M4	100 *330*
M5	85 *280*
K1	235 *770*
K2	210 *690*
K3	175 *570*
K4	170 *560*
K5	105 *345*
K6	150 *490*
K7	130 *425*
N1	1450 *4750*
N2	590 *1925*
N3	390 *1275*
N11	445 *1450*
S1	70 *230*
S2	55 *180*
S3	49 *160*
S11	100 *330*
S12	70 *230*
S13	40 *130*

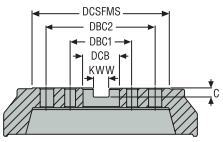


Code keys metric and *inch*

R	220	.	53	-	0100	-	12	-	7	A
1	2		3		4		5		6	7

R	220	.	53	-	04.00	-	12	-	7	A
1	2		3		4		5		6	7

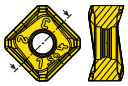
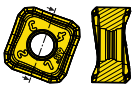
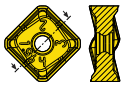
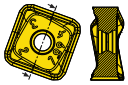
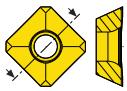
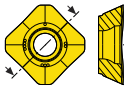
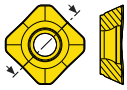
1.	2.	3.
R = Right hand rotation L = Left hand rotation Cx = For Seco-Capto	217 = With shank 220 = For arbor	Cutter system
4.	**5.**	**6.**
Mounting type & Cutter diameter 0xxx = shell mill mounting 8xxx = Flange mounting 9xxx = CAP mounting	Insert size	Effective No. of teeth (ZEFP)
7.		
A = With through coolant supply W = Insert locking with wedge G = Coarse pitch version for low power machines T = Close pitch version for high feed rates in powerful machines C = Cassettes S = Insert locking with screw M = Modified		



Dimensions in mm					
DCB	DCSFMS	DBC1	DBC2	KWW	C
16	30-35	–	–	8,4	5,6
22	42-47	–	–	10,4	6.3
27	48-62	–	–	12,4	7
32	60-90	–	–	14,4	8
40	90-130	66,7	–	16,4	9
60	130-270	101,6	177,8	25,7	14

Dimensions in inch					
DCB	DCSFMS	DBC1	DBC2	KWW	C
0.500	*1.181 - 1.378*			*0.258*	*0.165*
0.750	*1.378 - 1.850*	–	–	*0.321*	*0.193*
1.000	*1.803 - 2.441*	–	–	*0.382*	*0.224*
1.250	*2.250 - 3.031*	–	–	*0.508*	*0.287*
1.500	*2.750 - 3.543*	–	–	*0.630*	*0.382*
2.000	*4.331*	–	–	*0.756*	*0.445*
2.500	*5.118 - 6.299 (8.858)*	*4.000*	*(7.000)*	*1.000*	*0.551*

Selection – Metric

Cutter family	Insert	a_p max	a_p rec.	Material suitability								KAPRS°
				P	M	K	N	S				
Double Quattromill R220.54-14	SN.X14..AN 	6,0	4,0	■	■	■	◪	■	◪	■	◪	48°
Double Quattromill R220.56-14	SN.X14..ZN 	8,0	6,0	■	■	■	□	■	◪	■	◪	71°
Double Quattromill R220.54-22	SNMX22..AN 	9,0	6,0	■	■	■	□	■	□	■	◪	48°
Double Quattromill R220.56-22	SNMX22..ZN 	13	9,0	■	■	■	□	■	□	■	◪	71°
Quattromill R220.53-09	SE.X09T3 	4,5	3,0	■	■	◪	■	■	■	◪	■	45°
Quattromill R220.53-12	SE.X1204 	6,0	4,5	■	■	◪	■	■	■	■	■	45°
Quattromill R220.53-15	SE.X1505 	7,5	6,0	■	■	■	■	■	◪	■	■	45°

1st choice ■

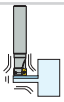
Alternative choice ◪

Possible choice □

High speed machine with low power/torque

Strong stable machine with rigid connecion

Not recommended -

Unstable condition suitability 

a_p max = Maximum depth of cut possible
a_p rec. = Recommended depth of cut for optimal result

Selection – Metric

Insert	No. of cutting edges	Application	Cutter diameter (mm) available with effective number of teeth													See page
			20	24*/25	32	40	50	63	80	100	125	160	200	250	315	
SNMX14..AN	8						4	5	6	7	8	10	12			191
							5	7	8	10	12	15	17			
												9	11	14	16	
SNMX14..ZN	8						4	5	6	7	8	10	12			191
							5	7	8	10	12	15	17			
												9	11	14	16	
SNMX22..AN	8								5	5	6	8				203
									6	7	8	11				
													9	11	14	
SNMX22..ZN	8									5	6	8				203
									5	7	8	10				
													9	11	14	
SE.X09T3	4		2	3	4	4	5	6	6	7						235
						5	6	7	8	10						
													8	10	12	
									5	6	8	10		16		
									6	8	10	14				
SE.X1204	4									5	6	7				243
						3	4	5	6	7	8	10				
						4	5	6	8	10	12					
								9	11	12	14	17	20			
												7	8	10	12	
									5	6	8	10	12	16		
									6	8	10	14				
SE.X1505	4							5	6	7	8	10	12			250
									7	9	10					
												7	8	10	12	
									5	6	8	10	12	16	18	

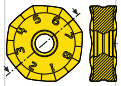
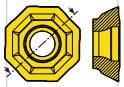
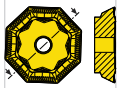
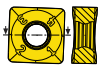
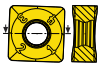
x	Fixed pocket (x indicates number of teeth)
x	With cassette (x indicates number of teeth)

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

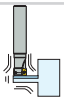
Productivity

Selection – Metric

Cutter family	Insert	a_p max	a_p rec.	Material suitability								KAPRS°
				P	M	K	N	S				
Double Octomill R220.48-05	ON..05	3,0	2,0	■	■	■	□	◪	◪	◪	□	40°
Double Octomill R220.48-09	ON..09 	6,0	3,0	■	■	■	□	◪	□	■	□	40°
Octomill R220.43-05	OF..05 	3,5	2,5	◪	◪	◪	◪	◪	■	◪	◪	43°
Octomill R220.43-07	OF..07 	5,0	4,0	◪	◪	◪	◪	◪	◪	■	◪	43°
R220.88-12	SNMU12.. 	9,0	5,0	■	◪	■	-	-	◪	■	◪	88°
R220.88-16	SNMU16.. 	13,0	8,0	■	◪	■	-	-	□	■	◪	88°

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability 

a_p max = Maximum depth of cut possible
a_p rec. = Recommended depth of cut for optimal result

Selection – Metric

Insert	No. of cutting edges	Application	Cutter diameter (mm) available with effective number of teeth															See page
			20	24*/25	32	40	50	63	80	100	125	160	200	250	315	400	500	
ON..05	16						4	5	6	7	8							216
				3	4	4	5	6										
						5	6	8	10	12	14							
										8	10	14	18					
ON..09	16							5	6	7	8	10	12	16	20			225, 226
								6	7	8	10	12						
									9	12	15	20	24	30	40	50	60	
													28					
											8	10	12	16	20			
OF..05	8				3	3	4	5	6	7	8	10						266
						4	5	6	8									
												7						
										6	8	10	12	16	20			
											10	14	18	22	28			
OF..07	8						4	4	5	6	8	10						272
								6	9	12	15							
												7						
										6	8	10	12	16				
											10	14	18	22	28			
SNMU12..	8						4	6	7	8	10	12						257
							5	7	9	11	13	16						
SNMU16..	8							4	6	8	10	12						261
								5	7	9	11	13						

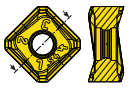
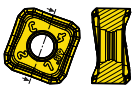
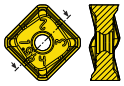
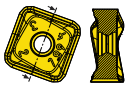
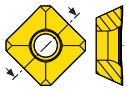
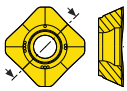
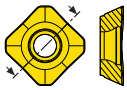
x	Fixed pocket (x indicates number of teeth)
x	With cassette (x indicates number of teeth)

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

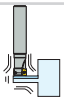
Productivity

Selection – Inch

Cutter family	Insert	a_p max	a_p rec.	Material suitability								KAPRS°
				P	M	K	N	S				
Double Quattromill R220.54-14	SN.X14..AN 	0,236	0,157	■	■	■	◪	■	◪	■	◪	48°
Double Quattromill R220.56-14	SN.X14..ZN 	0,315	0,236	■	■	■	◪	■	◪	■	◪	71°
Double Quattromill R220.54-22	SNMX22..AN 	0,354	0,236	■	■	■	□	■	□	■	◪	48°
Double Quattromill R220.56-22	SNMX22..ZN 	0,512	0,354	■	■	■	□	■	□	■	◪	71°
Quattromill R220.53-09	SE.X09T3 	0,177	0,118	■	■	◪	■	■	■	◪	■	45°
Quattromill R220.53-12	SE.X1204 	0,236	0,177	■	■	◪	■	■	◪	■	■	45°
Quattromill R220.53-15	SE.X1505 	0,295	0,236	■	■	■	■	■	◪	■	■	45°

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	

a_p max = Maximum depth of cut possible
a_p rec. = Recommended depth of cut for optimal result

Selection – Inch

Insert	No. of cutting edges	Application	Cutter diameter (inch) available with effective number of teeth													See page
			0,75	1	1,25	1,5	2	2,5	3	4	5	6	8	10	12,5	
SNMX14..AN	8						4	5	6	7	8	10	12			191
							5	7	8	10	12	15	17			
												9	11	14	16	
SNMX14..ZN	8						4	5	6	7	8	10	12			191
							5	7	8	10	12	15	17			
												9	11	14	16	
SNMX22..AN	8								5	5	6	8				203
									6	7	8	11				
													9	11	14	
SNMX22..ZN	8								5	5	6	8				203
										7	8	10				
													9	11	14	
SE.X09T3	4		2	3	4	4	5	6	8							235
SE.X1204	4					4	4	5	6	7	6	7				243
							5	6	8	10	8	10	12			
										12		12				
												17				
SE.X1505	4								6	7	10					250

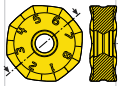
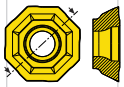
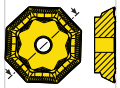
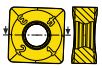
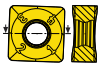
x	Fixed pocket (x indicates number of teeth)
x	With cassette (x indicates number of teeth)

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

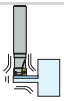
Productivity

Selection – Inch

Cutter family	Insert	a_p max	a_p rec.	Material suitability								KAPRS°
				P	M	K	N	S				
Double Octomill R220.48-05	ON..05	0,118	0,079	■	■	■	□	◪	◪	◪	□	40°
Double Octomill R220.48-09	ON..09 	0,236	0,118	■	■	■	□	◪	□	■	□	40°
Octomill R220.43-05	OF..05 	0,138	0,098	◪	◪	◪	◪	◪	■	◪	◪	43°
Octomill R220.43-07	OF..07 	0,197	0,157	◪	◪	◪	◪	◪	◪	■	◪	43°
R220.88-12	SNMU12.. 	0,354	0,197	■	◪	■	-	-	◪	■	◪	88°
R220.88-16	SNMU16.. 	0,512	0,354	■	◪	■	-	-	□	■	◪	88°

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability 

a_p max = Maximum depth of cut possible
a_p rec. = Recommended depth of cut for optimal result

Selection – Inch

Insert	No. of cutting edges	Application	Cutter diameter (inch) available with effective number of teeth													See page
			0,75	1	1,25	1,5	2	2,5	3	4	5	6	8	10	12,5	
ON..05	16				4	4	4	5	6	7						216
							5		10							
										8		14	18			
ON..09	16							5	6	7	8	10	12	16	20	225, 226
									9	12	15					
												10	12	16		
OF..05	8					3	4	5	6	7	8					266
OF..07	8							4	5	6		10				272
SNMU12..	8					4	4	6	7	8	10	12				257
							5	7	9	11	13	16				
SNMU16..	8								6	8	10	12				261
									7	9	11	13				

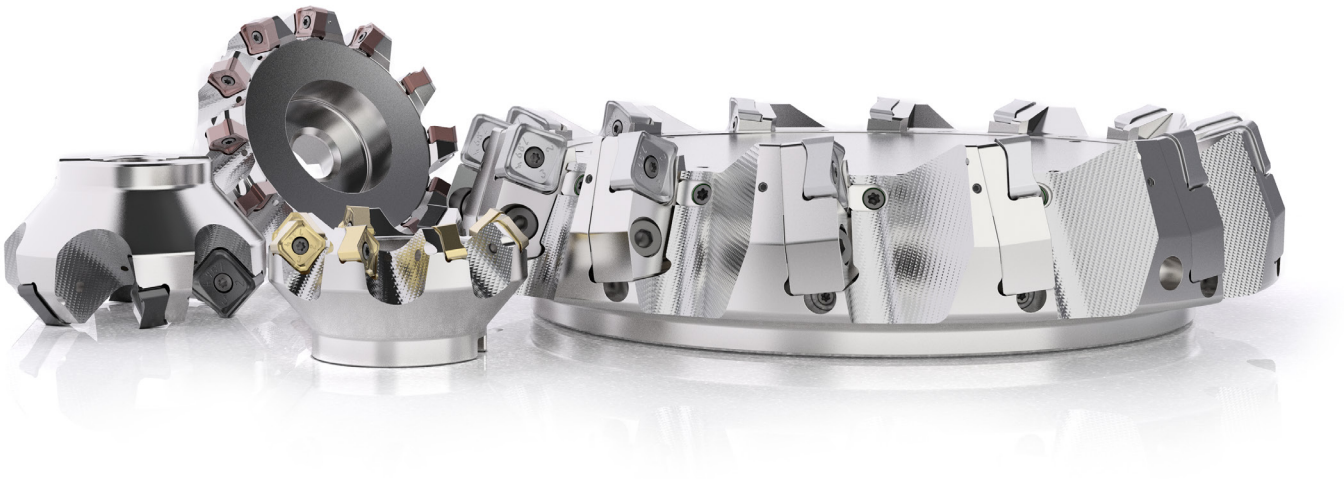
x	Fixed pocket (x indicates number of teeth)
x	With cassette (x indicates number of teeth)

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

Productivity

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

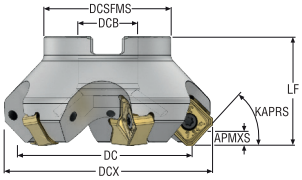


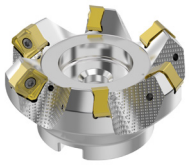
DOUBLE QUATTROMILL 14/22

Take full advantage of your machine tool's milling power for increased productivity with Seco's Double Quattromill™ face mill cutter for roughing and semi finishing. Achieve the industry's largest depths-of-cut and do so cost-effectively with eight multi-edge insert cutting edges.

- Insert size 14, cutter range 50-315mm (2 - 12.50 inches)
- Insert size 22, cutter range 80-315mm (3 - 12.50 inches)
- 8 cutting edges, double-sided inserts

R220.54-14 metric



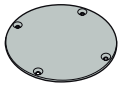


- For insert selection and cutting data recommendations, see page(s) 197-202
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.54-0050-14-4A	03213622	Arbor	50,0	4	6,0	48,0	65,0	22,0	47,0	40,0	8500	0,5	SN.X1407AN
R220.54-0050-14-5A	03213629	Arbor	50,0	5	6,0	48,0	65,0	22,0	47,0	40,0	8500	0,4	SN.X1407AN
R220.54-0063-14-5A	03213623	Arbor	63,0	5	6,0	48,0	78,0	22,0	47,0	40,0	7600	0,6	SN.X1407AN
R220.54-0063-14-7A	03213630	Arbor	63,0	7	6,0	48,0	78,0	22,0	47,0	40,0	7600	0,6	SN.X1407AN
R220.54-0080-14-6A	03213624	Arbor	80,0	6	6,0	48,0	95,0	27,0	62,0	50,0	6700	1,2	SN.X1407AN
R220.54-0080-14-8A	03213631	Arbor	80,0	8	6,0	48,0	95,0	27,0	62,0	50,0	6700	1,2	SN.X1407AN
R220.54-0100-14-7A	03213625	Arbor	100,0	7	6,0	48,0	115,0	32,0	77,0	50,0	6000	1,8	SN.X1407AN
R220.54-0100-14-10A	03213632	Arbor	100,0	10	6,0	48,0	115,0	32,0	77,0	50,0	6000	1,8	SN.X1407AN
R220.54-0125-14-8A	03213626	Arbor	125,0	8	6,0	48,0	140,0	40,0	90,0	63,0	5400	3,5	SN.X1407AN
R220.54-0125-14-12A	03213633	Arbor	125,0	12	6,0	48,0	140,0	40,0	90,0	63,0	5400	3,4	SN.X1407AN
R220.54-8160-14-10A	03213627	Arbor	160,0	10	6,0	48,0	175,0	40,0	90,0	63,0	4700	5,9	SN.X1407AN
R220.54-8160-14-15A	03213634	Arbor	160,0	15	6,0	48,0	175,0	40,0	90,0	63,0	4700	5,8	SN.X1407AN
R220.54-8200-14-12A	03213628	Arbor	200,0	12	6,0	48,0	215,0	60,0	130,0	63,0	4200	8,2	SN.X1407AN
R220.54-8200-14-17A	03213635	Arbor	200,0	17	6,0	48,0	215,0	60,0	130,0	63,0	4200	7,6	SN.X1407AN

Spare Parts

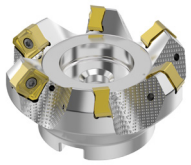
Accessories

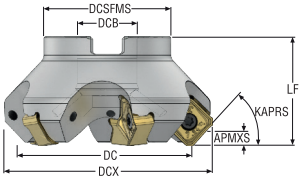
For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.54-0050-0063	220.17-691	C04011-T15P	–	–	T00-15P35	3.5NM
R220-54-0080-0125	–	C04011-T15P	–	–	T00-15P35	3.5NM
R220-54-8160	–	C04011-T15P	SC-160-90	MF6S4X10	T00-15P35	3.5NM
R220-54-8200	–	C04011-T15P	SC-200-90	MF6S4X10	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Quattro R220.54-14 – Inch



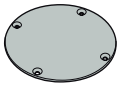


- For insert selection and cutting data recommendations, see page(s) 197-202
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.54-02.00-14-4A	03213636	Arbor	1.969	4	0.236	48.0	2.559	0.750	1.850	1.575	8500	1.100	SN.X1407AN
R220.54-02.00-14-5A	03213643	Arbor	1.969	5	0.236	48.0	2.559	0.750	1.850	1.575	8500	1.100	SN.X1407AN
R220.54-02.50-14-5A	03213637	Arbor	2.480	5	0.236	48.0	3.071	0.750	1.850	1.575	7600	1.320	SN.X1407AN
R220.54-02.50-14-7A	03213644	Arbor	2.480	7	0.236	48.0	3.071	0.750	1.850	1.575	7600	1.320	SN.X1407AN
R220.54-03.00-14-6A	03213638	Arbor	3.150	6	0.236	48.0	3.740	1.000	2.441	1.969	6700	2.870	SN.X1407AN
R220.54-03.00-14-8A	03213645	Arbor	3.150	8	0.236	48.0	3.740	1.000	2.441	1.969	6700	2.870	SN.X1407AN
R220.54-04.00-14-7A	03213639	Arbor	3.937	7	0.236	48.0	4.528	1.500	3.031	1.969	6000	3.970	SN.X1407AN
R220.54-04.00-14-10A	03213646	Arbor	3.937	10	0.236	48.0	4.528	1.500	3.031	1.969	6000	3.750	SN.X1407AN
R220.54-05.00-14-8A	03213640	Arbor	4.921	8	0.236	48.0	5.512	1.500	3.543	2.480	5400	8.160	SN.X1407AN
R220.54-05.00-14-12A	03213647	Arbor	4.921	12	0.236	48.0	5.512	1.500	3.543	2.480	5400	8.160	SN.X1407AN
R220.54-06.00-14-10A	03213641	Arbor	6.299	10	0.236	48.0	6.890	2.000	4.331	2.480	4700	13.670	SN.X1407AN
R220.54-06.00-14-15A	03213648	Arbor	6.299	15	0.236	48.0	6.890	2.000	4.331	2.480	4700	14.990	SN.X1407AN
R220.54-808.00-14-12A	03213642	Arbor	7.874	12	0.236	48.0	8.465	2.500	5.118	2.480	4200	16.760	SN.X1407AN
R220.54-808.00-14-17A	03213649	Arbor	7.874	17	0.236	48.0	8.465	2.500	5.118	2.480	4200	16.530	SN.X1407AN

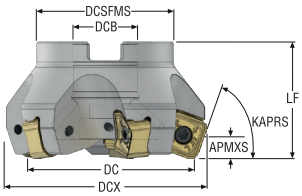
Spare Parts

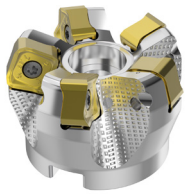
Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.54-02.00-02.50	220.17-698	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.54-03.00	UC6S1/2UNFX1-1/4	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.54-04.00	UF6S3/4UNFX1-3/4	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.54-05.00	UC6S3/4UNFX1-1/4	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.54-06.00	–	C04011-T15P	SC-160-90	MF6S4X10	T00-15P35	31.0IN.LBS
R220.54-808.00	–	C04011-T15P	SC-200-90	MF6S4X10	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Quattro R220.56-14 – Metric



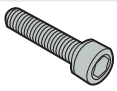
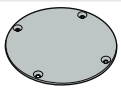


- For insert selection and cutting data recommendations, see page(s) 197-202
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.56-0050-14-4A	03241895	Arbor	50,0	4	8,0	71,0	57,0	22,0	47,0	40,0	8500	0,4	SN.X1407ZN
R220.56-0050-14-5A	03241902	Arbor	50,0	5	8,0	71,0	57,0	22,0	47,0	40,0	8500	0,4	SN.X1407ZN
R220.56-0063-14-5A	03241896	Arbor	63,0	5	8,0	71,0	70,0	22,0	47,0	40,0	7600	0,5	SN.X1407ZN
R220.56-0063-14-6A	03241903	Arbor	63,0	6	8,0	71,0	70,0	22,0	47,0	40,0	7600	0,5	SN.X1407ZN
R220.56-0080-14-6A	03241897	Arbor	80,0	6	8,0	71,0	87,0	27,0	62,0	50,0	6700	1,0	SN.X1407ZN
R220.56-0080-14-8A	03241904	Arbor	80,0	8	8,0	71,0	87,0	27,0	62,0	50,0	6700	1,0	SN.X1407ZN
R220.56-0100-14-7A	03241898	Arbor	100,0	7	8,0	71,0	107,0	32,0	77,0	50,0	6000	1,6	SN.X1407ZN
R220.56-0100-14-10A	03241905	Arbor	100,0	10	8,0	71,0	107,0	32,0	77,0	50,0	6000	1,6	SN.X1407ZN
R220.56-0125-14-8A	03241899	Arbor	125,0	8	8,0	71,0	132,0	40,0	90,0	63,0	5400	3,1	SN.X1407ZN
R220.56-0125-14-12A	03241906	Arbor	125,0	12	8,0	71,0	132,0	40,0	90,0	63,0	5400	3,1	SN.X1407ZN
R220.56-8160-14-10A	03241900	Arbor	160,0	10	8,0	71,0	167,0	40,0	90,0	63,0	4700	5,1	SN.X1407ZN
R220.56-8160-14-15A	03241907	Arbor	160,0	15	8,0	71,0	167,0	40,0	90,0	63,0	4700	5,1	SN.X1407ZN
R220.56-8200-14-12A	03241901	Arbor	200,0	12	8,0	71,0	207,0	60,0	130,0	63,0	4200	6,9	SN.X1407ZN
R220.56-8200-14-17A	03241908	Arbor	200,0	17	8,0	71,0	207,0	60,0	130,0	63,0	4200	6,9	SN.X1407ZN

Spare Parts

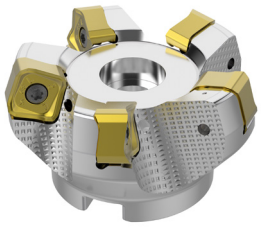
Accessories

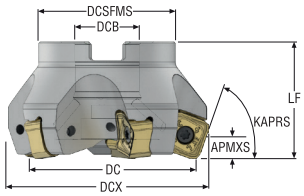
For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.56-0050-0063	220.17-692	C04011-T15P	–	–	T00-15P35	3.5NM
R220.56-0080-0125	–	C04011-T15P	–	–	T00-15P35	3.5NM
R220.56-8160	–	C04011-T15P	SC-160-90	MF6S4X10	T00-15P35	3.5NM
R220.56-8200	–	C04011-T15P	SC-200-90	MF6S4X10	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Quattro R220.56-14 – Inch



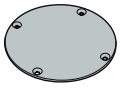


- For insert selection and cutting data recommendations, see page(s) 197-202
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.56-02.00-14-4A	03241909	Arbor	1.969	4	0.315	71.0	2.244	0.750	1.850	1.575	8500	0.880	SN.X1407ZN
R220.56-02.00-14-5A	03241916	Arbor	1.969	5	0.315	71.0	2.244	0.750	1.850	1.575	8500	0.880	SN.X1407ZN
R220.56-02.50-14-5A	03241910	Arbor	2.480	5	0.315	71.0	2.756	0.750	1.850	1.575	7600	1.100	SN.X1407ZN
R220.56-02.50-14-6A	03241917	Arbor	2.480	6	0.315	71.0	2.756	0.750	1.850	1.575	7600	1.100	SN.X1407ZN
R220.56-03.00-14-6A	03241911	Arbor	3.150	6	0.315	71.0	3.425	1.000	2.441	1.969	6700	2.650	SN.X1407ZN
R220.56-03.00-14-8A	03241918	Arbor	3.150	8	0.315	71.0	3.425	1.000	2.441	1.969	6700	2.650	SN.X1407ZN
R220.56-04.00-14-7A	03241912	Arbor	3.937	7	0.315	71.0	4.213	1.500	3.031	1.969	6000	3.530	SN.X1407ZN
R220.56-04.00-14-10A	03241919	Arbor	3.937	10	0.315	71.0	4.213	1.500	3.031	1.969	6000	3.530	SN.X1407ZN
R220.56-05.00-14-8A	03241913	Arbor	4.921	8	0.315	71.0	5.197	1.500	3.543	2.480	5400	7.500	SN.X1407ZN
R220.56-05.00-14-12A	03241920	Arbor	4.921	12	0.315	71.0	5.197	1.500	3.543	2.480	5400	7.500	SN.X1407ZN
R220.56-06.00-14-10A	03241914	Arbor	6.299	10	0.315	71.0	6.575	2.000	4.331	2.480	4700	12.570	SN.X1407ZN
R220.56-06.00-14-15A	03241921	Arbor	6.299	15	0.315	71.0	6.575	2.000	4.331	2.480	4700	12.570	SN.X1407ZN
R220.56-808.00-14-12A	03241915	Arbor	7.874	12	0.315	71.0	8.150	2.500	5.118	2.480	4200	15.210	SN.X1407ZN
R220.56-808.00-14-17A	03241922	Arbor	7.874	17	0.315	71.0	8.150	2.500	5.118	2.480	4200	14.990	SN.X1407ZN

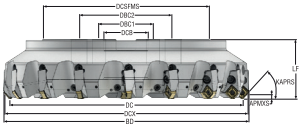
Spare Parts

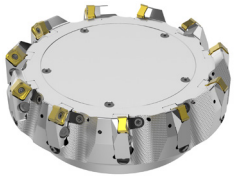
Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.56-02.00-02.50	UC6S3/8UNFX1	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.56-03.00	UC6S1/2UNFX1-1/4	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.56-04.00	UF6S3/4UNFX1-3/4	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.56-05.00	UC6S3/4UNFX1-1/4	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
R220.56-06.00	–	C04011-T15P	SC-160-90	MF6S4X10	T00-15P35	31.0IN.LBS
R220.56-808.00	–	C04011-T15P	SC-200-90	MF6S4X10	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Quattro R220.54/56-14CA – Metric



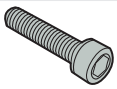
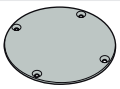


- For insert selection and cutting data recommendations, see page(s) 197-202
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	BD	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm	mm		kg	
R220.54-8160-14-9CA	03213787	Arbor	160,0	9	6,0	48,0	175,0	176,5	40,0	90,0	80,0	4700	7,7	SN.X1407AN
R220.54-8200-14-11CA	03213788	Arbor	200,0	11	6,0	48,0	215,0	216,5	60,0	130,0	80,0	4200	9,8	SN.X1407AN
R220.54-8250-14-14CA	03213789	Arbor	250,0	14	6,0	48,0	265,0	266,5	60,0	130,0	80,0	3800	18,7	SN.X1407AN
R220.54-8315-14-16CA	03213790	Arbor	315,0	16	6,0	48,0	330,0	331,5	60,0	225,0	80,0	3400	32,0	SN.X1407AN
R220.56-8160-14-9CA	03245958	Arbor	160,0	9	8,0	71,0	167,0	175,5	40,0	90,0	80,0	4700	7,7	SN.X1407ZN
R220.56-8200-14-11CA	03245959	Arbor	200,0	11	8,0	71,0	207,0	215,5	60,0	130,0	80,0	4200	18,6	SN.X1407ZN
R220.56-8250-14-14CA	03245960	Arbor	250,0	14	8,0	71,0	257,0	265,5	60,0	130,0	80,0	3800	18,5	SN.X1407ZN
R220.56-8315-14-16CA	03245961	Arbor	315,0	16	8,0	71,0	322,0	330,5	60,0	225,0	80,0	3400	29,8	SN.X1407ZN

Spare Parts

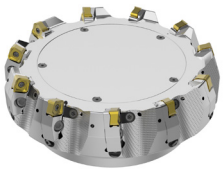
Accessories

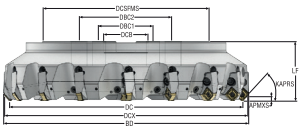
For cutter	Cassette	Cassette screw	Insert screw	Lid	Lid screw	Setting gauge	Wedge clamp	Wedge screw	Torque key	Torque value
										
R220.54-8160	SN14AR	MC6S6X20	C04011-T15P	SC-160-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.54-8200	SN14AR	MC6S6X20	C04011-T15P	SC-200-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.54-8250	SN14AR	MC6S6X20	C04011-T15P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.54-8315	SN14AR	MC6S6X20	C04011-T15P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.56-8160	SN14ZR	MC6S6X20	C04011-T15P	SC-160-90	MF6S4X8	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.56-8200	SN14ZR	MC6S6X20	C04011-T15P	SC-200-90	MF6S4X8	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.56-8250	SN14ZR	MC6S6X20	C04011-T15P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM
R220.56-8315	SN14ZR	MC6S6X20	C04011-T15P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Quattro R220.54/56-14CA – Inch



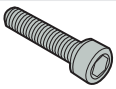
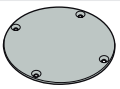


- For insert selection and cutting data recommendations, see page(s) 197-202
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	BD	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R220.54-06.00-14-9CA	03213791	Arbor	6.299	9	0.236	48,0	6.890	6.949	2.000	4.331	3.150	4700	16.090	SN.X1407AN
R220.54-808.00-14-11CA	03213792	Arbor	7.874	11	0.236	48,0	8.465	8.524	2.500	5.118	3.150	4200	22.050	SN.X1407AN
R220.54-810.00-14-14CA	03213793	Arbor	9.843	14	0.236	48,0	10.433	10.492	2.500	5.118	3.150	3800	41.230	SN.X1407AN
R220.54-812.50-14-16CA	03213794	Arbor	12.402	16	0.236	48,0	12.992	13.051	2.500	8.858	3.150	3400	65.700	SN.X1407AN
R220.56-06.00-14-9CA	03245962	Arbor	6.299	9	0.315	71,0	6.575	6.909	2.000	4.331	3.150	4700	17.420	SN.X1407ZN
R220.56-808.00-14-11CA	03245963	Arbor	7.874	11	0.315	71,0	8.150	8.484	2.500	5.118	3.150	4200	22.490	SN.X1407ZN
R220.56-810.00-14-14CA	03245964	Arbor	9.843	14	0.315	71,0	10.118	10.453	2.500	5.118	3.150	3800	43.650	SN.X1407ZN
R220.56-812.50-14-16CA	03245965	Arbor	12.402	16	0.315	71,0	12.677	13.012	2.500	8.858	3.150	3400	65.920	SN.X1407ZN

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Lid	Lid screw	Setting gauge	Wedge clamp	Wedge screw	Torque key	Torque value
										
R220.54-06.00	SN14AR	MC6S6X20	C04011-T15P	SC-160-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.54-808.00	SN14AR	MC6S6X20	C04011-T15P	SC-200-90	MF6S4X8	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.54-810.00	SN14AR	MC6S6X20	C04011-T15P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.54-812.50	SN14AR	MC6S6X20	C04011-T15P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.56-06.00	SN14ZR	MC6S6X20	C04011-T15P	SC-160-90	MF6S4X8	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.56-808.00	SN14ZR	MC6S6X20	C04011-T15P	SC-200-90	MF6S4X8	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.56-810.00	SN14ZR	MC6S6X20	C04011-T15P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.56-812.50	SN14ZR	MC6S6X20	C04011-T15P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.54-14 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SNMX1407ANTR-M10 T350M	5,0 *0.20*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P2	SNMX1407ANTR-M10 T350M	5,0 *0.20*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P3	SNMX1407ANTR-M16 MP2501	5,0 *0.20*	0,30 *0.012*	0,32 *0.013*	0,40 *0.016*
P4	SNMX1407ANTR-M16 MP2501	5,0 *0.20*	0,30 *0.012*	0,32 *0.013*	0,40 *0.016*
P5	SNMX1407ANTR-M16 MP2501	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P6	SNMX1407ANTR-M16 MP2501	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P7	SNMX1407ANTR-M10 T350M	5,0 *0.20*	0,24 *0.0095*	0,25 *0.010*	0,32 *0.013*
P8	SNMX1407ANTR-M10 T350M	5,0 *0.20*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P11	SNMX1407ANTR-M10 MP2050	5,0 *0.20*	0,24 *0.0095*	0,25 *0.010*	0,32 *0.013*
P12	SNMX1407ANTR-M10 MP2050	4,0 *0.16*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M1	SNHX1407ANR-ME10 F40M	5,0 *0.20*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
M2	SNHX1407ANR-ME10 F40M	5,0 *0.20*	0,20 *0.0080*	0,22 *0.0085*	0,28 *0.011*
M3	SNHX1407ANR-ME10 MS2050	4,0 *0.16*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M4	SNMX1407ANTR-M10 MP2050	3,0 *0.12*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
M5	SNMX1407ANTR-M10 MP2050	3,0 *0.12*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
K1	SNMX1407ANTR-M16 MK1500	5,0 *0.20*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
K2	SNMX1407ANTR-M16 MK1500	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
K3	SNMX1407ANTR-M16 MP1501	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
K4	SNMX1407ANTR-M16 MP1501	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
K5	SNMX1407ANTR-M16 MP1501	5,0 *0.20*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
K6	SNMX1407ANTR-M16 MK2050	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
K7	SNMX1407ANTR-M16 MK2050	5,0 *0.20*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
N1	SNHX1407ANR-ME10 H25	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
N2	SNHX1407ANR-ME10 H25	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
N3	SNHX1407ANR-ME10 H25	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
N11	SNHX1407ANR-ME10 H25	5,0 *0.20*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
S1	SNMX1407ANTR-M10 MS2500	3,0 *0.12*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
S2	SNMX1407ANTR-M10 MS2500	3,0 *0.12*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
S3	SNMX1407ANTR-M10 MS2500	3,0 *0.12*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
S11	SNHX1407ANR-ME10 MS2050	3,5 *0.14*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
S12	SNHX1407ANR-ME10 MS2050	3,5 *0.14*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
S13	SNHX1407ANR-ME10 MS2050	3,0 *0.12*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
H5	SNMX1407ANTR-M16 MP3000	4,0 *0.16*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*
H8	SNMX1407ANTR-M16 MP3000	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
H11	SNMX1407ANTR-M16 MP1501	4,0 *0.16*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*
H12	SNMX1407ANTR-M16 MP1501	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
H21	SNMX1407ANTR-M16 MP1501	3,5 *0.14*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.54-14 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			T350M			MP3000			MP2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	215 *710*	245 *800*	280 *920*	320 *1050*	365 *1200*	420 *1375*	285 *940*	325 *1075*	370 *1225*	250 *820*	285 *940*	320 *1050*	270 *890*	305 *1000*	350 *1150*	280 *920*	320 *1050*	365 *1200*
P2	210 *690*	240 *790*	275 *900*	315 *1025*	355 *1175*	405 *1325*	275 *900*	315 *1025*	360 *1175*	240 *790*	275 *900*	315 *1025*	260 *850*	300 *980*	340 *1125*	270 *890*	310 *1025*	355 *1175*
P3	185 *610*	210 *690*	240 *790*	275 *900*	315 *1025*	355 *1175*	240 *790*	280 *920*	315 *1025*	210 *690*	240 *790*	275 *900*	230 *750*	265 *870*	300 *980*	235 *770*	275 *900*	310 *1025*
P4	160 *520*	185 *610*	210 *690*	240 *790*	275 *900*	315 *1025*	215 *710*	245 *800*	280 *920*	185 *610*	215 *710*	240 *790*	200 *660*	230 *750*	265 *870*	210 *690*	240 *790*	275 *900*
P5	155 *510*	180 *590*	200 *660*	230 *750*	265 *870*	300 *980*	205 *670*	235 *770*	265 *870*	180 *590*	205 *670*	230 *750*	195 *640*	225 *740*	250 *820*	200 *660*	230 *750*	260 *850*
P6	175 *570*	200 *660*	225 *740*	260 *850*	300 *980*	335 *1100*	230 *750*	265 *870*	300 *980*	200 *660*	230 *750*	260 *850*	220 *720*	250 *820*	280 *920*	225 *740*	260 *850*	295 *970*
P7	165 *540*	190 *620*	215 *710*	245 *800*	285 *940*	320 *1050*	220 *720*	250 *820*	280 *920*	190 *620*	220 *720*	245 *800*	205 *670*	235 *770*	265 *870*	215 *710*	245 *800*	275 *900*
P8	155 *510*	175 *570*	200 *660*	230 *750*	265 *870*	300 *980*	205 *670*	235 *770*	265 *870*	175 *570*	205 *670*	230 *750*	190 *620*	220 *720*	250 *820*	200 *660*	230 *750*	260 *850*
P11	160 *520*	185 *610*	205 *670*	240 *790*	275 *900*	310 *1025*	210 *690*	245 *800*	275 *900*	185 *610*	210 *690*	240 *790*	200 *660*	230 *750*	260 *850*	210 *690*	240 *790*	270 *890*
P12	105 *345*	120 *395*	135 *445*	155 *510*	180 *590*	200 *660*	140 *460*	160 *520*	180 *590*	120 *395*	140 *460*	155 *510*	130 *425*	150 *490*	170 *560*	135 *445*	155 *510*	175 *570*
M1	170 *560*	195 *640*	220 *720*	— —	— —	— —	200 *660*	225 *740*	260 *850*	185 *610*	210 *690*	240 *790*	195 *640*	225 *740*	255 *840*	195 *640*	220 *720*	255 *840*
M2	140 *460*	160 *520*	180 *590*	— —	— —	— —	165 *540*	190 *620*	215 *710*	155 *510*	175 *570*	200 *660*	165 *540*	185 *610*	210 *690*	160 *520*	185 *610*	210 *690*
M3	110 *360*	130 *425*	145 *475*	— —	— —	— —	130 *425*	155 *510*	175 *570*	125 *410*	145 *475*	160 *520*	130 *425*	150 *490*	170 *560*	130 *425*	150 *490*	170 *560*
M4	85 *280*	100 *330*	115 *375*	— —	— —	— —	105 *345*	120 *395*	135 *445*	95 *310*	110 *360*	125 *410*	100 *330*	115 *375*	130 *425*	100 *330*	115 *375*	130 *425*
M5	75 *245*	85 *280*	95 *310*	— —	— —	— —	85 *280*	100 *330*	110 *360*	80 *260*	90 *295*	105 *345*	85 *280*	95 *310*	110 *360*	85 *280*	95 *310*	110 *360*
K1	165 *540*	190 *620*	215 *710*	250 *820*	280 *920*	320 *1050*	220 *720*	250 *820*	285 *940*	190 *620*	220 *720*	250 *820*	210 *690*	235 *770*	270 *890*	215 *710*	245 *800*	280 *920*
K2	150 *490*	170 *560*	190 *620*	220 *720*	255 *840*	285 *940*	195 *640*	225 *740*	250 *820*	170 *560*	195 *640*	220 *720*	185 *610*	215 *710*	240 *790*	190 *620*	220 *720*	245 *800*
K3	125 *410*	145 *475*	160 *520*	185 *610*	215 *710*	240 *790*	165 *540*	190 *620*	215 *710*	145 *475*	165 *540*	185 *610*	155 *510*	180 *590*	200 *660*	160 *520*	185 *610*	210 *690*
K4	120 *395*	135 *445*	155 *510*	180 *590*	205 *670*	230 *750*	160 *520*	180 *590*	205 *670*	135 *445*	160 *520*	175 *570*	150 *490*	170 *560*	195 *640*	155 *510*	180 *590*	200 *660*
K5	75 *245*	85 *280*	95 *310*	110 *360*	125 *410*	140 *460*	95 *310*	110 *360*	125 *410*	85 *280*	100 *330*	110 *360*	90 *295*	105 *345*	120 *395*	95 *310*	110 *360*	125 *410*
K6	105 *345*	120 *395*	135 *445*	155 *510*	180 *590*	200 *660*	140 *460*	160 *520*	180 *590*	120 *395*	140 *460*	155 *510*	130 *425*	150 *490*	170 *560*	135 *445*	155 *510*	175 *570*
K7	95 *310*	110 *360*	120 *395*	140 *460*	160 *520*	180 *590*	125 *410*	145 *475*	160 *520*	110 *360*	125 *410*	140 *460*	115 *375*	135 *445*	155 *510*	120 *395*	140 *460*	160 *520*
N1	1200 *3925*	1375 *4500*	1575 *5175*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	485 *1600*	560 *1825*	640 *2100*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	325 *1075*	370 *1225*	425 *1400*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	370 *1225*	425 *1400*	485 *1600*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	41 *135*	47 *155*	55 *180*	— —	— —	— —	50 *165*	55 *180*	65 *215*	45 *150*	50 *165*	60 *195*	47 *155*	55 *180*	60 *195*	49 *160*	55 *180*	65 *215*
S2	33 *110*	37 *120*	43 *140*	— —	— —	— —	40 *130*	46 *150*	50 *165*	36 *120*	41 *135*	47 *155*	38 *125*	43 *140*	49 *160*	40 *130*	45 *150*	50 *165*
S3	29 *95*	33 *110*	38 *125*	— —	— —	— —	35 *115*	41 *135*	46 *150*	32 *105*	37 *120*	41 *135*	33 *110*	39 *130*	44 *145*	35 *115*	40 *130*	45 *150*
S11	55 *180*	65 *215*	75 *245*	— —	— —	— —	70 *230*	80 *260*	90 *295*	60 *195*	70 *230*	80 *260*	65 *215*	75 *245*	85 *280*	70 *230*	80 *260*	90 *295*
S12	39 *130*	45 *150*	50 *165*	— —	— —	— —	48 *155*	55 *180*	65 *215*	43 *140*	50 *165*	55 *180*	45 *150*	55 *180*	60 *195*	47 *155*	55 *180*	60 *195*
S13	23 *75*	26 *85*	30 *100*	— —	— —	— —	28 *90*	32 *105*	37 *120*	25 *80*	29 *95*	33 *110*	27 *90*	30 *100*	34 *110*	28 *90*	32 *105*	36 *120*
H5	35 *115*	40 *130*	45 *150*	50 *165*	60 *195*	65 *215*	42 *140*	48 *155*	55 *180*	40 *130*	46 *150*	50 *165*	41 *135*	47 *155*	50 *165*	41 *135*	47 *155*	50 *165*
H8	37 *120*	43 *140*	48 *155*	55 *180*	65 *215*	70 *230*	45 *150*	50 *165*	60 *195*	43 *140*	49 *160*	55 *180*	43 *140*	50 *165*	55 *180*	43 *140*	50 *165*	55 *180*
H11	44 *145*	50 *165*	55 *180*	65 *215*	75 *245*	85 *280*	55 *180*	60 *195*	70 *230*	50 *165*	60 *195*	65 *215*	50 *165*	60 *195*	65 *215*	50 *165*	60 *195*	65 *215*
H12	65 *215*	75 *245*	85 *280*	100 *330*	115 *375*	130 *425*	90 *295*	100 *330*	115 *375*	75 *245*	90 *295*	100 *330*	85 *280*	95 *310*	110 *360*	85 *280*	100 *330*	115 *375*
H21	37 *120*	43 *140*	48 *155*	55 *180*	65 *215*	70 *230*	45 *150*	50 *165*	60 *195*	43 *140*	49 *160*	55 *180*	43 *140*	50 *165*	55 *180*	43 *140*	50 *165*	55 *180*

R220.54-14 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			H25			MS2500			MS2050			MM4500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	260	300	340	—	—	—	290	330	375	235	270	310	185	210	235
	—	—	—	*850*	*980*	*1125*	—	—	—	*950*	*1075*	*1225*	*770*	*890*	*1025*	*610*	*690*	*770*
P2	—	—	—	255	290	330	—	—	—	280	325	365	230	265	300	175	205	230
	—	—	—	*840*	*950*	*1075*	—	—	—	*920*	*1075*	*1200*	*750*	*870*	*980*	*570*	*670*	*750*
P3	—	—	—	225	255	290	—	—	—	250	285	320	200	230	265	155	180	200
	—	—	—	*740*	*840*	*950*	—	—	—	*820*	*940*	*1050*	*660*	*750*	*870*	*510*	*590*	*660*
P4	—	—	—	195	225	255	—	—	—	220	250	285	175	205	230	135	160	180
	—	—	—	*640*	*740*	*840*	—	—	—	*720*	*820*	*940*	*570*	*670*	*750*	*445*	*520*	*590*
P5	—	—	—	190	220	250	—	—	—	210	245	275	170	195	220	135	150	170
	—	—	—	*620*	*720*	*820*	—	—	—	*690*	*800*	*900*	*560*	*640*	*720*	*445*	*490*	*560*
P6	—	—	—	210	245	280	—	—	—	235	275	310	190	220	250	150	170	195
	—	—	—	*690*	*800*	*920*	—	—	—	*770*	*900*	*1025*	*620*	*720*	*820*	*490*	*560*	*640*
P7	—	—	—	200	235	265	—	—	—	220	260	290	180	210	235	140	160	185
	—	—	—	*660*	*770*	*870*	—	—	—	*720*	*850*	*950*	*590*	*690*	*770*	*460*	*520*	*610*
P8	—	—	—	190	215	245	—	—	—	210	240	270	170	195	220	130	150	170
	—	—	—	*620*	*710*	*800*	—	—	—	*690*	*790*	*890*	*560*	*640*	*720*	*425*	*490*	*560*
P11	—	—	—	195	225	255	—	—	—	215	250	285	175	205	230	140	155	180
	—	—	—	*640*	*740*	*840*	—	—	—	*710*	*820*	*940*	*570*	*670*	*750*	*460*	*510*	*590*
P12	—	—	—	130	150	165	—	—	—	145	165	185	115	135	150	90	100	115
	—	—	—	*425*	*490*	*540*	—	—	—	*475*	*540*	*610*	*375*	*445*	*490*	*295*	*330*	*375*
M1	—	—	—	—	—	—	—	—	—	200	230	265	185	210	240	150	175	195
	—	—	—	—	—	—	—	—	—	*660*	*750*	*870*	*610*	*690*	*790*	*490*	*570*	*640*
M2	—	—	—	—	—	—	—	—	—	165	195	220	155	175	200	130	145	165
	—	—	—	—	—	—	—	—	—	*540*	*640*	*720*	*510*	*570*	*660*	*425*	*475*	*540*
M3	—	—	—	—	—	—	—	—	—	135	155	180	125	145	160	100	120	130
	—	—	—	—	—	—	—	—	—	*445*	*510*	*590*	*410*	*475*	*520*	*330*	*395*	*425*
M4	—	—	—	—	—	—	—	—	—	105	120	140	95	110	125	80	90	100
	—	—	—	—	—	—	—	—	—	*345*	*395*	*460*	*310*	*360*	*410*	*260*	*295*	*330*
M5	—	—	—	—	—	—	—	—	—	90	100	115	80	90	105	65	75	85
	—	—	—	—	—	—	—	—	—	*295*	*330*	*375*	*260*	*295*	*345*	*215*	*245*	*280*
K1	290	335	380	275	315	360	—	—	—	—	—	—	—	—	—	—	—	—
	950	*1100*	*1250*	*900*	*1025*	*1175*	—	—	—	—	—	—	—	—	—	—	—	—
K2	255	300	340	245	285	320	—	—	—	—	—	—	—	—	—	—	—	—
	840	*980*	*1125*	*800*	*940*	*1050*	—	—	—	—	—	—	—	—	—	—	—	—
K3	215	255	285	205	240	270	—	—	—	—	—	—	—	—	—	—	—	—
	710	*840*	*940*	*670*	*790*	*890*	—	—	—	—	—	—	—	—	—	—	—	—
K4	205	245	275	195	230	260	—	—	—	—	—	—	—	—	—	—	—	—
	670	*800*	*900*	*640*	*750*	*850*	—	—	—	—	—	—	—	—	—	—	—	—
K5	130	150	170	125	140	160	—	—	—	—	—	—	—	—	—	—	—	—
	425	*490*	*560*	*410*	*460*	*520*	—	—	—	—	—	—	—	—	—	—	—	—
K6	185	215	240	175	200	230	—	—	—	—	—	—	—	—	—	—	—	—
	610	*710*	*790*	*570*	*660*	*750*	—	—	—	—	—	—	—	—	—	—	—	—
K7	165	190	215	155	180	205	—	—	—	—	—	—	—	—	—	—	—	—
	540	*620*	*710*	*510*	*590*	*670*	—	—	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	1200	1400	1575	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*3925*	*4600*	*5175*	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	480	560	630	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*1575*	*1825*	*2075*	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	320	375	425	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*1050*	*1225*	*1400*	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	365	430	485	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*1200*	*1400*	*1600*	—	—	—	—	—	—	—	—	—
S1	—	—	—	—	—	—	—	—	—	50	60	65	45	50	60	24	28	31
	—	—	—	—	—	—	—	—	—	*165*	*195*	*215*	*150*	*165*	*195*	*80*	*90*	*100*
S2	—	—	—	—	—	—	—	—	—	42	47	55	36	41	47	19	22	25
	—	—	—	—	—	—	—	—	—	*140*	*155*	*180*	*120*	*135*	*155*	*60*	*70*	*80*
S3	—	—	—	—	—	—	—	—	—	37	42	47	32	37	41	17	20	22
	—	—	—	—	—	—	—	—	—	*120*	*140*	*155*	*105*	*120*	*135*	*55*	*65*	*70*
S11	—	—	—	—	—	—	—	—	—	70	80	95	60	70	80	33	39	43
	—	—	—	—	—	—	—	—	—	*230*	*260*	*310*	*195*	*230*	*260*	*110*	*130*	*140*
S12	—	—	—	—	—	—	—	—	—	49	55	65	43	50	55	31	36	40
	—	—	—	—	—	—	—	—	—	*160*	*180*	*215*	*140*	*165*	*180*	*100*	*120*	*130*
S13	—	—	—	—	—	—	—	—	—	29	33	38	25	29	33	18	21	23
	—	—	—	—	—	—	—	—	—	*95*	*110*	*125*	*80*	*95*	*110*	*60*	*70*	*75*
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

R220.56-14 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SNMX1407ZNTR-M10 T350M	6,0 *0.24*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
P2	SNMX1407ZNTR-M10 T350M	6,0 *0.24*	0,22 *0.0085*	0,22 *0.0085*	0,26 *0.010*
P3	SNMX1407ZNTR-M16 MP2501	6,0 *0.24*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
P4	SNMX1407ZNTR-M16 MP2501	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
P5	SNMX1407ZNTR-M16 MP2501	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
P6	SNMX1407ZNTR-M16 MP2501	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
P7	SNMX1407ZNTR-M10 T350M	6,0 *0.24*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*
P8	SNMX1407ZNTR-M10 T350M	6,0 *0.24*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
P11	SNMX1407ZNTR-M10 MP2050	6,0 *0.24*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*
P12	SNMX1407ZNTR-M10 MP2050	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,17 *0.0065*
M1	SNHX1407ZNR-ME10 F40M	6,0 *0.24*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*
M2	SNHX1407ZNR-ME10 F40M	6,0 *0.24*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
M3	SNHX1407ZNR-ME10 MS2050	5,0 *0.20*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
M4	SNMX1407ZNTR-M10 MP2050	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
M5	SNMX1407ZNTR-M10 MP2050	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
K1	SNMX1407ZNTR-M16 MK1500	6,0 *0.24*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
K2	SNMX1407ZNTR-M16 MK1500	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
K3	SNMX1407ZNTR-M16 MP1501	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
K4	SNMX1407ZNTR-M16 MP1501	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
K5	SNMX1407ZNTR-M16 MP1501	6,0 *0.24*	0,22 *0.0085*	0,22 *0.0085*	0,26 *0.010*
K6	SNMX1407ZNTR-M16 MK2050	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
K7	SNMX1407ZNTR-M16 MK2050	6,0 *0.24*	0,22 *0.0085*	0,22 *0.0085*	0,26 *0.010*
N1	SNHX1407ZNR-ME10 H25	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
N2	SNHX1407ZNR-ME10 H25	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
N3	SNHX1407ZNR-ME10 H25	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
N11	SNHX1407ZNR-ME10 H25	6,0 *0.24*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
S1	SNMX1407ZNTR-M10 MS2500	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
S2	SNMX1407ZNTR-M10 MS2500	4,0 *0.16*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
S3	SNMX1407ZNTR-M10 MS2500	4,0 *0.16*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
S11	SNHX1407ZNR-ME10 MS2050	4,5 *0.18*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
S12	SNHX1407ZNR-ME10 MS2050	4,5 *0.18*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
S13	SNHX1407ZNR-ME10 MS2050	4,0 *0.16*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H5	SNMX1407ZNTR-M16 MP1501	5,0 *0.20*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
H8	SNMX1407ZNTR-M16 MP1501	4,5 *0.18*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H11	SNMX1407ZNTR-M16 MP1501	5,0 *0.20*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
H12	SNMX1407ZNTR-M16 MP1501	4,5 *0.18*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H21	SNMX1407ZNTR-M16 MP1501	4,5 *0.18*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

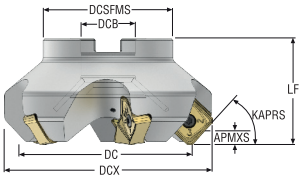
R220.56-14 – Cutting data v_c = (m/min)/*(sf/min)*

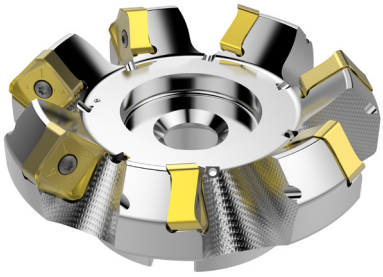
SMG	F40M			MP1501			MP2501			T350M			MP3000			MP2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	215 *710*	240 *790*	275 *900*	295 *970*	340 *1125*	385 *1275*	260 *850*	300 *980*	345 *1125*	245 *800*	275 *900*	320 *1050*	265 *870*	300 *980*	345 *1125*	275 *900*	310 *1025*	360 *1175*
P2	200 *660*	235 *770*	270 *890*	285 *940*	330 *1075*	375 *1225*	250 *820*	295 *970*	335 *1100*	230 *750*	270 *890*	310 *1025*	250 *820*	295 *970*	340 *1125*	260 *850*	305 *1000*	350 *1150*
P3	180 *590*	210 *690*	235 *770*	250 *820*	290 *950*	330 *1075*	220 *720*	255 *840*	295 *970*	205 *670*	240 *790*	270 *890*	225 *740*	260 *850*	295 *970*	230 *750*	270 *890*	305 *1000*
P4	155 *510*	185 *610*	205 *670*	220 *720*	255 *840*	290 *950*	195 *640*	230 *750*	260 *850*	180 *590*	210 *690*	240 *790*	195 *640*	230 *750*	260 *850*	205 *670*	235 *770*	270 *890*
P5	155 *510*	175 *570*	200 *660*	210 *690*	245 *800*	280 *920*	185 *610*	220 *720*	245 *800*	175 *570*	200 *660*	230 *750*	190 *620*	220 *720*	250 *820*	200 *660*	225 *740*	260 *850*
P6	170 *560*	195 *640*	225 *740*	235 *770*	275 *900*	310 *1025*	210 *690*	245 *800*	275 *900*	195 *640*	225 *740*	260 *850*	215 *710*	245 *800*	280 *920*	220 *720*	255 *840*	290 *950*
P7	160 *520*	185 *610*	210 *690*	225 *740*	260 *850*	295 *970*	195 *640*	230 *750*	260 *850*	185 *610*	215 *710*	245 *800*	200 *660*	230 *750*	265 *870*	210 *690*	240 *790*	275 *900*
P8	150 *490*	175 *570*	200 *660*	210 *690*	245 *800*	280 *920*	185 *610*	215 *710*	245 *800*	170 *560*	200 *660*	225 *740*	185 *610*	220 *720*	245 *800*	195 *640*	225 *740*	255 *840*
P11	155 *510*	180 *590*	205 *670*	215 *710*	255 *840*	285 *940*	190 *620*	225 *740*	255 *840*	180 *590*	205 *670*	235 *770*	195 *640*	225 *740*	260 *850*	205 *670*	235 *770*	265 *870*
P12	105 *345*	120 *395*	135 *445*	145 *475*	170 *560*	190 *620*	130 *425*	150 *490*	170 *560*	120 *395*	140 *460*	155 *510*	130 *425*	150 *490*	165 *540*	135 *445*	155 *510*	175 *570*
M1	160 *520*	190 *620*	220 *720*	— —	— —	— —	180 *590*	210 *690*	240 *790*	180 *590*	210 *690*	240 *790*	190 *620*	220 *720*	250 *820*	185 *610*	220 *720*	250 *820*
M2	135 *445*	155 *510*	180 *590*	— —	— —	— —	150 *490*	175 *570*	200 *660*	150 *490*	175 *570*	200 *660*	160 *520*	185 *610*	210 *690*	160 *520*	180 *590*	210 *690*
M3	110 *360*	130 *425*	145 *475*	— —	— —	— —	125 *410*	145 *475*	160 *520*	125 *410*	140 *460*	160 *520*	130 *425*	150 *490*	170 *560*	130 *425*	145 *475*	170 *560*
M4	90 *295*	100 *330*	115 *375*	— —	— —	— —	95 *310*	110 *360*	125 *410*	95 *310*	110 *360*	125 *410*	100 *330*	115 *375*	130 *425*	100 *330*	115 *375*	130 *425*
M5	75 *245*	85 *280*	95 *310*	— —	— —	— —	80 *260*	90 *295*	105 *345*	80 *260*	90 *295*	105 *345*	85 *280*	95 *310*	110 *360*	85 *280*	95 *310*	110 *360*
K1	160 *520*	185 *610*	215 *710*	225 *740*	260 *850*	300 *980*	200 *660*	230 *750*	265 *870*	185 *610*	215 *710*	245 *800*	200 *660*	230 *750*	265 *870*	205 *670*	240 *790*	275 *900*
K2	145 *475*	165 *540*	190 *620*	200 *660*	235 *770*	265 *870*	175 *570*	205 *670*	235 *770*	165 *540*	190 *620*	220 *720*	180 *590*	210 *690*	235 *770*	190 *620*	215 *710*	245 *800*
K3	125 *410*	140 *460*	160 *520*	170 *560*	195 *640*	225 *740*	150 *490*	175 *570*	200 *660*	140 *460*	160 *520*	185 *610*	155 *510*	175 *570*	200 *660*	160 *520*	180 *590*	210 *690*
K4	115 *375*	135 *445*	155 *510*	160 *520*	190 *620*	215 *710*	145 *475*	165 *540*	190 *620*	135 *445*	155 *510*	175 *570*	145 *475*	170 *560*	190 *620*	150 *490*	175 *570*	200 *660*
K5	70 *230*	80 *260*	95 *310*	100 *330*	115 *375*	135 *445*	90 *295*	100 *330*	120 *395*	85 *280*	95 *310*	110 *360*	90 *295*	105 *345*	115 *375*	95 *310*	105 *345*	120 *395*
K6	105 *345*	120 *395*	135 *445*	140 *460*	165 *540*	190 *620*	125 *410*	145 *475*	165 *540*	120 *395*	135 *445*	155 *510*	130 *425*	150 *490*	170 *560*	135 *445*	155 *510*	175 *570*
K7	90 *295*	105 *345*	120 *395*	125 *410*	150 *490*	170 *560*	110 *360*	130 *425*	150 *490*	105 *345*	120 *395*	140 *460*	115 *375*	130 *425*	150 *490*	120 *395*	135 *445*	155 *510*
N1	1200 *3925*	1350 *4425*	1550 *5075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	480 *1575*	550 *1800*	630 *2075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	320 *1050*	365 *1200*	420 *1375*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	365 *1200*	420 *1375*	480 *1575*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	41 *135*	46 *150*	55 *180*	— —	— —	— —	47 *155*	55 *180*	60 *195*	45 *150*	50 *165*	60 *195*	47 *155*	55 *180*	60 *195*	49 *160*	55 *180*	65 *215*
S2	33 *110*	37 *120*	42 *140*	— —	— —	— —	38 *125*	43 *140*	50 *165*	36 *120*	41 *135*	47 *155*	38 *125*	43 *140*	49 *160*	40 *130*	45 *150*	50 *165*
S3	28 *90*	33 *110*	37 *120*	— —	— —	— —	34 *110*	38 *125*	44 *145*	31 *100*	36 *120*	41 *135*	33 *110*	38 *125*	43 *140*	34 *110*	40 *130*	45 *150*
S11	55 *180*	65 *215*	75 *245*	— —	— —	— —	65 *215*	75 *245*	85 *280*	60 *195*	70 *230*	80 *260*	65 *215*	75 *245*	85 *280*	70 *230*	80 *260*	90 *295*
S12	39 *130*	45 *150*	50 *165*	— —	— —	— —	45 *150*	50 *165*	60 *195*	43 *140*	49 *160*	55 *180*	46 *150*	50 *165*	60 *195*	47 *155*	55 *180*	60 *195*
S13	23 *75*	26 *85*	30 *100*	— —	— —	— —	27 *90*	30 *100*	35 *115*	25 *80*	29 *95*	33 *110*	27 *90*	30 *100*	34 *110*	28 *90*	31 *100*	36 *120*
H5	34 *110*	40 *130*	44 *145*	48 *155*	55 *180*	65 *215*	39 *130*	45 *150*	50 *165*	40 *130*	46 *150*	50 *165*	40 *130*	47 *155*	50 *165*	40 *130*	47 *155*	50 *165*
H8	37 *120*	43 *140*	48 *155*	55 *180*	60 *195*	70 *230*	42 *140*	49 *160*	55 *180*	43 *140*	49 *160*	55 *180*	43 *140*	50 *165*	55 *180*	43 *140*	50 *165*	55 *180*
H11	44 *145*	50 *165*	55 *180*	60 *195*	70 *230*	80 *260*	49 *160*	60 *195*	65 *215*	50 *165*	60 *195*	65 *215*	50 *165*	60 *195*	65 *215*	50 *165*	60 *195*	65 *215*
H12	65 *215*	75 *245*	85 *280*	95 *310*	110 *360*	125 *410*	85 *280*	95 *310*	110 *360*	75 *245*	90 *295*	100 *330*	85 *280*	95 *310*	105 *345*	85 *280*	100 *330*	110 *360*
H21	37 *120*	43 *140*	48 *155*	55 *180*	60 *195*	70 *230*	42 *140*	49 *160*	55 *180*	43 *140*	49 *160*	55 *180*	43 *140*	50 *165*	55 *180*	43 *140*	50 *165*	55 *180*

R220.56-14 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			H25			MS2500			MS2050			MM4500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	255	295	340	—	—	—	285	330	375	235	265	305	180	210	235
	—	—	—	*840*	*970*	*1125*	—	—	—	*940*	*1075*	*1225*	*770*	*870*	*1000*	*590*	*690*	*770*
P2	—	—	—	245	290	330	—	—	—	275	320	365	220	260	295	175	200	230
	—	—	—	*800*	*950*	*1075*	—	—	—	*900*	*1050*	*1200*	*720*	*850*	*970*	*570*	*660*	*750*
P3	—	—	—	220	250	290	—	—	—	240	280	320	195	230	260	150	175	200
	—	—	—	*720*	*820*	*950*	—	—	—	*790*	*920*	*1050*	*640*	*750*	*850*	*490*	*570*	*660*
P4	—	—	—	190	225	255	—	—	—	215	250	280	175	200	230	135	155	175
	—	—	—	*620*	*740*	*840*	—	—	—	*710*	*820*	*920*	*570*	*660*	*750*	*445*	*510*	*570*
P5	—	—	—	185	215	245	—	—	—	205	240	270	170	190	220	130	150	170
	—	—	—	*610*	*710*	*800*	—	—	—	*670*	*790*	*890*	*560*	*620*	*720*	*425*	*490*	*560*
P6	—	—	—	205	240	270	—	—	—	230	265	300	190	215	245	145	165	190
	—	—	—	*670*	*790*	*890*	—	—	—	*750*	*870*	*980*	*620*	*710*	*800*	*475*	*540*	*620*
P7	—	—	—	195	225	255	—	—	—	215	250	285	180	205	235	140	160	180
	—	—	—	*640*	*740*	*840*	—	—	—	*710*	*820*	*940*	*590*	*670*	*770*	*460*	*520*	*590*
P8	—	—	—	185	210	245	—	—	—	205	235	270	165	190	215	130	145	165
	—	—	—	*610*	*690*	*800*	—	—	—	*670*	*770*	*890*	*540*	*620*	*710*	*425*	*475*	*540*
P11	—	—	—	190	220	250	—	—	—	210	245	275	175	200	225	135	155	175
	—	—	—	*620*	*720*	*820*	—	—	—	*690*	*800*	*900*	*570*	*660*	*740*	*445*	*510*	*570*
P12	—	—	—	125	145	165	—	—	—	140	165	185	115	130	145	90	100	115
	—	—	—	*410*	*475*	*540*	—	—	—	*460*	*540*	*610*	*375*	*425*	*475*	*295*	*330*	*375*
M1	—	—	—	—	—	—	—	—	—	195	230	260	180	210	240	150	170	200
	—	—	—	—	—	—	—	—	—	*640*	*750*	*850*	*590*	*690*	*790*	*490*	*560*	*660*
M2	—	—	—	—	—	—	—	—	—	165	190	215	150	175	200	125	145	165
	—	—	—	—	—	—	—	—	—	*540*	*620*	*710*	*490*	*570*	*660*	*410*	*475*	*540*
M3	—	—	—	—	—	—	—	—	—	135	155	175	125	140	160	100	115	130
	—	—	—	—	—	—	—	—	—	*445*	*510*	*570*	*410*	*460*	*520*	*330*	*375*	*425*
M4	—	—	—	—	—	—	—	—	—	105	120	140	95	110	125	75	90	100
	—	—	—	—	—	—	—	—	—	*345*	*395*	*460*	*310*	*360*	*410*	*245*	*295*	*330*
M5	—	—	—	—	—	—	—	—	—	90	100	115	80	90	105	65	75	85
	—	—	—	—	—	—	—	—	—	*295*	*330*	*375*	*260*	*295*	*345*	*215*	*245*	*280*
K1	280	330	375	265	310	355	—	—	—	—	—	—	—	—	—	—	—	—
	920	*1075*	*1225*	*870*	*1025*	*1175*	—	—	—	—	—	—	—	—	—	—	—	—
K2	250	295	330	235	275	315	—	—	—	—	—	—	—	—	—	—	—	—
	820	*970*	*1075*	*770*	*900*	*1025*	—	—	—	—	—	—	—	—	—	—	—	—
K3	210	250	280	200	235	265	—	—	—	—	—	—	—	—	—	—	—	—
	690	*820*	*920*	*660*	*770*	*870*	—	—	—	—	—	—	—	—	—	—	—	—
K4	200	235	270	190	225	255	—	—	—	—	—	—	—	—	—	—	—	—
	660	*770*	*890*	*620*	*740*	*840*	—	—	—	—	—	—	—	—	—	—	—	—
K5	125	145	165	115	135	160	—	—	—	—	—	—	—	—	—	—	—	—
	410	*475*	*540*	*375*	*445*	*520*	—	—	—	—	—	—	—	—	—	—	—	—
K6	180	210	235	170	195	225	—	—	—	—	—	—	—	—	—	—	—	—
	590	*690*	*770*	*560*	*640*	*740*	—	—	—	—	—	—	—	—	—	—	—	—
K7	160	185	215	150	175	200	—	—	—	—	—	—	—	—	—	—	—	—
	520	*610*	*710*	*490*	*570*	*660*	—	—	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	1150	1350	1525	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*3775*	*4425*	*5000*	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	470	550	620	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*1550*	*1800*	*2025*	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	315	365	415	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*1025*	*1200*	*1350*	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	355	420	475	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	*1175*	*1375*	*1550*	—	—	—	—	—	—	—	—	—
S1	—	—	—	—	—	—	—	—	—	50	60	70	45	50	60	24	27	31
	—	—	—	—	—	—	—	—	—	*165*	*195*	*230*	*150*	*165*	*195*	*80*	*90*	*100*
S2	—	—	—	—	—	—	—	—	—	42	47	55	36	41	47	19	22	25
	—	—	—	—	—	—	—	—	—	*140*	*155*	*180*	*120*	*135*	*155*	*60*	*70*	*80*
S3	—	—	—	—	—	—	—	—	—	37	42	48	31	36	41	17	19	22
	—	—	—	—	—	—	—	—	—	*120*	*140*	*155*	*100*	*120*	*135*	*55*	*60*	*70*
S11	—	—	—	—	—	—	—	—	—	70	80	95	60	70	80	33	38	43
	—	—	—	—	—	—	—	—	—	*230*	*260*	*310*	*195*	*230*	*260*	*110*	*125*	*140*
S12	—	—	—	—	—	—	—	—	—	49	55	65	43	49	55	31	35	40
	—	—	—	—	—	—	—	—	—	*160*	*180*	*215*	*140*	*160*	*180*	*100*	*115*	*130*
S13	—	—	—	—	—	—	—	—	—	29	33	38	25	29	33	18	21	23
	—	—	—	—	—	—	—	—	—	*95*	*110*	*125*	*80*	*95*	*110*	*60*	*70*	*75*
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

Double Quattro R220.54-22 – Metric



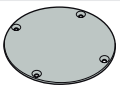


- For insert selection and cutting data recommendations, see page(s) 209-214
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.54-0080-22-5A	03156810	Arbor	80,0	5	9,0	48,0	104,0	27,0	62,0	63,0	4600	1,6	SNMX2209AN
R220.54-0080-22-6A	03157469	Arbor	80,0	6	9,0	48,0	104,0	27,0	62,0	63,0	4600	1,5	SNMX2209AN
R220.54-0100-22-5A	03156811	Arbor	100,0	5	9,0	48,0	124,0	32,0	77,0	63,0	4000	2,3	SNMX2209AN
R220.54-0100-22-7A	03157470	Arbor	100,0	7	9,0	48,0	124,0	32,0	77,0	63,0	4000	2,2	SNMX2209AN
R220.54-0125-22-6A	03156812	Arbor	125,0	6	9,0	48,0	149,0	40,0	90,0	63,0	3700	3,2	SNMX2209AN
R220.54-0125-22-8A	03157471	Arbor	125,0	8	9,0	48,0	149,0	40,0	90,0	63,0	3700	3,2	SNMX2209AN
R220.54-8160-22-8A	03156813	Arbor	160,0	8	9,0	48,0	184,0	40,0	90,0	63,0	3300	5,7	SNMX2209AN
R220.54-8160-22-11A	03157472	Arbor	160,0	11	9,0	48,0	184,0	40,0	90,0	63,0	3300	5,7	SNMX2209AN

Spare Parts

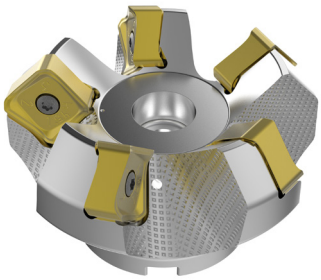
Accessories

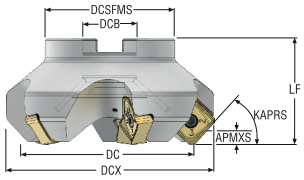
For cutter	Insert screw	Lid	Lid screw	Torque key	Torque value
					
R220.54-0080-0125	C05013-T20P	–	–	T00-20P50	5.0NM
R220.54-8160	C05013-T20P	SC-160-90	MF6S4X10	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Quattro R220.54-22 – Inch



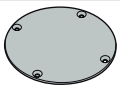


- For insert selection and cutting data recommendations, see page(s) 209-214
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.54-03.00-22-5A	03157473	Arbor	3.150	5	0.354	48.0	4.094	1.000	2.441	2.480	4600	3.750	SNMX2209AN
R220.54-03.00-22-6A	03157477	Arbor	3.150	6	0.354	48.0	4.094	1.000	2.441	2.480	4600	3.530	SNMX2209AN
R220.54-04.00-22-5A	03157474	Arbor	3.937	5	0.354	48.0	4.882	1.500	3.543	2.480	4000	5.730	SNMX2209AN
R220.54-04.00-22-7A	03157479	Arbor	3.937	7	0.354	48.0	4.882	1.500	3.543	2.480	4000	5.510	SNMX2209AN
R220.54-05.00-22-6A	03157475	Arbor	4.921	6	0.354	48.0	5.866	1.500	3.543	2.480	3700	7.500	SNMX2209AN
R220.54-05.00-22-8A	03157480	Arbor	4.921	8	0.354	48.0	5.866	1.500	3.543	2.480	3700	7.500	SNMX2209AN
R220.54-06.00-22-8A	03157476	Arbor	6.299	8	0.354	48.0	7.244	2.000	4.331	2.480	3300	13.010	SNMX2209AN
R220.54-06.00-22-11A	03157481	Arbor	6.299	11	0.354	48.0	7.244	2.000	4.331	2.480	3300	13.010	SNMX2209AN

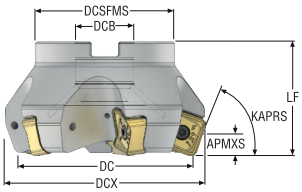
Spare Parts

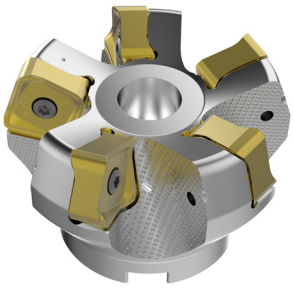
Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.54-03.00	UC6S1/2UNFX1-1/4	C05013-T20P	–	–	T00-20P50	44.3IN.LBS
R220.54-04.00	UC6S3/4UNFX1-1/4	C05013-T20P	–	–	T00-20P50	44.3IN.LBS
R220.54-05.00	UC6S3/4UNFX1-1/4	C05013-T20P	–	–	T00-20P50	44.3IN.LBS
R220.54-06.00	–	C05013-T20P	SC-160-90	MF6S4X10	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Quattro R220.56-22 – Metric



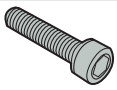
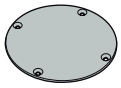


- For insert selection and cutting data recommendations, see page(s) 209-214
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.56-0080-22-5A	03157447	Arbor	80,0	5	13,0	71,0	91,5	27,0	62,0	63,0	4600	1,4	SN.X2209ZN
R220.56-0100-22-5A	03156816	Arbor	100,0	5	13,0	71,0	111,5	32,0	77,0	63,0	4000	2,0	SN.X2209ZN
R220.56-0100-22-7A	03157448	Arbor	100,0	7	13,0	71,0	111,5	32,0	77,0	63,0	4000	1,9	SN.X2209ZN
R220.56-0125-22-6A	03156817	Arbor	125,0	6	13,0	71,0	136,5	40,0	90,0	63,0	3700	2,9	SN.X2209ZN
R220.56-0125-22-8A	03157449	Arbor	125,0	8	13,0	71,0	136,5	40,0	90,0	63,0	3700	2,9	SN.X2209ZN
R220.56-8160-22-8A	03156818	Arbor	160,0	8	13,0	71,0	171,5	40,0	90,0	63,0	3300	5,0	SN.X2209ZN
R220.56-8160-22-10A	03157450	Arbor	160,0	10	13,0	71,0	171,5	40,0	90,0	63,0	3300	4,9	SN.X2209ZN

Spare Parts

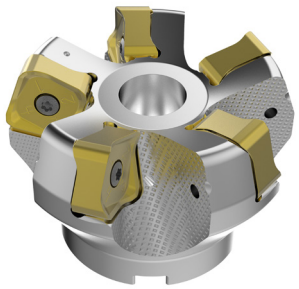
Accessories

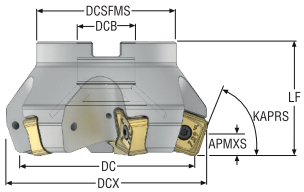
For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.56-0080	MC6S12X35	C05013-T20P	–	–	T00-20P50	5.0NM
R220.56-0100-0125	–	C05013-T20P	–	–	T00-20P50	5.0NM
R220.56-8160	–	C05013-T20P	SC-160-90	MF6S4X10	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Quattro R220.56-22 – Inch



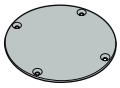


- For insert selection and cutting data recommendations, see page(s) 209-214
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.56-03.00-22-5A	03157454	Arbor	3.150	5	0.512	71.0	3.602	1.000	2.441	2.480	4600	3.090	SN.X2209ZN
R220.56-04.00-22-5A	03157451	Arbor	3.937	5	0.512	71.0	4.390	1.500	3.031	2.480	4000	4.630	SN.X2209ZN
R220.56-04.00-22-7A	03157455	Arbor	3.937	7	0.512	71.0	4.390	1.500	3.031	2.480	4000	4.410	SN.X2209ZN
R220.56-05.00-22-6A	03157452	Arbor	4.921	6	0.512	71.0	5.374	1.500	3.543	2.480	3700	7.050	SN.X2209ZN
R220.56-05.00-22-8A	03157456	Arbor	4.921	8	0.512	71.0	5.374	1.500	3.543	2.480	3700	7.050	SN.X2209ZN
R220.56-06.00-22-8A	03157453	Arbor	6.299	8	0.512	71.0	6.752	2.000	4.331	2.480	3300	10.580	SN.X2209ZN
R220.56-06.00-22-10A	03157457	Arbor	6.299	10	0.512	71.0	6.752	2.000	4.331	2.480	3300	10.360	SN.X2209ZN

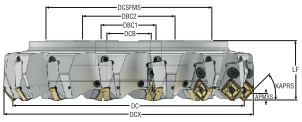
Spare Parts

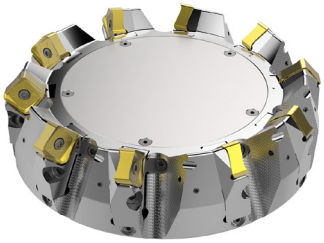
Accessories

For cutter	Arbor screw	Insert screw	Lid	Lid screw	Torque key	Torque value
						
R220.56-03.00	UC6S1/2UNFX1-1/4	C05013-T20P	–	–	T00-20P50	44.3IN.LBS
R220.56-04.00	UC6S3/4UNFX1-1/4	C05013-T20P	–	–	T00-20P50	44.3IN.LBS
R220.56-05.00	UC6S3/4UNFX1-1/4	C05013-T20P	–	–	T00-20P50	44.3IN.LBS
R220.56-06.00	–	C05013-T20P	SC-160-90	MF6S4X10	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Quattro R220.54/56-22CS – Metric



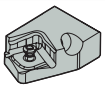
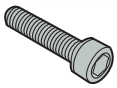
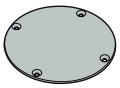


- For insert selection and cutting data recommendations, see page(s) 209-214
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	BD	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm	mm		kg	
R220.54-8200-22-9CS	03167768	Arbor	200,0	9	9,0	48,0	224,0	–	60,0	130,0	80,0	2700	9,9	SN.X2209AN
R220.54-8250-22-11CS	03167769	Arbor	250,0	11	9,0	48,0	274,0	–	60,0	130,0	80,0	2500	17,9	SN.X2209AN
R220.54-8315-22-14CS	03167770	Arbor	315,0	14	9,0	48,0	339,0	–	60,0	130,0	80,0	2200	33,7	SN.X2209AN
R220.56-8200-22-9CS	03167771	Arbor	200,0	9	13,0	71,0	211,5	222,5	60,0	130,0	80,0	2700	9,9	SN.X2209ZN
R220.56-8250-22-11CS	03167772	Arbor	250,0	11	13,0	71,0	261,5	272,5	60,0	130,0	80,0	2500	18,0	SN.X2209ZN
R220.56-8315-22-14CS	03167773	Arbor	315,0	14	13,0	71,0	326,5	337,5	60,0	130,0	80,0	2200	29,2	SN.X2209ZN

Spare Parts

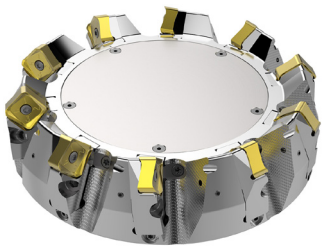
Accessories

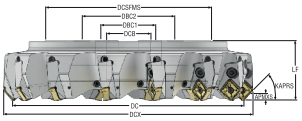
For cutter	Cassette	Cassette screw	Insert screw	Lid	Lid screw	Setting gauge	Wedge clamp	Wedge screw	Torque key	Torque value
										
R220.54-8200	SN22AR	MC6S8X30	C05013-T20P	SC-200-90	MF6S4X10	AU1114T-T15P	CW0810	LD8018-T25P	T00-20P50	5.0NM
R220.54-8250	SN22AR	MC6S8X30	C05013-T20P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	5.0NM
R220.54-8315	SN22AR	MC6S8X30	C05013-T20P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	5.0NM
R220.56-8200	SN22ZR	MC6S8X30	C05013-T20P	SC-200-90	MF6S4X10	AU1114T-T15P	CW0810	LD8018-T25P	T00-20P50	5.0NM
R220.56-8250	SN22ZR	MC6S8X30	C05013-T20P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	5.0NM
R220.56-8315	SN22ZR	MC6S8X30	C05013-T20P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Quattro R220.54/56-22C – Inch



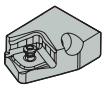
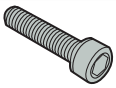
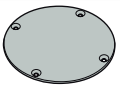


- For insert selection and cutting data recommendations, see page(s) 209-214
- For complete insert programme, see page(s) 767
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	BD	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R220.54-808.00-22-9C	03167774	Arbor	7.874	9	0.354	48,0	8.819	–	2.500	5.118	3.150	2700	23.150	SN.X2209AN
R220.54-810.00-22-11C	03167775	Arbor	9.843	11	0.354	48,0	10.787	–	2.500	5.118	3.150	2500	45.190	SN.X2209AN
R220.54-812.50-22-14C	03167776	Arbor	12.402	14	0.354	48,0	13.346	–	2.500	5.118	3.150	2200	74.300	SN.X2209AN
R220.56-808.00-22-9C	03167777	Arbor	7.874	9	0.512	71,0	8.335	8.760	2.500	5.118	3.150	2700	22.050	SN.X2209ZN
R220.56-810.00-22-11C	03167778	Arbor	9.843	11	0.512	71,0	10.307	10.728	2.500	5.118	3.150	2500	39.460	SN.X2209ZN
R220.56-812.50-22-14C	03167779	Arbor	12.402	14	0.512	71,0	12.866	13.287	2.500	5.118	3.150	2200	64.370	SN.X2209ZN

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Lid	Lid screw	Setting gauge	Wedge clamp	Wedge screw	Torque key	Torque value
										
R220.54-808.00	SN22AR	MC6S8X30	C05013-T20P	SC-200-90	MF6S4X10	AU1114T-T15P	CW0810	LD8018-T25P	T00-20P50	44.3IN.LBS
R220.54-810.00	SN22AR	MC6S8X30	C05013-T20P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	44.3IN.LBS
R220.54-812.50	SN22AR	MC6S8X30	C05013-T20P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	44.3IN.LBS
R220.56-808.00	SN22ZR	MC6S8X30	C05013-T20P	SC-200-90	MF6S4X10	AU1114T-T15P	CW0810	LD8018-T25P	T00-20P50	44.3IN.LBS
R220.56-810.00	SN22ZR	MC6S8X30	C05013-T20P	SC-250-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	44.3IN.LBS
R220.56-812.50	SN22ZR	MC6S8X30	C05013-T20P	SC-315-90	MF6S4X10	AU1114T-T15P	CW0810	LD8020-T25P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.54-22 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SNMX2209ANTR-M12 T350M	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
P2	SNMX2209ANTR-M12 T350M	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
P3	SNMX2209ANTR-M18 MP2501	7,0 *0.28*	0,36 *0.014*	0,38 *0.015*	0,46 *0.018*
P4	SNMX2209ANTR-M18 MP2501	7,0 *0.28*	0,36 *0.014*	0,36 *0.014*	0,46 *0.018*
P5	SNMX2209ANTR-M18 MP2501	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
P6	SNMX2209ANTR-M18 MP2501	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
P7	SNMX2209ANTR-M12 T350M	7,0 *0.28*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
P8	SNMX2209ANTR-M12 T350M	7,0 *0.28*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
P11	SNMX2209ANTR-M12 MP2050	7,0 *0.28*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
P12	SNMX2209ANTR-M12 MP2050	6,0 *0.24*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
M1	SNMX2209ANR-ME12 F40M	7,0 *0.28*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
M2	SNMX2209ANR-ME12 F40M	7,0 *0.28*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
M3	SNMX2209ANR-ME12 MS2050	6,0 *0.24*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
M4	SNMX2209ANTR-M12 MP2050	4,5 *0.18*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
M5	SNMX2209ANTR-M12 MP2050	4,5 *0.18*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
K1	SNMX2209ANTR-M18 MK1500	7,0 *0.28*	0,38 *0.015*	0,40 *0.016*	0,50 *0.020*
K2	SNMX2209ANTR-M18 MK1500	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K3	SNMX2209ANTR-M18 MP1501	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K4	SNMX2209ANTR-M18 MP1501	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K5	SNMX2209ANTR-M18 MP1501	7,0 *0.28*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
K6	SNMX2209ANTR-M18 MK2050	7,0 *0.28*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K7	SNMX2209ANTR-M18 MK2050	7,0 *0.28*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
S1	SNMX2209ANTR-M12 MS2500	4,5 *0.18*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
S2	SNMX2209ANTR-M12 MS2500	4,5 *0.18*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
S3	SNMX2209ANTR-M12 MS2500	4,5 *0.18*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
S11	SNMX2209ANR-ME12 MS2050	5,0 *0.20*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
S12	SNMX2209ANR-ME12 MS2050	5,0 *0.20*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
S13	SNMX2209ANR-ME12 MS2050	4,5 *0.18*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
H5	SNMX2209ANTR-M18 MP1501	6,0 *0.24*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
H8	SNMX2209ANTR-M18 MP1501	5,0 *0.20*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*
H11	SNMX2209ANTR-M18 MP1501	6,0 *0.24*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
H12	SNMX2209ANTR-M18 MP1501	5,0 *0.20*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*
H21	SNMX2209ANTR-M18 MP1501	5,0 *0.20*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.54-22 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			T350M			MP2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	195 *640*	225 *740*	255 *840*	290 *950*	335 *1100*	385 *1275*	255 *840*	295 *970*	340 *1125*	225 *740*	260 *850*	295 *970*	255 *840*	290 *950*	330 *1075*
P2	190 *620*	220 *720*	250 *820*	280 *920*	325 *1075*	370 *1225*	250 *820*	290 *950*	325 *1075*	220 *720*	250 *820*	285 *940*	245 *800*	285 *940*	325 *1075*
P3	165 *540*	190 *620*	220 *720*	245 *800*	285 *940*	325 *1075*	220 *720*	250 *820*	290 *950*	190 *620*	220 *720*	250 *820*	215 *710*	250 *820*	285 *940*
P4	145 *475*	170 *560*	190 *620*	220 *720*	255 *840*	285 *940*	195 *640*	225 *740*	255 *840*	170 *560*	195 *640*	220 *720*	190 *620*	220 *720*	250 *820*
P5	140 *460*	165 *540*	185 *610*	210 *690*	245 *800*	280 *920*	190 *620*	215 *710*	245 *800*	165 *540*	190 *620*	215 *710*	180 *590*	215 *710*	240 *790*
P6	160 *520*	185 *610*	210 *690*	240 *790*	275 *900*	315 *1025*	210 *690*	245 *800*	275 *900*	185 *610*	210 *690*	240 *790*	205 *670*	240 *790*	270 *890*
P7	150 *490*	175 *570*	195 *640*	225 *740*	260 *850*	295 *970*	200 *660*	230 *750*	260 *850*	175 *570*	200 *660*	230 *750*	195 *640*	225 *740*	255 *840*
P8	140 *460*	160 *520*	185 *610*	210 *690*	240 *790*	275 *900*	185 *610*	210 *690*	245 *800*	160 *520*	185 *610*	210 *690*	180 *590*	210 *690*	240 *790*
P11	145 *475*	170 *560*	190 *620*	220 *720*	250 *820*	285 *940*	195 *640*	225 *740*	255 *840*	170 *560*	195 *640*	220 *720*	185 *610*	220 *720*	250 *820*
P12	95 *310*	110 *360*	125 *410*	145 *475*	165 *540*	190 *620*	130 *425*	145 *475*	170 *560*	110 *360*	130 *425*	145 *475*	125 *410*	145 *475*	165 *540*
M1	155 *510*	175 *570*	200 *660*	— —	— —	— —	180 *590*	210 *690*	235 *770*	170 *560*	195 *640*	220 *720*	175 *570*	205 *670*	230 *750*
M2	125 *410*	150 *490*	170 *560*	— —	— —	— —	150 *490*	175 *570*	200 *660*	140 *460*	160 *520*	185 *610*	145 *475*	170 *560*	195 *640*
M3	105 *345*	120 *395*	135 *445*	— —	— —	— —	125 *410*	145 *475*	160 *520*	115 *375*	135 *445*	150 *490*	120 *395*	140 *460*	155 *510*
M4	80 *260*	95 *310*	105 *345*	— —	— —	— —	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	115 *375*	95 *310*	110 *360*	120 *395*
M5	65 *215*	80 *260*	90 *295*	— —	— —	— —	80 *260*	90 *295*	105 *345*	75 *245*	85 *280*	95 *310*	75 *245*	90 *295*	100 *330*
K1	150 *490*	175 *570*	200 *660*	225 *740*	260 *850*	290 *950*	200 *660*	230 *750*	260 *850*	170 *560*	200 *660*	225 *740*	195 *640*	225 *740*	255 *840*
K2	135 *445*	155 *510*	175 *570*	200 *660*	230 *750*	265 *870*	180 *590*	205 *670*	235 *770*	155 *510*	180 *590*	205 *670*	175 *570*	200 *660*	230 *750*
K3	115 *375*	130 *425*	150 *490*	170 *560*	195 *640*	225 *740*	150 *490*	175 *570*	200 *660*	130 *425*	150 *490*	175 *570*	145 *475*	170 *560*	195 *640*
K4	110 *360*	125 *410*	145 *475*	165 *540*	185 *610*	215 *710*	145 *475*	165 *540*	190 *620*	125 *410*	145 *475*	165 *540*	140 *460*	165 *540*	185 *610*
K5	65 *215*	75 *245*	90 *295*	100 *330*	115 *375*	130 *425*	90 *295*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	85 *280*	100 *330*	115 *375*
K6	95 *310*	110 *360*	125 *410*	145 *475*	165 *540*	190 *620*	125 *410*	145 *475*	165 *540*	110 *360*	125 *410*	145 *475*	125 *410*	145 *475*	165 *540*
K7	85 *280*	100 *330*	115 *375*	125 *410*	150 *490*	170 *560*	110 *360*	130 *425*	150 *490*	100 *330*	115 *375*	130 *425*	110 *360*	125 *410*	145 *475*
S1	38 *125*	44 *145*	49 *160*	— —	— —	— —	47 *155*	55 *180*	60 *195*	42 *140*	48 *155*	55 *180*	45 *150*	55 *180*	60 *195*
S2	30 *100*	35 *115*	40 *130*	— —	— —	— —	38 *125*	43 *140*	48 *155*	34 *110*	39 *130*	43 *140*	37 *120*	43 *140*	48 *155*
S3	27 *90*	30 *100*	35 *115*	— —	— —	— —	33 *110*	38 *125*	43 *140*	30 *100*	34 *110*	39 *130*	32 *105*	37 *120*	42 *140*
S11	50 *165*	60 *195*	70 *230*	— —	— —	— —	65 *215*	75 *245*	85 *280*	55 *180*	65 *215*	75 *245*	65 *215*	75 *245*	85 *280*
S12	36 *120*	42 *140*	47 *155*	— —	— —	— —	44 *145*	50 *165*	60 *195*	40 *130*	46 *150*	50 *165*	44 *145*	50 *165*	55 *180*
S13	21 *70*	25 *80*	28 *90*	— —	— —	— —	26 *85*	30 *100*	34 *110*	23 *75*	27 *90*	30 *100*	26 *85*	30 *100*	33 *110*
H5	32 *105*	37 *120*	42 *140*	48 *155*	55 *180*	65 *215*	39 *130*	44 *145*	50 *165*	37 *120*	43 *140*	49 *160*	37 *120*	43 *140*	49 *160*
H8	35 *115*	40 *130*	46 *150*	50 *165*	60 *195*	65 *215*	42 *140*	48 *155*	55 *180*	40 *130*	46 *150*	50 *165*	41 *135*	47 *155*	55 *180*
H11	41 *135*	47 *155*	55 *180*	60 *195*	70 *230*	80 *260*	49 *160*	55 *180*	65 *215*	47 *155*	55 *180*	60 *195*	48 *155*	55 *180*	60 *195*
H12	65 *215*	70 *230*	80 *260*	95 *310*	105 *345*	120 *395*	85 *280*	95 *310*	105 *345*	70 *230*	80 *260*	95 *310*	80 *260*	90 *295*	105 *345*
H21	35 *115*	40 *130*	46 *150*	50 *165*	60 *195*	65 *215*	42 *140*	48 *155*	55 *180*	40 *130*	46 *150*	50 *165*	41 *135*	47 *155*	55 *180*

R220.54-22 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			MS2050			MS2500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	255	290	335	215	245	280	280	325	370
	—	—	—	*840*	*950*	*1100*	*710*	*800*	*920*	*920*	*1075*	*1225*
P2	—	—	—	245	285	320	210	240	275	275	315	355
	—	—	—	*800*	*940*	*1050*	*690*	*790*	*900*	*900*	*1025*	*1175*
P3	—	—	—	215	250	285	185	210	240	240	275	315
	—	—	—	*710*	*820*	*940*	*610*	*690*	*790*	*790*	*900*	*1025*
P4	—	—	—	190	225	250	160	185	210	210	245	280
	—	—	—	*620*	*740*	*820*	*520*	*610*	*690*	*690*	*800*	*920*
P5	—	—	—	185	215	245	155	180	205	205	235	270
	—	—	—	*610*	*710*	*800*	*510*	*590*	*670*	*670*	*770*	*890*
P6	—	—	—	210	240	275	175	205	230	230	265	300
	—	—	—	*690*	*790*	*900*	*570*	*670*	*750*	*750*	*870*	*980*
P7	—	—	—	195	225	260	165	190	215	215	250	285
	—	—	—	*640*	*740*	*850*	*540*	*620*	*710*	*710*	*820*	*940*
P8	—	—	—	180	210	240	155	175	200	200	230	265
	—	—	—	*590*	*690*	*790*	*510*	*570*	*660*	*660*	*750*	*870*
P11	—	—	—	190	220	250	160	185	210	210	245	275
	—	—	—	*620*	*720*	*820*	*520*	*610*	*690*	*690*	*800*	*900*
P12	—	—	—	125	145	165	105	125	140	140	160	185
	—	—	—	*410*	*475*	*540*	*345*	*410*	*460*	*460*	*520*	*610*
M1	—	—	—	—	—	—	170	195	220	195	225	255
	—	—	—	—	—	—	*560*	*640*	*720*	*640*	*740*	*840*
M2	—	—	—	—	—	—	140	165	185	165	190	215
	—	—	—	—	—	—	*460*	*540*	*610*	*540*	*620*	*710*
M3	—	—	—	—	—	—	115	130	150	135	155	175
	—	—	—	—	—	—	*375*	*425*	*490*	*445*	*510*	*570*
M4	—	—	—	—	—	—	90	105	115	105	120	135
	—	—	—	—	—	—	*295*	*345*	*375*	*345*	*395*	*445*
M5	—	—	—	—	—	—	75	85	95	85	100	110
	—	—	—	—	—	—	*245*	*280*	*310*	*280*	*330*	*360*
K1	280	325	365	265	305	345	—	—	—	—	—	—
	920	*1075*	*1200*	*870*	*1000*	*1125*	—	—	—	—	—	—
K2	255	290	330	240	275	315	—	—	—	—	—	—
	840	*950*	*1075*	*790*	*900*	*1025*	—	—	—	—	—	—
K3	215	245	280	205	235	265	—	—	—	—	—	—
	710	*800*	*920*	*670*	*770*	*870*	—	—	—	—	—	—
K4	205	235	270	195	220	255	—	—	—	—	—	—
	670	*770*	*890*	*640*	*720*	*840*	—	—	—	—	—	—
K5	125	145	165	120	140	155	—	—	—	—	—	—
	410	*475*	*540*	*395*	*460*	*510*	—	—	—	—	—	—
K6	180	205	235	170	195	225	—	—	—	—	—	—
	590	*670*	*770*	*560*	*640*	*740*	—	—	—	—	—	—
K7	160	185	210	150	175	200	—	—	—	—	—	—
	520	*610*	*690*	*490*	*570*	*660*	—	—	—	—	—	—
S1	—	—	—	—	—	—	41	48	55	50	60	65
	—	—	—	—	—	—	*135*	*155*	*180*	*165*	*195*	*215*
S2	—	—	—	—	—	—	33	39	44	41	47	55
	—	—	—	—	—	—	*110*	*130*	*145*	*135*	*155*	*180*
S3	—	—	—	—	—	—	30	33	38	36	41	47
	—	—	—	—	—	—	*100*	*110*	*125*	*120*	*135*	*155*
S11	—	—	—	—	—	—	60	65	75	70	80	90
	—	—	—	—	—	—	*195*	*215*	*245*	*230*	*260*	*295*
S12	—	—	—	—	—	—	40	46	50	48	55	65
	—	—	—	—	—	—	*130*	*150*	*165*	*155*	*180*	*215*
S13	—	—	—	—	—	—	23	27	30	29	33	37
	—	—	—	—	—	—	*75*	*90*	*100*	*95*	*110*	*120*
H5	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—

R220.56-22 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SNMX2209ZNTR-M12 MP2501	10,0 *0.40*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P2	SNMX2209ZNTR-M12 MP2501	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P3	SNMX2209ZNTR-M18 MP2501	10,0 *0.40*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P4	SNMX2209ZNTR-M18 MP2501	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
P5	SNMX2209ZNTR-M18 MP2501	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P6	SNMX2209ZNTR-M18 MP2501	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P7	SNMX2209ZNTR-M18 T350M	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P8	SNMX2209ZNTR-M18 T350M	10,0 *0.40*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P11	SNMX2209ZNTR-M12 MP2050	10,0 *0.40*	0,25 *0.010*	0,25 *0.010*	0,32 *0.013*
P12	SNMX2209ZNTR-M12 MP2050	8,0 *0.32*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M1	SNMX2209ZNR-ME12 F40M	10,0 *0.40*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
M2	SNMX2209ZNR-ME12 F40M	10,0 *0.40*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
M3	SNMX2209ZNR-ME12 MS2050	8,0 *0.32*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
M4	SNMX2209ZNTR-M12 MP2050	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
M5	SNMX2209ZNTR-M12 MP2050	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
K1	SNMX2209ZNTR-M18 MK1500	10,0 *0.40*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K2	SNMX2209ZNTR-M18 MK1500	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
K3	SNMX2209ZNTR-M18 MP1501	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
K4	SNMX2209ZNTR-M18 MP1501	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
K5	SNMX2209ZNTR-M18 MP1501	10,0 *0.40*	0,25 *0.010*	0,25 *0.010*	0,32 *0.013*
K6	SNMX2209ZNTR-M18 MK2050	10,0 *0.40*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
K7	SNMX2209ZNTR-M18 MK2050	10,0 *0.40*	0,25 *0.010*	0,25 *0.010*	0,32 *0.013*
S1	SNMX2209ZNTR-M12 MS2050	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
S2	SNMX2209ZNTR-M12 MS2050	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
S3	SNMX2209ZNTR-M12 MS2050	6,0 *0.24*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
S11	SNMX2209ZNR-ME12 MS2050	7,0 *0.28*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
S12	SNMX2209ZNR-ME12 MS2050	7,0 *0.28*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
S13	SNMX2209ZNR-ME12 MS2050	6,0 *0.24*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
H5	SNMX2209ZNTR-M18 MP1501	8,0 *0.32*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
H8	SNMX2209ZNTR-M18 MP1501	7,0 *0.28*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
H11	SNMX2209ZNTR-M18 MP1501	8,0 *0.32*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
H12	SNMX2209ZNTR-M18 MP1501	7,0 *0.28*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
H21	SNMX2209ZNTR-M18 MP1501	7,0 *0.28*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.56-22 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			T350M			MP2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	195 *640*	220 *720*	255 *840*	285 *940*	335 *1100*	375 *1225*	250 *820*	295 *970*	335 *1100*	220 *720*	255 *840*	290 *950*	250 *820*	285 *940*	330 *1075*
P2	185 *610*	215 *710*	245 *800*	275 *900*	315 *1025*	365 *1200*	245 *800*	280 *920*	325 *1075*	215 *710*	245 *800*	285 *940*	240 *790*	280 *920*	320 *1050*
P3	160 *520*	190 *620*	215 *710*	245 *800*	280 *920*	320 *1050*	215 *710*	245 *800*	285 *940*	190 *620*	215 *710*	250 *820*	210 *690*	245 *800*	280 *920*
P4	145 *475*	165 *540*	190 *620*	215 *710*	250 *820*	285 *940*	190 *620*	225 *740*	250 *820*	165 *540*	195 *640*	220 *720*	190 *620*	215 *710*	245 *800*
P5	140 *460*	160 *520*	180 *590*	205 *670*	240 *790*	275 *900*	180 *590*	215 *710*	245 *800*	160 *520*	185 *610*	210 *690*	180 *590*	210 *690*	235 *770*
P6	155 *510*	180 *590*	205 *670*	230 *750*	270 *890*	310 *1025*	205 *670*	240 *790*	275 *900*	180 *590*	210 *690*	240 *790*	200 *660*	235 *770*	265 *870*
P7	145 *475*	170 *560*	195 *640*	215 *710*	255 *840*	290 *950*	190 *620*	225 *740*	260 *850*	170 *560*	195 *640*	225 *740*	190 *620*	220 *720*	250 *820*
P8	135 *445*	160 *520*	180 *590*	205 *670*	235 *770*	270 *890*	180 *590*	210 *690*	240 *790*	160 *520*	180 *590*	210 *690*	175 *570*	205 *670*	235 *770*
P11	140 *460*	165 *540*	185 *610*	210 *690*	245 *800*	285 *940*	185 *610*	220 *720*	250 *820*	165 *540*	190 *620*	220 *720*	185 *610*	215 *710*	245 *800*
P12	95 *310*	110 *360*	125 *410*	140 *460*	165 *540*	185 *610*	125 *410*	145 *475*	165 *540*	110 *360*	125 *410*	145 *475*	125 *410*	145 *475*	160 *520*
M1	150 *490*	175 *570*	200 *660*	— —	— —	— —	175 *570*	205 *670*	235 *770*	165 *540*	190 *620*	220 *720*	170 *560*	200 *660*	230 *750*
M2	125 *410*	145 *475*	165 *540*	— —	— —	— —	145 *475*	170 *560*	195 *640*	135 *445*	160 *520*	185 *610*	145 *475*	170 *560*	190 *620*
M3	100 *330*	120 *395*	135 *445*	— —	— —	— —	120 *395*	140 *460*	160 *520*	110 *360*	130 *425*	150 *490*	115 *375*	135 *445*	155 *510*
M4	80 *260*	90 *295*	105 *345*	— —	— —	— —	95 *310*	110 *360*	125 *410*	90 *295*	100 *330*	115 *375*	90 *295*	105 *345*	120 *395*
M5	65 *215*	75 *245*	85 *280*	— —	— —	— —	80 *260*	90 *295*	105 *345*	75 *245*	85 *280*	95 *310*	75 *245*	90 *295*	100 *330*
K1	145 *475*	170 *560*	195 *640*	220 *720*	250 *820*	290 *950*	195 *640*	225 *740*	255 *840*	170 *560*	195 *640*	225 *740*	190 *620*	220 *720*	255 *840*
K2	130 *425*	155 *510*	175 *570*	195 *640*	230 *750*	260 *850*	170 *560*	200 *660*	230 *750*	150 *490*	175 *570*	200 *660*	170 *560*	200 *660*	225 *740*
K3	110 *360*	130 *425*	145 *475*	165 *540*	195 *640*	220 *720*	145 *475*	170 *560*	195 *640*	125 *410*	150 *490*	170 *560*	145 *475*	170 *560*	190 *620*
K4	105 *345*	125 *410*	140 *460*	155 *510*	185 *610*	210 *690*	140 *460*	165 *540*	185 *610*	120 *395*	140 *460*	165 *540*	135 *445*	160 *520*	180 *590*
K5	65 *215*	75 *245*	85 *280*	95 *310*	115 *375*	130 *425*	85 *280*	100 *330*	115 *375*	75 *245*	90 *295*	100 *330*	85 *280*	100 *330*	110 *360*
K6	95 *310*	110 *360*	125 *410*	140 *460*	160 *520*	185 *610*	125 *410*	145 *475*	165 *540*	105 *345*	125 *410*	145 *475*	120 *395*	140 *460*	160 *520*
K7	85 *280*	100 *330*	110 *360*	125 *410*	145 *475*	165 *540*	110 *360*	130 *425*	145 *475*	95 *310*	115 *375*	125 *410*	110 *360*	130 *425*	145 *475*
S1	37 *120*	43 *140*	49 *160*	— —	— —	— —	46 *150*	55 *180*	60 *195*	41 *135*	47 *155*	55 *180*	45 *150*	50 *165*	60 *195*
S2	30 *100*	34 *110*	39 *130*	— —	— —	— —	37 *120*	42 *140*	49 *160*	33 *110*	38 *125*	43 *140*	36 *120*	42 *140*	47 *155*
S3	26 *85*	31 *100*	35 *115*	— —	— —	— —	32 *105*	38 *125*	43 *140*	29 *95*	34 *110*	38 *125*	32 *105*	37 *120*	42 *140*
S11	50 *165*	60 *195*	70 *230*	— —	— —	— —	65 *215*	75 *245*	85 *280*	55 *180*	65 *215*	75 *245*	60 *195*	70 *230*	80 *260*
S12	36 *120*	41 *135*	47 *155*	— —	— —	— —	44 *145*	50 *165*	60 *195*	39 *130*	46 *150*	50 *165*	43 *140*	50 *165*	55 *180*
S13	21 *70*	24 *80*	27 *90*	— —	— —	— —	26 *85*	30 *100*	34 *110*	23 *75*	27 *90*	30 *100*	25 *80*	29 *95*	33 *110*
H5	32 *105*	37 *120*	41 *135*	47 *155*	55 *180*	60 *195*	38 *125*	44 *145*	50 *165*	36 *120*	42 *140*	48 *155*	37 *120*	43 *140*	48 *155*
H8	34 *110*	40 *130*	45 *150*	50 *165*	60 *195*	65 *215*	42 *140*	47 *155*	55 *180*	40 *130*	45 *150*	50 *165*	40 *130*	46 *150*	50 *165*
H11	40 *130*	47 *155*	50 *165*	60 *195*	70 *230*	80 *260*	48 *155*	55 *180*	65 *215*	46 *150*	55 *180*	60 *195*	47 *155*	55 *180*	60 *195*
H12	60 *195*	70 *230*	80 *260*	95 *310*	105 *345*	120 *395*	80 *260*	95 *310*	105 *345*	70 *230*	80 *260*	95 *310*	80 *260*	90 *295*	105 *345*
H21	34 *110*	40 *130*	45 *150*	50 *165*	60 *195*	65 *215*	42 *140*	47 *155*	55 *180*	40 *130*	45 *150*	50 *165*	40 *130*	46 *150*	50 *165*

R220.56-22 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			MS2050			MS2500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	250	290	330	215	245	280	275	320	365
	—	—	—	*820*	*950*	*1075*	*710*	*800*	*920*	*900*	*1050*	*1200*
P2	—	—	—	240	275	320	200	235	270	265	305	355
	—	—	—	*790*	*900*	*1050*	*660*	*770*	*890*	*870*	*1000*	*1175*
P3	—	—	—	215	245	280	180	210	240	235	270	310
	—	—	—	*710*	*800*	*920*	*590*	*690*	*790*	*770*	*890*	*1025*
P4	—	—	—	185	220	245	160	185	210	205	245	275
	—	—	—	*610*	*720*	*800*	*520*	*610*	*690*	*670*	*800*	*900*
P5	—	—	—	180	210	240	150	180	200	200	230	265
	—	—	—	*590*	*690*	*790*	*490*	*590*	*660*	*660*	*750*	*870*
P6	—	—	—	200	235	270	170	200	225	220	260	300
	—	—	—	*660*	*770*	*890*	*560*	*660*	*740*	*720*	*850*	*980*
P7	—	—	—	190	220	255	160	190	210	210	245	280
	—	—	—	*620*	*720*	*840*	*520*	*620*	*690*	*690*	*800*	*920*
P8	—	—	—	180	205	235	150	175	200	200	225	260
	—	—	—	*590*	*670*	*770*	*490*	*570*	*660*	*660*	*740*	*850*
P11	—	—	—	185	215	245	155	185	205	205	240	275
	—	—	—	*610*	*710*	*800*	*510*	*610*	*670*	*670*	*790*	*900*
P12	—	—	—	125	145	160	105	120	135	135	160	180
	—	—	—	*410*	*475*	*520*	*345*	*395*	*445*	*445*	*520*	*590*
M1	—	—	—	—	—	—	165	190	220	190	220	255
	—	—	—	—	—	—	*540*	*620*	*720*	*620*	*720*	*840*
M2	—	—	—	—	—	—	135	160	180	160	185	215
	—	—	—	—	—	—	*445*	*520*	*590*	*520*	*610*	*710*
M3	—	—	—	—	—	—	110	130	150	130	155	170
	—	—	—	—	—	—	*360*	*425*	*490*	*425*	*510*	*560*
M4	—	—	—	—	—	—	90	100	115	100	115	135
	—	—	—	—	—	—	*295*	*330*	*375*	*330*	*375*	*445*
M5	—	—	—	—	—	—	75	85	95	85	100	110
	—	—	—	—	—	—	*245*	*280*	*310*	*280*	*330*	*360*
K1	275	315	365	260	300	345	—	—	—	—	—	—
	900	*1025*	*1200*	*850*	*980*	*1125*	—	—	—	—	—	—
K2	245	285	330	230	270	310	—	—	—	—	—	—
	800	*940*	*1075*	*750*	*890*	*1025*	—	—	—	—	—	—
K3	205	240	275	195	230	260	—	—	—	—	—	—
	670	*790*	*900*	*640*	*750*	*850*	—	—	—	—	—	—
K4	195	230	265	185	220	250	—	—	—	—	—	—
	640	*750*	*870*	*610*	*720*	*820*	—	—	—	—	—	—
K5	120	145	160	115	135	150	—	—	—	—	—	—
	395	*475*	*520*	*375*	*445*	*490*	—	—	—	—	—	—
K6	175	205	235	165	195	220	—	—	—	—	—	—
	570	*670*	*770*	*540*	*640*	*720*	—	—	—	—	—	—
K7	155	185	205	150	175	195	—	—	—	—	—	—
	510	*610*	*670*	*490*	*570*	*640*	—	—	—	—	—	—
S1	—	—	—	—	—	—	41	47	55	50	55	65
	—	—	—	—	—	—	*135*	*155*	*180*	*165*	*180*	*215*
S2	—	—	—	—	—	—	33	38	43	40	46	55
	—	—	—	—	—	—	*110*	*125*	*140*	*130*	*150*	*180*
S3	—	—	—	—	—	—	29	34	38	35	41	47
	—	—	—	—	—	—	*95*	*110*	*125*	*115*	*135*	*155*
S11	—	—	—	—	—	—	55	65	75	70	80	90
	—	—	—	—	—	—	*180*	*215*	*245*	*230*	*260*	*295*
S12	—	—	—	—	—	—	39	46	50	48	55	65
	—	—	—	—	—	—	*130*	*150*	*165*	*155*	*180*	*215*
S13	—	—	—	—	—	—	23	26	30	28	32	37
	—	—	—	—	—	—	*75*	*85*	*100*	*90*	*105*	*120*
H5	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—

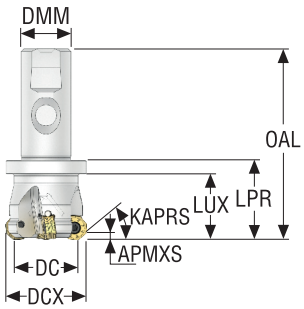
DOUBLE OCTOMILL 05/09

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

- Insert size 05, cutter range 25-200mm (1-8 inch)
- Insert size 09, cutter range 63-500mm (2.5-20 inch)
- Double-sided inserts with 16 cutting edges

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Octomill™ R217.48-05 – Metric



- For insert selection and cutting data recommendations, see page(s) 222 - 224
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DMM	OAL	LS	Weight	RPMX	Insert
			mm		mm		mm	mm	mm	mm	kg		
R217.48-2025.3S-05-3SA	02810001	Seco-Weldon	25,0	3	3,0	40,0	33,0	20,0	90,0	50,0	0,3	20400	ON.U0504
R217.48-2532.3S-05-4SA	02810002	Seco-Weldon	32,0	4	3,0	40,0	40,0	25,0	90,0	50,0	0,5	18000	ON.U0504

Spare Parts

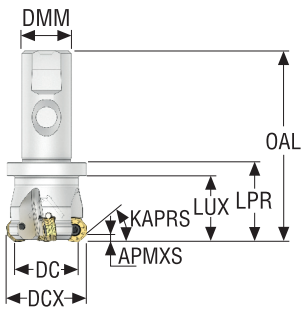
For cutter	Insert screw
R217.48-..	C04009-T15P

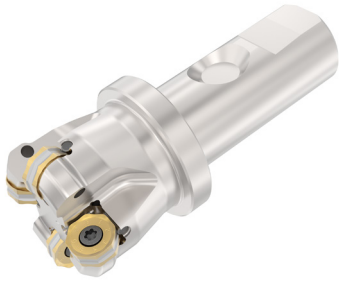
Accessories

Torque key	Torque value
T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Octomill™ R217.48-05 – Inch





- For insert selection and cutting data recommendations, see page(s) 222 - 224
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DMM	OAL	LS	Weight	RPMX	Insert
			Inch		Inch		Inch	Inch	Inch	Inch	lbs		
R217.48-01.25.3S-05-4SA	02810007	Seco-Weldon	1.250	4	0.118	40.0	1.575	0.750	3.543	1.969	1.100	20400	ON.U0504

Spare Parts

For cutter	Insert screw
R217.48-..	C04009-T15P

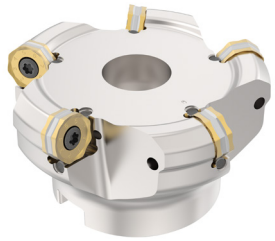
Accessories

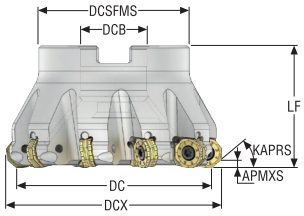
Torque key	Torque value
T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Octomill™ R220.48-05 – Metric



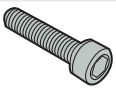


- For insert selection and cutting data recommendations, see page(s) 222 - 224
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.48-0040-05-04SA	02810082	Arbor	40,0	4	3,0	40,0	48,35	16,0	35,0	40,0	16100	0,3	ON.U0504
R220.48-0040-05-05SA	02810083	Arbor	40,0	5	3,0	40,0	48,35	16,0	35,0	40,0	16100	0,3	ON.U0504
R220.48-0050-05-04SA	02810003	Arbor	50,0	4	3,0	40,0	58,35	22,0	47,0	40,0	14400	0,4	ON.U0504
R220.48-0050-05-05SA	02810084	Arbor	50,0	5	3,0	40,0	58,35	22,0	47,0	40,0	14400	0,4	ON.U0504
R220.48-0050-05-06SA	02810085	Arbor	50,0	6	3,0	40,0	58,35	22,0	47,0	40,0	14400	0,4	ON.U0504
R220.48-0063-05-05SA	02810004	Arbor	63,0	5	3,0	40,0	71,35	22,0	47,0	40,0	12800	0,6	ON.U0504
R220.48-0063-05-06SA	02810086	Arbor	63,0	6	3,0	40,0	71,35	22,0	47,0	40,0	12800	0,6	ON.U0504
R220.48-0063-05-08SA	02810087	Arbor	63,0	8	3,0	40,0	71,35	22,0	47,0	40,0	12800	0,6	ON.U0504
R220.48-0080-05-06SA	02810005	Arbor	80,0	6	3,0	40,0	88,35	27,0	62,0	50,0	11400	1,2	ON.U0504
R220.48-0080-05-10SA	02810088	Arbor	80,0	10	3,0	40,0	88,35	27,0	62,0	50,0	11400	1,1	ON.U0504
R220.48-0100-05-07SA	02810089	Arbor	100,0	7	3,0	40,0	108,35	32,0	77,0	50,0	10200	1,8	ON.U0504
R220.48-0100-05-12SA	02810090	Arbor	100,0	12	3,0	40,0	108,35	32,0	77,0	50,0	10200	1,8	ON.U0504
R220.48-0125-05-08SA	02810091	Arbor	125,0	8	3,0	40,0	133,35	40,0	90,0	63,0	9100	3,4	ON.U0504
R220.48-0125-05-14SA	02810092	Arbor	125,0	14	3,0	40,0	133,35	40,0	90,0	63,0	9100	3,3	ON.U0504

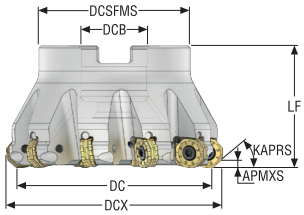
Spare Parts

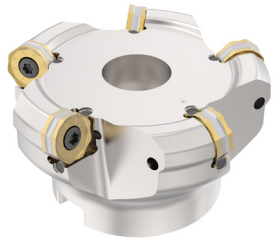
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.48-0040	TCEI0825	C04009-T15P	T00-15P35	3.5NM
R220.48-0050-0063	220.17-692	C04009-T15P	T00-15P35	3.5NM
R220.48-0080-0125	–	C04009-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Octomill™ R220.48-05 – Inch





- For insert selection and cutting data recommendations, see page(s) 222 - 224
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.48-01.50-05-04SA	02810093	Arbor	1.575	4	0.118	40.0	1.904	0.500	1.378	1.575	16100	0.660	ON.U0504
R220.48-02.00-05-04SA	02810095	Arbor	1.969	4	0.118	40.0	2.297	0.750	1.850	1.575	14400	1.100	ON.U0504
R220.48-02.00-05-05SA	02810096	Arbor	1.969	5	0.118	40.0	2.297	0.750	1.850	1.575	14400	0.880	ON.U0504
R220.48-02.50-05-05SA	02810098	Arbor	2.480	5	0.118	40.0	2.809	0.750	1.850	1.575	12800	1.320	ON.U0504
R220.48-03.00-05-06SA	02810101	Arbor	3.150	6	0.118	40.0	3.478	1.000	2.441	1.969	11400	2.870	ON.U0504
R220.48-03.00-05-10SA	02810102	Arbor	3.150	10	0.118	40.0	3.478	1.000	2.441	1.969	11400	2.650	ON.U0504
R220.48-04.00-05-07SA	02810103	Arbor	3.937	7	0.118	40.0	4.266	1.500	3.031	1.969	10200	3.970	ON.U0504

Spare Parts

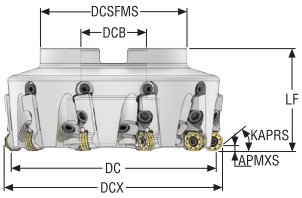
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.48-01.50	UC6S1/4UNFX1	C04009-T15P	T00-15P35	31.0IN.LBS
R220.48-02.00 / 02.50	UC6S3/8UNFX1	C04009-T15P	T00-15P35	31.0IN.LBS
R220.48-03.00	UC6S1/2UNFX1-1/4	C04009-T15P	T00-15P35	31.0IN.LBS
R220.48-04.00	UF6S3/4UNFX1-3/4	C04009-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Octomill™ R220.48-05CS – Metric



- For insert selection and cutting data recommendations, see page(s) 222 - 224
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.48-0100-05-8CS	03000629	Arbor	100,0	8	3,0	40,0	108,0	32,0	77,0	63,0	10200	3,0	ON.U0504
R220.48-0125-05-10CS	03000630	Arbor	125,0	10	3,0	40,0	133,0	40,0	90,0	63,0	9100	4,0	ON.U0504
R220.48-8160-05-14CS	03000631	Arbor	160,0	14	3,0	40,0	168,0	40,0	140,0	63,0	8000	6,5	ON.U0504
R220.48-8200-05-18CS	03000632	Arbor	200,0	18	3,0	40,0	208,0	60,0	160,0	63,0	7200	9,0	ON.U0504

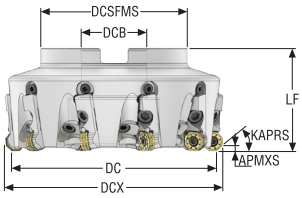
Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Wedge clamp	Wedge clamp axial adj.	Wedge screw	Torque key	Torque value
R220.48-..	ON05AR	FS96018	C04009-T15P	CW0810	AU1114T-T15P	LD8020-T25P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Octomill™ R220.48-05CS – Inch



- For insert selection and cutting data recommendations, see page(s) 222 - 224
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.48-04.00-05-8CS	03000634	Arbor	3.937	8	0.118	40.0	4.252	1.500	3.031	2.480	10200	6.610	ON.U0504
R220.48-06.00-05-14CS	03000636	Arbor	6.299	14	0.118	40.0	6.614	2.000	5.906	2.480	8000	13.230	ON.U0504
R220.48-808.00-05-18CS	03000637	Arbor	7.874	18	0.118	40.0	8.189	2.500	6.299	2.480	7200	18.960	ON.U0504

Spare Parts

Accessories

For cutter	Arbor screw	Cassette	Cassette screw	Insert screw	Wedge clamp	Wedge clamp axial adj.	Wedge screw	Torque key	Torque value
R220.48-04.00	UC6S3/4UNFX1-1/4	ON05AR	FS96018	C04009-T15P	CW0810	AU1114T-T15P	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.48-06.00	–	ON05AR	FS96018	C04009-T15P	CW0810	AU1114T-T15P	LD8020-T25P	T00-15P35	31.0IN.LBS
R220.48-808.00	–	ON05AR	FS96018	C04009-T15P	CW0810	AU1114T-T15P	LD8020-T25P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.48-05 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	ONMU050410ANTN-M10 T350M	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
P2	ONMU050410ANTN-M10 T350M	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
P3	ONMU050410ANTN-M10 MP2501	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,26 *0.010*
P4	ONMU050410ANTN-M10 MP2501	1,8 *0.070*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
P5	ONMU050410ANTN-M10 MP2501	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*
P6	ONMU050410ANTN-M10 MP2501	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
P7	ONMU050410ANTN-M10 MP2501	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
P8	ONMU050410ANTN-M10 T350M	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,26 *0.010*
P11	ONMU050410ANTN-M10 MP2050	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
P12	ONMU050410ANTN-M10 MP2050	1,4 *0.055*	0,14 *0.0055*	0,14 *0.0055*	0,17 *0.0065*
M1	ONMU050410ANTN-ME10 F40M	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
M2	ONMU050410ANTN-ME10 F40M	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*
M3	ONMU050410ANTN-ME10 MS2050	1,4 *0.055*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
M4	ONMU050410ANTN-M10 MP2050	1,1 *0.044*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
M5	ONMU050410ANTN-M10 MP2050	1,1 *0.044*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
K1	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,24 *0.0095*	0,25 *0.010*	0,32 *0.013*
K2	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
K3	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
K4	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
K5	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
K6	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
K7	ONMU050410ANTN-M11 MK2050	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
N1	ONMU050410ANTN-ME10 F40M	1,8 *0.070*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
N2	ONMU050410ANTN-ME10 F40M	1,8 *0.070*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
N3	ONMU050410ANTN-ME10 F40M	1,8 *0.070*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
N11	ONMU050410ANTN-ME10 F40M	1,8 *0.070*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
S1	ONMU050410ANTN-M10 T350M	1,1 *0.044*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
S2	ONMU050410ANTN-M10 T350M	1,1 *0.044*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
S3	ONMU050410ANTN-M10 T350M	1,1 *0.044*	0,13 *0.0050*	0,13 *0.0050*	0,17 *0.0065*
S11	ONMU050410ANTN-ME10 MS2050	1,3 *0.050*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
S12	ONMU050410ANTN-ME10 MS2050	1,3 *0.050*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
S13	ONMU050410ANTN-ME10 MS2050	1,1 *0.044*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
H5	ONMU050410ANTN-M11 MP1501	1,4 *0.055*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
H8	ONMU050410ANTN-M11 MP1501	1,3 *0.050*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H11	ONMU050410ANTN-M11 MP1501	1,4 *0.055*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
H12	ONMU050410ANTN-M11 MP1501	1,3 *0.050*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H21	ONMU050410ANTN-M11 MP1501	1,3 *0.050*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

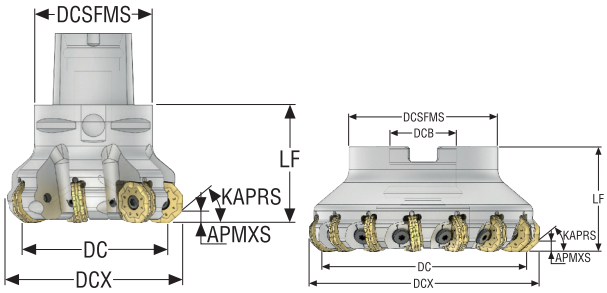
R217/220.48-05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			MP3000			MP2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	235 *770*	270 *890*	305 *1000*	340 *1125*	390 *1275*	445 *1450*	310 *1025*	360 *1175*	400 *1300*	295 *970*	340 *1125*	380 *1250*	305 *1000*	350 *1150*	395 *1300*
P2	230 *750*	265 *870*	295 *970*	330 *1075*	380 *1250*	425 *1400*	300 *980*	350 *1150*	390 *1275*	285 *940*	330 *1075*	370 *1225*	295 *970*	345 *1125*	385 *1275*
P3	195 *640*	225 *740*	260 *850*	285 *940*	330 *1075*	375 *1225*	260 *850*	300 *980*	345 *1125*	245 *800*	285 *940*	325 *1075*	255 *840*	295 *970*	340 *1125*
P4	180 *590*	200 *660*	230 *750*	255 *840*	290 *950*	335 *1100*	235 *770*	265 *870*	305 *1000*	220 *720*	250 *820*	285 *940*	230 *750*	260 *850*	295 *970*
P5	170 *560*	195 *640*	220 *720*	245 *800*	285 *940*	320 *1050*	225 *740*	260 *850*	290 *950*	210 *690*	245 *800*	275 *900*	220 *720*	255 *840*	285 *940*
P6	190 *620*	220 *720*	250 *820*	275 *900*	320 *1050*	360 *1175*	250 *820*	290 *950*	330 *1075*	240 *790*	275 *900*	310 *1025*	245 *800*	285 *940*	320 *1050*
P7	180 *590*	210 *690*	235 *770*	260 *850*	300 *980*	340 *1125*	235 *770*	275 *900*	310 *1025*	225 *740*	260 *850*	295 *970*	235 *770*	270 *890*	305 *1000*
P8	165 *540*	190 *620*	220 *720*	240 *790*	280 *920*	315 *1025*	220 *720*	250 *820*	290 *950*	205 *670*	240 *790*	275 *900*	215 *710*	250 *820*	285 *940*
P11	175 *570*	200 *660*	230 *750*	255 *840*	295 *970*	330 *1075*	230 *750*	265 *870*	300 *980*	220 *720*	255 *840*	285 *940*	225 *740*	260 *850*	295 *970*
P12	115 *375*	130 *425*	150 *490*	165 *540*	190 *620*	215 *710*	150 *490*	170 *560*	195 *640*	140 *460*	165 *540*	185 *610*	145 *475*	170 *560*	190 *620*
M1	185 *610*	215 *710*	240 *790*	— —	— —	— —	215 *710*	250 *820*	280 *920*	215 *710*	245 *800*	275 *900*	210 *690*	245 *800*	275 *900*
M2	155 *510*	175 *570*	195 *640*	— —	— —	— —	180 *590*	210 *690*	235 *770*	175 *570*	205 *670*	230 *750*	175 *570*	205 *670*	225 *740*
M3	125 *410*	140 *460*	160 *520*	— —	— —	— —	145 *475*	165 *540*	190 *620*	145 *475*	165 *540*	185 *610*	140 *460*	160 *520*	185 *610*
M4	95 *310*	110 *360*	125 *410*	— —	— —	— —	115 *375*	130 *425*	145 *475*	110 *360*	125 *410*	145 *475*	110 *360*	125 *410*	145 *460*
M5	80 *260*	90 *295*	105 *330*	— —	— —	— —	95 *310*	105 *345*	120 *395*	90 *295*	105 *345*	120 *395*	90 *295*	105 *345*	120 *395*
K1	180 *590*	210 *690*	235 *770*	260 *850*	300 *980*	335 *1100*	240 *790*	275 *900*	310 *1025*	225 *740*	260 *850*	295 *970*	235 *770*	270 *890*	305 *1000*
K2	160 *520*	185 *610*	210 *690*	235 *770*	270 *890*	305 *1000*	215 *710*	245 *800*	275 *900*	200 *660*	235 *770*	260 *850*	210 *690*	240 *790*	270 *890*
K3	135 *445*	160 *520*	175 *570*	195 *640*	230 *750*	255 *840*	180 *590*	210 *690*	230 *750*	170 *560*	195 *640*	220 *720*	175 *570*	205 *670*	230 *750*
K4	130 *425*	150 *490*	170 *560*	190 *620*	220 *720*	245 *800*	170 *560*	200 *660*	220 *720*	165 *540*	190 *620*	210 *690*	170 *560*	195 *640*	220 *720*
K5	80 *260*	90 *295*	100 *330*	115 *375*	135 *445*	150 *490*	105 *345*	120 *395*	135 *445*	100 *330*	115 *375*	130 *425*	105 *345*	120 *395*	130 *425*
K6	115 *375*	135 *445*	150 *490*	165 *540*	190 *620*	215 *710*	150 *490*	175 *570*	195 *640*	145 *475*	165 *540*	185 *610*	150 *490*	170 *560*	190 *620*
K7	100 *330*	115 *375*	130 *425*	150 *490*	170 *560*	195 *640*	135 *445*	155 *510*	175 *570*	130 *425*	145 *475*	165 *540*	130 *425*	150 *490*	170 *560*
N1	1325 *4350*	1525 *5000*	1725 *5650*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	540 *1775*	610 *2000*	700 *2300*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	360 *1175*	405 *1325*	465 *1525*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	410 *1350*	465 *1525*	530 *1750*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	45 *150*	50 *165*	60 *180*	— —	— —	— —	55 *180*	60 *195*	70 *230*	50 *165*	60 *195*	65 *215*	55 *180*	60 *195*	70 *230*
S2	36 *120*	41 *135*	47 *150*	— —	— —	— —	44 *145*	50 *165*	55 *180*	42 *140*	47 *155*	55 *180*	43 *140*	49 *160*	55 *180*
S3	32 *105*	36 *120*	41 *130*	— —	— —	— —	39 *130*	45 *150*	50 *165*	37 *120*	42 *140*	47 *155*	38 *125*	44 *145*	49 *160*
S11	60 *195*	70 *230*	80 *260*	— —	— —	— —	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	75 *245*	85 *280*	100 *330*
S12	43 *140*	49 *160*	55 *180*	— —	— —	— —	55 *180*	60 *195*	70 *230*	50 *165*	55 *180*	65 *215*	50 *165*	60 *195*	70 *230*
S13	25 *80*	28 *90*	32 *105*	— —	— —	— —	31 *100*	35 *115*	40 *130*	29 *95*	33 *110*	38 *120*	30 *100*	34 *110*	39 *130*
H5	38 *125*	43 *140*	49 *160*	55 *180*	60 *195*	70 *230*	45 *150*	50 *165*	60 *195*	44 *145*	50 *165*	60 *180*	44 *145*	50 *165*	60 *180*
H8	40 *130*	46 *150*	50 *165*	60 *195*	65 *215*	75 *245*	48 *155*	55 *180*	65 *195*	47 *155*	55 *180*	60 *195*	47 *155*	55 *180*	60 *195*
H11	48 *155*	55 *180*	65 *195*	70 *230*	80 *260*	90 *295*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*
H12	70 *230*	80 *260*	95 *310*	105 *345*	120 *395*	135 *445*	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	115 *375*	95 *310*	105 *345*	120 *395*
H21	40 *130*	46 *150*	50 *165*	60 *195*	65 *215*	75 *245*	48 *155*	55 *180*	65 *195*	47 *155*	55 *180*	60 *195*	47 *155*	55 *180*	60 *195*

R217/220.48-05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			T350M			MM4500			MS2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	300	350	390	260	295	340	185	215	245	245	285	325
	—	—	—	*980*	*1150*	*1275*	*850*	*970*	*1125*	*610*	*710*	*800*	*800*	*940*	*1075*
P2	—	—	—	290	340	380	250	290	330	180	210	235	240	275	315
	—	—	—	*950*	*1125*	*1250*	*820*	*950*	*1075*	*590*	*690*	*770*	*790*	*900*	*1025*
P3	—	—	—	250	290	335	215	250	285	155	180	210	205	240	270
	—	—	—	*820*	*950*	*1100*	*710*	*820*	*940*	*510*	*590*	*690*	*670*	*790*	*890*
P4	—	—	—	230	255	295	195	220	255	140	160	185	185	210	245
	—	—	—	*750*	*840*	*970*	*640*	*720*	*840*	*460*	*520*	*610*	*610*	*690*	*800*
P5	—	—	—	215	250	280	185	215	245	135	155	175	180	205	230
	—	—	—	*710*	*820*	*920*	*610*	*710*	*800*	*445*	*510*	*570*	*590*	*670*	*750*
P6	—	—	—	245	280	320	210	245	275	150	175	200	200	235	260
	—	—	—	*800*	*920*	*1050*	*690*	*800*	*900*	*490*	*570*	*660*	*660*	*770*	*850*
P7	—	—	—	230	265	300	200	230	255	145	165	185	190	220	245
	—	—	—	*750*	*870*	*980*	*660*	*750*	*840*	*475*	*540*	*610*	*620*	*720*	*800*
P8	—	—	—	210	245	280	180	210	240	130	155	175	175	200	230
	—	—	—	*690*	*800*	*920*	*590*	*690*	*790*	*425*	*510*	*570*	*570*	*660*	*750*
P11	—	—	—	225	260	290	190	225	250	140	160	180	185	215	240
	—	—	—	*740*	*850*	*950*	*620*	*740*	*820*	*460*	*520*	*590*	*610*	*710*	*790*
P12	—	—	—	145	165	190	125	145	165	90	105	120	120	135	155
	—	—	—	*475*	*540*	*620*	*410*	*475*	*540*	*295*	*345*	*395*	*395*	*445*	*510*
M1	—	—	—	—	—	—	195	225	255	155	180	205	195	225	255
	—	—	—	—	—	—	*640*	*740*	*840*	*510*	*590*	*670*	*640*	*740*	*840*
M2	—	—	—	—	—	—	160	185	210	130	150	165	160	185	210
	—	—	—	—	—	—	*520*	*610*	*690*	*425*	*490*	*540*	*520*	*610*	*690*
M3	—	—	—	—	—	—	130	150	170	105	120	135	130	150	170
	—	—	—	—	—	—	*425*	*490*	*560*	*345*	*395*	*445*	*425*	*490*	*560*
M4	—	—	—	—	—	—	100	115	130	80	95	105	100	115	130
	—	—	—	—	—	—	*330*	*375*	*425*	*260*	*310*	*345*	*330*	*375*	*425*
M5	—	—	—	—	—	—	85	95	110	70	80	90	85	95	110
	—	—	—	—	—	—	*280*	*310*	*360*	*230*	*260*	*280*	*280*	*310*	*360*
K1	335	385	435	315	365	410	200	230	260	—	—	—	—	—	—
	1100	*1275*	*1425*	*1025*	*1200*	*1350*	*660*	*750*	*850*	—	—	—	—	—	—
K2	295	345	385	280	325	360	175	205	230	—	—	—	—	—	—
	970	*1125*	*1275*	*920*	*1075*	*1175*	*570*	*670*	*750*	—	—	—	—	—	—
K3	250	290	325	240	275	305	150	175	195	—	—	—	—	—	—
	820	*950*	*1075*	*790*	*900*	*1000*	*490*	*570*	*640*	—	—	—	—	—	—
K4	240	275	310	225	265	295	145	165	185	—	—	—	—	—	—
	790	*900*	*1025*	*740*	*870*	*970*	*475*	*540*	*610*	—	—	—	—	—	—
K5	145	165	190	140	160	180	90	100	115	—	—	—	—	—	—
	475	*540*	*620*	*460*	*520*	*590*	*295*	*330*	*375*	—	—	—	—	—	—
K6	210	245	270	200	230	260	125	145	165	—	—	—	—	—	—
	690	*800*	*890*	*660*	*750*	*850*	*410*	*475*	*540*	—	—	—	—	—	—
K7	190	215	240	180	205	230	110	130	145	—	—	—	—	—	—
	620	*710*	*790*	*590*	*670*	*750*	*360*	*425*	*475*	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
S1	—	—	—	—	—	—	47	55	60	25	29	32	47	55	60
	—	—	—	—	—	—	*155*	*180*	*195*	*80*	*95*	*105*	*155*	*180*	*195*
S2	—	—	—	—	—	—	38	43	49	20	23	26	38	43	49
	—	—	—	—	—	—	*125*	*140*	*160*	*65*	*75*	*85*	*125*	*140*	*160*
S3	—	—	—	—	—	—	34	38	43	18	20	23	34	38	43
	—	—	—	—	—	—	*110*	*125*	*140*	*60*	*65*	*75*	*110*	*125*	*140*
S11	—	—	—	—	—	—	65	75	85	35	39	45	65	75	85
	—	—	—	—	—	—	*215*	*245*	*280*	*115*	*130*	*150*	*215*	*245*	*280*
S12	—	—	—	—	—	—	45	50	60	32	36	42	45	50	60
	—	—	—	—	—	—	*150*	*165*	*195*	*105*	*120*	*140*	*150*	*165*	*195*
S13	—	—	—	—	—	—	26	30	34	19	21	24	26	30	34
	—	—	—	—	—	—	*85*	*100*	*110*	*60*	*70*	*80*	*85*	*100*	*110*
H5	—	—	—	—	—	—	42	47	55	—	—	—	—	—	—
	—	—	—	—	—	—	*140*	*155*	*180*	—	—	—	—	—	—
H8	—	—	—	—	—	—	44	50	55	—	—	—	—	—	—
	—	—	—	—	—	—	*145*	*165*	*180*	—	—	—	—	—	—
H11	—	—	—	—	—	—	55	60	70	—	—	—	—	—	—
	—	—	—	—	—	—	*180*	*195*	*230*	—	—	—	—	—	—
H12	—	—	—	—	—	—	80	90	105	—	—	—	—	—	—
	—	—	—	—	—	—	*260*	*295*	*345*	—	—	—	—	—	—
H21	—	—	—	—	—	—	44	50	55	—	—	—	—	—	—
	—	—	—	—	—	—	*145*	*165*	*180*	—	—	—	—	—	—

Double Octomill™ R217/220.48-09 – Metric



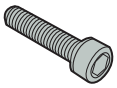
- For insert selection and cutting data recommendations, see page(s) 231 - 233
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
C6-R217.48-063-09-05SA	02731337	Seco-Capto	63,0	5	6,0	40,0	78,0	–	63,0	63,0	4900	1,5	ON.U0905
C6-R217.48-063-09-06SA	02731336	Seco-Capto	63,0	6	6,0	40,0	78,0	–	63,0	63,0	4900	1,5	ON.U0905
C6-R217.48-080-09-06SA	02731338	Seco-Capto	80,0	6	6,0	40,0	95,0	–	63,0	63,0	4400	1,7	ON.U0905
C6-R217.48-080-09-07SA	02731340	Seco-Capto	80,0	7	6,0	40,0	95,0	–	63,0	63,0	4400	1,8	ON.U0905
C6-R217.48-080-09-09M	02731344	Seco-Capto	80,0	9	6,0	40,0	95,0	–	63,0	63,0	4400	2,3	ON.U0905
C6-R217.48-100-09-07SA	02731347	Seco-Capto	100,0	7	6,0	40,0	115,0	–	63,0	80,0	3900	3,0	ON.U0905
C8-R217.48-100-09-07SA	02731341	Seco-Capto	100,0	7	6,0	40,0	115,0	–	80,0	80,0	3900	3,7	ON.U0905
C8-R217.48-100-09-08SA	02731342	Seco-Capto	100,0	8	6,0	40,0	115,0	–	80,0	80,0	3900	3,7	ON.U0905
C8-R217.48-100-09-12M	02731345	Seco-Capto	100,0	12	6,0	40,0	115,0	–	80,0	80,0	3900	4,0	ON.U0905
R220.48-0063-09-05SA	02670226	Arbor	63,0	5	6,0	40,0	78,0	22,0	47,0	40,0	4900	0,5	ON.U0905
R220.48-0063-09-06SA	02685780	Arbor	63,0	6	6,0	40,0	78,0	22,0	47,0	40,0	4900	0,5	ON.U0905
R220.48-0080-09-06SA	02670228	Arbor	80,0	6	6,0	40,0	95,0	27,0	62,0	50,0	4400	1,0	ON.U0905
R220.48-0080-09-07SA	02685781	Arbor	80,0	7	6,0	40,0	95,0	27,0	62,0	50,0	4400	1,0	ON.U0905
R220.48-0080-09-09M	02670210	Arbor	80,0	9	6,0	40,0	95,0	27,0	62,0	50,0	4400	1,2	ON.U0905
R220.48-0100-09-07SA	02670229	Arbor	100,0	7	6,0	40,0	115,0	32,0	77,0	50,0	3900	1,6	ON.U0905
R220.48-0100-09-08SA	02685782	Arbor	100,0	8	6,0	40,0	115,0	32,0	77,0	50,0	3900	1,6	ON.U0905
R220.48-0100-09-12M	02670213	Arbor	100,0	12	6,0	40,0	115,0	32,0	77,0	50,0	3900	1,9	ON.U0905
R220.48-0125-09-08SA	02670231	Arbor	125,0	8	6,0	40,0	140,0	40,0	90,0	63,0	3500	2,9	ON.U0905
R220.48-0125-09-10SA	02685847	Arbor	125,0	10	6,0	40,0	140,0	40,0	90,0	63,0	3500	3,0	ON.U0905
R220.48-0125-09-15M	02670214	Arbor	125,0	15	6,0	40,0	140,0	40,0	90,0	63,0	3500	3,4	ON.U0905
R220.48-8160-09-12S	02685849	Arbor	160,0	12	6,0	40,0	175,0	40,0	90,0	63,0	3100	4,4	ON.U0905
R220.48-8160-09-10S	02685776	Arbor	160,0	10	6,0	40,0	175,0	40,0	90,0	63,0	3100	4,2	ON.U0905
R220.48-8160-09-20M	02670215	Arbor	160,0	20	6,0	40,0	175,0	40,0	90,0	63,0	3100	4,8	ON.U0905
R220.48-8200-09-12S	02685845	Arbor	200,0	12	6,0	40,0	215,0	60,0	130,0	63,0	2700	5,4	ON.U0905
R220.48-8200-09-24M	02685773	Arbor	200,0	24	6,0	40,0	215,0	60,0	130,0	63,0	2700	6,0	ON.U0905
R220.48-8200-09-28M	02729891	Arbor	200,0	28	6,0	40,0	215,0	60,0	130,0	63,0	2700	5,9	ON.U0905
R220.48-8250-09-16S	02685777	Arbor	250,0	16	6,0	40,0	265,0	60,0	130,0	63,0	2500	13,0	ON.U0905
R220.48-8250-09-30M	02685774	Arbor	250,0	30	6,0	40,0	265,0	60,0	130,0	63,0	2500	14,1	ON.U0905
R220.48-8315-09-20S	02685846	Arbor	315,0	20	6,0	40,0	330,0	60,0	225,0	80,0	2200	27,0	ON.U0905
R220.48-8315-09-40M	02685775	Arbor	315,0	40	6,0	40,0	330,0	60,0	225,0	80,0	2200	28,6	ON.U0905

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

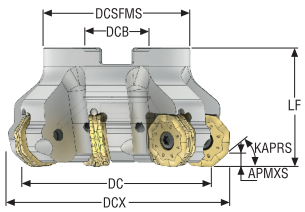
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Wedge kit	Torque key	Torque value
					
C6/C8-217.48-063-100	–	C05013-T20P	–	T00-20P50	5.0NM
C6/C8-217.48-080M	–	–	CW0816-RHA	–	–
R220.48-0063	220.17-692	C05013-T20P	–	T00-20P50	5.0NM
R220.48-0080-8315	–	C05013-T20P	–	T00-20P50	5.0NM
R220.48-0080-8315M	–	–	CW0816-RHA	–	–

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Octomill™ R220.48-09 – Inch



- For insert selection and cutting data recommendations, see page(s) 231 - 233
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.48-02.50-09-05SA	02685793	Arbor	2.480	5	0.236	40.0	3.071	0.750	1.260	1.575	4900	1.100	ON.U0905
R220.48-03.00-09-06SA	02685794	Arbor	3.150	6	0.236	40.0	3.740	1.000	2.441	1.969	4400	2.430	ON.U0905
R220.48-03.00-09-09M	02685806	Arbor	3.150	9	0.236	40.0	3.740	1.000	2.441	1.969	4400	2.870	ON.U0905
R220.48-04.00-09-07SA	02685795	Arbor	3.937	7	0.236	40.0	4.528	1.500	3.543	1.969	3900	3.530	ON.U0905
R220.48-04.00-09-12M	02685807	Arbor	3.937	12	0.236	40.0	4.528	1.500	3.543	1.969	3900	3.970	ON.U0905
R220.48-05.00-09-08SA	02685797	Arbor	4.921	8	0.236	40.0	5.512	1.500	3.543	2.480	3500	7.050	ON.U0905
R220.48-05.00-09-15M	02685808	Arbor	4.921	15	0.236	40.0	5.512	1.500	3.543	2.480	3500	8.160	ON.U0905
R220.48-06.00-09-10S	02685799	Arbor	6.299	10	0.236	40.0	6.890	2.000	4.331	2.480	3100	8.820	ON.U0905
R220.48-808.00-09-12S	02685801	Arbor	7.874	12	0.236	40.0	8.465	2.500	5.118	2.480	2700	11.900	ON.U0905
R220.48-810.00-09-16S	02685802	Arbor	9.843	16	0.236	40.0	10.433	2.500	5.118	2.480	2500	28.660	ON.U0905
R220.48-812.50-09-20S	02685803	Arbor	12.402	20	0.236	40.0	12.992	2.500	8.858	3.150	2200	59.520	ON.U0905

Spare Parts

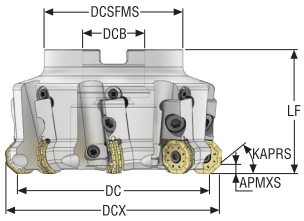
Accessories

For cutter	Arbor screw	Insert screw	Wedge kit	Torque key	Torque value
R220.48-02.50	UC6S3/8UNFX1	C05013-T20P	–	T00-20P50	44.3IN.LBS
R220.48-03.00	UC6S1/2UNFX1-1/4	C05013-T20P	–	T00-20P50	44.3IN.LBS
R220.48-03.00	UC6S1/2UNFX1-1/4	–	CW0816-RHA	–	–
R220.48-04.00	UF6S3/4UNFX1-3/4	C05013-T20P	–	T00-20P50	44.3IN.LBS
R220.48-04.00	UC6S3/4UNFX1-1/4	–	CW0816-RHA	–	–
R220.48-05.00	UC6S3/4UNFX1-1/4	C05013-T20P	–	T00-20P50	44.3IN.LBS
R220.48-05.00	UC6S3/4UNFX1-1/4	–	CW0816-RHA	–	–
R220.48-06.00 - 812.50	–	C05013-T20P	–	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Octomill™ R/L220.48-09CS – Metric



- For insert selection and cutting data recommendations, see page(s) 231 - 233
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.48-0125-09-08CS	02883045	Arbor	125,0	8	6,0	40,0	140,0	40,0	90,0	80,0	3500	4,9	ON.U0905
R220.48-8160-09-10CS	02883046	Arbor	160,0	10	6,0	40,0	175,0	40,0	130,0	80,0	3100	7,6	ON.U0905
R220.48-8200-09-12CS	02883047	Arbor	200,0	12	6,0	40,0	215,0	60,0	160,0	80,0	2700	10,5	ON.U0905
R220.48-8250-09-16CS	02883048	Arbor	250,0	16	6,0	40,0	265,0	60,0	200,0	80,0	2500	19,6	ON.U0905
R220.48-8315-09-20CS	02883049	Arbor	315,0	20	6,0	40,0	330,0	60,0	225,0	80,0	2200	35,5	ON.U0905
L220.48-8250-09-16CS	02883053	Arbor	250,0	16	6,0	40,0	265,0	60,0	200,0	80,0	2500	19,6	ON.U0905
L220.48-0125-09-08CS	02883050	Arbor	125,0	8	6,0	40,0	140,0	40,0	90,0	80,0	3500	4,9	ON.U0905
L220.48-8160-09-10CS	02883051	Arbor	160,0	10	6,0	40,0	175,0	40,0	130,0	80,0	3100	7,6	ON.U0905
L220.48-8200-09-12CS	02883052	Arbor	200,0	12	6,0	40,0	215,0	60,0	160,0	80,0	2700	10,5	ON.U0905

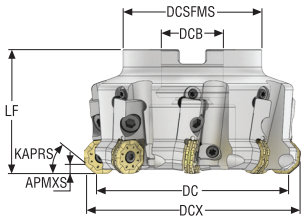
Spare Parts

Accessories

For cutter	Cassette (L)	Cassette (R)	Cassette screw	Insert screw	Setting gauge	Wedge clamp	Wedge screw	Setting key	Torque key	Torque value
R220.48	–	ON09AR	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	5.0NM
L220.48	ON09AL	–	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Double Octomill™ R/L220.48-09CS – Inch



- For insert selection and cutting data recommendations, see page(s) 231 - 233
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
L220.48-05.00-09-08CS	02882762	Arbor	4.921	8	0.236	40.0	5.512	1.500	3.543	3.150	3500	10.800	ON.U0905
L220.48-06.00-09-10CS	02882763	Arbor	6.299	10	0.236	40.0	6.890	2.000	4.331	3.150	3100	16.760	ON.U0905
L220.48-808.00-09-12CS	02883058	Arbor	7.874	12	0.236	40.0	8.465	2.500	5.118	3.150	2700	23.150	ON.U0905
L220.48-810.00-09-16CS	02883059	Arbor	9.843	16	0.236	40.0	10.433	2.500	5.118	3.150	2500	43.210	ON.U0905
L220.48-812.50-09-20CS	02882766	Arbor	12.402	20	0.236	40.0	12.992	2.500	8.858	3.150	2200	78.260	ON.U0905
R220.48-06.00-09-10CS	02882758	Arbor	6.299	10	0.236	40.0	6.890	2.000	4.331	3.150	3100	16.760	ON.U0905
R220.48-808.00-09-12CS	02883055	Arbor	7.874	12	0.236	40.0	8.465	2.500	5.118	3.150	2700	23.150	ON.U0905
R220.48-810.00-09-16CS	02883056	Arbor	9.843	16	0.236	40.0	10.433	2.500	5.118	3.150	2500	43.210	ON.U0905
R220.48-812.50-09-20CS	02883057	Arbor	12.402	20	0.236	40.0	12.992	2.500	8.858	3.150	2200	78.260	ON.U0905

Spare Parts

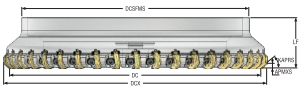
Accessories

For cutter	Cassette (L)	Cassette (R)	Cassette screw	Insert screw	Setting gauge	Wedge clamp	Wedge screw	Setting key	Torque key	Torque value
L220.48-05.00-06.00	ON09AL	–	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	44.3IN.LBS
L220.48-808.00-810.00	ON09AL	–	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	44.3IN.LBS
L220.48-812.50	ON09AL	–	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	44.3IN.LBS
R220.48-05.00-06.00	–	ON09AR	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	44.3IN.LBS
R220.48-808.00-810.00	–	ON09AR	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	44.3IN.LBS
R220.48-812.50	–	ON09AR	FS98030	C05013-T20P	AU1114T-T15P	CW0810	LD8020-T25P	T15P-4	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Double Octomill™ R220.48-09 CAP – Metric



- For insert selection and cutting data recommendations, see page(s) 231 - 233
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.48-9250-09-30M	02720552	CAP	250,0	30	6,0	40,0	265,0	–	220,0	63,0	2500	9,2	ON.U0905
R220.48-9315-09-40M	02720554	CAP	315,0	40	6,0	40,0	330,0	–	285,0	63,0	2200	13,2	ON.U0905
R220.48-9315-09-50M	02729890	CAP	315,0	50	6,0	40,0	330,0	–	285,0	63,0	2200	17,7	ON.U0905
R220.48-9355-09-50M	02671031	CAP	355,0	50	6,0	40,0	370,0	–	285,0	63,0	2000	15,1	ON.U0905
R220.48-9400-09-50M	02720555	CAP	400,0	50	6,0	40,0	415,0	–	370,0	63,0	1900	18,6	ON.U0905
R220.48-9500-09-60M	02720556	CAP	500,0	60	6,0	40,0	515,0	–	470,0	63,0	1700	27,0	ON.U0905

Spare Parts

For cutter	Wedge kit
R220.48-...	CW0816-RHA

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.48-09 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	ONMU090520ANTN-M12 T350M	3,5 *0.14*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P2	ONMU090520ANTN-M12 T350M	3,5 *0.14*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P3	ONMU090520ANTN-M12 MP2500	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P4	ONMU090520ANTN-M12 MP2500	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P5	ONMU090520ANTN-M12 MP2500	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,32 *0.013*
P6	ONMU090520ANTN-M12 MP2500	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
P7	ONMU090520ANTN-M12 T350M	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
P8	ONMU090520ANTN-M12 T350M	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P11	ONMU090520ANTN-M12 MP2050	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
P12	ONMU090520ANTN-M12 MP2050	3,0 *0.12*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M1	ONMU090520ANTN-ME12 F40M	3,5 *0.14*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
M2	ONMU090520ANTN-ME12 F40M	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,32 *0.013*
M3	ONMU090520ANTN-ME12 MS2050	3,0 *0.12*	0,19 *0.0075*	0,20 *0.0080*	0,25 *0.010*
M4	ONMU090520ANTN-M12 MP2050	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M5	ONMU090520ANTN-M12 MP2050	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
K1	ONMU090520ANTN-M14 MK1500	3,5 *0.14*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
K2	ONMU090520ANTN-M14 MK1500	3,5 *0.14*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
K3	ONMU090520ANTN-M14 MP1500	3,5 *0.14*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
K4	ONMU090520ANTN-M14 MP1500	3,5 *0.14*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
K5	ONMU090520ANTN-M14 MK2050	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
K6	ONMU090520ANTN-M14 MK2050	3,5 *0.14*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
K7	ONMU090520ANTN-M14 MK2050	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
N1	ONMU090520ANTN-ME12 F40M	3,5 *0.14*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
N2	ONMU090520ANTN-ME12 F40M	3,5 *0.14*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
N3	ONMU090520ANTN-ME12 F40M	3,5 *0.14*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
N11	ONMU090520ANTN-ME12 F40M	3,5 *0.14*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
S1	ONMU090520ANTN-M12 MS2500	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
S2	ONMU090520ANTN-M12 MS2500	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
S3	ONMU090520ANTN-M12 MS2500	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
S11	ONMU090520ANTN-ME12 MS2050	2,5 *0.10*	0,19 *0.0075*	0,20 *0.0080*	0,25 *0.010*
S12	ONMU090520ANTN-ME12 MS2050	2,5 *0.10*	0,19 *0.0075*	0,20 *0.0080*	0,25 *0.010*
S13	ONMU090520ANTN-M12 F40M	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
H5	ONMU090520ANTN-M15 MP3000	3,0 *0.12*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
H8	ONMU090520ANTN-M15 MP3000	2,5 *0.10*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
H11	ONMU090520ANTN-MD16 MP1500	3,0 *0.12*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
H12	ONMU090520ANTN-MD16 MP1500	2,5 *0.10*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
H21	ONMU090520ANTN-MD16 MP1500	2,5 *0.10*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.48-09 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1500			MP2500			MP3000			MP2050			T350M		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	225 *740*	260 *850*	295 *970*	330 *1075*	375 *1225*	430 *1400*	290 *950*	335 *1100*	380 *1250*	275 *900*	315 *1025*	360 *1175*	285 *940*	325 *1075*	375 *1225*	255 *840*	290 *950*	330 *1075*
P2	220 *720*	250 *820*	285 *940*	320 *1050*	365 *1200*	410 *1350*	285 *940*	325 *1075*	365 *1200*	270 *890*	305 *1000*	345 *1125*	280 *920*	320 *1050*	360 *1175*	250 *820*	285 *940*	320 *1050*
P3	190 *620*	220 *720*	250 *820*	275 *900*	320 *1050*	360 *1175*	245 *800*	285 *940*	320 *1050*	230 *750*	270 *890*	305 *1000*	240 *790*	280 *920*	315 *1025*	215 *710*	250 *820*	280 *920*
P4	170 *560*	195 *640*	220 *720*	250 *820*	285 *940*	325 *1075*	220 *720*	250 *820*	285 *940*	210 *690*	240 *790*	270 *890*	215 *710*	245 *800*	280 *920*	190 *620*	220 *720*	250 *820*
P5	165 *540*	190 *620*	210 *690*	240 *790*	270 *890*	310 *1025*	210 *690*	240 *790*	275 *900*	200 *660*	225 *740*	260 *850*	205 *670*	235 *770*	270 *890*	185 *610*	210 *690*	240 *790*
P6	185 *610*	210 *690*	240 *790*	265 *870*	310 *1025*	345 *1125*	235 *770*	275 *900*	305 *1000*	225 *740*	260 *850*	290 *950*	230 *750*	270 *890*	300 *980*	205 *670*	240 *790*	265 *870*
P7	175 *570*	200 *660*	230 *750*	250 *820*	295 *970*	325 *1075*	225 *740*	260 *850*	290 *950*	210 *690*	245 *800*	275 *900*	220 *720*	255 *840*	285 *940*	195 *640*	225 *740*	250 *820*
P8	160 *520*	185 *610*	210 *690*	230 *750*	270 *890*	305 *1000*	205 *670*	240 *790*	270 *890*	195 *640*	225 *740*	255 *840*	200 *660*	235 *770*	265 *870*	180 *590*	210 *690*	235 *770*
P11	170 *560*	195 *640*	220 *720*	245 *800*	285 *940*	320 *1050*	215 *710*	250 *820*	280 *920*	205 *670*	240 *790*	265 *870*	215 *710*	250 *820*	275 *900*	190 *620*	220 *720*	245 *800*
P12	110 *360*	125 *410*	140 *460*	160 *520*	185 *610*	210 *690*	140 *460*	165 *540*	185 *610*	135 *445*	155 *510*	175 *570*	140 *460*	160 *520*	185 *610*	125 *410*	145 *475*	165 *520*
M1	180 *590*	200 *660*	230 *750*	— —	— —	— —	205 *670*	235 *770*	265 *870*	200 *660*	230 *750*	260 *850*	200 *660*	230 *750*	255 *840*	190 *620*	220 *720*	245 *800*
M2	145 *475*	170 *560*	190 *620*	— —	— —	— —	170 *560*	195 *640*	220 *720*	165 *540*	190 *620*	215 *710*	165 *540*	190 *620*	215 *710*	160 *520*	180 *590*	205 *670*
M3	120 *395*	135 *445*	155 *510*	— —	— —	— —	135 *445*	155 *510*	175 *590*	135 *445*	155 *510*	175 *570*	130 *425*	155 *510*	175 *570*	125 *410*	145 *475*	165 *560*
M4	90 *295*	105 *345*	120 *395*	— —	— —	— —	105 *345*	120 *395*	140 *445*	105 *345*	120 *395*	135 *445*	105 *345*	120 *395*	135 *445*	100 *330*	115 *375*	130 *410*
M5	75 *245*	90 *295*	100 *330*	— —	— —	— —	90 *295*	100 *330*	115 *375*	85 *280*	100 *330*	115 *360*	85 *280*	100 *330*	115 *360*	85 *280*	95 *310*	110 *345*
K1	175 *570*	200 *660*	225 *740*	255 *840*	290 *950*	325 *1075*	225 *740*	255 *840*	290 *950*	215 *710*	245 *800*	275 *900*	220 *720*	250 *820*	285 *940*	195 *640*	225 *740*	250 *820*
K2	155 *510*	180 *590*	200 *660*	225 *740*	255 *840*	295 *970*	200 *660*	230 *750*	260 *850*	190 *620*	215 *710*	245 *800*	195 *640*	225 *740*	255 *840*	175 *570*	200 *660*	225 *740*
K3	130 *425*	150 *490*	170 *560*	190 *620*	215 *710*	250 *820*	170 *560*	195 *640*	220 *720*	160 *520*	180 *590*	210 *690*	165 *540*	190 *620*	215 *710*	150 *490*	170 *560*	190 *620*
K4	125 *410*	145 *475*	160 *520*	180 *590*	210 *690*	235 *770*	160 *520*	185 *610*	210 *690*	155 *510*	175 *570*	200 *660*	160 *520*	180 *590*	205 *670*	140 *460*	160 *520*	185 *610*
K5	75 *245*	90 *295*	100 *330*	110 *360*	130 *425*	145 *475*	100 *330*	115 *375*	130 *425*	95 *310*	110 *360*	120 *395*	95 *310*	115 *375*	125 *410*	85 *280*	100 *330*	115 *375*
K6	110 *360*	125 *410*	140 *460*	160 *520*	185 *610*	210 *690*	140 *460*	160 *520*	185 *610*	135 *445*	155 *510*	175 *570*	140 *460*	160 *520*	180 *590*	125 *410*	140 *460*	160 *520*
K7	100 *330*	115 *375*	130 *425*	145 *475*	165 *540*	185 *610*	125 *410*	145 *475*	165 *540*	120 *395*	140 *460*	155 *510*	125 *410*	145 *475*	165 *540*	110 *360*	130 *425*	145 *475*
N1	1275 *4175*	1450 *4750*	1650 *5425*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	510 *1675*	590 *1925*	670 *2200*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	340 *1125*	390 *1275*	445 *1450*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	390 *1275*	450 *1475*	510 *1675*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	43 *140*	49 *160*	55 *180*	— —	— —	— —	— —	— —	— —	49 *160*	55 *180*	65 *195*	50 *165*	60 *195*	65 *215*	46 *150*	55 *180*	60 *195*
S2	34 *110*	40 *130*	45 *145*	— —	— —	— —	— —	— —	— —	39 *130*	45 *150*	50 *165*	41 *135*	47 *155*	55 *165*	37 *120*	42 *140*	49 *155*
S3	30 *100*	35 *115*	40 *130*	— —	— —	— —	— —	— —	— —	34 *110*	39 *130*	45 *145*	36 *120*	41 *135*	47 *150*	33 *110*	37 *120*	43 *140*
S11	60 *195*	70 *230*	80 *245*	— —	— —	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	70 *230*	80 *260*	90 *295*	65 *215*	75 *245*	85 *280*
S12	42 *140*	48 *155*	55 *180*	— —	— —	— —	— —	— —	— —	46 *150*	55 *180*	60 *195*	48 *155*	55 *180*	65 *215*	44 *145*	50 *165*	60 *195*
S13	24 *80*	28 *90*	32 *100*	— —	— —	— —	— —	— —	— —	27 *90*	31 *100*	36 *115*	29 *95*	32 *105*	37 *120*	26 *85*	30 *100*	34 *110*
H5	36 *120*	42 *140*	47 *155*	55 *180*	60 *195*	70 *230*	43 *140*	50 *165*	55 *180*	42 *140*	48 *155*	55 *180*	42 *140*	48 *155*	55 *180*	41 *135*	48 *155*	55 *180*
H8	39 *130*	45 *150*	50 *165*	55 *180*	65 *215*	75 *245*	46 *150*	55 *180*	60 *195*	45 *150*	50 *165*	60 *195*	45 *150*	50 *165*	60 *195*	44 *145*	50 *165*	55 *180*
H11	46 *150*	55 *180*	60 *195*	70 *230*	80 *260*	90 *295*	55 *180*	65 *215*	70 *230*	55 *180*	60 *195*	70 *230*	55 *180*	60 *195*	70 *230*	50 *165*	60 *195*	70 *230*
H12	70 *230*	80 *260*	90 *295*	100 *330*	115 *375*	135 *445*	90 *295*	105 *345*	115 *395*	85 *280*	100 *330*	110 *360*	90 *295*	100 *330*	115 *375*	80 *260*	90 *295*	100 *330*
H21	39 *130*	45 *150*	50 *165*	55 *180*	65 *215*	75 *245*	46 *150*	55 *180*	60 *195*	45 *150*	50 *165*	60 *195*	45 *150*	50 *165*	60 *195*	44 *145*	50 *165*	55 *180*

R217/220.48-09 – Cutting data v_c = (m/min)/*(sf/min)*

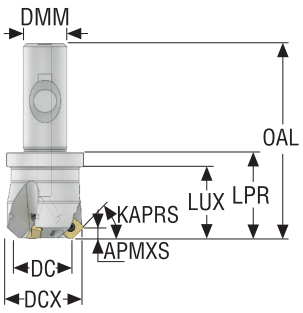
SMG	MK1500			MK2050			MS2500			MS2050			MM4500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	265	305	345	320	365	415	245	280	320	185	210	240
	—	—	—	*870*	*1000*	*1125*	*1050*	*1200*	*1350*	*800*	*920*	*1050*	*610*	*690*	*790*
P2	—	—	—	255	295	335	310	355	400	235	270	305	180	205	230
	—	—	—	*840*	*970*	*1100*	*1025*	*1175*	*1300*	*770*	*890*	*1000*	*590*	*670*	*750*
P3	—	—	—	225	260	295	265	310	350	205	240	265	155	180	205
	—	—	—	*740*	*850*	*970*	*870*	*1025*	*1150*	*670*	*790*	*870*	*510*	*590*	*670*
P4	—	—	—	200	230	260	240	275	310	185	210	240	135	160	180
	—	—	—	*660*	*750*	*850*	*790*	*900*	*1025*	*610*	*690*	*790*	*445*	*520*	*590*
P5	—	—	—	190	220	250	230	260	300	175	200	230	135	150	170
	—	—	—	*620*	*720*	*820*	*750*	*850*	*980*	*570*	*660*	*750*	*445*	*490*	*560*
P6	—	—	—	215	245	280	260	300	335	195	230	255	150	170	195
	—	—	—	*710*	*800*	*920*	*850*	*980*	*1100*	*640*	*750*	*840*	*490*	*560*	*640*
P7	—	—	—	205	230	265	245	285	315	185	215	240	140	160	185
	—	—	—	*670*	*750*	*870*	*800*	*940*	*1025*	*610*	*710*	*790*	*460*	*520*	*610*
P8	—	—	—	185	220	245	225	260	295	170	200	225	130	150	170
	—	—	—	*610*	*720*	*800*	*740*	*850*	*970*	*560*	*660*	*740*	*425*	*490*	*560*
P11	—	—	—	195	225	260	235	275	305	180	210	235	135	155	180
	—	—	—	*640*	*740*	*850*	*770*	*900*	*1000*	*590*	*690*	*770*	*445*	*510*	*590*
P12	—	—	—	130	150	170	155	180	205	120	135	155	90	100	115
	—	—	—	*425*	*490*	*560*	*510*	*590*	*670*	*395*	*445*	*510*	*295*	*330*	*375*
M1	—	—	—	—	—	—	220	255	285	190	220	245	155	175	200
	—	—	—	—	—	—	*720*	*840*	*940*	*620*	*720*	*800*	*510*	*570*	*660*
M2	—	—	—	—	—	—	185	210	240	160	180	205	125	145	165
	—	—	—	—	—	—	*610*	*690*	*790*	*520*	*590*	*670*	*410*	*475*	*540*
M3	—	—	—	—	—	—	145	170	190	125	145	165	105	120	135
	—	—	—	—	—	—	*475*	*560*	*640*	*410*	*475*	*560*	*345*	*395*	*445*
M4	—	—	—	—	—	—	115	130	150	100	115	130	80	90	105
	—	—	—	—	—	—	*375*	*425*	*490*	*330*	*375*	*410*	*260*	*295*	*330*
M5	—	—	—	—	—	—	95	110	125	85	95	110	65	75	85
	—	—	—	—	—	—	*310*	*360*	*410*	*280*	*310*	*345*	*215*	*245*	*280*
K1	290	340	385	275	320	365	—	—	—	—	—	—	—	—	—
	950	*1125*	*1275*	*900*	*1050*	*1200*	—	—	—	—	—	—	—	—	—
K2	260	300	345	245	280	325	—	—	—	—	—	—	—	—	—
	850	*980*	*1125*	*800*	*920*	*1075*	—	—	—	—	—	—	—	—	—
K3	220	250	290	210	240	275	—	—	—	—	—	—	—	—	—
	720	*820*	*950*	*690*	*790*	*900*	—	—	—	—	—	—	—	—	—
K4	210	240	275	200	230	260	—	—	—	—	—	—	—	—	—
	690	*790*	*900*	*660*	*750*	*850*	—	—	—	—	—	—	—	—	—
K5	130	150	165	120	140	160	—	—	—	—	—	—	—	—	—
	425	*490*	*540*	*395*	*460*	*520*	—	—	—	—	—	—	—	—	—
K6	185	210	245	175	200	230	—	—	—	—	—	—	—	—	—
	610	*690*	*800*	*570*	*660*	*750*	—	—	—	—	—	—	—	—	—
K7	165	190	215	155	180	205	—	—	—	—	—	—	—	—	—
	540	*620*	*710*	*510*	*590*	*670*	—	—	—	—	—	—	—	—	—
S1	—	—	—	—	—	—	55	65	75	46	55	60	24	28	32
	—	—	—	—	—	—	*180*	*215*	*230*	*150*	*180*	*195*	*80*	*90*	*100*
S2	—	—	—	—	—	—	45	50	60	37	42	49	19	22	26
	—	—	—	—	—	—	*150*	*165*	*195*	*120*	*140*	*155*	*60*	*70*	*80*
S3	—	—	—	—	—	—	40	45	50	33	37	43	17	20	23
	—	—	—	—	—	—	*130*	*150*	*165*	*110*	*120*	*140*	*55*	*65*	*70*
S11	—	—	—	—	—	—	75	90	100	65	75	85	34	39	44
	—	—	—	—	—	—	*245*	*295*	*345*	*215*	*245*	*280*	*110*	*130*	*145*
S12	—	—	—	—	—	—	55	60	70	44	50	60	31	36	41
	—	—	—	—	—	—	*180*	*195*	*230*	*145*	*165*	*195*	*100*	*120*	*130*
S13	—	—	—	—	—	—	32	36	41	26	30	34	18	21	24
	—	—	—	—	—	—	*105*	*120*	*135*	*85*	*100*	*110*	*60*	*70*	*75*
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

QUATTROMILL 09/12/15

QuattroMill™ is more than a general-purpose face mill. It is a simple solution with more teeth per cutter that increases productivity, ease of use, reliability and precision for the full range of face milling applications and materials.

- Insert size 09, cutter range 20-315mm (0.75-12.5 inch)
- Insert size 12, cutter range 40-315mm (1.5-12.5 inch)
- Insert size 15, cutter range 63-315mm (2.5-12.5 inch)

Quattromill R217.53-09 – Metric



- For insert selection and cutting data recommendations, see page(s) 240-242
- For complete insert programme, see page(s) 753
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DMM	OAL	LS	Weight	RPMX	Insert
			mm		mm		mm	mm	mm	mm	kg		
R217.53-2020.3S-09-2A	02422248	Seco-Weldon	20,0	2	4,5	45,0	30,0	20,0	90,0	50,0	0,3	25100	SE.X09T3
R217.53-2025.3S-09-3A	02422250	Seco-Weldon	25,0	3	4,5	45,0	35,0	20,0	90,0	50,0	0,4	22400	SE.X09T3
R217.53-2032.3S-09-4A	02422251	Seco-Weldon	32,0	4	4,5	45,0	42,0	20,0	90,0	50,0	0,4	19800	SE.X09T3

Spare Parts

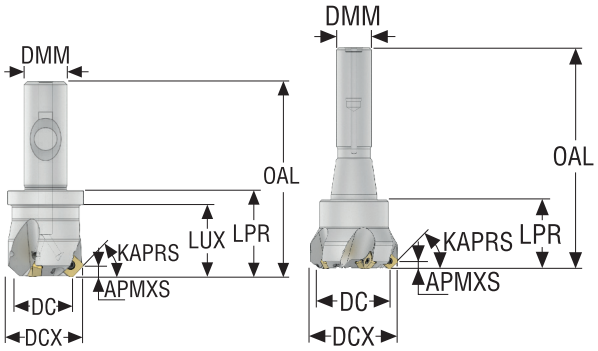
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.53..	C03008-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Quattromill R217.53-09 – Inch



- For insert selection and cutting data recommendations, see page(s) 240-242
- For complete insert programme, see page(s) 753
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DMM	OAL	LS	Weight	RPMX	Insert
			Inch		Inch		Inch	Inch	Inch	Inch	lbs		
R217.53-00.75.3S-09-2A	02422259	Seco-Weldon	0.787	2	0.177	45.0	1.181	0.750	3.543	1.969	0.880	25100	SE.X09T3
R217.53-01.00.3S-09-3A	02422260	Seco-Weldon	0.984	3	0.177	45.0	1.378	0.750	3.543	1.969	0.880	22400	SE.X09T3
R217.53-01.25.3S-09-4A	02422261	Seco-Weldon	1.260	4	0.177	45.0	1.654	0.750	3.543	1.969	1.100	19800	SE.X09T3
R217.53-02.00.R8-09-5	02422262	Bridgeport R8	1.575	5	0.180	45.0	1.969	0.949	6.024	4.000	2.430	15800	SE.X09T3

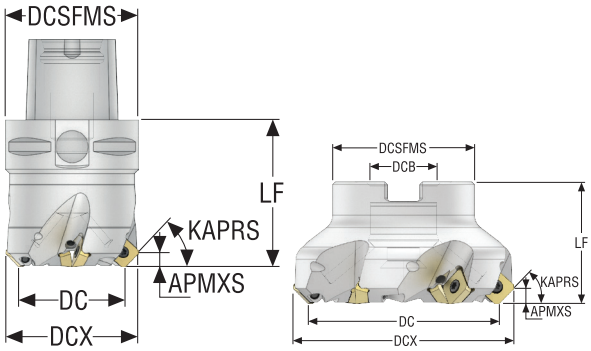
Spare Parts

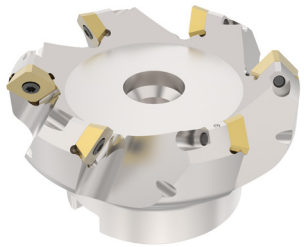
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.53-..	C03008-T09P	T00-09P20	17.7IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Quattromill R220.53-09 – Metric





- For insert selection and cutting data recommendations, see page(s) 240-242
- For complete insert programme, see page(s) 753
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
C5-R217.53-040-09-4A	02745046	Seco-Capto	40,0	4	4,5	45,0	50,0	–	50,0	55,0	17700	0,8	SE.X09T3
R220.53-0032-09-4A	02422230	Arbor	32,0	4	4,5	45,0	42,0	16,0	35,0	40,0	19800	0,3	SE.X09T3
R220.53-0040-09-4A	02422231	Arbor	40,0	4	4,5	45,0	50,0	22,0	47,0	40,0	17700	0,4	SE.X09T3
R220.53-0040-09-5A	02422161	Arbor	40,0	5	4,5	45,0	50,0	22,0	42,0	40,0	17700	0,4	SE.X09T3
R220.53-0050-09-5A	02422232	Arbor	50,0	5	4,5	45,0	60,0	22,0	47,0	40,0	15800	0,5	SE.X09T3
R220.53-0050-09-6A	02422162	Arbor	50,0	6	4,5	45,0	60,0	22,0	42,0	40,0	15800	0,5	SE.X09T3
R220.53-0063-09-6A	02422233	Arbor	63,0	6	4,5	45,0	73,0	22,0	47,0	40,0	14100	0,6	SE.X09T3
R220.53-0063-09-7A	02422163	Arbor	63,0	7	4,5	45,0	73,0	22,0	47,0	40,0	14100	0,6	SE.X09T3
R220.53-0080-09-6A	02422234	Arbor	80,0	6	4,5	45,0	90,0	27,0	62,0	50,0	12500	1,2	SE.X09T3
R220.53-0080-09-8A	02422164	Arbor	80,0	8	4,5	45,0	90,0	27,0	62,0	50,0	12500	1,2	SE.X09T3
R220.53-0100-09-7A	02422235	Arbor	100,0	7	4,5	45,0	110,0	32,0	77,0	50,0	11200	1,8	SE.X09T3
R220.53-0100-09-10A	02422165	Arbor	100,0	10	4,5	45,0	110,0	32,0	77,0	50,0	11200	1,8	SE.X09T3

Spare Parts

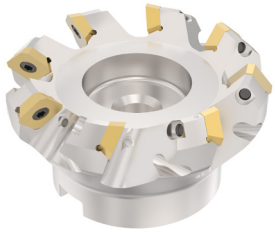
Accessories

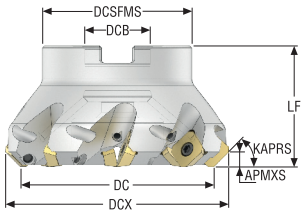
For cutter	Arbor screw	Insert screw	Torque key	Torque value
C5-R217.53-..	–	C03008-T09P	T00-09P20	2.0NM
R220.53-0032	220.17-690	C03008-T09P	T00-09P20	2.0NM
R220.53-0040-0063	220.17-696	C03008-T09P	T00-09P20	2.0NM
R220.53-0080-0100	–	C03008-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Quattromill R220.53-09 – Inch





- For insert selection and cutting data recommendations, see page(s) 240-242
- For complete insert programme, see page(s) 753
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.53-01.50-09-4A	02422254	Arbor	1.575	4	0.180	45,0	1.969	0.750	1.850	1.575	17700	1.100	SE.X09T3
R220.53-02.00-09-5A	02422255	Arbor	1.969	5	0.180	45,0	2.362	0.750	1.850	1.575	15800	1.320	SE.X09T3
R220.53-02.50-09-6A	02422256	Arbor	2.480	6	0.180	45,0	2.874	0.750	1.850	1.575	14100	1.540	SE.X09T3
R220.53-03.00-09-6A	02422257	Arbor	3.150	6	0.180	45,0	3.543	1.000	2.441	1.969	12500	3.530	SE.X09T3

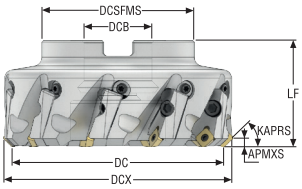
Spare Parts

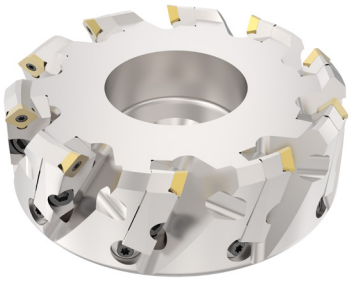
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.53-01.50	220.17-698	C03008-T09P	T00-09P20	17.7IN.LBS
R220.53-02.00	220.17-698	C03008-T09P	T00-09P20	17.7IN.LBS
R220.53-02.50	220.17-698	C03008-T09P	T00-09P20	17.7IN.LBS
R220.53-03.00	UC6S1/2UNFX1-1/4	C03008-T09P	T00-09P20	17.7IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Quattromill R220.53-09C – Metric



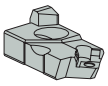
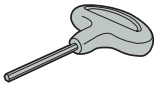


- For insert selection and cutting data recommendations, see page(s) 240-242
- For complete insert programme, see page(s) 753
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.53-0080-09-5C	02510157	Arbor	80,0	5	4,5	45,0	90,0	27,0	62,0	50,0	7400	1,7	SE.X09T3
R220.53-0080-09-6C	02510183	Arbor	80,0	6	4,5	45,0	90,0	27,0	62,0	50,0	7400	1,7	SE.X09T3
R220.53-0100-09-6C	02510181	Arbor	100,0	6	4,5	45,0	110,0	32,0	77,0	50,0	6600	2,5	SE.X09T3
R220.53-0100-09-8C	02510185	Arbor	100,0	8	4,5	45,0	110,0	32,0	77,0	50,0	6600	2,6	SE.X09T3
R220.53-0125-09-8C	02510182	Arbor	125,0	8	4,5	45,0	135,0	40,0	90,0	63,0	5900	4,2	SE.X09T3
R220.53-0125-09-10C	02510190	Arbor	125,0	10	4,5	45,0	135,0	40,0	90,0	63,0	5900	4,2	SE.X09T3
R220.53-8160-09-10C	02510158	Arbor	160,0	10	4,5	45,0	170,0	40,0	90,0	63,0	5200	6,6	SE.X09T3
R220.53-8160-09-14C	02510228	Arbor	160,0	14	4,5	45,0	170,0	40,0	90,0	63,0	5200	6,6	SE.X09T3
R220.53-8200-09-8C	02510192	Arbor	200,0	8	4,5	45,0	210,0	60,0	130,0	63,0	4700	9,4	SE.X09T3
R220.53-8250-09-10C	02510229	Arbor	250,0	10	4,5	45,0	260,0	60,0	130,0	63,0	4200	17,1	SE.X09T3
R220.53-8250-09-16C	02510226	Arbor	250,0	16	4,5	45,0	260,0	60,0	130,0	63,0	4200	17,2	SE.X09T3
R220.53-8315-09-12C	02510230	Arbor	315,0	12	4,5	45,0	325,0	60,0	225,0	80,0	3700	32,6	SE.X09T3

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Setting gauge	Key	Torque key	Torque value
							
R220.53-09C	SE09AR-53	FS96018	C03008-T09P	AU1114T-T15P	H04-4	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.53-09 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SEMX09T3AFTN-ME06 T350M	2,5 *0.10*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
P2	SEMX09T3AFTN-ME06 T350M	2,5 *0.10*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*
P3	SEMX09T3AFTN-M08 MP2501	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
P4	SEMX09T3AFTN-M08 MP2501	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
P5	SEMX09T3AFTN-M08 MP2501	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
P6	SEMX09T3AFTN-M08 MP2501	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
P7	SEMX09T3AFTN-M08 T350M	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
P8	SEMX09T3AFTN-M08 T350M	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
P11	SEEX09T3AFTN-M08 T350M	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
P12	SEEX09T3AFTN-M08 T350M	2,0 *0.080*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
M1	SEEX09T3AFN-M05 F40M	2,5 *0.10*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
M2	SEEX09T3AFN-M05 F40M	2,5 *0.10*	0,090 *0.0036*	0,095 *0.0038*	0,12 *0.0048*
M3	SEEX09T3AFN-M05 MS2050	2,0 *0.080*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
M4	SEEX09T3AFTN-ME07 T350M	1,6 *0.065*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
M5	SEEX09T3AFTN-ME07 T350M	1,6 *0.065*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K1	SEEX09T3AFTN-M08 MK1500	2,5 *0.10*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
K2	SEEX09T3AFTN-M08 MK1500	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
K3	SEEX09T3AFTN-M08 MK2050	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
K4	SEEX09T3AFTN-M08 MK2050	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
K5	SEEX09T3AFTN-M08 MK2050	2,5 *0.10*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
K6	SEEX09T3AFTN-M08 MK2050	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
K7	SEEX09T3AFTN-M08 MK2050	2,5 *0.10*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
N1	SEEX09T3AFN-E04 H15	2,5 *0.10*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*
N2	SEEX09T3AFN-E04 H15	2,5 *0.10*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*
N3	SEEX09T3AFN-E04 H15	2,5 *0.10*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*
N11	SEEX09T3AFN-E04 H15	2,5 *0.10*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*
S1	SEEX09T3AFTN-ME07 T350M	1,6 *0.065*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
S2	SEEX09T3AFTN-ME07 T350M	1,6 *0.065*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
S3	SEEX09T3AFTN-ME07 T350M	1,6 *0.065*	0,085 *0.0034*	0,085 *0.0034*	0,11 *0.0044*
S11	SEEX09T3AFN-M05 MS2050	1,9 *0.075*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
S12	SEEX09T3AFN-M05 MS2050	1,9 *0.075*	0,075 *0.0030*	0,075 *0.0030*	0,095 *0.0038*
S13	SEEX09T3AFN-M05 MS2050	1,6 *0.065*	0,065 *0.0026*	0,065 *0.0026*	0,080 *0.0032*
H5	SEEX09T3AFTN-D09 MP1501	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*
H8	SEEX09T3AFTN-D09 MP1501	1,9 *0.075*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*
H11	SEEX09T3AFTN-D09 MP1501	2,0 *0.080*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*
H12	SEEX09T3AFTN-D09 MP1501	1,9 *0.075*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*
H21	SEEX09T3AFTN-D09 MP1501	1,9 *0.075*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

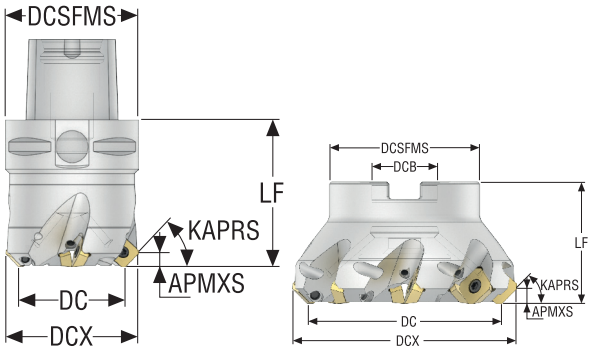
R217/220.53-09 – Cutting data v_c = (m/min)/*(sf/min)*

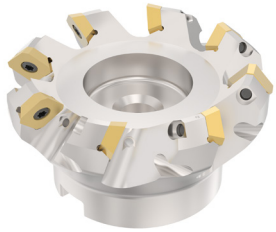
SMG	F40M			MP1501			MP2501			MP3000			T350M			F30M			T25M		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	240	280	315	350	405	455	320	370	415	340	390	435	280	320	360	285	330	365	265	305	345
	790	*920*	*1025*	*1150*	*1325*	*1500*	*1050*	*1225*	*1350*	*1125*	*1275*	*1425*	*920*	*1050*	*1175*	*940*	*1075*	*1200*	*870*	*1000*	*1125*
P2	235	270	305	340	385	445	310	355	405	335	380	425	270	310	350	280	320	355	260	295	335
	770	*890*	*1000*	*1125*	*1275*	*1450*	*1025*	*1175*	*1325*	*1100*	*1250*	*1400*	*890*	*1025*	*1150*	*920*	*1050*	*1175*	*850*	*970*	*1100*
P3	205	235	265	295	340	385	270	310	350	290	330	370	235	270	305	245	275	315	225	255	295
	670	*770*	*870*	*970*	*1125*	*1275*	*890*	*1025*	*1150*	*950*	*1075*	*1225*	*770*	*890*	*1000*	*800*	*900*	*1025*	*740*	*840*	*970*
P4	180	210	235	260	300	335	240	275	310	255	295	330	210	240	270	215	245	275	200	230	260
	590	*690*	*770*	*850*	*980*	*1100*	*790*	*900*	*1025*	*840*	*970*	*1075*	*690*	*790*	*890*	*710*	*800*	*900*	*660*	*750*	*850*
P5	175	200	225	250	290	330	230	265	295	245	280	315	200	230	260	210	235	265	190	220	245
	570	*660*	*740*	*820*	*950*	*1075*	*750*	*870*	*970*	*800*	*920*	*1025*	*660*	*750*	*850*	*690*	*770*	*870*	*620*	*720*	*800*
P6	195	225	255	285	325	370	255	295	335	275	315	360	225	260	295	235	265	300	215	245	280
	640	*740*	*840*	*940*	*1075*	*1225*	*840*	*970*	*1100*	*900*	*1025*	*1175*	*740*	*850*	*970*	*770*	*870*	*980*	*710*	*800*	*920*
P7	185	210	240	270	305	350	240	280	320	260	295	340	210	245	275	220	250	285	200	235	265
	610	*690*	*790*	*890*	*1000*	*1150*	*790*	*920*	*1050*	*850*	*970*	*1125*	*690*	*800*	*900*	*720*	*820*	*940*	*660*	*770*	*870*
P8	175	195	225	250	285	320	230	260	295	245	275	315	200	225	260	205	230	265	190	215	245
	570	*640*	*740*	*820*	*940*	*1050*	*750*	*850*	*970*	*800*	*900*	*1025*	*660*	*740*	*850*	*670*	*750*	*870*	*620*	*710*	*800*
P11	180	205	235	260	295	340	235	270	310	255	290	330	205	235	270	215	240	275	195	225	260
	590	*670*	*770*	*850*	*970*	*1125*	*770*	*890*	*1025*	*840*	*950*	*1075*	*670*	*770*	*890*	*710*	*790*	*900*	*640*	*740*	*850*
P12	115	135	150	170	190	220	155	175	195	160	185	205	135	155	170	135	155	175	130	145	165
	375	*445*	*490*	*560*	*620*	*720*	*510*	*570*	*640*	*520*	*610*	*670*	*445*	*510*	*560*	*445*	*510*	*570*	*425*	*475*	*540*
M1	190	215	245	—	—	—	225	255	290	250	285	320	210	235	270	225	260	290	210	235	270
	620	*710*	*800*	—	—	—	*740*	*840*	*950*	*820*	*940*	*1050*	*690*	*770*	*890*	*740*	*850*	*950*	*690*	*770*	*890*
M2	155	180	200	—	—	—	185	215	240	205	235	260	170	200	220	185	210	235	170	200	220
	510	*590*	*660*	—	—	—	*610*	*710*	*790*	*670*	*770*	*850*	*560*	*660*	*720*	*610*	*690*	*770*	*560*	*660*	*720*
M3	125	145	165	—	—	—	150	170	195	165	185	210	140	160	180	150	170	190	140	160	180
	410	*475*	*540*	—	—	—	*490*	*560*	*620*	*540*	*610*	*690*	*460*	*520*	*590*	*490*	*560*	*620*	*460*	*520*	*590*
M4	100	110	125	—	—	—	115	130	150	125	145	160	110	120	140	115	130	145	110	120	140
	330	*360*	*410*	—	—	—	*375*	*425*	*490*	*410*	*475*	*520*	*360*	*395*	*460*	*375*	*425*	*475*	*360*	*395*	*460*
M5	80	90	105	—	—	—	95	110	125	105	120	135	90	100	115	95	110	120	90	100	115
	260	*295*	*345*	—	—	—	*310*	*360*	*410*	*345*	*395*	*445*	*295*	*330*	*375*	*310*	*360*	*395*	*295*	*330*	*375*
K1	185	210	245	270	305	350	245	280	320	265	305	335	215	245	280	220	255	285	205	235	265
	610	*690*	*800*	*890*	*1000*	*1150*	*800*	*920*	*1050*	*870*	*1000*	*1100*	*710*	*800*	*920*	*720*	*840*	*940*	*670*	*770*	*870*
K2	165	190	215	235	275	315	215	250	280	235	265	295	190	220	245	195	225	250	180	210	235
	540	*620*	*710*	*770*	*900*	*1025*	*710*	*820*	*920*	*770*	*870*	*970*	*620*	*720*	*800*	*640*	*740*	*820*	*590*	*690*	*770*
K3	140	160	180	200	230	265	185	210	240	200	225	250	160	185	205	165	190	210	155	175	200
	460	*520*	*590*	*660*	*750*	*870*	*610*	*690*	*790*	*660*	*740*	*820*	*520*	*610*	*670*	*540*	*620*	*690*	*510*	*570*	*660*
K4	135	155	170	190	220	255	175	205	225	190	215	240	155	175	200	160	180	200	145	170	190
	445	*510*	*560*	*620*	*720*	*840*	*570*	*670*	*740*	*620*	*710*	*790*	*510*	*570*	*660*	*520*	*590*	*660*	*475*	*560*	*620*
K5	80	95	105	120	135	155	110	125	140	115	130	150	95	105	120	95	110	125	90	100	115
	260	*310*	*345*	*395*	*445*	*510*	*360*	*410*	*460*	*375*	*425*	*490*	*310*	*345*	*395*	*310*	*360*	*410*	*295*	*330*	*375*
K6	115	135	150	170	195	225	155	180	200	165	190	210	135	155	175	140	160	180	130	150	165
	375	*445*	*490*	*560*	*640*	*740*	*510*	*590*	*660*	*540*	*620*	*690*	*445*	*510*	*570*	*460*	*520*	*590*	*425*	*490*	*540*
K7	105	120	135	150	175	195	140	155	180	145	165	190	120	135	155	125	140	160	115	130	150
	345	*395*	*445*	*490*	*570*	*640*	*460*	*510*	*590*	*475*	*540*	*620*	*395*	*445*	*510*	*410*	*460*	*520*	*375*	*425*	*490*
N1	1375	1550	1800	—	—	—	—	—	—	1950	2250	2550	—	—	—	1650	1900	2125	—	—	—
	4500	*5075*	*5900*	—	—	—	—	—	—	*6400*	*7375*	*8375*	—	—	—	*5425*	*6225*	*6975*	—	—	—
N2	560	630	720	—	—	—	—	—	—	790	910	1025	—	—	—	660	760	860	—	—	—
	1825	*2075*	*2350*	—	—	—	—	—	—	*2600*	*2975*	*3375*	—	—	—	*2175*	*2500*	*2825*	—	—	—
N3	370	420	480	—	—	—	—	—	—	530	610	680	—	—	—	440	510	570	—	—	—
	1225	*1375*	*1575*	—	—	—	—	—	—	*1750*	*2000*	*2225*	—	—	—	*1450*	*1675*	*1875*	—	—	—
N11	425	480	550	—	—	—	—	—	—	600	690	780	—	—	—	500	580	660	—	—	—
	1400	*1575*	*1800*	—	—	—	—	—	—	*1975*	*2275*	*2550*	—	—	—	*1650*	*1900*	*2175*	—	—	—
S1	46	50	60	—	—	—	55	65	75	60	65	75	50	55	65	55	60	70	—	—	—
	150	*165*	*195*	—	—	—	*180*	*215*	*230*	*195*	*215*	*245*	*165*	*180*	*215*	*180*	*195*	*230*	—	—	—
S2	37	42	48	—	—	—	46	50	60	47	55	60	41	46	50	43	49	55	—	—	—
	120	*140*	*155*	—	—	—	*150*	*165*	*195*	*155*	*180*	*195*	*135*	*150*	*165*	*140*	*160*	*180*	—	—	—
S3	32	37	42	—	—	—	40	45	50	42	47	55	36	40	46	38	43	48	—	—	—
	105	*120*	*135*	—	—	—	*130*	*150*	*165*	*140*	*155*	*180*	*120*	*130*	*150*	*125*	*140*	*155*	—	—	—
S11	65	75	80	—	—	—	80	90	100	85	95	105	70	80	90	75	85	95	—	—	—
	215	*245*	*260*	—	—	—	*260*	*295*	*330*	*280*	*310*	*345*	*230*	*260*	*295*	*245*	*280*	*310*	—	—	—
S12	44	50	55	—	—	—	55	60	70	55	65	75	48	55	65	43	49	55	—	—	—
	145	*165*	*180*	—	—	—	*180*	*195*	*230*	*180*	*215*	*245*	*155*	*180*	*215*	*140*	*160*	*180*	—	—	—
S13	26	29	33	—	—	—	32	36	41	33	38	43	28	32	37	25	28	32	—	—	—
	85	*95*	*110*	—	—	—	*105*	*120*	*135*	*110*	*125*	*140*	*90*	*105*	*120*	*80*	*90*	*105*	—	—	—
H5	39	44	50	55	65	75	46	55	60	50	55	65	45	50	55	45	50	60	—	—	—
	130	*145*	*160*	*180*	*215*	*230*	*150*	*180*	*195*	*165*	*180*	*215*	*150*	*165*	*180*	*150*	*165*	*180*	—	—	—
H8	41	47	55	60	70	75	50	55	65	55	60	65	48	55	60	48	55	60	—	—	—
	135	*155*	*180*	*195*	*230*	*245*	*165*	*180*	*215*	*180*	*195*	*215*	*155*	*180*	*195*	*155*	*180*	*195*	—	—	—
H11	49	55	65	70	80	95	60	70	75	65	70	80	55	65	75	55	65	75	—	—	—
	160	*180*	*215*	*230*	*260*	*295*	*195*	*230*	*245*	*215*	*230*	*260*	*180*	*215*	*230*	*180*	*215*	*245*	—	—	—
H12	75	85	95	110	120	140	100	110	125	100	115	130	85	95	110	85	95	110	—	—	—
	245	*280*	*310*	*360*	*395*	*445*	*330*	*360*	*410*	*330*	*375*	*425*	*280*	*310*	*360*	*280*	*310*	*360*	—	—	—
H21	41	47	55	60	70	75	50	55	65	55	60	65	48	55	60	48	55	60	—	—	—
	135	*155*	*180*	*195*	*230*	*245*	*165*	*180*	*215*	*180*	*195*	*215*	*155*	*180*	*195*	*155*	*180*	*195*	—	—	—

R217/220.53-09 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			F15M			H15			MS2050			MM4500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	315	365	410	—	—	—	—	—	—	300	345	385	195	225	255
	—	—	—	*1025*	*1200*	*1350*	—	—	—	—	—	—	*980*	*1125*	*1275*	*640*	*740*	*840*
P2	—	—	—	305	350	400	—	—	—	—	—	—	295	335	375	190	215	250
	—	—	—	*1000*	*1150*	*1300*	—	—	—	—	—	—	*970*	*1100*	*1225*	*620*	*710*	*820*
P3	—	—	—	270	305	345	—	—	—	—	—	—	255	290	330	165	190	215
	—	—	—	*890*	*1000*	*1125*	—	—	—	—	—	—	*840*	*950*	*1075*	*540*	*620*	*710*
P4	—	—	—	235	270	305	—	—	—	—	—	—	225	260	290	145	170	190
	—	—	—	*770*	*890*	*1000*	—	—	—	—	—	—	*740*	*850*	*950*	*475*	*560*	*620*
P5	—	—	—	225	260	290	—	—	—	—	—	—	215	245	275	140	160	180
	—	—	—	*740*	*850*	*950*	—	—	—	—	—	—	*710*	*800*	*900*	*460*	*520*	*590*
P6	—	—	—	255	290	330	—	—	—	—	—	—	245	275	315	160	180	205
	—	—	—	*840*	*950*	*1075*	—	—	—	—	—	—	*800*	*900*	*1025*	*520*	*590*	*670*
P7	—	—	—	240	275	315	—	—	—	—	—	—	230	260	295	150	170	195
	—	—	—	*790*	*900*	*1025*	—	—	—	—	—	—	*750*	*850*	*970*	*490*	*560*	*640*
P8	—	—	—	225	255	290	—	—	—	—	—	—	215	245	275	140	160	180
	—	—	—	*740*	*840*	*950*	—	—	—	—	—	—	*710*	*800*	*900*	*460*	*520*	*590*
P11	—	—	—	230	270	305	—	—	—	—	—	—	225	255	290	145	165	190
	—	—	—	*750*	*890*	*1000*	—	—	—	—	—	—	*740*	*840*	*950*	*475*	*540*	*620*
P12	—	—	—	150	175	195	—	—	—	—	—	—	140	160	180	95	110	120
	—	—	—	*490*	*570*	*640*	—	—	—	—	—	—	*460*	*520*	*590*	*310*	*360*	*395*
M1	—	—	—	—	—	—	—	—	—	—	—	—	235	270	300	165	185	215
	—	—	—	—	—	—	—	—	—	—	—	—	*770*	*890*	*980*	*540*	*610*	*710*
M2	—	—	—	—	—	—	—	—	—	—	—	—	195	220	250	135	155	175
	—	—	—	—	—	—	—	—	—	—	—	—	*640*	*720*	*820*	*445*	*510*	*570*
M3	—	—	—	—	—	—	—	—	—	—	—	—	155	175	200	110	125	140
	—	—	—	—	—	—	—	—	—	—	—	—	*510*	*570*	*660*	*360*	*410*	*460*
M4	—	—	—	—	—	—	—	—	—	—	—	—	120	135	155	85	95	110
	—	—	—	—	—	—	—	—	—	—	—	—	*395*	*445*	*510*	*280*	*310*	*360*
M5	—	—	—	—	—	—	—	—	—	—	—	—	100	115	130	70	80	90
	—	—	—	—	—	—	—	—	—	—	—	—	*330*	*375*	*410*	*230*	*260*	*295*
K1	350	395	455	330	375	430	315	355	400	—	—	—	—	—	—	—	—	—
	1150	*1300*	*1500*	*1075*	*1225*	*1400*	*1025*	*1175*	*1300*	—	—	—	—	—	—	—	—	—
K2	310	355	400	290	335	375	275	315	350	—	—	—	—	—	—	—	—	—
	1025	*1175*	*1300*	*950*	*1100*	*1225*	*900*	*1025*	*1150*	—	—	—	—	—	—	—	—	—
K3	260	300	335	245	285	320	235	265	300	—	—	—	—	—	—	—	—	—
	850	*980*	*1100*	*800*	*940*	*1050*	*770*	*870*	*980*	—	—	—	—	—	—	—	—	—
K4	250	285	320	235	270	305	225	255	285	—	—	—	—	—	—	—	—	—
	820	*940*	*1050*	*770*	*890*	*1000*	*740*	*840*	*940*	—	—	—	—	—	—	—	—	—
K5	155	175	195	145	165	185	135	155	175	—	—	—	—	—	—	—	—	—
	510	*570*	*640*	*475*	*540*	*610*	*445*	*510*	*570*	—	—	—	—	—	—	—	—	—
K6	220	255	285	205	240	270	195	225	250	—	—	—	—	—	—	—	—	—
	720	*840*	*940*	*670*	*790*	*890*	*640*	*740*	*820*	—	—	—	—	—	—	—	—	—
K7	195	225	250	185	210	240	175	195	220	—	—	—	—	—	—	—	—	—
	640	*740*	*820*	*610*	*690*	*790*	*570*	*640*	*720*	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	2350	2650	3000	1875	2100	2375	—	—	—	—	—	—
	—	—	—	—	—	—	*7700*	*8700*	*9850*	*6150*	*6900*	*7800*	—	—	—	—	—	—
N2	—	—	—	—	—	—	950	1075	1225	750	850	960	—	—	—	—	—	—
	—	—	—	—	—	—	*3125*	*3525*	*4025*	*2450*	*2800*	*3150*	—	—	—	—	—	—
N3	—	—	—	—	—	—	630	710	810	500	560	640	—	—	—	—	—	—
	—	—	—	—	—	—	*2075*	*2325*	*2650*	*1650*	*1825*	*2100*	—	—	—	—	—	—
N11	—	—	—	—	—	—	730	810	930	570	640	730	—	—	—	—	—	—
	—	—	—	—	—	—	*2400*	*2650*	*3050*	*1875*	*2100*	*2400*	—	—	—	—	—	—
S1	—	—	—	—	—	—	—	—	—	—	—	—	55	65	70	26	29	33
	—	—	—	—	—	—	—	—	—	—	—	—	*180*	*215*	*230*	*85*	*95*	*110*
S2	—	—	—	—	—	—	—	—	—	—	—	—	45	50	60	21	24	27
	—	—	—	—	—	—	—	—	—	—	—	—	*150*	*165*	*180*	*70*	*80*	*90*
S3	—	—	—	—	—	—	—	—	—	—	—	—	39	45	50	18	21	24
	—	—	—	—	—	—	—	—	—	—	—	—	*130*	*150*	*165*	*60*	*70*	*75*
S11	—	—	—	—	—	—	—	—	—	—	—	—	80	90	100	36	41	47
	—	—	—	—	—	—	—	—	—	—	—	—	*260*	*295*	*330*	*120*	*135*	*150*
S12	—	—	—	—	—	—	—	—	—	—	—	—	55	60	70	33	38	43
	—	—	—	—	—	—	—	—	—	—	—	—	*180*	*195*	*230*	*110*	*125*	*140*
S13	—	—	—	—	—	—	—	—	—	—	—	—	31	36	40	20	22	25
	—	—	—	—	—	—	—	—	—	—	—	—	*100*	*120*	*130*	*65*	*70*	*80*
H3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H7	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

Quattromill R217/220.53-12 – Metric





- For insert selection and cutting data recommendations, see page(s) 247-249
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
C5-R217.53-040-12-3A	02745057	Seco-Capto	40,0	3	6,0	45,0	52,0	–	50,0	55,0	16500	0,8	SE.X1204
C6-R217.53-040-12-3A	02745061	Seco-Capto	40,0	3	6,0	45,0	52,0	–	63,0	63,0	16500	1,2	SE.X1204
C5-R217.53-050-12-4A	02745058	Seco-Capto	50,0	4	6,0	45,0	62,0	–	50,0	55,0	14800	0,9	SE.X1204
C6-R217.53-050-12-4A	02745062	Seco-Capto	50,0	4	6,0	45,0	62,0	–	63,0	63,0	14800	1,3	SE.X1204
C5-R217.53-063-12-5A	02745059	Seco-Capto	63,0	5	6,0	45,0	75,0	–	50,0	55,0	13200	1,1	SE.X1204
C6-R217.53-063-12-5A	02745063	Seco-Capto	63,0	5	6,0	45,0	75,0	–	63,0	63,0	13200	1,6	SE.X1204
C5-R217.53-080-12-6A	02745060	Seco-Capto	80,0	6	6,0	45,0	92,0	–	50,0	55,0	11700	1,2	SE.X1204
C6-R217.53-080-12-6A	02745064	Seco-Capto	80,0	6	6,0	45,0	92,0	–	63,0	63,0	11700	1,9	SE.X1204
R220.53-0040-12-3A	02410703	Arbor	40,0	3	6,0	45,0	52,0	22,0	47,0	40,0	16500	0,4	SE.X1204
R220.53-0040-12-4A	02410704	Arbor	40,0	4	6,0	45,0	52,0	22,0	47,0	40,0	16500	0,4	SE.X1204
R220.53-0050-12-4A	00040081	Arbor	50,0	4	6,0	45,0	62,0	22,0	47,0	40,0	14800	0,5	SE.X1204
R220.53-0050-12-5A	00040082	Arbor	50,0	5	6,0	45,0	62,0	22,0	47,0	40,0	14800	0,4	SE.X1204
R220.53-0063-12-5A	00040083	Arbor	63,0	5	6,0	45,0	75,0	22,0	47,0	40,0	13200	0,6	SE.X1204
R220.53-0063-12-6A	00040084	Arbor	63,0	6	6,0	45,0	75,0	22,0	47,0	40,0	13200	0,6	SE.X1204
R220.53-0080-12-6A	00040085	Arbor	80,0	6	6,0	45,0	92,0	27,0	62,0	50,0	11700	1,1	SE.X1204
R220.53-0080-12-8A	00040086	Arbor	80,0	8	6,0	45,0	92,0	27,0	62,0	50,0	11700	1,1	SE.X1204
R220.53-0100-12-5A	02448963	Arbor	100,0	5	6,0	45,0	112,0	32,0	77,0	50,0	10500	1,8	SE.X1204
R220.53-0100-12-7A	00040087	Arbor	100,0	7	6,0	45,0	112,0	32,0	77,0	50,0	10500	1,8	SE.X1204
R220.53-0100-12-10A	00040088	Arbor	100,0	10	6,0	45,0	112,0	32,0	77,0	50,0	10500	1,7	SE.X1204
R220.53-0125-12-6A	02448964	Arbor	125,0	6	6,0	45,0	137,0	40,0	90,0	63,0	9400	3,1	SE.X1204
R220.53-0125-12-8A	00040089	Arbor	125,0	8	6,0	45,0	137,0	40,0	90,0	63,0	9400	3,1	SE.X1204
R220.53-0125-12-12A	00040090	Arbor	125,0	12	6,0	45,0	137,0	40,0	90,0	63,0	9400	3,1	SE.X1204
R220.53-8160-12-7	02448965	Arbor	160,0	7	6,0	45,0	172,0	40,0	90,0	63,0	8300	4,6	SE.X1204
R220.53-8160-12-10	00040091	Arbor	160,0	10	6,0	45,0	172,0	40,0	90,0	63,0	8300	4,6	SE.X1204

Spare Parts

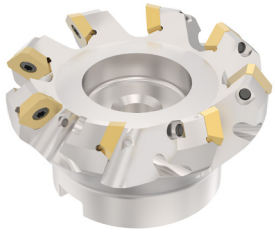
Accessories

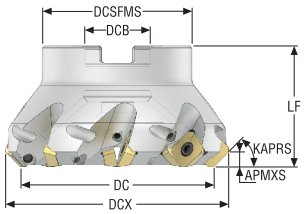
For cutter	Arbor screw	Insert screw	Torque key	Torque value
Cx-R217.53-12	–	C04011-T15P	T00-15P35	3.5NM
R220.53-0040-0063	220.17-696	C04011-T15P	T00-15P35	3.5NM
R220.53-0080-8160	–	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Quattromill R220.53-12 – Metric

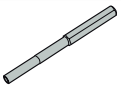




- For insert selection and cutting data recommendations, see page(s) 247-249
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

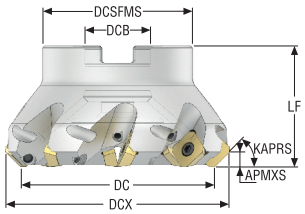
Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.53-0063-12-9A	02997159	Arbor	63,0	9	6,0	43,87	75,0	22,0	47,0	40,0	13200	0,6	SE.X1204
R220.53-0080-12-11A	02997160	Arbor	80,0	11	6,0	43,87	92,0	27,0	62,0	50,0	11700	1,1	SE.X1204
R220.53-0100-12-12A	02997161	Arbor	100,0	12	6,0	43,87	112,0	32,0	77,0	50,0	10500	1,7	SE.X1204
R220.53-0125-12-14A	02997162	Arbor	125,0	14	6,0	43,87	137,0	40,0	90,0	63,0	9400	3,1	SE.X1204
R220.53-8160-12-17	02997163	Arbor	160,0	17	6,0	43,87	172,0	40,0	130,0	63,0	8300	5,3	SE.X1204
R220.53-8200-12-20	02997164	Arbor	200,0	20	6,0	43,87	212,0	60,0	160,0	63,0	7400	7,2	SE.X1204

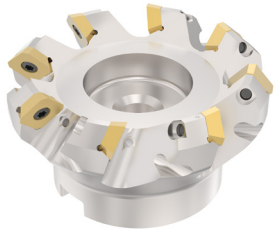
Spare Parts

For cutter	Back insert key	Front insert key	Insert screw
			
R220.53-0063-8200	H6B-H3.0	T15P-E8	C04008-H3

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Quattromill R217/220.53-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 247-249
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.53-01.50-12-4A	02422139	Arbor	1.575	4	0.236	45.0	2.047	0.750	1.850	1.575	16500	1.100	SE.X1204
R220.53-02.00-12-4A	02422140	Arbor	1.969	4	0.236	45.0	2.441	0.750	1.850	1.575	14800	1.320	SE.X1204
R220.53-02.00-12-5A	02422141	Arbor	1.969	5	0.236	45.0	2.441	0.750	1.850	1.575	14800	1.320	SE.X1204
R220.53-02.50-12-5A	02422142	Arbor	2.480	5	0.236	45.0	2.953	0.750	1.850	1.575	13200	1.320	SE.X1204
R220.53-02.50-12-6A	02422143	Arbor	2.480	6	0.236	45.0	2.953	0.750	1.850	1.575	13200	1.320	SE.X1204
R220.53-03.00-12-6A	02422144	Arbor	3.150	6	0.236	45.0	3.622	1.000	2.441	1.969	11700	3.310	SE.X1204
R220.53-03.00-12-8A	02422145	Arbor	3.150	8	0.236	45.0	3.622	1.000	2.441	1.969	11700	3.310	SE.X1204
R220.53-04.00-12-7A	02422146	Arbor	3.937	7	0.236	45.0	4.409	1.500	3.543	1.969	10500	5.070	SE.X1204
R220.53-04.00-12-10A	02422147	Arbor	3.937	10	0.236	45.0	4.409	1.500	3.543	1.969	10500	4.850	SE.X1204
R220.53-04.00-12-12A	02997166	Arbor	3.937	12	0.236	43.87	4.409	1.500	3.031	1.969	10500	3.750	SE.X1204
R220.53-05.00-12-6A	02449819	Arbor	4.921	6	0.236	45.0	5.394	1.500	3.543	2.480	9400	8.380	SE.X1204
R220.53-05.00-12-8A	02422148	Arbor	4.921	8	0.236	45.0	5.394	1.500	3.543	2.480	9400	8.380	SE.X1204
R220.53-06.00-12-10	02422150	Arbor	6.299	10	0.236	45.0	6.772	2.000	3.543	2.480	8300	10.800	SE.X1204
R220.53-06.00-12-7	02449820	Arbor	6.299	7	0.236	45.0	6.772	2.000	3.543	2.480	8300	10.800	SE.X1204
R220.53-06.00-12-16	02449821	Arbor	6.299	16	0.236	45.0	6.772	2.000	3.543	2.480	8300	10.580	SE.X1204
R220.53-06.00-12-17	02997168	Arbor	6.299	17	0.236	43.87	6.772	2.000	5.118	2.480	8300	11.460	SE.X1204
R220.53-808.00-12-12	02422151	Arbor	7.874	12	0.236	45.0	8.346	2.500	5.118	2.480	7400	17.640	SE.X1204

Spare Parts

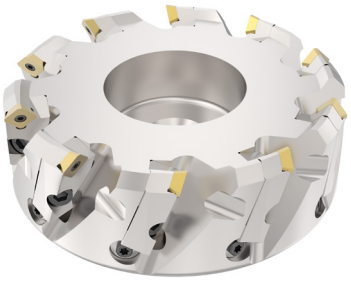
Accessories

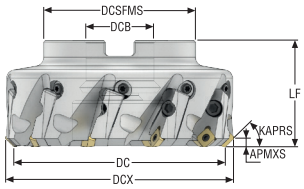
For cutter	Arbor screw	Front insert key	Insert screw	Torque key	Torque value
R220.53-01.50-02.50	220.17-698	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.53-03.00	UC6S1/2UNFX1-1/4	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.53-04.00	UF6S3/4UNFX1-3/4	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.53-04.00-12A	UC6S3/4UNFX1-1/4	T15P-E8	C04008-H3	–	–
R220.53-05.00	UF6S3/4UNFX2	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.53-06.00	–	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.53-06.00-17	–	T15P-E8	C04008-H3	–	–
R220.53-808.00	–	–	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Quattromill R220.53-12C – Metric



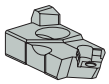
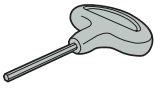


- For insert selection and cutting data recommendations, see page(s) 247-249
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.53-0080-12-5C	02448838	Arbor	80,0	5	6,0	45,0	90,0	27,0	62,0	50,0	7400	1,7	SE.X1204
R220.53-0080-12-6C	02448867	Arbor	80,0	6	6,0	45,0	92,0	27,0	62,0	50,0	7400	1,7	SE.X1204
R220.53-0100-12-6C	02448839	Arbor	100,0	6	6,0	45,0	112,0	32,0	77,0	50,0	6600	2,6	SE.X1204
R220.53-0100-12-8C	02448888	Arbor	100,0	8	6,0	45,0	112,0	32,0	77,0	50,0	6600	2,6	SE.X1204
R220.53-0125-12-8C	02448846	Arbor	125,0	8	6,0	45,0	137,0	40,0	90,0	63,0	5900	4,2	SE.X1204
R220.53-0125-12-10C	02448890	Arbor	125,0	10	6,0	45,0	137,0	40,0	90,0	63,0	5900	4,2	SE.X1204
R220.53-8160-12-7C	02510195	Arbor	160,0	7	6,0	45,0	172,0	40,0	90,0	63,0	5200	6,5	SE.X1204
R220.53-8160-12-10C	02448847	Arbor	160,0	10	6,0	45,0	172,0	40,0	90,0	63,0	5200	6,6	SE.X1204
R220.53-8160-12-14C	02448893	Arbor	160,0	14	6,0	45,0	172,0	40,0	90,0	63,0	5200	6,6	SE.X1204
R220.53-8200-12-8C	02448894	Arbor	200,0	8	6,0	45,0	212,0	60,0	130,0	63,0	4700	9,4	SE.X1204
R220.53-8200-12-12C	02448849	Arbor	200,0	12	6,0	45,0	212,0	60,0	130,0	63,0	4700	9,3	SE.X1204
R220.53-8250-12-10C	02448896	Arbor	250,0	10	6,0	45,0	262,0	60,0	130,0	63,0	4200	17,0	SE.X1204
R220.53-8250-12-16C	02448853	Arbor	250,0	16	6,0	45,0	262,0	60,0	130,0	63,0	4200	16,0	SE.X1204
R220.53-8315-12-12C	02448900	Arbor	315,0	12	6,0	45,0	327,0	60,0	225,0	80,0	3700	32,9	SE.X1204

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Setting gauge	Key	Torque key	Torque value
							
R220.53-0080	SE12AR-53	FS96018	C04011-T15P	AU1114T-T15P	H04-4	T00-15P35	3.5NM
R220.53-0100-8315	SE12AR-53	FS96018	C04011-T15P	AU1114T-T15P	H04-4	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.53-12 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SEMX1204AFTN-ME12 T350M	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
P2	SEMX1204AFTN-ME12 T350M	3,5 *0.14*	0,24 *0.0095*	0,25 *0.010*	0,30 *0.012*
P3	SEMX1204AFTN-M15 MP2501	3,5 *0.14*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P4	SEMX1204AFTN-M15 MP2501	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
P5	SEMX1204AFTN-M15 MP2501	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
P6	SEMX1204AFTN-M15 MP2501	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P7	SEMX1204AFTN-M15 MP2501	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P8	SEEX1204AFTN-M14 T350M	3,5 *0.14*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P11	SEEX1204AFTN-M14 T350M	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P12	SEEX1204AFTN-M14 T350M	3,0 *0.12*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
M1	SEEX1204AFN-M10 F40M	3,5 *0.14*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*
M2	SEEX1204AFN-M10 F40M	3,5 *0.14*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*
M3	SEEX1204AFN-M10 MS2050	3,0 *0.12*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
M4	SEEX1204AFTN-ME11 T350M	2,0 *0.080*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
M5	SEEX1204AFTN-ME11 T350M	2,0 *0.080*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
K1	SEMX1204AFTN-M15 MK1500	3,5 *0.14*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K2	SEMX1204AFTN-M15 MK1500	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
K3	SEMX1204AFTN-M15 MP1501	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
K4	SEMX1204AFTN-M15 MP1501	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
K5	SEMX1204AFTN-M15 MP1501	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
K6	SEMX1204AFTN-M15 MK2050	3,5 *0.14*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
K7	SEMX1204AFTN-M15 MK2050	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
N1	SEEX1204AFN-E08 H25	3,5 *0.14*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
N2	SEEX1204AFN-E08 H25	3,5 *0.14*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
N3	SEEX1204AFN-E08 H25	3,5 *0.14*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
N11	SEEX1204AFN-E08 H25	3,5 *0.14*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
S1	SEEX1204AFTN-ME11 T350M	2,0 *0.080*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
S2	SEEX1204AFTN-ME11 T350M	2,0 *0.080*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
S3	SEEX1204AFTN-ME11 T350M	2,0 *0.080*	0,13 *0.0050*	0,13 *0.0050*	0,17 *0.0065*
S11	SEEX1204AFN-M10 MS2050	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
S12	SEEX1204AFN-M10 MS2050	2,5 *0.10*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
S13	SEEX1204AFN-M10 MS2050	2,0 *0.080*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
H5	SEMX1204AFTN-MD19 MP3000	3,0 *0.12*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
H8	SEMX1204AFTN-MD19 MP3000	2,5 *0.10*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*
H11	SEMX1204AFTN-MD19 MP1501	3,0 *0.12*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
H12	SEMX1204AFTN-MD19 MP1501	2,5 *0.10*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*
H21	SEMX1204AFTN-MD19 MP1501	2,5 *0.10*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.53-12 – Cutting data v_c = (m/min)/*(sf/min)*

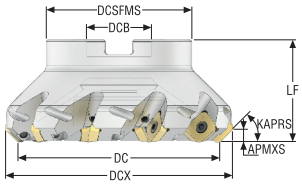
SMG	F40M			MP1501			MP2501			T350M			MP3000			F30M		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	215 *710*	250 *820*	285 *940*	315 *1025*	370 *1225*	415 *1350*	280 *920*	325 *1075*	365 *1200*	250 *820*	290 *950*	325 *1075*	235 *770*	275 *900*	310 *1025*	225 *740*	265 *870*	295 *970*
P2	210 *690*	240 *790*	275 *900*	305 *1000*	350 *1150*	405 *1325*	270 *890*	310 *1025*	355 *1175*	240 *790*	275 *900*	315 *1025*	230 *750*	265 *870*	305 *1000*	220 *720*	250 *820*	290 *950*
P3	185 *610*	210 *690*	240 *790*	270 *890*	310 *1025*	355 *1175*	240 *790*	275 *900*	315 *1025*	215 *710*	245 *800*	275 *900*	200 *660*	230 *750*	265 *870*	195 *640*	220 *720*	255 *840*
P4	165 *540*	185 *610*	210 *690*	240 *790*	275 *900*	310 *1025*	210 *690*	245 *800*	275 *900*	190 *620*	215 *710*	245 *800*	180 *590*	210 *690*	235 *770*	170 *560*	195 *640*	225 *740*
P5	155 *510*	180 *590*	205 *670*	225 *740*	265 *870*	295 *970*	200 *660*	235 *770*	265 *870*	180 *590*	210 *690*	235 *770*	170 *560*	200 *660*	225 *740*	165 *540*	190 *620*	215 *710*
P6	175 *570*	205 *670*	230 *750*	255 *840*	295 *970*	340 *1125*	225 *740*	265 *870*	300 *980*	205 *670*	235 *770*	265 *870*	195 *640*	225 *740*	255 *840*	185 *610*	215 *710*	245 *800*
P7	165 *540*	195 *640*	220 *720*	240 *790*	280 *920*	320 *1050*	215 *710*	250 *820*	285 *940*	195 *640*	220 *720*	250 *820*	185 *610*	210 *690*	240 *790*	175 *570*	200 *660*	230 *750*
P8	155 *510*	180 *590*	205 *670*	225 *740*	260 *850*	295 *970*	200 *660*	230 *750*	265 *870*	180 *590*	205 *670*	235 *770*	170 *560*	195 *640*	225 *740*	165 *540*	185 *610*	215 *710*
P11	165 *540*	185 *610*	210 *690*	235 *770*	275 *900*	310 *1025*	205 *670*	240 *790*	275 *900*	185 *610*	215 *710*	245 *800*	180 *590*	205 *670*	235 *770*	170 *560*	195 *640*	225 *740*
P12	105 *345*	120 *395*	140 *460*	155 *510*	180 *590*	205 *660*	135 *445*	160 *520*	180 *590*	120 *395*	140 *460*	160 *520*	120 *395*	135 *445*	155 *510*	110 *360*	130 *425*	145 *475*
M1	170 *560*	195 *640*	220 *720*	— —	— —	— —	195 *640*	225 *740*	255 *840*	185 *610*	215 *710*	245 *800*	170 *560*	200 *660*	225 *740*	180 *590*	205 *670*	235 *770*
M2	140 *460*	165 *540*	185 *610*	— —	— —	— —	160 *520*	190 *620*	210 *690*	155 *510*	180 *590*	205 *670*	140 *460*	165 *540*	190 *620*	145 *475*	170 *560*	195 *640*
M3	115 *375*	130 *425*	150 *490*	— —	— —	— —	135 *445*	155 *510*	175 *570*	125 *410*	145 *475*	165 *540*	120 *395*	135 *445*	155 *510*	120 *395*	135 *445*	160 *510*
M4	90 *295*	105 *345*	120 *375*	— —	— —	— —	105 *345*	120 *395*	135 *445*	100 *330*	115 *375*	130 *425*	90 *295*	105 *345*	120 *395*	95 *310*	110 *360*	125 *395*
M5	75 *245*	85 *280*	100 *310*	— —	— —	— —	85 *280*	100 *330*	110 *360*	80 *260*	95 *310*	110 *345*	75 *245*	85 *280*	100 *330*	80 *260*	90 *295*	105 *330*
K1	165 *540*	190 *620*	220 *720*	245 *800*	280 *920*	320 *1050*	215 *710*	245 *800*	285 *940*	190 *620*	220 *720*	250 *820*	185 *610*	210 *690*	240 *790*	175 *570*	200 *660*	230 *750*
K2	150 *490*	175 *570*	195 *640*	215 *710*	250 *820*	280 *920*	190 *620*	225 *740*	250 *820*	170 *560*	200 *660*	225 *740*	160 *520*	190 *620*	215 *710*	155 *510*	180 *590*	205 *670*
K3	125 *410*	145 *475*	165 *540*	180 *590*	215 *710*	240 *790*	160 *520*	190 *620*	210 *690*	145 *475*	170 *560*	190 *620*	135 *445*	160 *520*	180 *590*	130 *425*	155 *510*	175 *570*
K4	120 *395*	140 *460*	160 *520*	175 *570*	205 *670*	225 *740*	155 *510*	180 *590*	200 *660*	140 *460*	160 *520*	180 *590*	130 *425*	150 *490*	175 *570*	125 *410*	145 *475*	165 *540*
K5	75 *245*	85 *280*	95 *310*	105 *345*	125 *410*	140 *460*	95 *310*	110 *360*	125 *410*	85 *280*	100 *330*	110 *360*	80 *260*	95 *310*	105 *345*	75 *245*	90 *295*	100 *330*
K6	105 *345*	125 *410*	140 *460*	155 *510*	180 *590*	200 *660*	135 *445*	160 *520*	180 *590*	120 *395*	140 *460*	160 *520*	115 *375*	135 *445*	155 *510*	110 *360*	130 *425*	145 *475*
K7	95 *310*	110 *360*	125 *410*	140 *460*	160 *520*	180 *590*	120 *395*	140 *460*	160 *520*	110 *360*	125 *410*	140 *460*	105 *345*	120 *395*	135 *445*	100 *330*	115 *375*	130 *425*
N1	1200 *3925*	1400 *4600*	1600 *5250*	— —	— —	— —	— —	— —	— —	— —	— —	— —	1325 *4350*	1525 *5000*	1725 *5650*	1275 *4175*	1475 *4850*	1675 *5500*
N2	490 *1600*	560 *1825*	640 *2100*	— —	— —	— —	— —	— —	— —	— —	— —	— —	530 *1750*	620 *2025*	700 *2300*	510 *1675*	590 *1925*	680 *2225*
N3	325 *1075*	375 *1225*	430 *1400*	— —	— —	— —	— —	— —	— —	— —	— —	— —	355 *1175*	410 *1350*	470 *1550*	345 *1125*	395 *1300*	450 *1475*
N11	375 *1225*	430 *1400*	490 *1600*	— —	— —	— —	— —	— —	— —	— —	— —	— —	405 *1325*	470 *1550*	530 *1750*	390 *1275*	450 *1475*	520 *1700*
S1	41 *135*	48 *155*	55 *180*	— —	— —	— —	50 *165*	55 *180*	65 *215*	46 *150*	55 *180*	60 *195*	42 *140*	49 *160*	55 *180*	44 *145*	50 *165*	60 *180*
S2	33 *110*	39 *130*	44 *145*	— —	— —	— —	40 *130*	46 *150*	55 *180*	37 *120*	43 *140*	49 *155*	34 *110*	39 *130*	44 *145*	35 *115*	41 *135*	47 *150*
S3	29 *95*	34 *110*	38 *125*	— —	— —	— —	35 *115*	41 *135*	47 *155*	32 *105*	37 *120*	42 *140*	30 *100*	35 *115*	39 *130*	31 *100*	36 *120*	40 *130*
S11	60 *195*	65 *215*	75 *245*	— —	— —	— —	70 *230*	80 *260*	90 *295*	65 *215*	70 *230*	85 *280*	60 *195*	70 *230*	75 *245*	60 *195*	70 *230*	80 *260*
S12	40 *130*	46 *150*	55 *165*	— —	— —	— —	48 *155*	55 *180*	65 *215*	44 *145*	50 *165*	60 *180*	41 *135*	47 *155*	55 *180*	35 *115*	40 *130*	46 *150*
S13	23 *75*	27 *90*	31 *100*	— —	— —	— —	28 *90*	32 *105*	37 *120*	26 *85*	30 *100*	34 *110*	24 *80*	27 *90*	31 *100*	20 *65*	24 *80*	27 *90*
H5	35 *115*	41 *135*	46 *150*	50 *165*	60 *195*	65 *215*	41 *135*	48 *155*	55 *180*	40 *130*	47 *155*	55 *180*	37 *120*	42 *140*	48 *155*	37 *120*	43 *140*	49 *155*
H8	38 *125*	43 *140*	49 *160*	55 *180*	65 *215*	75 *230*	45 *150*	50 *165*	60 *195*	44 *145*	50 *165*	55 *180*	40 *130*	45 *150*	50 *165*	40 *130*	45 *150*	50 *165*
H11	45 *150*	50 *165*	60 *195*	65 *215*	75 *245*	85 *280*	55 *180*	60 *195*	70 *230*	50 *165*	60 *195*	70 *230*	47 *155*	55 *180*	60 *195*	47 *155*	55 *180*	60 *195*
H12	70 *230*	80 *260*	90 *295*	100 *330*	115 *375*	130 *425*	90 *295*	100 *330*	115 *375*	80 *260*	90 *295*	100 *330*	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*
H21	38 *125*	43 *140*	49 *160*	55 *180*	65 *215*	75 *230*	45 *150*	50 *165*	60 *195*	44 *145*	50 *165*	55 *180*	40 *130*	45 *150*	50 *165*	40 *130*	45 *150*	50 *165*

R217/220.53-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			H25			MS2050			MM4500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	275	320	360	—	—	—	265	305	345	175	205	230
	—	—	—	*900*	*1050*	*1175*	—	—	—	*870*	*1000*	*1125*	*570*	*670*	*750*
P2	—	—	—	270	305	350	—	—	—	260	300	335	170	195	225
	—	—	—	*890*	*1000*	*1150*	—	—	—	*850*	*980*	*1100*	*560*	*640*	*740*
P3	—	—	—	235	270	310	—	—	—	225	255	295	150	170	195
	—	—	—	*770*	*890*	*1025*	—	—	—	*740*	*840*	*970*	*490*	*560*	*640*
P4	—	—	—	205	240	270	—	—	—	200	230	260	130	150	170
	—	—	—	*670*	*790*	*890*	—	—	—	*660*	*750*	*850*	*425*	*490*	*560*
P5	—	—	—	200	230	260	—	—	—	190	220	245	125	145	165
	—	—	—	*660*	*750*	*850*	—	—	—	*620*	*720*	*800*	*410*	*475*	*540*
P6	—	—	—	220	260	295	—	—	—	215	245	275	145	165	190
	—	—	—	*720*	*850*	*970*	—	—	—	*710*	*800*	*900*	*475*	*540*	*620*
P7	—	—	—	210	245	280	—	—	—	205	230	260	135	155	175
	—	—	—	*690*	*800*	*920*	—	—	—	*670*	*750*	*850*	*445*	*510*	*570*
P8	—	—	—	200	225	260	—	—	—	190	215	245	125	145	165
	—	—	—	*660*	*740*	*850*	—	—	—	*620*	*710*	*800*	*410*	*475*	*540*
P11	—	—	—	205	240	270	—	—	—	200	225	255	130	150	170
	—	—	—	*670*	*790*	*890*	—	—	—	*660*	*740*	*840*	*425*	*490*	*560*
P12	—	—	—	135	155	175	—	—	—	125	145	165	85	100	115
	—	—	—	*445*	*510*	*570*	—	—	—	*410*	*475*	*540*	*280*	*330*	*375*
M1	—	—	—	—	—	—	—	—	—	210	240	270	145	165	190
	—	—	—	—	—	—	—	—	—	*690*	*790*	*890*	*475*	*540*	*620*
M2	—	—	—	—	—	—	—	—	—	175	195	220	120	140	160
	—	—	—	—	—	—	—	—	—	*570*	*640*	*720*	*395*	*460*	*520*
M3	—	—	—	—	—	—	—	—	—	140	160	180	100	115	130
	—	—	—	—	—	—	—	—	—	*460*	*520*	*590*	*330*	*375*	*425*
M4	—	—	—	—	—	—	—	—	—	105	125	140	75	90	100
	—	—	—	—	—	—	—	—	—	*345*	*410*	*460*	*245*	*295*	*330*
M5	—	—	—	—	—	—	—	—	—	90	105	115	65	75	85
	—	—	—	—	—	—	—	—	—	*295*	*345*	*375*	*215*	*245*	*280*
K1	305	350	400	290	330	380	—	—	—	—	—	—	—	—	—
	1000	*1150*	*1300*	*950*	*1075*	*1250*	—	—	—	—	—	—	—	—	—
K2	270	315	355	255	300	335	—	—	—	—	—	—	—	—	—
	890	*1025*	*1175*	*840*	*980*	*1100*	—	—	—	—	—	—	—	—	—
K3	230	265	300	215	255	285	—	—	—	—	—	—	—	—	—
	750	*870*	*980*	*710*	*840*	*940*	—	—	—	—	—	—	—	—	—
K4	220	255	285	205	240	270	—	—	—	—	—	—	—	—	—
	720	*840*	*940*	*670*	*790*	*890*	—	—	—	—	—	—	—	—	—
K5	135	155	175	130	145	165	—	—	—	—	—	—	—	—	—
	445	*510*	*570*	*425*	*475*	*540*	—	—	—	—	—	—	—	—	—
K6	190	225	250	180	210	240	—	—	—	—	—	—	—	—	—
	620	*740*	*820*	*590*	*690*	*790*	—	—	—	—	—	—	—	—	—
K7	175	200	225	165	190	215	—	—	—	—	—	—	—	—	—
	570	*660*	*740*	*540*	*620*	*710*	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	1575	1775	2025	—	—	—	—	—	—
	—	—	—	—	—	—	*5175*	*5825*	*6650*	—	—	—	—	—	—
N2	—	—	—	—	—	—	630	710	820	—	—	—	—	—	—
	—	—	—	—	—	—	*2075*	*2325*	*2700*	—	—	—	—	—	—
N3	—	—	—	—	—	—	420	475	540	—	—	—	—	—	—
	—	—	—	—	—	—	*1375*	*1550*	*1775*	—	—	—	—	—	—
N11	—	—	—	—	—	—	480	540	620	—	—	—	—	—	—
	—	—	—	—	—	—	*1575*	*1775*	*2025*	—	—	—	—	—	—
S1	—	—	—	—	—	—	—	—	—	50	60	65	23	27	31
	—	—	—	—	—	—	—	—	—	*165*	*195*	*215*	*75*	*90*	*100*
S2	—	—	—	—	—	—	—	—	—	40	46	55	19	22	25
	—	—	—	—	—	—	—	—	—	*130*	*150*	*165*	*60*	*70*	*80*
S3	—	—	—	—	—	—	—	—	—	35	41	46	17	19	22
	—	—	—	—	—	—	—	—	—	*115*	*135*	*150*	*55*	*60*	*70*
S11	—	—	—	—	—	—	—	—	—	70	80	90	33	37	43
	—	—	—	—	—	—	—	—	—	*230*	*260*	*295*	*110*	*120*	*140*
S12	—	—	—	—	—	—	—	—	—	48	55	65	30	34	40
	—	—	—	—	—	—	—	—	—	*155*	*180*	*195*	*100*	*110*	*130*
S13	—	—	—	—	—	—	—	—	—	28	32	37	18	20	23
	—	—	—	—	—	—	—	—	—	*90*	*105*	*120*	*60*	*65*	*75*

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Quattromill R220.53-15 – Metric



- For insert selection and cutting data recommendations, see page(s) 253-255
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.53-0063-15-5A	02486622	Arbor	63,0	5	7,5	45,0	78,0	22,0	47,0	40,0	8300	0,6	SE.X1505
R220.53-0080-15-6A	02486624	Arbor	80,0	6	7,5	45,0	96,0	27,0	62,0	50,0	7400	1,2	SE.X1505
R220.53-0080-15-7A	02486625	Arbor	80,0	7	7,5	45,0	96,0	27,0	62,0	50,0	7400	1,2	SE.X1505
R220.53-0100-15-7A	02486627	Arbor	100,0	7	7,5	45,0	116,0	32,0	77,0	50,0	6600	1,8	SE.X1505
R220.53-0100-15-9A	02486628	Arbor	100,0	9	7,5	45,0	116,0	32,0	77,0	50,0	6600	1,8	SE.X1505
R220.53-0125-15-8A	02486630	Arbor	125,0	8	7,5	45,0	141,0	40,0	90,0	63,0	5900	3,3	SE.X1505
R220.53-0125-15-10A	02486631	Arbor	125,0	10	7,5	45,0	141,0	40,0	90,0	63,0	5900	3,2	SE.X1505
R220.53-8160-15-10	02486633	Arbor	160,0	10	7,5	45,0	176,0	40,0	90,0	63,0	5200	4,8	SE.X1505
R220.53-8200-15-12	02486636	Arbor	200,0	12	7,5	45,0	216,0	60,0	130,0	63,0	4700	7,7	SE.X1505

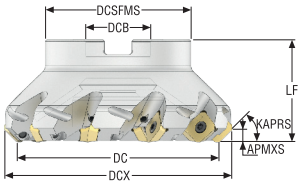
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.53-0063	220.17-696	C05013-T20P	T00-20P50	5.0NM
R220.53-0080-8200	–	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Quattromill R220.53-15 – Inch



- For insert selection and cutting data recommendations, see page(s) 253-255
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.53-03.00-15-6A	02486638	Arbor	3.150	6	0.295	45.0	3.740	1.000	2.441	1.969	7400	3.310	SE.X1505
R220.53-04.00-15-7A	02486644	Arbor	3.937	7	0.295	45.0	4.528	1.500	3.543	1.969	6600	5.070	SE.X1505
R220.53-06.00-15-10	02486653	Arbor	6.299	10	0.295	45.0	6.890	2.000	3.543	2.480	5200	10.800	SE.X1505

Spare Parts

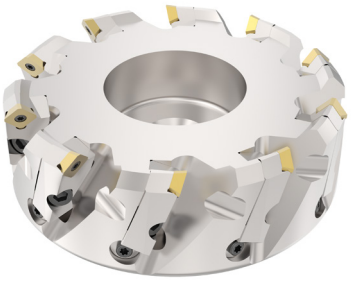
Accessories

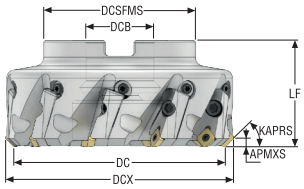
For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.53-03.00	UC6S1/2UNFX1-1/4	C05013-T20P	T00-20P50	44.3IN.LBS
R220.53-04.00	UF6S3/4UNFX1-3/4	C05013-T20P	T00-20P50	44.3IN.LBS
R220.53-06.00 / 808.00	–	C05013-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Quattromill R220.53-15C – Metric



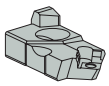
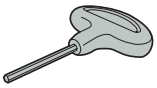


- For insert selection and cutting data recommendations, see page(s) 253-255
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.53-0080-15-5C	02510197	Arbor	80,0	5	7,5	45,0	96,0	27,0	62,0	50,0	7400	1,7	SE.X1505
R220.53-0100-15-6C	02510198	Arbor	100,0	6	7,5	45,0	116,0	32,0	77,0	50,0	6600	2,6	SE.X1505
R220.53-0125-15-8C	02510199	Arbor	125,0	8	7,5	45,0	141,0	40,0	90,0	63,0	5900	4,2	SE.X1505
R220.53-8160-15-7C	02510219	Arbor	160,0	7	7,5	45,0	176,0	40,0	90,0	63,0	5200	6,5	SE.X1505
R220.53-8160-15-10C	02510202	Arbor	160,0	10	7,5	45,0	176,0	40,0	90,0	63,0	5200	6,6	SE.X1505
R220.53-8200-15-8C	02510221	Arbor	200,0	8	7,5	45,0	216,0	60,0	130,0	63,0	4700	9,4	SE.X1505
R220.53-8200-15-12C	02510204	Arbor	200,0	12	7,5	45,0	216,0	60,0	130,0	63,0	4700	9,8	SE.X1505
R220.53-8250-15-10C	02510234	Arbor	250,0	10	7,5	45,0	266,0	60,0	130,0	63,0	4200	17,0	SE.X1505
R220.53-8250-15-16C	02510231	Arbor	250,0	16	7,5	45,0	260,0	60,0	130,0	63,0	4200	17,1	SE.X1505
R220.53-8315-15-12C	02510235	Arbor	315,0	12	7,5	45,0	331,0	60,0	225,0	80,0	3700	32,6	SE.X1505
R220.53-8315-15-18C	02510232	Arbor	315,0	18	7,5	45,0	331,0	60,0	225,0	80,0	3700	38,0	SE.X1505

Spare Parts

Accessories

For cutter	Cassette	Cassette screw	Insert screw	Setting gauge	Key	Torque key	Torque value
							
R220.53-0080	SE15AR-53	FS96018	C05010-T20P	AU1114T-T15P	H04-4	T00-20P50	5.0NM
R220.53-0100-8500	SE15AR-53	FS96018	C05010-T20P	AU1114T-T15P	H04-4	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.53-15 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SEMX1505AFTN-ME15 T350M	4,5 *0.18*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P2	SEMX1505AFTN-ME15 T350M	4,5 *0.18*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
P3	SEMX1505AFTN-M18 MP2501	4,5 *0.18*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
P4	SEMX1505AFTN-M18 MP2501	4,5 *0.18*	0,34 *0.013*	0,34 *0.013*	0,44 *0.017*
P5	SEMX1505AFTN-M18 MP2501	4,5 *0.18*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
P6	SEMX1505AFTN-M18 MP2501	4,5 *0.18*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
P7	SEMX1505AFTN-M18 T350M	4,5 *0.18*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
P8	SEMX1505AFTN-M18 T350M	4,5 *0.18*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
P11	SEMX1505AFTN-ME15 T350M	4,5 *0.18*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P12	SEMX1505AFTN-ME15 T350M	3,5 *0.14*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
M1	SEEX1505AFN-M12 F40M	4,5 *0.18*	0,24 *0.0095*	0,25 *0.010*	0,32 *0.013*
M2	SEEX1505AFN-M12 F40M	4,5 *0.18*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
M3	SEEX1505AFN-M12 MS2050	3,5 *0.14*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
M4	SEEX1505AFN-M12 T350M	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
M5	SEEX1505AFN-M12 T350M	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
K1	SEMX1505AFTN-M18 MK1500	4,5 *0.18*	0,36 *0.014*	0,38 *0.015*	0,46 *0.018*
K2	SEMX1505AFTN-M18 MK1500	4,5 *0.18*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K3	SEMX1505AFTN-M18 MP1501	4,5 *0.18*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K4	SEMX1505AFTN-M18 MP1501	4,5 *0.18*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K5	SEMX1505AFTN-M18 MP1501	4,5 *0.18*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
K6	SEMX1505AFTN-M18 MK2050	4,5 *0.18*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K7	SEMX1505AFTN-M18 MK2050	4,5 *0.18*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
N1	SEEX1505AFN-E10 H25	4,5 *0.18*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
N2	SEEX1505AFN-E10 H25	4,5 *0.18*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
N3	SEEX1505AFN-E10 H25	4,5 *0.18*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
N11	SEEX1505AFN-E10 H25	4,5 *0.18*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
S1	SEEX1505AFN-M12 T350M	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
S2	SEEX1505AFN-M12 T350M	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
S3	SEEX1505AFN-M12 T350M	2,5 *0.10*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
S11	SEEX1505AFN-M12 MS2050	3,0 *0.12*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
S12	SEEX1505AFN-M12 MS2050	3,0 *0.12*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
S13	SEEX1505AFN-M12 MS2050	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
H5	SEMX1505AFTN-MD20 MP3000	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
H8	SEMX1505AFTN-MD20 MP3000	3,0 *0.12*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*
H11	SEMX1505AFTN-MD20 MP1501	3,5 *0.14*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
H12	SEMX1505AFTN-MD20 MP1501	3,0 *0.12*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*
H21	SEMX1505AFTN-MD20 MP1501	3,0 *0.12*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.53-15 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			T350M			MP3000		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	200 *660*	235 *770*	260 *850*	290 *950*	340 *1125*	385 *1275*	260 *850*	305 *1000*	340 *1125*	225 *740*	265 *870*	295 *970*	230 *750*	265 *870*	305 *1000*
P2	195 *640*	225 *740*	255 *840*	285 *940*	325 *1075*	375 *1225*	250 *820*	290 *950*	330 *1075*	220 *720*	250 *820*	290 *950*	220 *720*	255 *840*	295 *970*
P3	170 *560*	195 *640*	225 *740*	250 *820*	285 *940*	325 *1075*	220 *720*	255 *840*	290 *950*	190 *620*	220 *720*	250 *820*	195 *640*	225 *740*	255 *840*
P4	150 *490*	175 *570*	200 *660*	220 *720*	255 *840*	290 *950*	195 *640*	230 *750*	255 *840*	170 *560*	200 *660*	220 *720*	170 *560*	200 *660*	225 *740*
P5	145 *475*	170 *560*	190 *620*	210 *690*	245 *800*	280 *920*	185 *610*	215 *710*	245 *800*	160 *520*	190 *620*	215 *710*	165 *540*	190 *620*	220 *720*
P6	165 *540*	190 *620*	215 *710*	240 *790*	275 *900*	315 *1025*	215 *710*	245 *800*	275 *900*	185 *610*	215 *710*	240 *790*	185 *610*	215 *710*	245 *800*
P7	155 *510*	180 *590*	200 *660*	225 *740*	260 *850*	295 *970*	200 *660*	230 *750*	260 *850*	175 *570*	200 *660*	230 *750*	175 *570*	205 *670*	230 *750*
P8	145 *475*	165 *540*	185 *610*	210 *690*	240 *790*	275 *900*	185 *610*	215 *710*	245 *800*	160 *520*	185 *610*	210 *690*	165 *540*	190 *620*	215 *710*
P11	150 *490*	175 *570*	195 *640*	220 *720*	250 *820*	285 *940*	195 *640*	225 *740*	255 *840*	170 *560*	195 *640*	220 *720*	170 *560*	195 *640*	225 *740*
P12	100 *330*	115 *375*	130 *425*	145 *475*	165 *540*	190 *620*	130 *425*	145 *475*	170 *560*	115 *375*	130 *425*	145 *475*	115 *375*	130 *425*	150 *490*
M1	155 *510*	180 *590*	205 *670*	— —	— —	— —	180 *590*	210 *690*	240 *790*	170 *560*	195 *640*	225 *740*	165 *540*	190 *620*	220 *720*
M2	130 *425*	150 *490*	170 *560*	— —	— —	— —	150 *490*	175 *570*	200 *660*	140 *460*	165 *540*	185 *610*	140 *460*	160 *520*	185 *610*
M3	105 *345*	120 *395*	140 *460*	— —	— —	— —	125 *410*	140 *460*	160 *520*	115 *375*	130 *425*	150 *490*	110 *360*	130 *425*	145 *475*
M4	80 *260*	95 *310*	110 *360*	— —	— —	— —	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	115 *375*	90 *295*	100 *330*	115 *375*
M5	70 *230*	80 *260*	90 *295*	— —	— —	— —	80 *260*	90 *295*	105 *345*	75 *245*	85 *280*	95 *310*	75 *245*	85 *280*	95 *310*
K1	155 *510*	175 *570*	200 *660*	225 *740*	260 *850*	295 *970*	200 *660*	230 *750*	260 *850*	175 *570*	200 *660*	230 *750*	175 *570*	205 *670*	235 *770*
K2	135 *445*	160 *520*	180 *590*	200 *660*	235 *770*	265 *870*	175 *570*	205 *670*	235 *770*	155 *510*	180 *590*	205 *670*	160 *520*	180 *590*	210 *690*
K3	115 *375*	135 *445*	155 *510*	170 *560*	195 *640*	225 *740*	150 *490*	175 *570*	200 *660*	130 *425*	150 *490*	175 *570*	135 *445*	155 *510*	175 *570*
K4	110 *360*	130 *425*	145 *475*	160 *520*	190 *620*	215 *710*	140 *460*	165 *540*	190 *620*	125 *410*	145 *475*	165 *540*	130 *425*	145 *475*	170 *560*
K5	70 *230*	80 *260*	90 *295*	100 *330*	115 *375*	130 *425*	90 *295*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	80 *260*	90 *295*	105 *345*
K6	95 *310*	115 *375*	130 *425*	140 *460*	165 *540*	190 *620*	125 *410*	145 *475*	165 *540*	110 *360*	130 *425*	145 *475*	110 *360*	130 *425*	150 *490*
K7	90 *295*	100 *330*	115 *375*	130 *425*	150 *490*	170 *560*	115 *375*	130 *425*	150 *490*	100 *330*	115 *375*	130 *425*	100 *330*	115 *375*	130 *425*
N1	1100 *3600*	1275 *4175*	1475 *4850*	— —	— —	— —	— —	— —	— —	— —	— —	— —	1275 *4175*	1450 *4750*	1675 *5500*
N2	450 *1475*	520 *1700*	600 *1975*	— —	— —	— —	— —	— —	— —	— —	— —	— —	520 *1700*	590 *1925*	680 *2225*
N3	300 *980*	345 *1125*	400 *1300*	— —	— —	— —	— —	— —	— —	— —	— —	— —	345 *1125*	390 *1275*	455 *1500*
N11	340 *1125*	395 *1300*	455 *1500*	— —	— —	— —	— —	— —	— —	— —	— —	— —	395 *1300*	450 *1475*	520 *1700*
S1	38 *125*	45 *150*	50 *165*	— —	— —	— —	46 *150*	55 *180*	60 *195*	41 *135*	48 *155*	55 *180*	41 *135*	48 *155*	55 *180*
S2	31 *100*	36 *120*	40 *130*	— —	— —	— —	37 *120*	43 *140*	49 *160*	33 *110*	39 *130*	44 *145*	33 *110*	38 *125*	44 *145*
S3	28 *90*	32 *105*	36 *120*	— —	— —	— —	33 *110*	38 *125*	43 *140*	29 *95*	34 *110*	38 *125*	29 *95*	33 *110*	38 *125*
S11	55 *180*	60 *195*	70 *230*	— —	— —	— —	65 *215*	75 *245*	85 *280*	60 *195*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*
S12	37 *120*	43 *140*	48 *155*	— —	— —	— —	45 *150*	50 *165*	60 *195*	40 *130*	46 *150*	50 *165*	39 *130*	46 *150*	50 *165*
S13	22 *70*	25 *80*	28 *90*	— —	— —	— —	26 *85*	30 *100*	34 *110*	23 *75*	27 *90*	30 *100*	23 *75*	27 *90*	30 *100*
H5	33 *110*	38 *125*	43 *140*	48 *155*	55 *180*	65 *215*	39 *130*	44 *145*	50 *165*	37 *120*	42 *140*	49 *160*	35 *115*	41 *135*	46 *150*
H8	36 *120*	41 *135*	46 *150*	50 *165*	60 *195*	65 *215*	42 *140*	48 *155*	55 *180*	40 *130*	46 *150*	50 *165*	38 *125*	44 *145*	50 *165*
H11	41 *135*	48 *155*	55 *180*	60 *195*	70 *230*	80 *260*	50 *165*	55 *180*	65 *215*	48 *155*	55 *180*	60 *195*	45 *150*	50 *165*	60 *195*
H12	65 *215*	75 *245*	85 *280*	95 *310*	105 *345*	120 *395*	85 *280*	95 *310*	105 *345*	70 *230*	80 *260*	95 *310*	75 *245*	85 *280*	95 *310*
H21	36 *120*	41 *135*	46 *150*	50 *165*	60 *195*	65 *215*	42 *140*	48 *155*	55 *180*	40 *130*	46 *150*	50 *165*	38 *125*	44 *145*	50 *165*

R220.53-15 – Cutting data v_c = (m/min)/*(sf/min)*

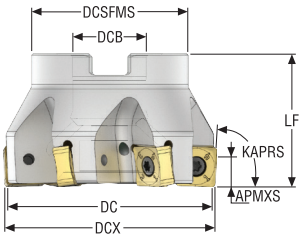
SMG	MK1500			MK2050			H25			MS2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	265	310	345	—	—	—	250	290	330
	—	—	—	*870*	*1025*	*1125*	—	—	—	*820*	*950*	*1075*
P2	—	—	—	260	295	340	—	—	—	245	280	320
	—	—	—	*850*	*970*	*1125*	—	—	—	*800*	*920*	*1050*
P3	—	—	—	225	260	295	—	—	—	215	245	275
	—	—	—	*740*	*850*	*970*	—	—	—	*710*	*800*	*900*
P4	—	—	—	200	235	265	—	—	—	190	215	250
	—	—	—	*660*	*770*	*870*	—	—	—	*620*	*710*	*820*
P5	—	—	—	190	225	250	—	—	—	180	210	240
	—	—	—	*620*	*740*	*820*	—	—	—	*590*	*690*	*790*
P6	—	—	—	220	250	285	—	—	—	205	240	265
	—	—	—	*720*	*820*	*940*	—	—	—	*670*	*790*	*870*
P7	—	—	—	205	235	265	—	—	—	195	225	250
	—	—	—	*670*	*770*	*870*	—	—	—	*640*	*740*	*820*
P8	—	—	—	190	220	250	—	—	—	180	205	235
	—	—	—	*620*	*720*	*820*	—	—	—	*590*	*670*	*770*
P11	—	—	—	200	230	260	—	—	—	190	220	245
	—	—	—	*660*	*750*	*850*	—	—	—	*620*	*720*	*800*
P12	—	—	—	130	150	175	—	—	—	125	140	160
	—	—	—	*425*	*490*	*570*	—	—	—	*410*	*460*	*520*
M1	—	—	—	—	—	—	—	—	—	200	225	260
	—	—	—	—	—	—	—	—	—	*660*	*740*	*850*
M2	—	—	—	—	—	—	—	—	—	165	190	215
	—	—	—	—	—	—	—	—	—	*540*	*620*	*710*
M3	—	—	—	—	—	—	—	—	—	130	155	175
	—	—	—	—	—	—	—	—	—	*425*	*510*	*570*
M4	—	—	—	—	—	—	—	—	—	105	120	135
	—	—	—	—	—	—	—	—	—	*345*	*395*	*425*
M5	—	—	—	—	—	—	—	—	—	85	100	110
	—	—	—	—	—	—	—	—	—	*280*	*330*	*360*
K1	295	340	385	280	320	365	—	—	—	—	—	—
	970	*1125*	*1275*	*920*	*1050*	*1200*	—	—	—	—	—	—
K2	260	305	345	245	290	325	—	—	—	—	—	—
	850	*1000*	*1125*	*800*	*950*	*1075*	—	—	—	—	—	—
K3	220	260	290	210	245	275	—	—	—	—	—	—
	720	*850*	*950*	*690*	*800*	*900*	—	—	—	—	—	—
K4	210	245	280	200	235	265	—	—	—	—	—	—
	690	*800*	*920*	*660*	*770*	*870*	—	—	—	—	—	—
K5	130	155	170	125	145	160	—	—	—	—	—	—
	425	*510*	*560*	*410*	*475*	*520*	—	—	—	—	—	—
K6	185	215	245	175	205	230	—	—	—	—	—	—
	610	*710*	*800*	*570*	*670*	*750*	—	—	—	—	—	—
K7	170	195	220	160	185	205	—	—	—	—	—	—
	560	*640*	*720*	*520*	*610*	*670*	—	—	—	—	—	—
N1	—	—	—	—	—	—	1475	1725	1950	—	—	—
	—	—	—	—	—	—	*4850*	*5650*	*6400*	—	—	—
N2	—	—	—	—	—	—	590	690	790	—	—	—
	—	—	—	—	—	—	*1925*	*2275*	*2600*	—	—	—
N3	—	—	—	—	—	—	395	460	520	—	—	—
	—	—	—	—	—	—	*1300*	*1500*	*1700*	—	—	—
N11	—	—	—	—	—	—	450	530	600	—	—	—
	—	—	—	—	—	—	*1475*	*1750*	*1975*	—	—	—
S1	—	—	—	—	—	—	—	—	—	48	55	65
	—	—	—	—	—	—	—	—	—	*155*	*180*	*195*
S2	—	—	—	—	—	—	—	—	—	39	44	50
	—	—	—	—	—	—	—	—	—	*130*	*145*	*165*
S3	—	—	—	—	—	—	—	—	—	34	39	45
	—	—	—	—	—	—	—	—	—	*110*	*130*	*145*
S11	—	—	—	—	—	—	—	—	—	65	75	90
	—	—	—	—	—	—	—	—	—	*215*	*245*	*280*
S12	—	—	—	—	—	—	—	—	—	46	55	60
	—	—	—	—	—	—	—	—	—	*150*	*180*	*195*
S13	—	—	—	—	—	—	—	—	—	27	31	35
	—	—	—	—	—	—	—	—	—	*90*	*100*	*115*
H5	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—

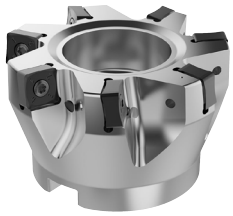
R220.88 (SNMU)

The R220.88 cutters with SNMU12/16 inserts provide high depth-of-cut capabilities, along with an economical eight cutting edges per insert. These cutters provide strong performance in machining steels and cast iron and are available in two insert sizes, 12 and 16. This tool is ideal for roughing and semi-finishing operations.

- Insert size 12, cutter range 50-160mm (2-6 inch)
- Insert size 16, cutter range 63-160mm (2.5-6 inch)

R220.88-12 – Metric



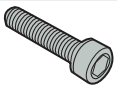


- For insert selection and cutting data recommendations, see page(s) 259-260
- For complete insert programme, see page(s) 766
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.88-0050-12-4SA	03091359	Arbor	50,0	4	9,0	88,0	51,2	22,0	47,0	40,0	12600	0,4	SNMU1204..
R220.88-0050-12-5SA	03091371	Arbor	50,0	5	9,0	88,0	51,2	22,0	47,0	40,0	12600	0,4	SNMU1204..
R220.88-0063-12-6SA	03091360	Arbor	63,0	6	9,0	88,0	64,2	22,0	47,0	40,0	11200	0,5	SNMU1204..
R220.88-0063-12-7SA	03091372	Arbor	63,0	7	9,0	88,0	64,2	22,0	47,0	40,0	11200	0,5	SNMU1204..
R220.88-0080-12-7SA	03091361	Arbor	80,0	7	9,0	88,0	81,15	27,0	62,0	50,0	9900	1,0	SNMU1204..
R220.88-0080-12-9SA	03091373	Arbor	80,0	9	9,0	88,0	81,15	27,0	62,0	50,0	9900	1,0	SNMU1204..
R220.88-0100-12-8SA	03091362	Arbor	100,0	8	9,0	88,0	101,15	32,0	77,0	50,0	8900	1,6	SNMU1204..
R220.88-0100-12-11SA	03091374	Arbor	100,0	11	9,0	88,0	101,15	32,0	77,0	50,0	8900	1,6	SNMU1204..
R220.88-0125-12-10SA	03091363	Arbor	125,0	10	9,0	88,0	126,15	40,0	90,0	63,0	7900	3,0	SNMU1204..
R220.88-0125-12-13SA	03091375	Arbor	125,0	13	9,0	88,0	126,15	40,0	90,0	63,0	7900	3,0	SNMU1204..
R220.88-8160-12-12S	03091364	Arbor	160,0	12	9,0	88,0	161,1	40,0	90,0	63,0	7000	5,2	SNMU1204..
R220.88-8160-12-16S	03091376	Arbor	160,0	16	9,0	88,0	161,1	40,0	90,0	63,0	7000	5,2	SNMU1204..

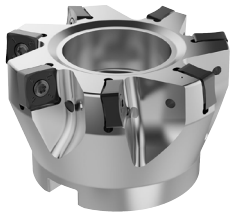
Spare Parts

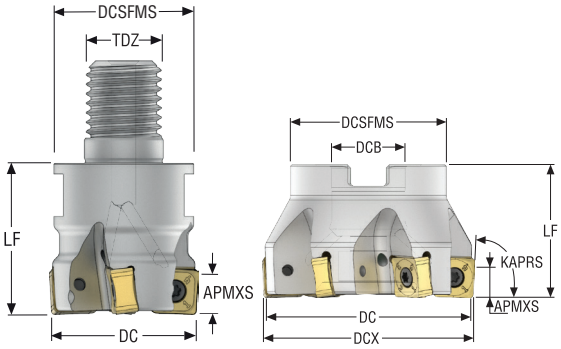
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.88-0050-0063	220.17-692	C04011-T15P	T00-15P35	3.5NM
R220.88-0080-8160	–	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.88-12 – Inch





- For insert selection and cutting data recommendations, see page(s) 259-260
- For complete insert programme, see page(s) 766
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R217.88-01.50-20RE-12-4SA	03280116	Combimaster	1.500	4	0.354	88.0	2.039	–	1.457	1.575	12600	0.660	SNMU1204..
R220.88-01.50-12-4SA	03139351	Arbor	1.500	4	0.354	88.0	2.039	0.750	1.850	1.575	12600	0.660	SNMU1204..
R220.88-02.00-12-4SA	03091365	Arbor	2.000	4	0.354	88.0	2.039	0.750	1.850	1.575	12600	0.880	SNMU1204..
R220.88-02.00-12-5SA	03091377	Arbor	2.000	5	0.354	88.0	2.039	0.750	1.850	1.575	12600	0.880	SNMU1204..
R220.88-02.50-12-6SA	03091366	Arbor	2.500	6	0.354	88.0	2.539	0.750	1.850	1.575	11200	1.100	SNMU1204..
R220.88-02.50-12-7SA	03091378	Arbor	2.500	7	0.354	88.0	2.539	0.750	1.850	1.575	11200	1.100	SNMU1204..
R220.88-03.00-12-7SA	03091367	Arbor	3.000	7	0.354	88.0	3.039	1.000	2.441	1.969	9900	2.430	SNMU1204..
R220.88-03.00-12-9SA	03091379	Arbor	3.000	9	0.354	88.0	3.039	1.000	2.441	1.969	9900	2.200	SNMU1204..
R220.88-04.00-12-8SA	03091368	Arbor	4.000	8	0.354	88.0	4.039	1.500	3.031	1.969	8900	3.750	SNMU1204..
R220.88-04.00-12-11SA	03091380	Arbor	4.000	11	0.354	88.0	4.039	1.500	3.031	1.969	8900	3.530	SNMU1204..
R220.88-05.00-12-10SA	03091369	Arbor	5.000	10	0.354	88.0	5.039	1.500	3.543	2.480	7900	0.880	SNMU1204..
R220.88-05.00-12-13SA	03091381	Arbor	5.000	13	0.354	88.0	5.039	1.500	3.543	2.480	7900	7.500	SNMU1204..
R220.88-06.00-12-12S	03091370	Arbor	6.000	12	0.354	88.0	6.039	2.000	4.331	2.480	7000	10.140	SNMU1204..
R220.88-06.00-12-16S	03091382	Arbor	6.000	16	0.354	88.0	6.039	2.000	4.331	2.480	7000	10.140	SNMU1204..

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.88-..	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.88-01.50	UC6S1/4UNFX1	C04011-T15P	T00-15P35	31.0IN.LBS
R220.88-02.00-02.50	UC6S3/8UNFX1	C04011-T15P	T00-15P35	31.0IN.LBS
R220.88-03.00	UC6S1/2UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.88-04.00-05.00	UC6S3/4UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.88-06.00	–	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.88-12 – Insert selection – mm/*Inch*

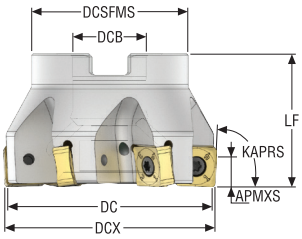
SMG		a_p	f_z		
			70%	40%	20%
P1	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,14 *0.0055*	0,14 *0.0055*	0,18 *0.0070*
P2	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
P3	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,14 *0.0055*	0,14 *0.0055*	0,17 *0.0065*
P4	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
P5	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P6	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P7	SNMU120410TN-M10 MP2501	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P8	SNMU120410TN-M10 MS2500	5,0 *0.20*	0,14 *0.0055*	0,14 *0.0055*	0,17 *0.0065*
P11	SNMU120410TN-M10 MS2500	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P12	SNMU120410TN-M10 MS2500	4,5 *0.18*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K1	SNMU120410TN-MD13 MK1500	5,0 *0.20*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
K2	SNMU120410TN-MD13 MK1500	5,0 *0.20*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
K3	SNMU120410TN-M10 MP1501	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
K4	SNMU120410TN-M10 MP1501	5,0 *0.20*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
K5	SNMU120410TN-MD13 MP1501	5,0 *0.20*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
K6	SNMU120410TN-MD13 MK2050	5,0 *0.20*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
K7	SNMU120410TN-MD13 MK2050	5,0 *0.20*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
H5	SNMU120410TN-MD13 MP1501	4,5 *0.18*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*
H8	SNMU120410TN-MD13 MP1501	4,0 *0.16*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
H11	SNMU120410TN-MD13 MP1501	4,5 *0.18*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*
H12	SNMU120410TN-MD13 MP1501	4,0 *0.16*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
H21	SNMU120410TN-MD13 MP1501	4,0 *0.16*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*

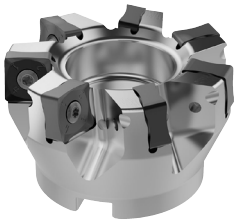
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.88-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			MS2500			MK1500			MK2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	220 *720*	255 *840*	285 *940*	330 *1075*	380 *1250*	430 *1400*	290 *950*	340 *1125*	380 *1250*	320 *1050*	370 *1225*	415 *1350*	— —	— —	— —	290 *950*	335 *1100*	375 *1225*
P2	215 *710*	245 *800*	280 *920*	320 *1050*	365 *1200*	415 *1350*	285 *940*	325 *1075*	370 *1225*	310 *1025*	355 *1175*	405 *1325*	— —	— —	— —	280 *920*	320 *1050*	365 *1200*
P3	185 *610*	215 *710*	245 *800*	275 *900*	320 *1050*	365 *1200*	245 *800*	285 *940*	325 *1075*	265 *870*	310 *1025*	350 *1150*	— —	— —	— —	240 *790*	280 *920*	320 *1050*
P4	165 *540*	190 *620*	215 *710*	250 *820*	280 *920*	320 *1050*	220 *720*	250 *820*	285 *940*	240 *790*	275 *900*	310 *1025*	— —	— —	— —	215 *710*	245 *800*	280 *920*
P5	160 *520*	185 *610*	210 *690*	235 *770*	275 *900*	310 *1025*	210 *690*	245 *800*	275 *900*	230 *750*	265 *870*	300 *980*	— —	— —	— —	205 *670*	240 *790*	270 *890*
P6	180 *590*	205 *670*	235 *770*	265 *870*	310 *1025*	350 *1150*	235 *770*	275 *900*	310 *1025*	255 *840*	300 *980*	340 *1125*	— —	— —	— —	230 *750*	270 *890*	305 *1000*
P7	170 *560*	195 *640*	220 *720*	250 *820*	290 *950*	330 *1075*	225 *740*	260 *850*	290 *950*	245 *800*	280 *920*	320 *1050*	— —	— —	— —	220 *720*	255 *840*	290 *950*
P8	155 *510*	180 *590*	205 *670*	230 *750*	270 *890*	305 *1000*	205 *670*	240 *790*	270 *890*	225 *740*	260 *850*	295 *970*	— —	— —	— —	200 *660*	235 *770*	265 *870*
P11	165 *540*	190 *620*	215 *710*	245 *800*	285 *940*	320 *1050*	215 *710*	250 *820*	285 *940*	235 *770*	275 *900*	310 *1025*	— —	— —	— —	215 *710*	245 *800*	280 *920*
P12	105 *345*	125 *410*	140 *460*	160 *520*	185 *610*	210 *690*	140 *460*	165 *540*	185 *610*	155 *510*	180 *590*	200 *660*	— —	— —	— —	140 *460*	160 *520*	180 *590*
K1	170 *560*	195 *640*	220 *720*	255 *840*	290 *950*	330 *1075*	225 *740*	255 *840*	290 *950*	— —	— —	— —	320 *1050*	365 *1200*	415 *1350*	300 *980*	345 *1125*	390 *1275*
K2	150 *490*	175 *570*	200 *660*	225 *740*	260 *850*	295 *970*	200 *660*	230 *750*	260 *850*	— —	— —	— —	285 *940*	330 *1075*	370 *1225*	270 *890*	310 *1025*	350 *1150*
K3	130 *425*	150 *490*	170 *560*	190 *620*	220 *720*	250 *820*	170 *560*	195 *640*	220 *720*	— —	— —	— —	240 *790*	275 *900*	315 *1025*	225 *740*	260 *850*	295 *970*
K4	120 *395*	140 *460*	160 *520*	180 *590*	210 *690*	240 *790*	160 *520*	185 *610*	210 *690*	— —	— —	— —	230 *750*	265 *870*	300 *980*	215 *710*	250 *820*	285 *940*
K5	75 *245*	85 *280*	95 *310*	110 *360*	130 *425*	145 *475*	100 *330*	115 *375*	130 *425*	— —	— —	— —	140 *460*	160 *520*	180 *590*	130 *425*	150 *490*	170 *560*
K6	110 *360*	125 *410*	140 *460*	160 *520*	185 *610*	210 *690*	140 *460*	165 *540*	185 *610*	— —	— —	— —	200 *660*	235 *770*	265 *870*	190 *620*	220 *720*	250 *820*
K7	95 *310*	110 *360*	125 *410*	140 *460*	165 *540*	185 *610*	125 *410*	145 *475*	165 *540*	— —	— —	— —	180 *590*	205 *670*	230 *750*	170 *560*	195 *640*	220 *720*
H5	36 *120*	41 *135*	46 *150*	55 *180*	60 *195*	70 *230*	43 *140*	49 *160*	55 *180*	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	38 *125*	44 *145*	49 *160*	55 *180*	65 *215*	75 *245*	46 *150*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	45 *150*	50 *165*	60 *195*	70 *230*	80 *260*	90 *295*	55 *180*	65 *215*	70 *230*	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	70 *230*	80 *260*	90 *295*	100 *330*	115 *375*	130 *425*	90 *295*	105 *345*	115 *375*	— —	— —	— —	— —	— —	— —	— —	— —	— —

R220.88-16 – Metric



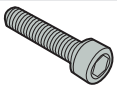


- For insert selection and cutting data recommendations, see page(s) 263-264
- For complete insert programme, see page(s) 766
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.88-0063-16-4SA	03091383	Arbor	63,0	4	13,0	88,0	64,5	22,0	47,0	40,0	7100	0,5	SNMU1606..
R220.88-0063-16-5SA	03091392	Arbor	63,0	5	13,0	88,0	64,5	22,0	47,0	40,0	7100	0,5	SNMU1606..
R220.88-0080-16-6SA	03091384	Arbor	80,0	6	13,0	88,0	81,5	27,0	62,0	50,0	6300	1,0	SNMU1606..
R220.88-0080-16-7SA	03091393	Arbor	80,0	7	13,0	88,0	81,5	27,0	62,0	50,0	6300	1,0	SNMU1606..
R220.88-0100-16-8SA	03091385	Arbor	100,0	8	13,0	88,0	101,5	32,0	77,0	50,0	5600	1,6	SNMU1606..
R220.88-0100-16-9SA	03091394	Arbor	100,0	9	13,0	88,0	101,5	32,0	77,0	50,0	5600	1,6	SNMU1606..
R220.88-0125-16-10SA	03091386	Arbor	125,0	10	13,0	88,0	126,5	40,0	90,0	63,0	5000	3,0	SNMU1606..
R220.88-0125-16-11SA	03091395	Arbor	125,0	11	13,0	88,0	126,5	40,0	90,0	63,0	5000	3,0	SNMU1606..
R220.88-8160-16-12S	03091387	Arbor	160,0	12	13,0	88,0	161,5	40,0	90,0	63,0	4400	5,1	SNMU1606..
R220.88-8160-16-13S	03091396	Arbor	160,0	13	13,0	88,0	161,5	40,0	90,0	63,0	4400	5,0	SNMU1606..

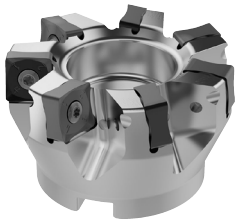
Spare Parts

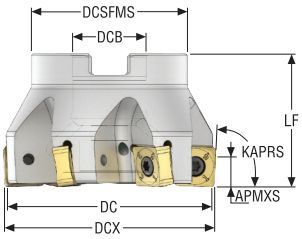
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.88-0063	220.17-692	C05013-T20P	T00-20P50	5.0NM
R220.88-0080-8160	–	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.88-16 – Inch





- For insert selection and cutting data recommendations, see page(s) 263-264
- For complete insert programme, see page(s) 766
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.88-03.00-16-6SA	03091388	Arbor	3.000	6	0.512	88.0	3.039	1.000	2.441	1.969	6300	2.200	SNMU1606..
R220.88-03.00-16-7SA	03091397	Arbor	3.000	7	0.531	88.0	3.039	1.000	2.441	1.969	6300	2.200	SNMU1606..
R220.88-04.00-16-8SA	03091389	Arbor	4.000	8	0.512	88.0	4.039	1.500	3.031	1.969	5600	3.530	SNMU1606..
R220.88-04.00-16-9SA	03091398	Arbor	4.000	9	0.531	88.0	4.039	1.500	3.031	1.969	5600	3.530	SNMU1606..
R220.88-05.00-16-10SA	03091390	Arbor	5.000	10	0.512	88.0	5.039	1.500	3.543	2.480	5000	7.500	SNMU1606..
R220.88-05.00-16-11SA	03091399	Arbor	5.000	11	0.531	88.0	5.039	1.500	3.543	2.480	5000	7.500	SNMU1606..
R220.88-06.00-16-12S	03091391	Arbor	6.000	12	0.512	88.0	6.039	2.000	4.331	2.480	4400	9.920	SNMU1606..
R220.88-06.00-16-13S	03091400	Arbor	6.000	13	0.531	88.0	6.039	2.000	4.331	2.480	4400	9.920	SNMU1606..

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.88-03.00	UC6S1/2UNFX1-1/4	C05013-T20P	T00-20P50	44.3IN.LBS
R220.88-04.00-05.00	UC6S3/4UNFX1-1/4	C05013-T20P	T00-20P50	44.3IN.LBS
R220.88-06.00	–	C05013-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.88-16 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,18 *0.0070*
P2	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
P3	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,17 *0.0065*
P4	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
P5	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P6	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P7	SNMU160612TN-M10 MP2501	8,0 *0.32*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P8	SNMU160612TN-M10 MS2500	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,17 *0.0065*
P11	SNMU160612TN-M10 MS2500	8,0 *0.32*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
P12	SNMU160612TN-M10 MS2500	6,0 *0.24*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
K1	SNMU160612TN-MD16 MK1500	8,0 *0.32*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*
K2	SNMU160612TN-MD16 MK1500	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
K3	SNMU160612TN-MD16 MP1501	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
K4	SNMU160612TN-MD16 MP1501	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
K5	SNMU160612TN-MD16 MP1501	8,0 *0.32*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
K6	SNMU160612TN-MD16 MK2050	8,0 *0.32*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
K7	SNMU160612TN-MD16 MK2050	8,0 *0.32*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
H5	SNMU160612TN-MD16 MP1501	6,0 *0.24*	0,14 *0.0055*	0,14 *0.0055*	0,18 *0.0070*
H8	SNMU160612TN-MD16 MP1501	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
H11	SNMU160612TN-MD16 MP1501	6,0 *0.24*	0,14 *0.0055*	0,14 *0.0055*	0,18 *0.0070*
H12	SNMU160612TN-MD16 MP1501	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
H21	SNMU160612TN-MD16 MP1501	5,0 *0.20*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.88-16 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			MS2500			MK1500			MK2050		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	160	190	215	325	380	425	290	335	375	315	365	410	—	—	—	285	330	370
	520	*620*	*710*	*1075*	*1250*	*1400*	*950*	*1100*	*1225*	*1025*	*1200*	*1350*	—	—	—	*940*	*1075*	*1225*
P2	160	180	210	315	360	410	280	320	365	305	350	400	—	—	—	275	315	360
	520	*590*	*690*	*1025*	*1175*	*1350*	*920*	*1050*	*1200*	*1000*	*1150*	*1300*	—	—	—	*900*	*1025*	*1175*
P3	135	160	180	275	315	360	240	280	320	265	305	350	—	—	—	240	275	315
	445	*520*	*590*	*900*	*1025*	*1175*	*790*	*920*	*1050*	*870*	*1000*	*1150*	—	—	—	*790*	*900*	*1025*
P4	120	140	160	245	280	315	220	245	280	235	270	305	—	—	—	215	245	275
	395	*460*	*520*	*800*	*920*	*1025*	*720*	*800*	*920*	*770*	*890*	*1000*	—	—	—	*710*	*800*	*900*
P5	120	135	155	235	270	310	210	240	275	225	265	295	—	—	—	205	235	270
	395	*445*	*510*	*770*	*890*	*1025*	*690*	*790*	*900*	*740*	*870*	*970*	—	—	—	*670*	*770*	*890*
P6	135	150	175	265	305	345	235	270	305	255	295	335	—	—	—	230	265	300
	445	*490*	*570*	*870*	*1000*	*1125*	*770*	*890*	*1000*	*840*	*970*	*1100*	—	—	—	*750*	*870*	*980*
P7	125	140	165	250	290	325	220	255	290	240	280	315	—	—	—	215	250	285
	410	*460*	*540*	*820*	*950*	*1075*	*720*	*840*	*950*	*790*	*920*	*1025*	—	—	—	*710*	*820*	*940*
P8	115	135	150	230	265	305	205	235	270	220	255	295	—	—	—	200	230	265
	375	*445*	*490*	*750*	*870*	*1000*	*670*	*770*	*890*	*720*	*840*	*970*	—	—	—	*660*	*750*	*870*
P11	120	135	160	240	280	315	215	250	280	235	270	305	—	—	—	210	245	275
	395	*445*	*520*	*790*	*920*	*1025*	*710*	*820*	*920*	*770*	*890*	*1000*	—	—	—	*690*	*800*	*900*
P12	80	95	105	160	180	205	140	160	180	155	175	200	—	—	—	140	160	180
	260	*310*	*345*	*520*	*590*	*670*	*460*	*520*	*590*	*510*	*570*	*660*	—	—	—	*460*	*520*	*590*
K1	125	140	165	250	285	325	220	255	290	—	—	—	315	360	410	300	340	390
	410	*460*	*540*	*820*	*940*	*1075*	*720*	*840*	*950*	—	—	—	*1025*	*1175*	*1350*	*980*	*1125*	*1275*
K2	110	125	145	225	260	290	195	230	260	—	—	—	280	325	365	265	305	345
	360	*410*	*475*	*740*	*850*	*950*	*640*	*750*	*850*	—	—	—	*920*	*1075*	*1200*	*870*	*1000*	*1125*
K3	95	105	125	190	220	245	165	195	220	—	—	—	235	275	310	225	260	295
	310	*345*	*410*	*620*	*720*	*800*	*540*	*640*	*720*	—	—	—	*770*	*900*	*1025*	*740*	*850*	*970*
K4	90	100	120	180	210	235	160	185	210	—	—	—	225	260	295	215	250	280
	295	*330*	*395*	*590*	*690*	*770*	*520*	*610*	*690*	—	—	—	*740*	*850*	*970*	*710*	*820*	*920*
K5	55	65	70	110	125	145	95	110	125	—	—	—	140	160	180	130	150	170
	180	*215*	*230*	*360*	*410*	*475*	*310*	*360*	*410*	—	—	—	*460*	*520*	*590*	*425*	*490*	*560*
K6	80	90	105	160	185	210	140	165	185	—	—	—	200	230	260	190	220	245
	260	*295*	*345*	*520*	*610*	*690*	*460*	*540*	*610*	—	—	—	*660*	*750*	*850*	*620*	*720*	*800*
K7	70	80	90	140	160	185	125	145	160	—	—	—	175	205	230	165	195	215
	230	*260*	*295*	*460*	*520*	*610*	*410*	*475*	*520*	—	—	—	*570*	*670*	*750*	*540*	*640*	*710*
H5	27	31	35	50	60	70	42	49	55	—	—	—	—	—	—	—	—	—
	90	*100*	*115*	*165*	*195*	*230*	*140*	*160*	*180*	—	—	—	—	—	—	—	—	—
H11	34	39	44	65	75	85	55	60	70	—	—	—	—	—	—	—	—	—
	110	*130*	*145*	*215*	*245*	*280*	*180*	*195*	*230*	—	—	—	—	—	—	—	—	—
H12	50	60	65	100	115	130	90	100	115	—	—	—	—	—	—	—	—	—
	165	*195*	*215*	*330*	*375*	*425*	*295*	*330*	*375*	—	—	—	—	—	—	—	—	—

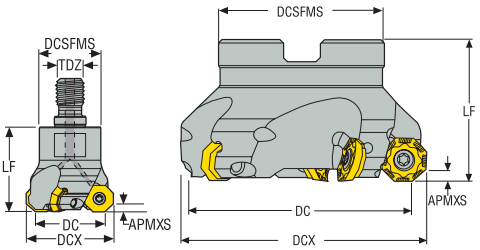
OCTOMILL 05/07

Octomill™ 05 and 07 provide one of the most comprehensive ranges of face milling cutters on the market. Designed to handle many applications, Octomill 05 and 07 offer high performance and process security. These cutters excel in medium to rough machining in steel and stainless steel. With eight edges, the cutters are more economical than traditional cutters due to a lower cost per cutting edge.

- Insert size 05, cutter range 32-315mm (1.25-12.40 inch)
- Insert size 07, cutter range 50-315mm (2-12.40 inch)
- Octomill 05 is for small machines and Octomill 07 is for medium sized machines

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Octomill R217/R220.43-05 – Metric



- For insert selection and cutting data recommendations, see page(s) 269 - 271
- For complete insert programme, see page(s) 743
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	TDZ	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm		mm	mm		kg	
R217.43-1632.RE-05.3A	00005768	Combimaster	32,0	3	3,5	43,0	40,0	–	M16	30,0	40,0	14800	0,3	OFEX/OFMT05
R217.43-1642.RE-05.3A	00005769	Combimaster	42,0	3	3,5	43,0	50,0	–	M16	30,0	40,0	13000	0,3	OFEX/OFMT05
R220.43-0032-05	75069157	Arbor	32,0	3	3,5	43,0	41,0	16,0	–	35,0	40,0	14800	0,2	OFEX/OFMT05
R220.43-0040-05	75069158	Arbor	40,0	3	3,5	43,0	49,0	16,0	–	35,0	40,0	13200	0,3	OFEX/OFMT05
R220.43-0040-05-4A	00026516	Arbor	40,0	4	3,5	43,0	49,0	16,0	–	35,0	40,0	13200	0,3	OFEX/OFMT05
R220.43-0050-05	75069159	Arbor	50,0	4	3,5	43,0	59,0	22,0	–	47,0	40,0	11900	0,4	OFEX/OFMT05
R220.43-0050-05-5A	00026517	Arbor	50,0	5	3,5	43,0	59,0	22,0	–	47,0	40,0	11900	0,4	OFEX/OFMT05
R220.43-0063-05	75069160	Arbor	63,0	5	3,5	43,0	72,0	22,0	–	47,0	40,0	10600	0,6	OFEX/OFMT05
R220.43-0063-05-6A	00026518	Arbor	63,0	6	3,5	43,0	72,0	22,0	–	47,0	40,0	10600	0,5	OFEX/OFMT05
R220.43-0080-05	75069161	Arbor	80,0	6	3,5	43,0	89,0	27,0	–	62,0	50,0	9400	1,1	OFEX/OFMT05
R220.43-0080-05-8A	00026519	Arbor	80,0	8	3,5	43,0	89,0	27,0	–	62,0	50,0	9400	1,1	OFEX/OFMT05
R220.43-0100-05	75069162	Arbor	100,0	7	3,5	43,0	109,0	32,0	–	77,0	50,0	8400	1,8	OFEX/OFMT05
R220.43-0125-05	75079618	Arbor	125,0	8	3,5	43,0	134,0	40,0	–	90,0	63,0	7500	3,3	OFEX/OFMT05
R220.43-8160-05	75080766	Arbor	160,0	10	3,5	43,0	169,0	40,0	–	90,0	63,0	6600	5,1	OFEX/OFMT05

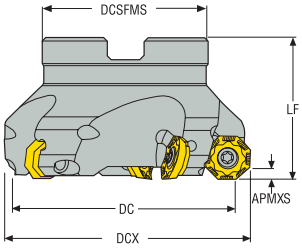
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.43-..	–	C04008-T15P	T00-15P35	3.5NM
R220.43-0032	220.17-690	C04008-T15P	T00-15P35	3.5NM
R220.43-0040	TCEI0825	C04008-T15P	T00-15P35	3.5NM
R220.43-0050-0063	220.17-692	C04008-T15P	T00-15P35	3.5NM
R220.43-0080-8160	–	C04008-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Octomill R220.43-05 – Inch



- For insert selection and cutting data recommendations, see page(s) 269 - 271
- For complete insert programme, see page(s) 743
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.43-01.50-05	00086837	Arbor	1.575	3	0.138	43.0	2.047	0.500	1.378	1.575	13200	0.880	OFEX/OFMT05
R220.43-02.00-05	00086838	Arbor	1.969	4	0.138	43.0	2.441	0.750	1.850	1.575	11900	1.100	OFEX/OFMT05
R220.43-02.50-05	00086839	Arbor	2.480	5	0.138	43.0	2.953	0.750	1.850	1.575	10600	1.320	OFEX/OFMT05
R220.43-03.00-05	00086840	Arbor	3.150	6	0.138	43.0	3.622	1.000	2.441	1.969	9400	2.870	OFEX/OFMT05
R220.43-04.00-05	00086841	Arbor	3.937	7	0.138	43.0	4.291	1.500	3.543	1.969	8400	4.190	OFEX/OFMT05

Spare Parts

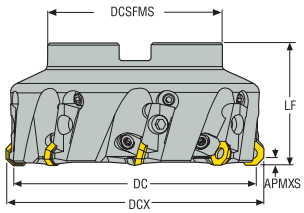
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.43-1.50	UC6S1/4UNFX1	C04008-T15P	T00-15P35	31.0IN.LBS
R220.43-02.00	UC6S3/8UNFX1	C04008-T15P	T00-15P35	31.0IN.LBS
R220.43-02.50-04.00	–	C04008-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Octomill R220.43-05C/CT/CG – Metric

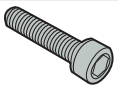
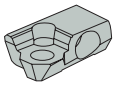
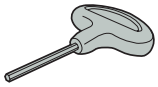


- For insert selection and cutting data recommendations, see page(s) 269 - 271
- For complete insert programme, see page(s) 743
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.43-0100-05C	00090985	Arbor	100,0	6	3,5	43,0	109,0	32,0	77,0	50,0	4300	2,5	OFEX05T305
R220.43-0125-05C	00090988	Arbor	125,0	8	3,5	43,0	134,0	40,0	90,0	63,0	3800	3,7	OFEX05T305
R220.43-0125-05CT	00090989	Arbor	125,0	10	3,5	43,0	134,0	40,0	90,0	63,0	3800	4,0	OFEX05T305
R220.43-8160-05C	00090991	Arbor	160,0	10	3,5	43,0	169,0	40,0	90,0	63,0	3300	5,8	OFEX05T305
R220.43-8160-05CT	00090992	Arbor	160,0	14	3,5	43,0	169,0	40,0	90,0	63,0	3300	5,8	OFEX05T305
R220.43-8160-05CG	00090990	Arbor	160,0	7	3,5	43,0	169,0	40,0	90,0	63,0	3300	5,9	OFEX05T305
R220.43-8200-05C	00090994	Arbor	200,0	12	3,5	43,0	209,0	60,0	130,0	63,0	3000	8,4	OFEX05T305
R220.43-8200-05CT	00090995	Arbor	200,0	18	3,5	43,0	209,0	60,0	130,0	63,0	3000	7,4	OFEX05T305
R220.43-8250-05C	00090997	Arbor	250,0	16	3,5	43,0	259,0	60,0	130,0	63,0	2700	14,3	OFEX05T305
R220.43-8250-05CT	00090998	Arbor	250,0	22	3,5	43,0	259,0	60,0	130,0	63,0	2700	19,0	OFEX05T305
R220.43-8315-05C	00091000	Arbor	315,0	20	3,5	43,0	324,0	60,0	225,0	80,0	2400	28,0	OFEX05T305
R220.43-8315-05CT	00091001	Arbor	315,0	28	3,5	43,0	324,0	60,0	225,0	80,0	2400	27,5	OFEX05T305

Spare Parts

Accessories

For cutter	Arbor screw	Cassette	Cassette screw	Insert wedge	Key	Setting gauge	Wedge screw	Nest key
								
R220.43-0100	220.17-694	OF05AR	FS96018	CW0810	–	AU1114T-T15P	LD8020-T25P	H05-4
R220.43-0125-8160C/CG	–	OF05AR	FS96018	CW0810	–	AU1114T-T15P	LD8020-T25P	H05-4
R220.43-0125-8315CT	–	OF05AR	FS96018	334.5-640	–	AU1114T-T15P	LD8020-T25P	–
R220.43-8250	–	OF05AR	FS96018	334.5-640	H6B-T25PL	AU1114T-T15P	LD8020-T25P	–
R220.43-8315-05C	–	OF05AR	FS96018	CW0810	–	AU1114T-T15P	LD8020-T25P	H05-4
R220.43-8315-05CT	–	OF05AR	FS96018	334.5-640	–	AU1114T-T15P	LD8020-T25P	–

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.43-05 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	OFEX05T305TN-ME07 T350M	2,0 *0.080*	0,14 *0.0055*	0,15 *0.0060*	0,18 *0.0070*
P2	OFEX05T305TN-ME07 T350M	2,0 *0.080*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
P3	OFEX05T305TN-ME07 MP2501	2,0 *0.080*	0,14 *0.0055*	0,14 *0.0055*	0,18 *0.0070*
P4	OFEX05T305TN-M08 MP2501	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
P5	OFEX05T305TN-M08 MP2501	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
P6	OFEX05T305TN-M08 MP2501	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
P7	OFEX05T305TN-M08 MP2501	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
P8	OFEX05T305TN-M08 T350M	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,20 *0.0080*
P11	OFEX05T305TN-M08 T350M	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
P12	OFEX05T305TN-M08 T350M	1,7 *0.065*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*
M1	OFEX05T305TN-ME07 F40M	2,0 *0.080*	0,15 *0.0060*	0,15 *0.0060*	0,19 *0.0075*
M2	OFEX05T305TN-ME07 F40M	2,0 *0.080*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
M3	OFEX05T305TN-ME07 T350M	1,7 *0.065*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
M4	OFEX05T305TN-ME07 T350M	1,3 *0.050*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
M5	OFEX05T305TN-ME07 T350M	1,3 *0.050*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
K1	OFEX05T305TN-M08 MK1500	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
K2	OFEX05T305TN-M08 MK1500	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
K3	OFEX05T305TN-D09 MP1501	2,0 *0.080*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
K4	OFEX05T305TN-D09 MP1501	2,0 *0.080*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
K5	OFEX05T305TN-D09 MP1501	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
K6	OFEX05T305TN-D09 MP1501	2,0 *0.080*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
K7	OFEX05T305TN-D09 MP1501	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
N1	OFEX05T305N-E04 H15	2,0 *0.080*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
N2	OFEX05T305N-E04 H15	2,0 *0.080*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
N3	OFEX05T305N-E04 H15	2,0 *0.080*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
N11	OFEX05T305N-E04 H15	2,0 *0.080*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
S1	OFEX05T305TN-ME07 T350M	1,3 *0.050*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
S2	OFEX05T305TN-ME07 T350M	1,3 *0.050*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
S3	OFEX05T305TN-ME07 T350M	1,3 *0.050*	0,085 *0.0034*	0,090 *0.0036*	0,11 *0.0044*
S11	OFEX05T305TN-ME07 F40M	1,5 *0.060*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0050*
S12	OFEX05T305TN-ME07 F40M	1,5 *0.060*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0050*
S13	OFEX05T305TN-ME07 F40M	1,3 *0.050*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
H5	OFEX05T305TN-D09 MP1501	1,7 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H8	OFEX05T305TN-D09 MP1501	1,5 *0.060*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
H11	OFEX05T305TN-D09 MP1501	1,7 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
H12	OFEX05T305TN-D09 MP1501	1,5 *0.060*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
H21	OFEX05T305TN-D09 MP1501	1,5 *0.060*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.43-05 – Cutting data v_c = (m/min)/*(sf/min)*

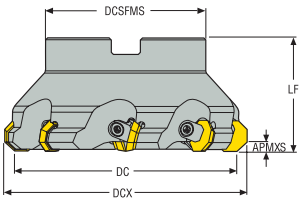
SMG	F40M			T350M			MP1501			MP2501			T25M		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	250 *820*	280 *920*	325 *1075*	335 *1100*	375 *1225*	430 *1400*	355 *1175*	410 *1350*	460 *1500*	330 *1075*	375 *1225*	425 *1400*	320 *1050*	360 *1175*	410 *1350*
P2	240 *790*	275 *900*	305 *1000*	320 *1050*	365 *1200*	420 *1375*	345 *1125*	395 *1300*	445 *1450*	315 *1025*	365 *1200*	405 *1325*	305 *1000*	350 *1150*	400 *1300*
P3	210 *690*	240 *790*	270 *890*	280 *920*	320 *1050*	365 *1200*	300 *980*	345 *1125*	395 *1300*	275 *900*	315 *1025*	355 *1175*	265 *870*	310 *1025*	350 *1150*
P4	185 *610*	210 *690*	240 *790*	245 *800*	285 *940*	320 *1050*	270 *890*	305 *1000*	345 *1125*	240 *790*	280 *920*	315 *1025*	235 *770*	270 *890*	305 *1000*
P5	180 *590*	200 *660*	230 *750*	240 *790*	270 *890*	305 *1000*	255 *840*	290 *950*	330 *1075*	235 *770*	265 *870*	305 *1000*	230 *750*	260 *850*	295 *970*
P6	200 *660*	230 *750*	260 *850*	270 *890*	305 *1000*	345 *1125*	290 *950*	335 *1100*	370 *1225*	265 *870*	305 *1000*	340 *1125*	255 *840*	290 *950*	330 *1075*
P7	190 *620*	220 *720*	245 *800*	255 *840*	285 *940*	325 *1075*	270 *890*	315 *1025*	350 *1150*	250 *820*	285 *940*	320 *1050*	240 *790*	275 *900*	310 *1025*
P8	175 *570*	200 *660*	225 *740*	235 *770*	270 *890*	305 *1000*	250 *820*	290 *950*	330 *1075*	230 *750*	265 *870*	300 *980*	225 *740*	260 *850*	295 *970*
P11	185 *610*	210 *690*	235 *770*	245 *800*	280 *920*	315 *1025*	265 *870*	305 *1000*	340 *1125*	240 *790*	280 *920*	315 *1025*	235 *770*	265 *870*	300 *980*
P12	120 *395*	135 *445*	155 *510*	160 *520*	180 *590*	205 *670*	170 *560*	195 *640*	220 *720*	160 *520*	180 *590*	200 *660*	150 *490*	170 *560*	195 *640*
M1	190 *620*	220 *720*	245 *800*	245 *800*	285 *940*	320 *1050*	— —	— —	— —	225 *740*	260 *850*	290 *950*	245 *800*	285 *940*	320 *1050*
M2	160 *520*	180 *590*	205 *670*	205 *670*	235 *770*	265 *870*	— —	— —	— —	190 *620*	215 *710*	245 *800*	205 *670*	235 *770*	265 *870*
M3	130 *425*	150 *490*	165 *540*	165 *540*	190 *620*	215 *710*	— —	— —	— —	155 *510*	175 *570*	200 *640*	165 *540*	190 *620*	215 *710*
M4	100 *330*	115 *375*	130 *425*	125 *410*	145 *475*	165 *540*	— —	— —	— —	115 *375*	135 *445*	155 *510*	125 *410*	145 *475*	165 *540*
M5	85 *280*	95 *310*	110 *360*	105 *345*	120 *395*	135 *445*	— —	— —	— —	95 *310*	110 *360*	130 *410*	105 *345*	120 *395*	135 *445*
K1	190 *620*	220 *720*	245 *800*	— —	— —	— —	270 *890*	315 *1025*	355 *1175*	250 *820*	285 *940*	320 *1050*	— —	— —	— —
K2	170 *560*	190 *620*	220 *720*	— —	— —	— —	245 *800*	275 *900*	315 *1025*	225 *740*	255 *840*	290 *950*	— —	— —	— —
K3	145 *475*	160 *520*	185 *610*	— —	— —	— —	205 *670*	235 *770*	265 *870*	190 *620*	215 *710*	245 *800*	— —	— —	— —
K4	135 *445*	155 *510*	175 *570*	— —	— —	— —	195 *640*	225 *740*	255 *840*	180 *590*	205 *670*	235 *770*	— —	— —	— —
K5	85 *280*	95 *310*	110 *360*	— —	— —	— —	120 *395*	135 *445*	155 *510*	110 *360*	125 *410*	145 *475*	— —	— —	— —
K6	120 *395*	135 *445*	155 *510*	— —	— —	— —	175 *570*	195 *640*	225 *740*	160 *520*	180 *590*	205 *670*	— —	— —	— —
K7	105 *345*	120 *395*	140 *460*	— —	— —	— —	155 *510*	175 *570*	200 *660*	140 *460*	160 *520*	185 *610*	— —	— —	— —
N1	1375 *4500*	1600 *5250*	1850 *6075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	560 *1825*	650 *2125*	740 *2425*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	370 *1225*	430 *1400*	495 *1625*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	425 *1400*	495 *1625*	570 *1875*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	46 *150*	55 *180*	60 *195*	60 *195*	70 *230*	75 *245*	— —	— —	— —	55 *180*	65 *215*	75 *245*	— —	— —	— —
S2	37 *120*	43 *140*	49 *160*	48 *155*	55 *180*	60 *195*	— —	— —	— —	46 *150*	55 *180*	60 *195*	— —	— —	— —
S3	33 *110*	38 *125*	43 *140*	42 *140*	48 *155*	55 *180*	— —	— —	— —	40 *130*	46 *150*	55 *165*	— —	— —	— —
S11	65 *215*	75 *245*	85 *280*	85 *280*	95 *310*	110 *360*	— —	— —	— —	80 *260*	90 *295*	105 *345*	— —	— —	— —
S12	45 *150*	50 *165*	60 *195*	55 *180*	65 *215*	75 *245*	— —	— —	— —	55 *180*	65 *215*	70 *230*	— —	— —	— —
S13	26 *85*	30 *100*	34 *110*	33 *110*	38 *125*	43 *140*	— —	— —	— —	32 *105*	37 *120*	42 *140*	— —	— —	— —
H5	40 *130*	45 *150*	50 *165*	55 *180*	60 *195*	70 *230*	55 *180*	65 *215*	75 *245*	48 *155*	55 *180*	60 *195*	— —	— —	— —
H8	42 *140*	48 *155*	55 *180*	55 *180*	65 *215*	70 *230*	60 *195*	70 *230*	80 *260*	50 *165*	55 *180*	65 *215*	— —	— —	— —
H11	50 *165*	55 *180*	65 *215*	65 *215*	75 *245*	85 *280*	70 *230*	85 *280*	95 *310*	60 *195*	70 *230*	80 *260*	— —	— —	— —
H12	75 *245*	85 *280*	95 *310*	100 *330*	115 *375*	130 *425*	110 *360*	125 *410*	140 *460*	100 *330*	115 *375*	125 *410*	— —	— —	— —
H21	42 *140*	48 *155*	55 *180*	55 *180*	65 *215*	70 *230*	60 *195*	70 *230*	80 *260*	50 *165*	55 *180*	65 *215*	— —	— —	— —

R217/220.43-05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			F30M			F15M			H15		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	295	330	375	—	—	—	—	—	—
	—	—	—	*970*	*1075*	*1225*	—	—	—	—	—	—
P2	—	—	—	285	320	365	—	—	—	—	—	—
	—	—	—	*940*	*1050*	*1200*	—	—	—	—	—	—
P3	—	—	—	245	285	320	—	—	—	—	—	—
	—	—	—	*800*	*940*	*1050*	—	—	—	—	—	—
P4	—	—	—	220	250	280	—	—	—	—	—	—
	—	—	—	*720*	*820*	*920*	—	—	—	—	—	—
P5	—	—	—	210	240	270	—	—	—	—	—	—
	—	—	—	*690*	*790*	*890*	—	—	—	—	—	—
P6	—	—	—	235	270	305	—	—	—	—	—	—
	—	—	—	*770*	*890*	*1000*	—	—	—	—	—	—
P7	—	—	—	225	255	285	—	—	—	—	—	—
	—	—	—	*740*	*840*	*940*	—	—	—	—	—	—
P8	—	—	—	210	240	270	—	—	—	—	—	—
	—	—	—	*690*	*790*	*890*	—	—	—	—	—	—
P11	—	—	—	215	250	275	—	—	—	—	—	—
	—	—	—	*710*	*820*	*900*	—	—	—	—	—	—
P12	—	—	—	140	160	175	—	—	—	—	—	—
	—	—	—	*460*	*520*	*570*	—	—	—	—	—	—
M1	—	—	—	230	260	295	—	—	—	—	—	—
	—	—	—	*750*	*850*	*970*	—	—	—	—	—	—
M2	—	—	—	190	215	245	—	—	—	—	—	—
	—	—	—	*620*	*710*	*800*	—	—	—	—	—	—
M3	—	—	—	150	170	195	—	—	—	—	—	—
	—	—	—	*490*	*560*	*640*	—	—	—	—	—	—
M4	—	—	—	115	130	150	—	—	—	—	—	—
	—	—	—	*375*	*425*	*490*	—	—	—	—	—	—
M5	—	—	—	100	110	125	—	—	—	—	—	—
	—	—	—	*330*	*360*	*410*	—	—	—	—	—	—
K1	350	405	455	225	255	290	305	350	390	—	—	—
	1150	*1325*	*1500*	*740*	*840*	*950*	*1000*	*1150*	*1275*	—	—	—
K2	315	360	410	200	225	255	275	310	350	—	—	—
	1025	*1175*	*1350*	*660*	*740*	*840*	*900*	*1025*	*1150*	—	—	—
K3	270	305	345	170	190	215	230	260	295	—	—	—
	890	*1000*	*1125*	*560*	*620*	*710*	*750*	*850*	*970*	—	—	—
K4	255	290	330	160	185	205	220	250	280	—	—	—
	840	*950*	*1075*	*520*	*610*	*670*	*720*	*820*	*920*	—	—	—
K5	155	180	200	100	110	125	135	150	170	—	—	—
	510	*590*	*660*	*330*	*360*	*410*	*445*	*490*	*560*	—	—	—
K6	225	255	290	140	160	180	195	220	250	—	—	—
	740	*840*	*950*	*460*	*520*	*590*	*640*	*720*	*820*	—	—	—
K7	200	230	260	125	140	160	170	195	220	—	—	—
	660	*750*	*850*	*410*	*460*	*520*	*560*	*640*	*720*	—	—	—
N1	—	—	—	1675	1900	2150	2275	2625	2975	1800	2075	2375
	—	—	—	*5500*	*6225*	*7050*	*7475*	*8600*	*9750*	*5900*	*6800*	*7800*
N2	—	—	—	680	770	870	920	1050	1200	730	840	950
	—	—	—	*2225*	*2525*	*2850*	*3025*	*3450*	*3925*	*2400*	*2750*	*3125*
N3	—	—	—	455	510	580	620	710	800	485	560	640
	—	—	—	*1500*	*1675*	*1900*	*2025*	*2325*	*2625*	*1600*	*1825*	*2100*
N11	—	—	—	520	590	660	700	810	920	560	640	730
	—	—	—	*1700*	*1925*	*2175*	*2300*	*2650*	*3025*	*1825*	*2100*	*2400*
S1	—	—	—	55	60	70	—	—	—	—	—	—
	—	—	—	*180*	*195*	*230*	—	—	—	—	—	—
S2	—	—	—	44	49	55	—	—	—	—	—	—
	—	—	—	*145*	*160*	*180*	—	—	—	—	—	—
S3	—	—	—	39	43	49	—	—	—	—	—	—
	—	—	—	*130*	*140*	*155*	—	—	—	—	—	—
S11	—	—	—	75	85	100	—	—	—	—	—	—
	—	—	—	*245*	*280*	*330*	—	—	—	—	—	—
S12	—	—	—	44	50	55	—	—	—	—	—	—
	—	—	—	*145*	*165*	*180*	—	—	—	—	—	—
S13	—	—	—	26	29	32	—	—	—	—	—	—
	—	—	—	*85*	*95*	*105*	—	—	—	—	—	—
H5	—	—	—	46	50	60	—	—	—	—	—	—
	—	—	—	*150*	*165*	*195*	—	—	—	—	—	—
H8	—	—	—	48	55	60	—	—	—	—	—	—
	—	—	—	*155*	*180*	*195*	—	—	—	—	—	—
H11	—	—	—	60	65	75	—	—	—	—	—	—
	—	—	—	*195*	*215*	*245*	—	—	—	—	—	—
H12	—	—	—	85	100	110	—	—	—	—	—	—
	—	—	—	*280*	*330*	*360*	—	—	—	—	—	—
H21	—	—	—	48	55	60	—	—	—	—	—	—
	—	—	—	*155*	*180*	*195*	—	—	—	—	—	—

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Octomill R220.43-07W – Metric



- For insert selection and cutting data recommendations, see page(s) 276-278
- For complete insert programme, see page(s) 744
- For ISO attribute explanation, see page 16

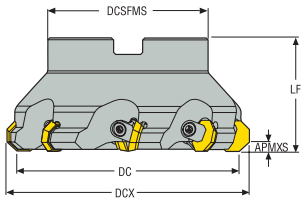
Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.43-0050-07W	00034758	Arbor	50,0	4	5,0	43,0	62,0	22,0	47,0	60,0	6300	0,4	OF..0704
R220.43-0063-07W	00005691	Arbor	63,0	4	5,0	43,0	75,0	22,0	47,0	40,0	5600	0,6	OF..0704
R220.43-0080-07W	00005692	Arbor	80,0	5	5,0	43,0	92,0	27,0	62,0	50,0	5000	1,3	OF..0704
R220.43-0100-07W	00005693	Arbor	100,0	6	5,0	43,0	112,0	32,0	77,0	50,0	4400	1,8	OF..0704
R220.43-0125-07W	00005694	Arbor	125,0	8	5,0	43,0	137,0	40,0	90,0	63,0	4000	3,2	OF..0704
R220.43-8160-07W	00005695	Arbor	160,0	10	5,0	43,0	172,0	40,0	90,0	63,0	3500	5,1	OF..0704

Spare Parts

For cutter	Arbor screw	Insert wedge	Wedge key	Wedge screw
R220.43-0050	220.17-696	334.5-640	H6B-T25P	LD8018-T25P
R220.43-0063	MF6S10X40	CW0810	H6B-T25P	LD8018-T25P
R220.43-0080	MC6S12X35	CW0810	H6B-T25P	LD8018-T25P
R220.43-0100-8160	–	CW0810	H6B-T25PL	LD8018-T25P

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Octomill R220.43-07W – Inch



- For insert selection and cutting data recommendations, see page(s) 276-278
- For complete insert programme, see page(s) 744
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.43-02.50-07W	00003262	Arbor	2.480	4	0.197	43.0	2.953	0.750	1.850	1.575	6000	1.540	OF..0704
R220.43-03.00-07W	00003266	Arbor	3.150	5	0.197	43.0	3.622	1.000	2.441	1.969	5000	3.530	OF..0704
R220.43-04.00-07W	00003268	Arbor	3.937	6	0.197	43.0	4.409	1.500	3.543	1.969	4400	5.070	OF..0704
R220.43-05.00-07W	00003273	Arbor	4.921	8	0.197	43.0	5.394	1.500	3.543	2.480	4000	7.050	OF..0704
R220.43-06.00-07W	00003278	Arbor	6.299	10	0.197	43.0	6.772	2.000	4.331	2.480	3500	11.680	OF..0704

Spare Parts

For cutter	Arbor screw	Insert wedge	Wedge key	Wedge screw
R220.43-02.50	UF6S3/8UNFX11/2	CW0810	H6B-T25P	LD8018-T25P
R220.43-03.00	UF6S1/2UNFX1-1/2	CW0810	H6B-T25P	LD8018-T25P
R220.43-04.00	UF6S3/4UNFX2	CW0810	H6B-T25PL	LD8020-T25P
R220.43-05.00 / 06.00	–	CW0810	H6B-T25PL	LD8018-T25P

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
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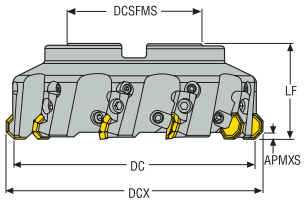
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Octomill R220.43-07C/CG/CT – Metric

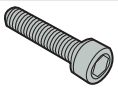
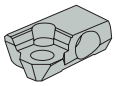
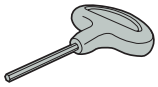


- For insert selection and cutting data recommendations, see page(s) 276-278
- For complete insert programme, see page(s) 744
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.43-0100-07C	75077234	Arbor	100,0	6	5,0	43,0	112,0	32,0	77,0	50,0	4300	2,3	OF..0704
R220.43-0125-07C	75077237	Arbor	125,0	8	5,0	43,0	137,0	40,0	90,0	63,0	3800	3,6	OF..0704
R220.43-8160-07C	75077240	Arbor	160,0	10	5,0	43,0	172,0	40,0	90,0	63,0	3300	5,7	OF..0704
R220.43-8160-07CT	75077241	Arbor	160,0	14	5,0	43,0	172,0	40,0	90,0	63,0	3300	5,6	OF..0704
R220.43-8160-07CG	75077239	Arbor	160,0	7	5,0	43,0	172,0	40,0	90,0	63,0	3300	5,8	OF..0704
R220.43-8200-07C	75077243	Arbor	200,0	12	5,0	43,0	212,0	60,0	130,0	63,0	3000	8,3	OF..0704
R220.43-8200-07CT	75077244	Arbor	200,0	18	5,0	43,0	212,0	60,0	130,0	63,0	3000	8,1	OF..0704
R220.43-8250-07C	75077246	Arbor	250,0	16	5,0	43,0	262,0	60,0	130,0	63,0	2700	14,3	OF..0704
R220.43-8250-07CT	75077247	Arbor	250,0	22	5,0	43,0	262,0	60,0	130,0	63,0	2700	16,9	OF..0704
R220.43-8315-07CT	75077250	Arbor	315,0	28	5,0	43,0	327,0	60,0	225,0	80,0	2400	28,0	OF..0704

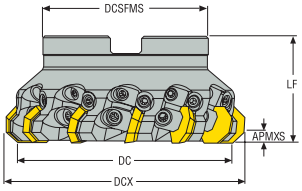
Spare Parts

Accessories

For cutter	Arbor screw	Cassette	Cassette screw	Insert wedge	Setting gauge	Wedge key	Wedge screw	Nest key
								
R220.43-0100-C	220.17-694	OF07AR	FS96018	CW0810	AU1114T-T15P	H6B-T25PL	LD8020-T25P	H05-4
R220.43-0125-8500-C	–	OF07AR	FS96018	CW0810	AU1114T-T15P	H6B-T25PL	LD8020-T25P	H05-4
R220.43-0125-8315-CT	–	OF07AR	FS96018	334.5-640	AU1114T-T15P	H6B-T25PL	LD8020-T25P	H05-4
R220.43-8160-07CG	–	OF07AR	FS96018	CW0810	AU1114T-T15P	–	LD8020-T25P	H05-4

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Octomill R220.43-07T – Metric



- For insert selection and cutting data recommendations, see page(s) 276-278
- For complete insert programme, see page(s) 744
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.43-0063-07-6T	00004368	Arbor	63,0	6	5,0	43,0	75,0	22,0	47,0	50,0	5600	0,8	OF..0704
R220.43-0080-07-9T	00004369	Arbor	80,0	9	5,0	43,0	92,0	27,0	62,0	50,0	5000	1,2	OF..0704
R220.43-0100-07-12T	00004371	Arbor	100,0	12	5,0	43,0	112,0	32,0	77,0	50,0	4400	1,6	OF..0704
R220.43-0125-07-15T	00004372	Arbor	125,0	15	5,0	43,0	137,0	40,0	90,0	63,0	4000	3,0	OF..0704

Spare Parts

For cutter	Arbor screw	Axial setting unit	Insert/Clamp key	Insert wedge	Setting key	Setting screw (axial)	Wedge clamp axial adj.	Wedge screw
R220.43-0063	MF6S10X40	AS6011	H6B-T25P	334.5-640	T15P-4ST	LD6019-T15P	CW0608	LD8020-T25P
R220.43-0080	MC6S12X35	AS6011	H6B-T25P	334.5-640	T15P-4ST	LD6019-T15P	CW0608	LD8020-T25P
R220.43-0100-0125	–	AS6011	H6B-T25PL	334.5-640	T15P-4ST	LD6019-T15P	CW0608	LD8020-T25P

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.43-07 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	OFMR070405TR-ME13 T350M	3,0 *0.12*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P2	OFMR070405TR-ME13 T350M	3,0 *0.12*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P3	OFMR070405TR-ME13 MP2501	3,0 *0.12*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
P4	OFMR070405TR-M15 MP2501	3,0 *0.12*	0,30 *0.012*	0,30 *0.012*	0,36 *0.014*
P5	OFMR070405TR-M15 MP2501	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P6	OFMR070405TR-M15 MP2501	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P7	OFMR070405TR-M15 MP2501	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P8	OFMR070405TR-M15 T350M	3,0 *0.12*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P11	OFMR070405TR-M15 T350M	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P12	OFMR070405TR-M15 T350M	2,5 *0.10*	0,19 *0.0075*	0,20 *0.0080*	0,25 *0.010*
M1	OFER070405TN-ME10 F40M	3,0 *0.12*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
M2	OFER070405TN-ME10 F40M	3,0 *0.12*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*
M3	OFER070405TN-ME15 T350M	2,5 *0.10*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*
M4	OFER070405TN-ME15 T350M	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
M5	OFER070405TN-ME15 T350M	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
K1	OFER070405TN-M16 MK1500	3,0 *0.12*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K2	OFER070405TN-M16 MK1500	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K3	OFER070405TN-M16 MP1501	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K4	OFER070405TN-M16 MP1501	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K5	OFER070405TN-M16 MP1501	3,0 *0.12*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
K6	OFER070405TN-M16 MK2050	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K7	OFER070405TN-M16 MK2050	3,0 *0.12*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
N1	OFER070405N-E07 H15	3,0 *0.12*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
N2	OFER070405N-E07 H15	3,0 *0.12*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
N3	OFER070405N-E07 H15	3,0 *0.12*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
N11	OFER070405N-E07 H15	3,0 *0.12*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
S1	OFER070405TN-ME15 T350M	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
S2	OFER070405TN-ME15 T350M	1,8 *0.070*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
S3	OFER070405TN-ME15 T350M	1,8 *0.070*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
S11	OFER070405TN-ME10 F40M	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
S12	OFER070405TN-ME10 F40M	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
S13	OFER070405TN-ME10 F40M	1,8 *0.070*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
H5	OFEN070405TN-D18 MP3000	2,5 *0.10*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
H8	OFEN070405TN-D18 MP3000	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
H11	OFEN070405TN-D18 MP1501	2,5 *0.10*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
H12	OFEN070405TN-D18 MP1501	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
H21	OFEN070405TN-D18 MP1501	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

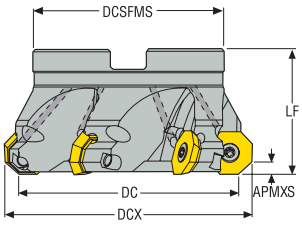
R220.43-07 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			MP3000			T350M			F30M		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	245 *800*	280 *920*	315 *1025*	315 *1025*	365 *1200*	410 *1350*	280 *920*	320 *1050*	365 *1200*	310 *1025*	350 *1150*	400 *1300*	250 *820*	285 *940*	325 *1075*	260 *850*	290 *950*	335 *1100*
P2	235 *770*	270 *890*	305 *1000*	300 *980*	355 *1175*	400 *1300*	270 *890*	315 *1025*	355 *1175*	300 *980*	340 *1125*	390 *1275*	240 *790*	280 *920*	315 *1025*	250 *820*	285 *940*	325 *1075*
P3	205 *670*	240 *790*	270 *890*	265 *870*	310 *1025*	350 *1150*	235 *770*	275 *900*	310 *1025*	260 *850*	300 *980*	340 *1125*	210 *690*	245 *800*	275 *900*	215 *710*	250 *820*	285 *940*
P4	180 *590*	210 *690*	235 *770*	235 *770*	275 *900*	310 *1025*	205 *670*	240 *790*	275 *900*	230 *750*	265 *870*	295 *970*	185 *610*	215 *710*	240 *790*	195 *640*	220 *720*	250 *820*
P5	175 *570*	200 *660*	230 *750*	230 *750*	260 *850*	300 *980*	200 *660*	230 *750*	265 *870*	220 *720*	250 *820*	285 *940*	180 *590*	205 *670*	235 *770*	185 *610*	210 *690*	240 *790*
P6	195 *640*	225 *740*	260 *850*	255 *840*	290 *950*	335 *1100*	225 *740*	260 *850*	300 *980*	245 *800*	285 *940*	320 *1050*	200 *660*	230 *750*	265 *870*	210 *690*	240 *790*	270 *890*
P7	185 *610*	210 *690*	245 *800*	240 *790*	275 *900*	315 *1025*	215 *710*	245 *800*	280 *920*	235 *770*	270 *890*	305 *1000*	190 *620*	215 *710*	250 *820*	195 *640*	225 *740*	255 *840*
P8	170 *560*	200 *660*	225 *740*	225 *740*	260 *850*	295 *970*	195 *640*	230 *750*	260 *850*	215 *710*	250 *820*	285 *940*	175 *570*	205 *670*	230 *750*	180 *590*	210 *690*	240 *790*
P11	180 *590*	205 *670*	235 *770*	235 *770*	270 *890*	310 *1025*	210 *690*	235 *770*	275 *900*	225 *740*	265 *870*	295 *970*	185 *610*	210 *690*	240 *790*	190 *620*	220 *720*	250 *820*
P12	120 *395*	135 *445*	155 *510*	155 *510*	175 *570*	200 *660*	140 *460*	155 *510*	180 *590*	150 *490*	170 *560*	195 *640*	125 *410*	140 *460*	160 *520*	125 *410*	145 *475*	160 *520*
M1	185 *610*	220 *720*	245 *800*	— —	— —	— —	195 *640*	225 *740*	255 *840*	225 *740*	255 *840*	290 *950*	185 *610*	215 *710*	240 *790*	205 *670*	230 *750*	265 *870*
M2	160 *520*	180 *590*	205 *670*	— —	— —	— —	160 *520*	185 *610*	215 *710*	185 *610*	210 *690*	240 *790*	155 *510*	175 *570*	200 *660*	165 *540*	190 *620*	215 *710*
M3	130 *425*	145 *475*	165 *540*	— —	— —	— —	130 *425*	150 *490*	175 *570*	150 *490*	170 *560*	195 *640*	125 *410*	145 *475*	165 *520*	135 *445*	155 *510*	175 *570*
M4	100 *330*	115 *375*	130 *425*	— —	— —	— —	100 *330*	120 *395*	135 *445*	115 *375*	130 *425*	150 *490*	95 *310*	115 *375*	130 *410*	105 *345*	120 *395*	135 *445*
M5	85 *280*	95 *310*	110 *360*	— —	— —	— —	85 *280*	100 *330*	110 *360*	95 *310*	110 *360*	125 *410*	80 *260*	95 *310*	105 *345*	85 *280*	100 *330*	115 *360*
K1	185 *610*	215 *710*	245 *800*	240 *790*	280 *920*	320 *1050*	210 *690*	250 *820*	280 *920*	240 *790*	270 *890*	305 *1000*	190 *620*	220 *720*	250 *820*	200 *660*	225 *740*	260 *850*
K2	165 *540*	190 *620*	220 *720*	215 *710*	245 *800*	285 *940*	190 *620*	220 *720*	250 *820*	210 *690*	240 *790*	270 *890*	170 *560*	195 *640*	225 *740*	175 *570*	200 *660*	230 *750*
K3	140 *460*	160 *520*	185 *610*	185 *610*	210 *690*	240 *790*	160 *520*	185 *610*	215 *710*	175 *570*	200 *660*	230 *750*	145 *475*	165 *540*	190 *620*	150 *490*	170 *560*	195 *640*
K4	135 *445*	155 *510*	175 *570*	175 *570*	200 *660*	230 *750*	155 *510*	175 *570*	205 *670*	170 *560*	195 *640*	220 *720*	140 *460*	155 *510*	180 *590*	140 *460*	160 *520*	185 *610*
K5	80 *260*	95 *310*	110 *360*	105 *345*	125 *410*	140 *460*	95 *310*	110 *360*	125 *410*	105 *345*	120 *395*	135 *445*	85 *280*	100 *330*	110 *360*	85 *280*	100 *330*	115 *375*
K6	120 *395*	135 *445*	155 *510*	155 *510*	175 *570*	200 *660*	135 *445*	155 *510*	180 *590*	150 *490*	170 *560*	195 *640*	120 *395*	140 *460*	160 *520*	125 *410*	145 *475*	165 *540*
K7	105 *345*	120 *395*	140 *460*	135 *445*	160 *520*	180 *590*	120 *395*	140 *460*	160 *520*	135 *445*	150 *490*	170 *560*	110 *360*	125 *410*	140 *460*	110 *360*	125 *410*	145 *475*
N1	1350 *4425*	1550 *5075*	1800 *5900*	— —	— —	— —	— —	— —	— —	1725 *5650*	1975 *6475*	2250 *7375*	— —	— —	— —	1450 *4750*	1650 *5425*	1900 *6225*
N2	550 *1800*	630 *2075*	720 *2350*	— —	— —	— —	— —	— —	— —	700 *2300*	800 *2625*	910 *2975*	— —	— —	— —	590 *1925*	670 *2200*	760 *2500*
N3	365 *1200*	420 *1375*	480 *1575*	— —	— —	— —	— —	— —	— —	465 *1525*	530 *1750*	610 *2000*	— —	— —	— —	390 *1275*	445 *1450*	510 *1675*
N11	415 *1350*	480 *1575*	550 *1800*	— —	— —	— —	— —	— —	— —	530 *1750*	610 *2000*	690 *2275*	— —	— —	— —	450 *1475*	510 *1675*	580 *1900*
S1	46 *150*	55 *180*	60 *195*	— —	— —	— —	49 *160*	55 *180*	65 *215*	55 *180*	60 *195*	70 *230*	45 *150*	55 *180*	60 *195*	49 *160*	55 *180*	65 *215*
S2	37 *120*	43 *140*	49 *160*	— —	— —	— —	40 *130*	46 *150*	55 *180*	44 *145*	49 *160*	55 *180*	37 *120*	42 *140*	48 *155*	39 *130*	45 *150*	50 *165*
S3	33 *110*	38 *125*	43 *140*	— —	— —	— —	35 *115*	41 *135*	46 *150*	38 *125*	43 *140*	49 *160*	32 *105*	37 *120*	42 *140*	35 *115*	39 *130*	45 *145*
S11	65 *215*	75 *245*	85 *280*	— —	— —	— —	70 *230*	80 *260*	90 *295*	75 *245*	85 *280*	100 *310*	65 *215*	70 *230*	80 *280*	70 *230*	75 *245*	90 *295*
S12	45 *150*	50 *165*	60 *195*	— —	— —	— —	48 *155*	55 *180*	65 *215*	50 *165*	60 *195*	70 *215*	44 *145*	50 *165*	55 *195*	39 *130*	45 *150*	50 *165*
S13	26 *85*	30 *100*	34 *110*	— —	— —	— —	28 *90*	32 *105*	37 *120*	30 *100*	34 *110*	39 *130*	26 *85*	30 *100*	34 *110*	23 *75*	26 *85*	30 *95*
H5	40 *130*	45 *150*	50 *165*	50 *165*	60 *195*	65 *215*	42 *140*	47 *155*	55 *180*	46 *150*	55 *180*	60 *195*	41 *135*	46 *150*	55 *165*	41 *135*	48 *155*	55 *180*
H8	42 *140*	49 *160*	55 *180*	55 *180*	65 *215*	70 *230*	44 *145*	50 *165*	60 *195*	49 *160*	55 *180*	65 *195*	43 *140*	50 *165*	55 *180*	44 *145*	50 *165*	55 *180*
H11	50 *165*	60 *195*	65 *215*	65 *215*	75 *245*	85 *280*	55 *180*	60 *195*	70 *230*	60 *195*	70 *230*	75 *245*	50 *165*	60 *195*	65 *215*	55 *180*	60 *195*	70 *230*
H12	75 *245*	90 *295*	100 *330*	100 *330*	115 *375*	130 *425*	90 *295*	100 *330*	115 *375*	95 *310*	110 *360*	120 *395*	80 *260*	90 *295*	100 *330*	80 *260*	90 *295*	100 *330*
H21	42 *140*	49 *160*	55 *180*	55 *180*	65 *215*	70 *230*	44 *145*	50 *165*	60 *195*	49 *160*	55 *180*	65 *195*	43 *140*	50 *165*	55 *180*	44 *145*	50 *165*	55 *180*

R220.43-07 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500			MK2050			F15M			H15			MM4500			T25M		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	—	—	—	275	315	360	—	—	—	—	—	—	170	195	225	270	305	345
	—	—	—	*900*	*1025*	*1175*	—	—	—	—	—	—	*560*	*640*	*740*	*890*	*1000*	*1125*
P2	—	—	—	265	310	350	—	—	—	—	—	—	165	190	220	255	300	340
	—	—	—	*870*	*1025*	*1150*	—	—	—	—	—	—	*540*	*620*	*720*	*840*	*980*	*1125*
P3	—	—	—	230	270	305	—	—	—	—	—	—	145	170	190	225	260	295
	—	—	—	*750*	*890*	*1000*	—	—	—	—	—	—	*475*	*560*	*620*	*740*	*850*	*970*
P4	—	—	—	205	240	270	—	—	—	—	—	—	125	150	170	200	230	260
	—	—	—	*670*	*790*	*890*	—	—	—	—	—	—	*410*	*490*	*560*	*660*	*750*	*850*
P5	—	—	—	200	225	260	—	—	—	—	—	—	125	140	165	195	220	250
	—	—	—	*660*	*740*	*850*	—	—	—	—	—	—	*410*	*460*	*540*	*640*	*720*	*820*
P6	—	—	—	225	255	295	—	—	—	—	—	—	140	160	185	215	250	285
	—	—	—	*740*	*840*	*970*	—	—	—	—	—	—	*460*	*520*	*610*	*710*	*820*	*940*
P7	—	—	—	210	240	275	—	—	—	—	—	—	130	150	170	205	235	265
	—	—	—	*690*	*790*	*900*	—	—	—	—	—	—	*425*	*490*	*560*	*670*	*770*	*870*
P8	—	—	—	195	225	255	—	—	—	—	—	—	120	140	160	190	220	250
	—	—	—	*640*	*740*	*840*	—	—	—	—	—	—	*395*	*460*	*520*	*620*	*720*	*820*
P11	—	—	—	205	235	270	—	—	—	—	—	—	130	145	170	200	225	260
	—	—	—	*670*	*770*	*890*	—	—	—	—	—	—	*425*	*475*	*560*	*660*	*740*	*850*
P12	—	—	—	135	155	175	—	—	—	—	—	—	85	95	110	130	150	170
	—	—	—	*445*	*510*	*570*	—	—	—	—	—	—	*280*	*310*	*360*	*425*	*490*	*560*
M1	—	—	—	—	—	—	—	—	—	—	—	—	140	165	185	205	240	270
	—	—	—	—	—	—	—	—	—	—	—	—	*460*	*540*	*610*	*670*	*790*	*890*
M2	—	—	—	—	—	—	—	—	—	—	—	—	120	135	155	175	200	225
	—	—	—	—	—	—	—	—	—	—	—	—	*395*	*445*	*510*	*570*	*660*	*740*
M3	—	—	—	—	—	—	—	—	—	—	—	—	95	110	125	145	160	185
	—	—	—	—	—	—	—	—	—	—	—	—	*310*	*360*	*410*	*475*	*520*	*590*
M4	—	—	—	—	—	—	—	—	—	—	—	—	75	85	100	110	125	145
	—	—	—	—	—	—	—	—	—	—	—	—	*245*	*280*	*330*	*360*	*410*	*475*
M5	—	—	—	—	—	—	—	—	—	—	—	—	60	70	80	90	105	120
	—	—	—	—	—	—	—	—	—	—	—	—	*195*	*230*	*260*	*295*	*345*	*395*
K1	300	350	400	285	330	375	280	325	365	—	—	—	—	—	—	—	—	—
	980	*1150*	*1300*	*940*	*1075*	*1225*	*920*	*1075*	*1200*	—	—	—	—	—	—	—	—	—
K2	270	310	355	255	295	335	255	285	325	—	—	—	—	—	—	—	—	—
	890	*1025*	*1175*	*840*	*970*	*1100*	*840*	*940*	*1075*	—	—	—	—	—	—	—	—	—
K3	230	260	300	215	250	285	215	245	275	—	—	—	—	—	—	—	—	—
	750	*850*	*980*	*710*	*820*	*940*	*710*	*800*	*900*	—	—	—	—	—	—	—	—	—
K4	220	250	290	205	235	275	205	230	265	—	—	—	—	—	—	—	—	—
	720	*820*	*950*	*670*	*770*	*900*	*670*	*750*	*870*	—	—	—	—	—	—	—	—	—
K5	135	155	175	125	145	170	125	145	160	—	—	—	—	—	—	—	—	—
	445	*510*	*570*	*410*	*475*	*560*	*410*	*475*	*520*	—	—	—	—	—	—	—	—	—
K6	195	220	255	185	210	240	180	205	230	—	—	—	—	—	—	—	—	—
	640	*720*	*840*	*610*	*690*	*790*	*590*	*670*	*750*	—	—	—	—	—	—	—	—	—
K7	170	200	225	160	190	215	160	185	205	—	—	—	—	—	—	—	—	—
	560	*660*	*740*	*520*	*620*	*710*	*520*	*610*	*670*	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	2075	2425	2725	1650	1925	2150	—	—	—	—	—	—
	—	—	—	—	—	—	*6800*	*7950*	*8950*	*5425*	*6325*	*7050*	—	—	—	—	—	—
N2	—	—	—	—	—	—	840	980	1100	670	770	870	—	—	—	—	—	—
	—	—	—	—	—	—	*2750*	*3225*	*3600*	*2200*	*2525*	*2850*	—	—	—	—	—	—
N3	—	—	—	—	—	—	560	650	730	445	520	580	—	—	—	—	—	—
	—	—	—	—	—	—	*1825*	*2125*	*2400*	*1450*	*1700*	*1900*	—	—	—	—	—	—
N11	—	—	—	—	—	—	640	740	840	510	590	660	—	—	—	—	—	—
	—	—	—	—	—	—	*2100*	*2425*	*2750*	*1675*	*1925*	*2175*	—	—	—	—	—	—
S1	—	—	—	—	—	—	—	—	—	—	—	—	23	26	30	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*75*	*85*	*100*	—	—	—
S2	—	—	—	—	—	—	—	—	—	—	—	—	18	21	24	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*60*	*70*	*80*	—	—	—
S3	—	—	—	—	—	—	—	—	—	—	—	—	16	19	21	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*50*	*60*	*70*	—	—	—
S11	—	—	—	—	—	—	—	—	—	—	—	—	32	37	42	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*105*	*120*	*140*	—	—	—
S12	—	—	—	—	—	—	—	—	—	—	—	—	30	34	39	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*100*	*110*	*130*	—	—	—
S13	—	—	—	—	—	—	—	—	—	—	—	—	17	20	23	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*55*	*65*	*75*	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

Octomill R220.43-07S/SA – Metric

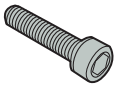


- For insert selection and cutting data recommendations, see page(s) 280 - 281
- For complete insert programme, see page(s) 743
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.43-0051-07S	00092123	Arbor	51,0	4	5,0	43,0	63,0	22,0	47,0	40,0	7300	0,4	OF..0704
R220.43-0063-07SA	00090770	Arbor	63,0	4	5,0	43,0	75,0	22,0	47,0	40,0	6800	0,5	OF..0704
R220.43-0080-07SA	00090771	Arbor	80,0	5	5,0	43,0	92,0	27,0	62,0	50,0	6200	1,0	OF..0704
R220.43-0100-07SA	00090773	Arbor	100,0	6	5,0	43,0	112,0	32,0	77,0	50,0	5600	1,7	OF..0704
R220.43-0125-07S	00045811	Arbor	125,0	8	5,0	43,0	137,0	40,0	90,0	63,0	5100	3,0	OF..0704

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.43-0051-0063	220.17-692	C05013-T20P	T00-20P50	5.0NM
R220.43-0080-0125	–	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

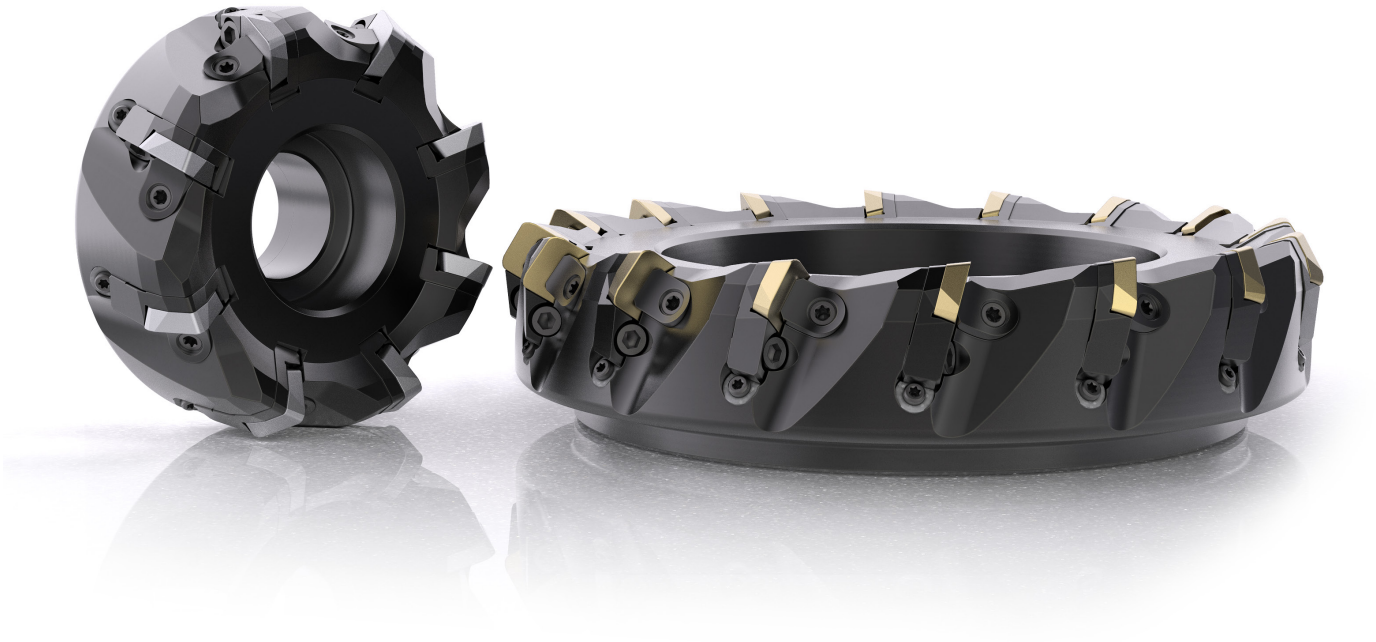
R220.43-7S – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	OFMT070405TR-ME13 T350M	3,0 *0.12*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P2	OFMT070405TR-ME13 T350M	3,0 *0.12*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P3	OFMT070405TN-ME13 MP2501	3,0 *0.12*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
P4	OFMT070405TN-M15 MP2501	3,0 *0.12*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P5	OFMT070405TN-M15 MP2501	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P6	OFMT070405TN-M15 MP2501	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P7	OFMT070405TN-M15 MP2501	3,0 *0.12*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
P8	OFMT070405TR-ME13 T350M	3,0 *0.12*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
P11	OFMT070405TR-ME13 T350M	3,0 *0.12*	0,25 *0.010*	0,25 *0.010*	0,32 *0.013*
P12	OFMT070405TR-ME13 T350M	2,5 *0.10*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M1	OFET070405TN-ME10 F40M	3,0 *0.12*	0,20 *0.0080*	0,22 *0.0085*	0,26 *0.010*
M2	OFET070405TN-ME10 F40M	3,0 *0.12*	0,19 *0.0075*	0,20 *0.0080*	0,24 *0.0095*
M3	OFET070405TN-ME10 F40M	2,5 *0.10*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
M4	OFET070405TN-ME10 F40M	1,8 *0.070*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
M5	OFET070405TN-ME10 F40M	1,8 *0.070*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
K1	OFET070405TN-M16 MK1500	3,0 *0.12*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K2	OFET070405TN-M16 MK1500	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
K3	OFEW070405TN-D18 MP1501	3,0 *0.12*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K4	OFEW070405TN-D18 MP1501	3,0 *0.12*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K5	OFEW070405TN-D18 MP1501	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,40 *0.016*
K6	OFEW070405TN-D18 MP1501	3,0 *0.12*	0,34 *0.013*	0,36 *0.014*	0,44 *0.017*
K7	OFEW070405TN-D18 MP1501	3,0 *0.12*	0,30 *0.012*	0,32 *0.013*	0,40 *0.016*
N1	OFET070405TN-ME10 F30M	3,0 *0.12*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
N2	OFET070405TN-ME10 F30M	3,0 *0.12*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
N3	OFET070405TN-ME10 F30M	3,0 *0.12*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
N11	OFET070405TN-ME10 F30M	3,0 *0.12*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
S1	OFMT070405TR-ME13 T350M	1,8 *0.070*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
S2	OFMT070405TR-ME13 T350M	1,8 *0.070*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
S3	OFMT070405TR-ME13 T350M	1,8 *0.070*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
S11	OFET070405TN-ME10 F40M	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
S12	OFET070405TN-ME10 F40M	2,0 *0.080*	0,15 *0.0060*	0,16 *0.0065*	0,19 *0.0075*
S13	OFET070405TN-ME10 F40M	1,8 *0.070*	0,13 *0.0050*	0,14 *0.0055*	0,17 *0.0065*
H5	OFEW070405TN-D18 MP1501	2,5 *0.10*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
H8	OFEW070405TN-D18 MP1501	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
H11	OFEW070405TN-D18 MP1501	2,5 *0.10*	0,24 *0.0095*	0,24 *0.0095*	0,30 *0.012*
H12	OFEW070405TN-D18 MP1501	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
H21	OFEW070405TN-D18 MP1501	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.43-07S – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP1501			MP2501			T350M			F30M			MK1500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	245	280	315	300	350	395	300	340	390	295	335	380	290	330	375	—	—	—
	800	*920*	*1025*	*980*	*1150*	*1300*	*980*	*1125*	*1275*	*970*	*1100*	*1250*	*950*	*1075*	*1225*	—	—	—
P2	235	270	305	290	340	385	285	335	380	280	325	370	285	320	365	—	—	—
	770	*890*	*1000*	*950*	*1125*	*1275*	*940*	*1100*	*1250*	*920*	*1075*	*1225*	*940*	*1050*	*1200*	—	—	—
P3	205	240	270	255	300	335	250	295	330	245	285	325	245	285	320	—	—	—
	670	*790*	*890*	*840*	*980*	*1100*	*820*	*970*	*1075*	*800*	*940*	*1075*	*800*	*940*	*1050*	—	—	—
P4	180	210	235	230	260	300	225	260	290	220	250	285	220	250	280	—	—	—
	590	*690*	*770*	*750*	*850*	*980*	*740*	*850*	*950*	*720*	*820*	*940*	*720*	*820*	*920*	—	—	—
P5	175	200	230	220	250	285	215	250	280	210	245	275	210	240	270	—	—	—
	570	*660*	*750*	*720*	*820*	*940*	*710*	*820*	*920*	*690*	*800*	*900*	*690*	*790*	*890*	—	—	—
P6	195	225	260	245	285	320	240	280	315	235	275	305	235	270	305	—	—	—
	640	*740*	*850*	*800*	*940*	*1050*	*790*	*920*	*1025*	*770*	*900*	*1000*	*770*	*890*	*1000*	—	—	—
P7	185	210	245	230	270	305	225	265	295	220	260	290	220	255	285	—	—	—
	610	*690*	*800*	*750*	*890*	*1000*	*740*	*870*	*970*	*720*	*850*	*950*	*720*	*840*	*940*	—	—	—
P8	170	200	225	215	250	280	210	245	280	205	240	275	205	240	270	—	—	—
	560	*660*	*740*	*710*	*820*	*920*	*690*	*800*	*920*	*670*	*790*	*900*	*670*	*790*	*890*	—	—	—
P11	180	205	235	225	265	295	220	255	285	215	250	280	215	250	280	—	—	—
	590	*670*	*770*	*740*	*870*	*970*	*720*	*840*	*940*	*710*	*820*	*920*	*710*	*820*	*920*	—	—	—
P12	120	135	155	150	170	195	145	170	190	140	165	185	140	160	185	—	—	—
	395	*445*	*510*	*490*	*560*	*640*	*475*	*560*	*620*	*460*	*540*	*610*	*460*	*520*	*590*	—	—	—
M1	185	220	245	—	—	—	205	240	275	215	250	285	230	260	295	—	—	—
	610	*720*	*800*	—	—	—	*670*	*790*	*900*	*710*	*820*	*940*	*750*	*850*	*970*	—	—	—
M2	160	180	205	—	—	—	170	200	225	180	210	235	185	215	245	—	—	—
	520	*590*	*670*	—	—	—	*560*	*660*	*740*	*590*	*690*	*770*	*610*	*710*	*800*	—	—	—
M3	130	145	165	—	—	—	140	160	185	145	170	190	150	170	200	—	—	—
	425	*475*	*540*	—	—	—	*460*	*520*	*610*	*475*	*560*	*620*	*490*	*560*	*640*	—	—	—
M4	100	115	130	—	—	—	110	125	145	115	130	150	120	135	150	—	—	—
	330	*375*	*425*	—	—	—	*360*	*410*	*460*	*375*	*425*	*490*	*395*	*445*	*490*	—	—	—
M5	85	95	110	—	—	—	90	105	120	95	110	125	100	110	125	—	—	—
	280	*310*	*360*	—	—	—	*295*	*345*	*395*	*310*	*360*	*410*	*330*	*360*	*410*	—	—	—
K1	185	215	245	230	270	305	225	265	300	—	—	—	—	—	—	300	350	400
	610	*710*	*800*	*750*	*890*	*1000*	*740*	*870*	*980*	—	—	—	—	—	—	*980*	*1150*	*1300*
K2	165	190	220	205	240	270	205	235	265	—	—	—	—	—	—	270	310	355
	540	*620*	*720*	*670*	*790*	*890*	*670*	*770*	*870*	—	—	—	—	—	—	*890*	*1025*	*1175*
K3	140	160	185	175	200	230	170	200	225	—	—	—	—	—	—	230	260	300
	460	*520*	*610*	*570*	*660*	*750*	*560*	*660*	*740*	—	—	—	—	—	—	*750*	*850*	*980*
K4	135	155	175	165	190	220	165	190	215	—	—	—	—	—	—	220	250	290
	445	*510*	*570*	*540*	*620*	*720*	*540*	*620*	*710*	—	—	—	—	—	—	*720*	*820*	*950*
K5	80	95	110	105	120	135	100	120	130	—	—	—	—	—	—	135	155	175
	260	*310*	*360*	*345*	*395*	*445*	*330*	*395*	*425*	—	—	—	—	—	—	*445*	*510*	*570*
K6	120	135	155	150	170	195	145	170	190	—	—	—	—	—	—	195	220	255
	395	*445*	*510*	*490*	*560*	*640*	*475*	*560*	*620*	—	—	—	—	—	—	*640*	*720*	*840*
K7	105	120	140	135	150	170	130	150	170	—	—	—	—	—	—	170	200	225
	345	*395*	*460*	*445*	*490*	*560*	*425*	*490*	*560*	—	—	—	—	—	—	*560*	*660*	*740*
N1	1350	1550	1800	—	—	—	—	—	—	—	—	—	1650	1875	2125	—	—	—
	4425	*5075*	*5900*	—	—	—	—	—	—	—	—	—	*5425*	*6150*	*6975*	—	—	—
N2	550	630	720	—	—	—	—	—	—	—	—	—	660	750	860	—	—	—
	1800	*2075*	*2350*	—	—	—	—	—	—	—	—	—	*2175*	*2450*	*2825*	—	—	—
N3	365	420	480	—	—	—	—	—	—	—	—	—	440	500	570	—	—	—
	1200	*1375*	*1575*	—	—	—	—	—	—	—	—	—	*1450*	*1650*	*1875*	—	—	—
N11	415	480	550	—	—	—	—	—	—	—	—	—	500	570	650	—	—	—
	1350	*1575*	*1800*	—	—	—	—	—	—	—	—	—	*1650*	*1875*	*2125*	—	—	—
S1	46	55	60	—	—	—	—	—	—	55	60	70	55	60	70	—	—	—
	150	*180*	*195*	—	—	—	—	—	—	*180*	*195*	*230*	*180*	*195*	*230*	—	—	—
S2	37	43	49	—	—	—	—	—	—	43	49	55	44	50	55	—	—	—
	120	*140*	*160*	—	—	—	—	—	—	*140*	*160*	*180*	*145*	*165*	*180*	—	—	—
S3	33	38	43	—	—	—	—	—	—	38	43	50	39	44	50	—	—	—
	110	*125*	*140*	—	—	—	—	—	—	*125*	*140*	*160*	*130*	*145*	*165*	—	—	—
S11	65	75	85	—	—	—	—	—	—	75	85	95	75	85	100	—	—	—
	215	*245*	*280*	—	—	—	—	—	—	*245*	*280*	*310*	*245*	*280*	*330*	—	—	—
S12	45	50	60	—	—	—	—	—	—	50	60	65	44	50	60	—	—	—
	150	*165*	*195*	—	—	—	—	—	—	*165*	*195*	*215*	*145*	*165*	*180*	—	—	—
S13	26	30	34	—	—	—	—	—	—	30	34	39	26	29	33	—	—	—
	85	*100*	*110*	—	—	—	—	—	—	*100*	*110*	*130*	*85*	*95*	*110*	—	—	—
H5	40	45	50	49	55	65	—	—	—	47	55	60	—	—	—	—	—	—
	130	*150*	*165*	*160*	*180*	*215*	—	—	—	*155*	*180*	*195*	—	—	—	—	—	—
H8	42	49	55	55	60	70	—	—	—	50	60	65	—	—	—	—	—	—
	140	*160*	*180*	*180*	*195*	*230*	—	—	—	*165*	*195*	*215*	—	—	—	—	—	—
H11	50	60	65	65	75	80	—	—	—	60	70	80	—	—	—	—	—	—
	165	*195*	*215*	*215*	*245*	*260*	—	—	—	*195*	*230*	*260*	—	—	—	—	—	—
H12	75	90	100	95	110	125	—	—	—	90	105	120	—	—	—	—	—	—
	245	*295*	*330*	*310*	*360*	*410*	—	—	—	*295*	*345*	*395*	—	—	—	—	—	—
H21	42	49	55	55	60	70	—	—	—	50	60	65	—	—	—	—	—	—
	140	*160*	*180*	*180*	*195*	*230*	—	—	—	*165*	*195*	*215*	—	—	—	—	—	—

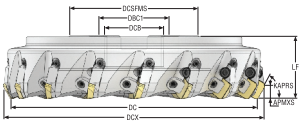


R220.60

Face mills for heavy duty. Strong inserts and the cutter is equipt with cassettes for handling high metal removal.

- Cutter range 63-250 mm (2.5 - 10 inch)
- Inserts SPEN/SPER/SPMR 19
- Available in many different grades for most common workpiece materials

R220.60-19CM – Metric

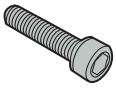


- For insert selection and cutting data recommendations, see page(s) 284 - 285
- For complete insert programme, see page(s) 769
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.60-0063-19-4CM	00073305	Arbor	63,0	4	12,0	60,0	77,6	22,0	47,0	50,0	3700	1,1	SP..1906ZETR
R220.60-0080-19-5CM	00073306	Arbor	80,0	5	12,0	60,0	94,5	27,0	62,0	50,0	3300	1,7	SP..1906ZETR
R220.60-0100-19-6CM	00073307	Arbor	100,0	6	12,0	60,0	114,4	32,0	77,0	50,0	2900	2,4	SP..1906ZETR
R220.60-0125-19-8CM	00073309	Arbor	125,0	8	12,0	60,0	139,3	40,0	90,0	63,0	2600	4,0	SP..1906ZETR
R220.60-8160-19-10CM	00073311	Arbor	160,0	10	12,0	60,0	174,3	40,0	128,0	63,0	2300	6,3	SP..1906ZETR
R220.60-8200-19-12CM	00073313	Arbor	200,0	12	12,0	60,0	214,2	60,0	168,0	63,0	2000	9,0	SP..1906ZETR
R220.60-8250-19-16CM	00073318	Arbor	250,0	16	12,0	60,0	264,2	60,0	218,0	63,0	1800	20,0	SP..1906ZETR

Spare Parts

Accessories

For cutter	Arbor screw	Cassette	Cassette screw	Insert wedge	Setting gauge	Wedge key	Wedge screw	Key
								
R220.66-0063	220.17-692	SP19DRM	FS96018	CW0813	AU1114T-T15P	H6B-T25P	LD8020-T25P	5SMS795
R220.66-0080	MC6S12X35	SP19DRM	FS96018	CW0813	AU1114T-T15P	H6B-T25P	LD8020-T25P	5SMS795
R220.66-0100-8250	–	SP19DRM	FS96018	CW0813	AU1114T-T15P	H6B-T25PL	LD8020-T25P	–

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.60-19 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SPER1906ZETR-M17 T350M	7,0 *0.28*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
P2	SPER1906ZETR-M17 T350M	7,0 *0.28*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
P3	SPEN1906ZETR-MD20 MP2501	7,0 *0.28*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
P4	SPEN1906ZETR-MD20 MP2501	7,0 *0.28*	0,30 *0.012*	0,32 *0.013*	0,38 *0.015*
P5	SPEN1906ZETR-MD20 MP2501	7,0 *0.28*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P6	SPEN1906ZETR-MD20 MP2501	7,0 *0.28*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
P7	SPER1906ZETR-M17 T350M	7,0 *0.28*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P8	SPER1906ZETR-M17 T350M	7,0 *0.28*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
P11	SPMR1906ZETR-M17 MM4500	7,0 *0.28*	0,25 *0.010*	0,26 *0.010*	0,32 *0.013*
P12	SPMR1906ZETR-M17 MM4500	6,0 *0.24*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
M1	SPER1906ZETR-M17 T350M	7,0 *0.28*	0,28 *0.011*	0,28 *0.011*	0,36 *0.014*
M2	SPER1906ZETR-M17 T350M	7,0 *0.28*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
M3	SPER1906ZETR-M17 T350M	6,0 *0.24*	0,20 *0.0080*	0,20 *0.0080*	0,26 *0.010*
M4	SPMR1906ZETR-M17 MM4500	4,5 *0.18*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
M5	SPMR1906ZETR-M17 MM4500	4,5 *0.18*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
K1	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,42 *0.017*	0,42 *0.017*	0,50 *0.020*
K2	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,38 *0.015*	0,38 *0.015*	0,48 *0.019*
K3	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,38 *0.015*	0,38 *0.015*	0,48 *0.019*
K4	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,38 *0.015*	0,38 *0.015*	0,48 *0.019*
K5	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
K6	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,38 *0.015*	0,38 *0.015*	0,48 *0.019*
K7	SPEN1906ZETR-D25 MP1501	7,0 *0.28*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.60-19 – Cutting data v_c = (m/min)/*(sf/min)*

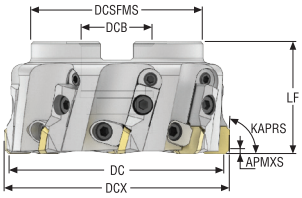
SMG	MP1501			MP2501			T350M			MM4500		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	225 *740*	260 *850*	300 *980*	200 *660*	230 *750*	265 *870*	190 *620*	215 *710*	245 *800*	160 *520*	185 *610*	210 *690*
P2	215 *710*	255 *840*	295 *970*	190 *620*	225 *740*	260 *850*	180 *590*	210 *690*	240 *790*	155 *510*	180 *590*	200 *660*
P3	190 *620*	220 *720*	250 *820*	165 *540*	195 *640*	225 *740*	160 *520*	185 *610*	210 *690*	135 *445*	155 *510*	175 *570*
P4	170 *560*	195 *640*	225 *740*	150 *490*	175 *570*	200 *660*	140 *460*	165 *540*	190 *620*	120 *395*	140 *460*	160 *520*
P5	160 *520*	190 *620*	215 *710*	145 *475*	170 *560*	190 *620*	135 *445*	160 *520*	180 *590*	115 *375*	135 *445*	150 *490*
P6	180 *590*	215 *710*	240 *790*	160 *520*	190 *620*	215 *710*	150 *490*	180 *590*	200 *660*	130 *425*	150 *490*	170 *560*
P7	170 *560*	200 *660*	225 *740*	150 *490*	180 *590*	200 *660*	145 *475*	170 *560*	190 *620*	120 *395*	140 *460*	160 *520*
P8	160 *520*	185 *610*	210 *690*	140 *460*	165 *540*	185 *610*	135 *445*	155 *510*	175 *570*	115 *375*	130 *425*	150 *490*
P11	165 *540*	195 *640*	220 *720*	145 *475*	175 *570*	195 *640*	140 *460*	165 *540*	185 *610*	120 *395*	135 *445*	155 *510*
P12	110 *360*	130 *425*	150 *490*	100 *330*	115 *375*	130 *425*	95 *310*	110 *360*	125 *410*	80 *260*	90 *295*	105 *345*
M1	— —	— —	— —	135 *445*	160 *520*	185 *610*	140 *460*	165 *540*	185 *610*	130 *425*	155 *510*	175 *570*
M2	— —	— —	— —	115 *375*	135 *445*	155 *510*	115 *375*	135 *445*	155 *510*	110 *360*	130 *425*	145 *475*
M3	— —	— —	— —	95 *310*	110 *360*	125 *410*	95 *310*	110 *360*	125 *410*	90 *295*	105 *345*	120 *395*
M4	— —	— —	— —	75 *245*	85 *280*	100 *330*	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	90 *295*
M5	— —	— —	— —	60 *195*	75 *245*	80 *260*	60 *195*	70 *230*	80 *260*	60 *195*	70 *230*	75 *245*
K1	170 *560*	200 *660*	230 *750*	150 *490*	180 *590*	205 *670*	140 *460*	165 *540*	190 *620*	— —	— —	— —
K2	155 *510*	180 *590*	205 *670*	135 *445*	160 *520*	180 *590*	130 *425*	150 *490*	170 *560*	— —	— —	— —
K3	130 *425*	155 *510*	170 *560*	115 *375*	135 *445*	155 *510*	110 *360*	130 *425*	145 *475*	— —	— —	— —
K4	125 *410*	145 *475*	165 *540*	110 *360*	130 *425*	145 *475*	105 *345*	120 *395*	140 *460*	— —	— —	— —
K5	75 *245*	90 *295*	105 *345*	70 *230*	80 *260*	90 *295*	65 *215*	75 *245*	85 *280*	— —	— —	— —
K6	110 *360*	130 *425*	145 *475*	95 *310*	115 *375*	130 *425*	90 *295*	110 *360*	120 *395*	— —	— —	— —
K7	100 *330*	115 *375*	130 *425*	85 *280*	100 *330*	115 *375*	80 *260*	95 *310*	110 *360*	— —	— —	— —

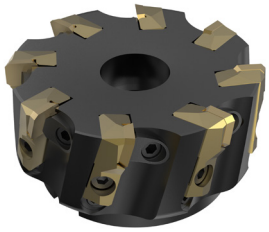
R220.30 -12

This cutter family can meet the highest surface finish requirements in a variety of materials. The strength is in cast iron materials due to a comprehensive offer in geometry and grade combinations. The adjustable pocket ensures a high run out accuracy and the precise inserts reduces the efforts to set the cutter. The single sided inserts are light cutting and include a long wiper flat to meet the requirements of bigger diameter cutters. The included crown design on the SEEX1203 inserts compensates a misalignment between spindle head and the workpiece to ensure a superb surface finish and appearance. The inserts offer is ideal for special cutters like hybrid cutters for rough-finishing with dedicated roughing inserts as well as pure finishing cutters with customized pitches and handling units.

- DC = 80 – 355 mm
- Available in both course and close pitch versions
- Available in both cassette version and fix pocket and also for mounting as CAP

R220.30-12CT – Metric

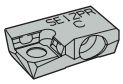
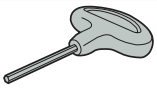




- For insert selection and cutting data recommendations, see page(s) 290 - 291
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

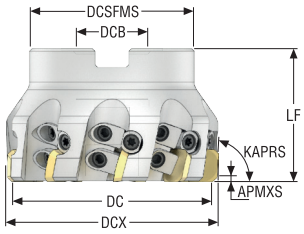
Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.30-0080-12CT	75068850	Arbor	80,0	6	1,0	88,0	–	27,0	56,0	50,0	4800	1,1	SE..1203
R220.30-0100-12CT	75068851	Arbor	100,0	8	1,0	88,0	–	32,0	77,0	50,0	4300	1,8	SE..1203
R220.30-0125-12CT	75068852	Arbor	125,0	10	1,0	88,0	–	40,0	90,0	63,0	3800	3,3	SE..1203
R220.30-8250-12CT	75068855	Arbor	250,0	22	1,0	88,0	250,0	60,0	130,0	63,0	2700	16,5	SE..1203

Spare Parts

For cutter	Arbor screw	Cassette	Cassette screw	Insert wedge	Key	Setting gauge	Wedge screw
							
R220.30-0080	MF6S12X45	SE12PRC	FS95018	334.5-640	H04-4	AU1114T-T15P	268-650
R220.30-0100	220.17-694	SE12PRC	FS95018	334.5-640	H04-4	AU1114T-T15P	268-650
R220.30-0125-8250	–	SE12PRC	FS95018	334.5-640	H04-4	AU1114T-T15P	268-650

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

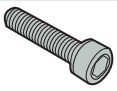
R220.30-12ST – Metric



- For insert selection and cutting data recommendations, see page(s) 290 - 291
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

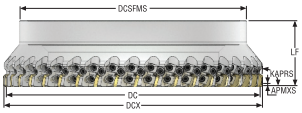
Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.30-0080-12ST	75038551	Arbor	80,0	9	1,0	88,0	80,0	27,0	56,0	50,0	5300	1,2	SE..1203
R220.30-8160-12ST	75036394	Arbor	160,0	20	1,0	88,0	160,0	40,0	90,0	63,0	3800	5,1	SE..1203
R220.30-8200-12ST	75066297	Arbor	200,0	25	1,0	88,0	200,0	60,0	130,0	63,0	3300	7,2	SE..1203

Spare Parts

For cutter	Arbor screw	Insert wedge	Key	Setting gauge	Setting screw	Wedge screw
						
R220.30-0080	MC6S12X40	CW0608	T15P-4ST	AS6011	LD6019-T15P	LD6018T-T15P
R220.30-8160-8200	–	CW0608	T15P-4ST	AS6011	LD6019-T15P	LD6018T-T15P

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.30-12ST CAP – Metric



- For insert selection and cutting data recommendations, see page(s) 290 - 291
- For complete insert programme, see page(s) 754
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.30-9250-12ST	75077274	Arbor	250,0	32	1,0	88,0	–	–	220,0	63,0	3000	9,2	SE..1203
R220.30-9355-12ST	75077276	Arbor	355,0	44	1,0	88,0	–	–	285,0	63,0	2500	15,9	SE..1203

Spare Parts

For cutter	Insert wedge	Key	Setting gauge	Setting screw	Wedge screw
R220.30-9250-9355	CW0608	T15P-4ST	AS6011	LD6019-T15P	LD6018T-T15P

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.30-12 – Insert selection – mm/*Inch*

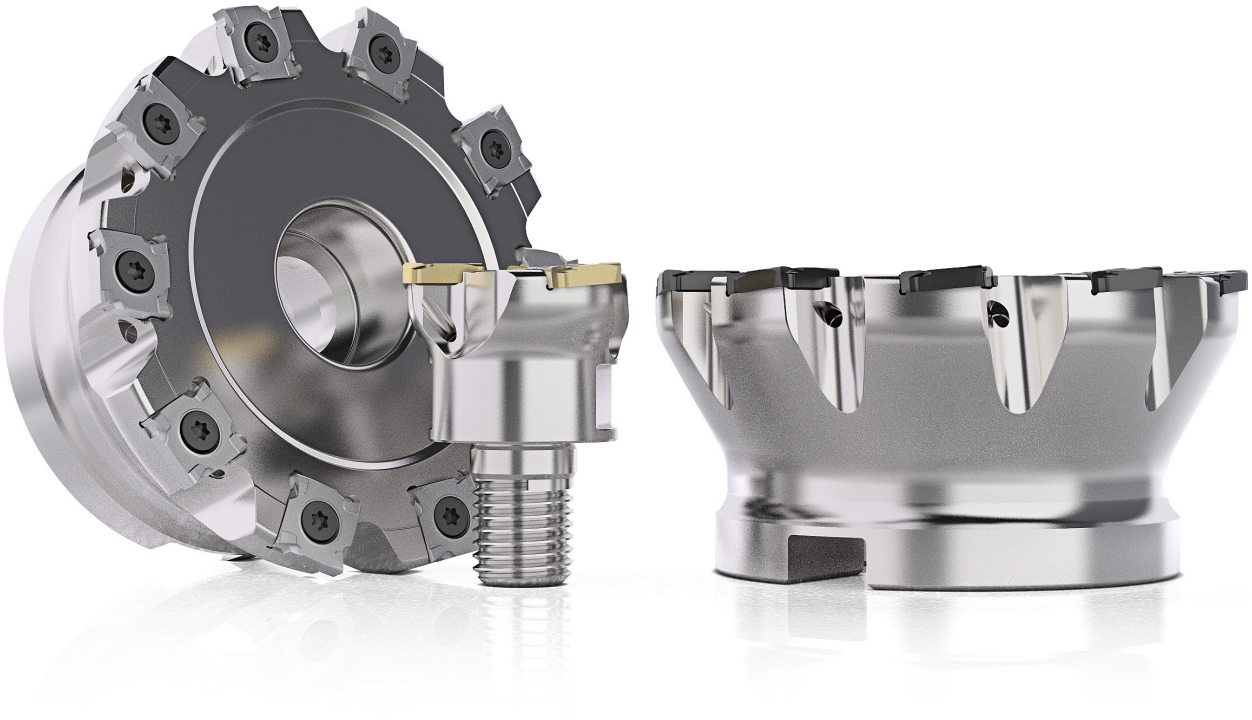
SMG		a_p	f_z		
			70%	40%	20%
P1	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*
P2	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
P3	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
P4	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*
P5	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
P6	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,17 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
P7	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,17 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
P8	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,18 *0.0070*	0,18 *0.0070*	0,22 *0.0085*
P11	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,17 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
P12	SEEX1203AFTN-M13 T350M	0,48 *0.019*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*
M1	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,19 *0.0075*	0,19 *0.0075*	0,24 *0.0095*
M2	SEEX1203AFTN-M13 T350M	0,60 *0.024*	0,17 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
M3	SEEX1203AFTN-M13 T350M	0,48 *0.019*	0,14 *0.0055*	0,14 *0.0055*	0,17 *0.0065*
M4	SEEX1203AFTN-M13 T350M	0,36 *0.014*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
M5	SEEX1203AFTN-M13 T350M	0,36 *0.014*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
K1	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,20 *0.0080*	0,20 *0.0080*	0,25 *0.010*
K2	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*
K3	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*
K4	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*
K5	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
K6	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,18 *0.0070*	0,19 *0.0075*	0,22 *0.0085*
K7	SEEX1203AFTN-MD14 MH1000	0,60 *0.024*	0,16 *0.0065*	0,17 *0.0065*	0,20 *0.0080*
H5	SEEX1203AFTN-MD14 F15M	0,48 *0.019*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*
H8	SEEX1203AFTN-MD14 F15M	0,42 *0.017*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
H11	SEEX1203AFTN-MD14 F15M	0,48 *0.019*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*
H12	SEEX1203AFTN-MD14 F15M	0,42 *0.017*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*
H21	SEEX1203AFTN-MD14 F15M	0,42 *0.017*	0,095 *0.0038*	0,095 *0.0038*	0,12 *0.0048*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.30-12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	T350M			F15M			MK1500			MH1000			H15		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	245 *800*	275 *900*	320 *1050*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P2	235 *770*	270 *890*	305 *1000*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P3	205 *670*	235 *770*	270 *890*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P4	180 *590*	210 *690*	235 *770*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P5	175 *570*	200 *660*	225 *740*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P6	195 *640*	225 *740*	260 *850*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P7	185 *610*	215 *710*	245 *800*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P8	170 *560*	200 *660*	225 *740*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P11	180 *590*	205 *670*	240 *790*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
P12	120 *395*	135 *445*	155 *510*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
M1	180 *590*	210 *690*	235 *770*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
M2	150 *490*	175 *570*	195 *640*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
M3	120 *395*	140 *460*	160 *520*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
M4	95 *310*	110 *360*	125 *410*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
M5	80 *260*	90 *295*	100 *345*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K1	185 *610*	215 *710*	240 *790*	190 *620*	220 *720*	250 *820*	295 *970*	345 *1125*	385 *1275*	230 *750*	265 *870*	300 *980*	150 *490*	175 *570*	195 *640*
K2	165 *540*	190 *620*	215 *710*	170 *560*	195 *640*	225 *740*	265 *870*	300 *980*	345 *1125*	205 *670*	235 *770*	270 *890*	135 *445*	155 *510*	175 *570*
K3	140 *460*	160 *520*	180 *590*	145 *475*	165 *540*	190 *620*	225 *740*	255 *840*	295 *970*	175 *570*	200 *660*	230 *750*	115 *375*	130 *425*	150 *490*
K4	135 *445*	155 *510*	175 *570*	135 *445*	155 *510*	180 *590*	215 *710*	245 *800*	280 *920*	165 *540*	190 *620*	220 *720*	110 *360*	125 *410*	145 *475*
K5	80 *260*	95 *310*	105 *345*	85 *280*	95 *310*	110 *360*	130 *425*	150 *490*	170 *560*	100 *330*	115 *375*	135 *445*	65 *215*	75 *245*	85 *280*
K6	120 *395*	135 *445*	150 *490*	120 *395*	140 *460*	160 *520*	190 *620*	215 *710*	245 *800*	145 *475*	165 *540*	190 *620*	95 *310*	110 *360*	125 *410*
K7	105 *345*	120 *395*	135 *445*	110 *360*	125 *410*	140 *460*	170 *560*	190 *620*	220 *720*	130 *425*	150 *490*	170 *560*	85 *280*	95 *310*	110 *360*
H5	40 *130*	45 *150*	50 *165*	41 *135*	46 *150*	50 *180*	— —	— —	— —	49 *160*	55 *180*	65 *215*	— —	— —	— —
H8	42 *140*	48 *155*	55 *180*	43 *140*	50 *165*	55 *180*	— —	— —	— —	50 *165*	60 *195*	65 *215*	— —	— —	— —
H11	50 *165*	55 *180*	65 *215*	50 *165*	60 *195*	65 *215*	— —	— —	— —	60 *195*	70 *230*	80 *260*	— —	— —	— —
H12	75 *245*	85 *280*	95 *330*	80 *260*	90 *295*	100 *330*	— —	— —	— —	95 *310*	110 *360*	120 *395*	— —	— —	— —
H21	42 *140*	48 *155*	55 *180*	43 *140*	50 *165*	55 *180*	— —	— —	— —	50 *165*	60 *195*	65 *215*	— —	— —	— —

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

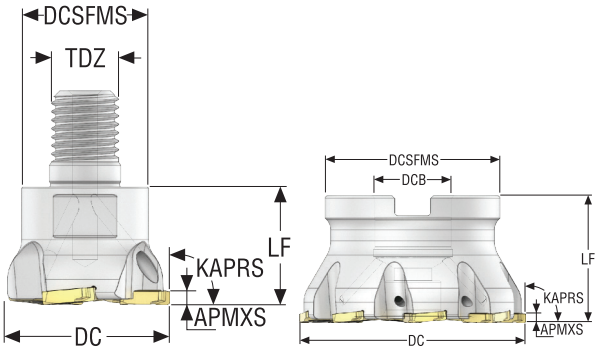


R230.19

This finishing cutter subsist on an exceptional run out even though it is a fixed pocket solution. The axial mounted inserts have a high accuracy and are light cutting at the same time thanks to the positive rake face design. The small wiper flat length created furthermore low axial tool pressure and the high run out accuracy enables you to run above the wiper flat and still achieve an excellent surface finish. This family is ideal for weak machines and smaller diameter in steel and stainless-steel materials.

- DC = 30 – 100 mm
- R230.19 Face mills for finishing
- Inserts with 4 cutting edges
- Single sided inserts

R230.19 - Metric – Metric

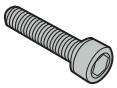


- For insert selection and cutting data recommendations, see page(s) 294 - 295
- For complete insert programme, see page(s) 756
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCSFMS	DCB	TDZ	LF	Weight	RPMX	Insert
			mm		mm		mm	mm		mm	kg		
R230.19-1030.RE-SN1103-3A	02735709	Combimaster	30,0	3	2,6	90,0	18,5	–	M10	20,0	0,1	18900	SNHQ1103xxR
R230.19-1640.RE-SN1203-3A	02735718	Combimaster	40,0	3	3,1	90,0	30,0	–	M16	28,0	0,2	16700	SNHQ1203xxR
R230.19-0050-SN1203-5A	02735719	Arbor	50,0	5	3,1	90,0	42,0	22,0	–	40,0	0,3	12300	SNHQ1203xxR
R230.19-0063-SN1203-6A	02735734	Arbor	63,0	5	3,1	90,0	50,0	27,0	–	45,0	0,6	10900	SNHQ1203xxR
R230.19-0080-SN1203-8A	02735736	Arbor	80,0	5	3,1	90,0	62,0	27,0	–	45,0	1,0	9700	SNHQ1203xxR
R230.19-0100-SN1203-10A	02735737	Arbor	100,0	10	3,1	90,0	77,0	32,0	–	50,0	1,7	8700	SNHQ1203xxR

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R230.19-1103	–	C93505-T09P	T00-09P20	2.0NM
R230.19-1203	–	C94006-T15P	T00-15P35	3.5NM
R230.19-1203 ø50	220.17-692M	C94006-T15P	T00-15P35	3.5NM
R230.19-1203 ø63-80	MC6S12X35	C94006-T15P	T00-15P35	3.5NM
R230.19-1203 ø100	MC6S16X40	C94006-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R230.19 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			70%	40%	20%
P1	SNHQ....-M07 F40M	1,9 *0.075*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
P2	SNHQ....-M07 F40M	1,9 *0.075*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
P3	SNHQ120308TR4-M07 F40M	1,9 *0.075*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*
P4	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*
P5	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
P6	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
P7	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
P8	SNHQ....-M07 F40M	1,9 *0.075*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*
P11	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
P12	SNHQ....-M07 F40M	1,5 *0.060*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
M1	SNHQ....-M07 F40M	1,9 *0.075*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
M2	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
M3	SNHQ....-M07 F40M	1,5 *0.060*	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0048*
M4	SNHQ....-M07 F40M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0044*
M5	SNHQ....-M07 F40M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0044*
K1	SNHQ....-M07 F40M	1,9 *0.075*	0,12 *0.0048*	0,12 *0.0048*	0,15 *0.0060*
K2	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
K3	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
K4	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
K5	SNHQ....-M07 F40M	1,9 *0.075*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
K6	SNHQ....-M07 F40M	1,9 *0.075*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
K7	SNHQ....-M07 F40M	1,9 *0.075*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
N1	SNHQ....-E05 H25	1,9 *0.075*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N2	SNHQ....-E05 H25	1,9 *0.075*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N3	SNHQ....-E05 H25	1,9 *0.075*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
N11	SNHQ....-E05 H25	1,9 *0.075*	0,13 *0.0050*	0,13 *0.0050*	0,16 *0.0065*
S1	SNHQ....-M07 F40M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0044*
S2	SNHQ....-M07 F40M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0044*
S3	SNHQ....-M07 F40M	1,1 *0.044*	0,080 *0.0032*	0,085 *0.0034*	0,090 *0.0040*
S11	SNHQ....-M07 F40M	1,3 *0.050*	0,095 *0.0038*	0,10 *0.0040*	0,11 *0.0048*
S12	SNHQ....-M07 F40M	1,3 *0.050*	0,095 *0.0038*	0,10 *0.0040*	0,11 *0.0048*
S13	SNHQ....-M07 F40M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0044*
H5	SNHQ....-M07 F40M	1,5 *0.060*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0040*
H8	SNHQ....-M07 F40M	1,3 *0.050*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0032*
H11	SNHQ....-M07 F40M	1,5 *0.060*	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0040*
H12	SNHQ....-M07 F40M	1,3 *0.050*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0032*
H21	SNHQ....-M07 F40M	1,3 *0.050*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0032*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

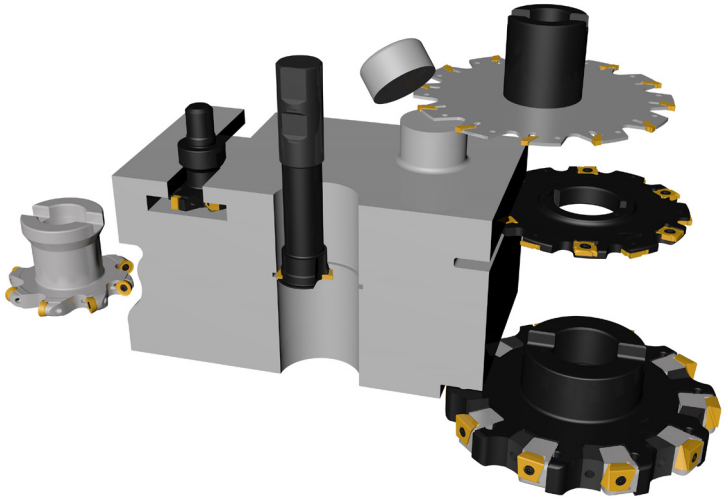
R230.19 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			F30M			MP2501			H25		
	70%	40%	20%	70%	40%	20%	70%	40%	20%	70%	40%	20%
P1	250 *820*	285 *940*	320 *1050*	260 *850*	290 *950*	335 *1100*	330 *1075*	380 *1250*	425 *1400*	— —	— —	— —
P2	240 *790*	275 *900*	310 *1025*	245 *800*	285 *940*	320 *1050*	320 *1050*	360 *1175*	405 *1325*	— —	— —	— —
P3	210 *690*	240 *790*	270 *890*	215 *710*	250 *820*	280 *920*	275 *900*	315 *1025*	355 *1175*	— —	— —	— —
P4	185 *610*	210 *690*	240 *790*	190 *620*	220 *720*	245 *800*	240 *790*	280 *920*	320 *1050*	— —	— —	— —
P5	180 *590*	200 *660*	230 *750*	185 *610*	210 *690*	240 *790*	235 *770*	265 *870*	305 *1000*	— —	— —	— —
P6	200 *660*	230 *750*	260 *850*	205 *670*	235 *770*	270 *890*	265 *870*	305 *1000*	340 *1125*	— —	— —	— —
P7	190 *620*	220 *720*	245 *800*	195 *640*	225 *740*	255 *840*	250 *820*	290 *950*	320 *1050*	— —	— —	— —
P8	175 *570*	200 *660*	225 *740*	185 *610*	210 *690*	235 *770*	230 *750*	265 *870*	300 *980*	— —	— —	— —
P11	185 *610*	210 *690*	235 *770*	190 *620*	215 *710*	245 *800*	245 *800*	280 *920*	315 *1025*	— —	— —	— —
P12	120 *395*	135 *445*	155 *510*	125 *410*	140 *460*	160 *520*	160 *520*	180 *590*	200 *660*	— —	— —	— —
M1	195 *640*	220 *720*	250 *820*	200 *660*	230 *750*	260 *850*	230 *750*	260 *850*	295 *970*	— —	— —	— —
M2	160 *520*	180 *590*	205 *670*	165 *540*	190 *620*	215 *710*	190 *620*	215 *710*	245 *800*	— —	— —	— —
M3	130 *425*	150 *490*	165 *540*	135 *445*	155 *510*	170 *570*	155 *510*	175 *570*	195 *640*	— —	— —	— —
M4	100 *330*	115 *375*	130 *425*	105 *345*	120 *395*	135 *445*	120 *395*	135 *445*	150 *510*	— —	— —	— —
M5	85 *280*	95 *310*	105 *360*	90 *295*	100 *330*	110 *375*	100 *330*	115 *375*	125 *425*	— —	— —	— —
K1	190 *620*	215 *710*	245 *800*	195 *640*	225 *740*	255 *840*	255 *840*	285 *940*	320 *1050*	— —	— —	— —
K2	170 *560*	190 *620*	220 *720*	175 *570*	200 *660*	230 *750*	225 *740*	250 *820*	290 *950*	— —	— —	— —
K3	145 *475*	160 *520*	185 *610*	145 *475*	170 *560*	195 *640*	190 *620*	215 *710*	245 *800*	— —	— —	— —
K4	135 *445*	155 *510*	175 *570*	140 *460*	160 *520*	185 *610*	180 *590*	205 *670*	235 *770*	— —	— —	— —
K5	85 *280*	95 *310*	105 *345*	85 *280*	100 *330*	110 *360*	110 *360*	125 *410*	140 *460*	— —	— —	— —
K6	120 *395*	135 *445*	155 *510*	125 *410*	140 *460*	160 *520*	160 *520*	180 *590*	205 *670*	— —	— —	— —
K7	105 *345*	125 *410*	135 *445*	110 *360*	125 *410*	145 *475*	140 *460*	165 *540*	180 *590*	— —	— —	— —
N1	1400 *4600*	1625 *5325*	1825 *6000*	1450 *4750*	1675 *5500*	1875 *6150*	— —	— —	— —	1350 *4425*	1550 *5075*	1775 *5825*
N2	560 *1825*	650 *2125*	740 *2425*	590 *1925*	680 *2225*	760 *2500*	— —	— —	— —	540 *1775*	630 *2075*	710 *2325*
N3	375 *1225*	435 *1425*	490 *1600*	390 *1275*	450 *1475*	510 *1675*	— —	— —	— —	365 *1200*	420 *1375*	475 *1550*
N11	430 *1400*	500 *1650*	560 *1825*	445 *1450*	520 *1700*	580 *1900*	— —	— —	— —	415 *1350*	480 *1575*	540 *1775*
S1	47 *155*	55 *180*	60 *195*	49 *160*	55 *180*	60 *215*	60 *195*	65 *215*	75 *245*	— —	— —	— —
S2	38 *125*	43 *140*	48 *160*	40 *130*	45 *150*	50 *165*	47 *155*	55 *180*	60 *195*	— —	— —	— —
S3	33 *110*	38 *125*	42 *140*	35 *115*	39 *130*	44 *145*	41 *135*	47 *155*	50 *180*	— —	— —	— —
S11	65 *215*	75 *245*	85 *280*	70 *230*	80 *260*	85 *295*	80 *260*	90 *295*	105 *345*	— —	— —	— —
S12	45 *150*	50 *165*	60 *195*	40 *130*	45 *150*	50 *165*	55 *180*	65 *215*	70 *230*	— —	— —	— —
S13	26 *85*	30 *100*	34 *110*	23 *75*	26 *85*	29 *100*	33 *110*	37 *120*	41 *140*	— —	— —	— —
H5	40 *130*	45 *150*	50 *165*	41 *135*	47 *155*	55 *180*	48 *155*	55 *180*	60 *195*	— —	— —	— —
H8	42 *140*	48 *155*	55 *180*	44 *145*	49 *160*	55 *180*	50 *165*	55 *180*	65 *215*	— —	— —	— —
H11	50 *165*	60 *195*	65 *215*	50 *165*	60 *195*	65 *230*	60 *195*	70 *230*	80 *260*	— —	— —	— —
H12	75 *245*	85 *280*	95 *310*	80 *260*	90 *295*	100 *330*	100 *330*	115 *375*	125 *410*	— —	— —	— —
H21	42 *140*	48 *155*	55 *180*	44 *145*	49 *160*	55 *180*	50 *165*	55 *180*	65 *215*	— —	— —	— —

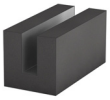
Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

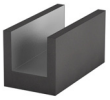
A full range of cutters for all kinds of disc Milling operations

Seco's disc mills, available from 0,7 to 32 mm (0.029 to 1.25") in width, offer a wide range of cutter diameters and connection types suitable for all relevant machine tools and disc milling applications.



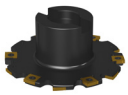
The core of the range consists of 4 main cutter families



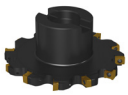


Min **Max**

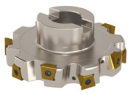
335.10 for narrow slotting and sawing
Width 2,25-4,1mm, .089"-.122"



335.19 for small width of cut and sawing
Fixed pockets
Width 4-12mm, .156"-.500"

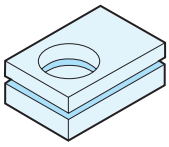


335.18 for medium width of cut
Fixed and adjustable width
Width 8-20mm, .312"-.750"

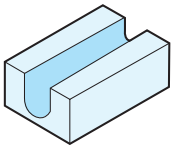


335.25 for large width of cut
Fixed and adjustable width
Width 13,5 -32mm, .53"-1.26"

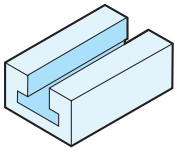
And 4 other families dedicated to specific disc milling operation



335.14 and 335.15 for circlips groove and narrow slotting
Width 0,7-5,15mm, .029"-.203"



335.29, 335.18 and 335.25 equipped with round insert - full radius profile and copy milling. Fixed and adjustable width
Width 5 - 20 mm, .197"-.787"



335.16 for T-slots
Width 11 - 22 mm, 0.387" - 0.823"

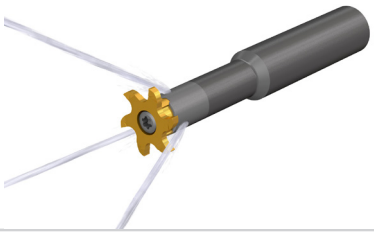
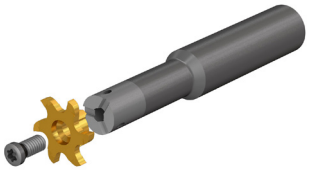
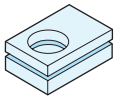
335.14

Small diameter disc milling cutter system dedicated for shallow grooving, circlips grooving, top and bottom chamfering, full radius profile and threading

- Exchangeable carbide head systems to help controlling machining costs
- Width of cut range 0.7-6.0 mm (0.043-0.236 inch)
- Diameter insert range 9.7-34.7 mm (.381 - 1.36 inch)
- A comprehensive range of cylindrical carbide and steel shanks, complemented with integrated ER collet chuck holder
- High precision width of cut +/-0.02mm - +/-0.0008”

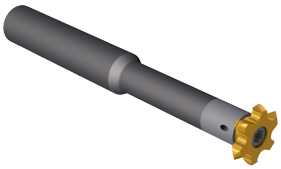
Disc Milling cutter 335.14

Disc milling cutter with exchangeable carbide head

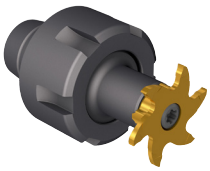




A broad range of heads and shanks available for all your disc milling operation by circular interpolation or linear slotting.
- Strong, Reliable and precise connection between the head and the cutter body
- Cover all type of material with universal M geometry and F32M grade
- Heads from diameter 9.7 mm

Cylindrical



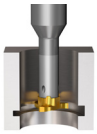
ER collet chuck



2 types of shanks available: cylindrical available both in steel and carbide, or ER collet chuck system

Grooving

Head from dia 9.7 to 34.7 mm (0.382” to 1.366”) for bore with minimum dia 10mm (0.393”)
Width from 1 to 6 mm (0.039 to 0.236”)



Disc Milling cutter 335.14

Circlip groove

Head from dia 9.7 to 21.7 mm (0.382 to 0.854”) and width from 0.7 to 5.15 mm (.029” to.203”)

Full radius profile

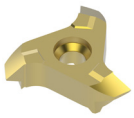
Head from dia 11.7 to 21.7 (0.460 to 0.854”) and width from 1 to 5 mm (0.039 to 0.197”)

Top & bottom Chamfering profile

Head from dia 11.7 to 21.7 (0.460 to 0.854”)and width from 1 to 4 mm (0.039 to 0.157”)

Threading

Head from dia 11,7 to 27,7 mm (0.460 to 0.854”) for partial metric threads with pitch 1-6 mm and full profile whitworth threads with pitch 19 to 11 tpi and UN threads with pitch 24 to 6 tpi.



Code key – Heads

Code key inserts

R	335	.	14	-	217	150	.	12	Z3	-	M03	F32M
1	2		3		4	5		6	7		8	9

1.	2.	3.
Right hand rotation	Disc Milling code	System
4.	**5.**	**6.**
Head diameter example: 21.7mm	Width of cut : example 1.5mm Alternative: R20: Corner radius for full radius - example R=2mm C45: Top/ bottom chamfering - example 45° Threading code key: see page	Connection size (insert / shank) in mm Example: 12mm
7.	**8.**	**9.**
Number of teeth Example Zc=3	Edge geometry	Grade

Code key – Heads Threading

Code key Threading

R	335	.	14	-	217	M	N	P	250500	-	12	Z3
1	2		3		4	5	6	7	8		9	10

1.	2.	3.
Right hand	Disc milling code	System
4.	**5.**	**6.**
Head diameter example: 21.7 mm	Thread type (W and UN)	Internal thread (E = external, X = internal/external)
7.	**8.**	**9.**
Partial profile (F = full profile)	Pitch size (2,50-5,00 mm or ex. only a fixed pitch 2,5 mm, 16 tpi...)	Connection size
10		
No. of teeth		

Code keys – Shanks

Code key cylindrical shank

335	.	14	-	16	9	.	0	-	45	-	110	-	E
1		2		3	4		5		6		7		8

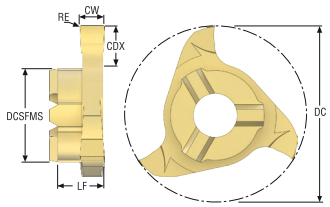
1.	2.	3.
Disc Milling code	System	Shank diameter DMM = 16mm Alternative inch, example 0625 for DMM=0.625”
4.	**5.**	**6.**
Connection size (insert/shank) in mm Example: 9mm	.0 cylindrical connection type	Access length including insert 45 mm Alternative Inch, example 177 for 1.77”
7.	**8.**	
Overall length including insert 110 mm Alternative Inch, example 433 for 4.33”	-E for carbide shank otherwise steel shank	

Code key collet chuck

335	.	14	-	ER25	-	12	-	30
1		2		3		4		5

1.	2.	3.
Disc Milling code	System	ER Collet chuck size
4.	**5.**	
Connection size (insert / shank) in mm Example: 12mm	Access length in mm including insert Example 30mm	

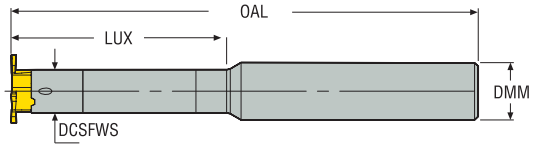
Selection – heads

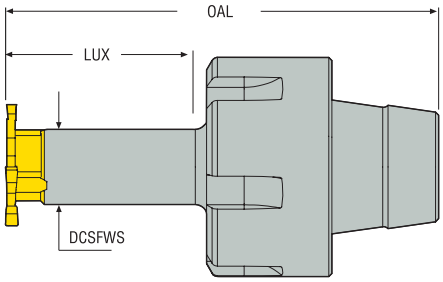


		mm	Inch	Cutter diameter in mm (min bore diameter in mm)													See page
				9.7 (10)		11.7 (12)	13.7 (14)		15,7	17.7 (20)		21.7 (22)		27.7 (28)		34.7 (35)	
				Cutter Diameter DC in inch (min bore diameter in inch)													
				0,382 (0,394)		0,461 (0,472)	0,539 (0,551)			0,697 (0,709)		0,854 (0,866)		1,091 (1,102)		1,366 (1,378)	
				Connection size DCSFMS in mm													
				6		6	8	8	8	9		12		14		14	
				Number of teeth ZEFP													
				ZEFP=3	ZEFP=6	ZEFP=3	ZEFP=3	ZEFP=6	ZEFP=3	ZEFP=3	ZEFP=6	ZEFP=3	ZEFP=6	ZEFP=3	ZEFP=6	ZEFP=6	
Grooving	Width of cut	1	0,039	x			x										305, 306
		1,5	0,059	x			x			x		x	x	x	x	x	
		2	0,079	x			x			x		x	x	x	x	x	
		2,5	0,098	x			x			x		x	x	x	x	x	
		3	0,118							x		x	x	x	x	x	
		3,5	0,138											x			
		4	0,157							x		x		x	x		
		5	0,197									x		x	x		
		6	0,236											x	x		
	*CDX (mm)=			1,5			2,5			3,5		4,5		6,5		10	
	*CDX (inch)=			0,059			0,098			0,138		0,177		0,256		0,394	
Circlips Groove	Nominal width of cut	0.7	0,028	x													308
		0,8	0,031	x													
		0,9	0,035	x													
		1,1	0,043	x						x							
		1,3	0,051	x						x							
		1,6	0,063							x		x					
		1,85	0,073									x					
		2,15	0,085									x					
		2,65	0,104									x					
		3,15	0,124									x					
		4,15	0,163									x					
		5,15	0,203									x					
	*CDX (mm)=			1,5						3,5		4,5					
	*CDX (inch)=			0,059						0,138		0,177					
Full radius	Width of cut and (Radius)	1 (R0,5)	0,039 (0,020)									x					309
		2 (R1)	0,079 (0,039)									x					
		2.2 (R1,1)	0,087 (0,043)			x				x							
		3 (R1,5)	0,118 (0,059)									x					
		4 (R2)	0,157 (0,079)									x					
		5 (R2,5)	0,197 (0,098)									x					
	*CDX (mm)=					2,5				3,5		4,5					
	*CDX (inch)=					0,098				0,138		0,177					
Chamfering	Width of cut x angle°	1.2 x45°	0,047x45°		x												310
		1.5x45°	0,059x45°					X			X						
		2,0x45°	0,079x45°								X						
		2,2x45°	0,087x45°										X				
	Type of thread	Metric				x			x	x		x					311
		Whitworth				x			x	x							
		UN								x							

X Solution available - grade F32M

Selection – shanks



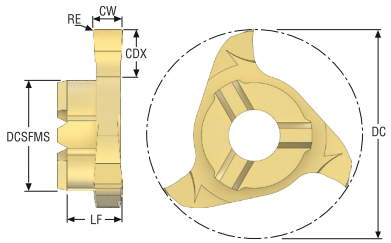


		Shank diameter mm								Shank diameter inch				ER collect chuck size			
		DMM = 10		DMM = 12		DMM = 16		DMM = 20		DMM=0,5		DMM=0,625		ER11	ER16	ER25	ER32
		OAL	LUX	OAL	LUX	OAL	LUX	OAL	LUX	OAL	LUX	OAL	LUX	LUX in mm (Inch)			
Connection size (DCSFWS)	6	60	15	80	21					3,15	0,83			16 (0,63)			
				90	30					3,54	1,18						
				100	42					3,94	1,65						
	8	60	17	95	29					3,74	1,14			16 (0,63)	22 (0,866)		
				110	42					4,33	1,65						
				120	56					4,72	2,2						
	9					80	18					3,15	0,71	22 (0,866)	22 (0,866)	22 (0,866)	
						100	32					3,94	1,26				
						110	45					4,33	1,77				
						130	64					5,12	2,52				
	12					80	24					3,15	0,94	30 (1,181)	30 (1,181)	30 (1,181)	
						100	42					3,94	1,65				
						130	60					5,12	2,36				
						160	85					6,3	3,35				
	14					100	42					3,94	1,65			19 (0,748)	19 (0,748)
						130	60					5,12	2,36			35 (1,378)	35 (1,378)
						160	85					6,3	3,35				
								100	35								
See page		314-315												316			

The dimensions OAL and LUX are indicated for a tool with 3 teeth.

	Shank in steel
	Shank in carbide

335.14 insert: general grooving

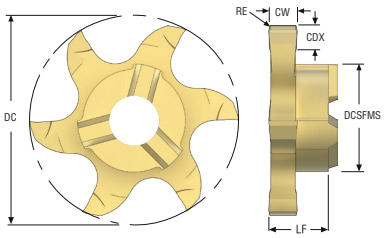


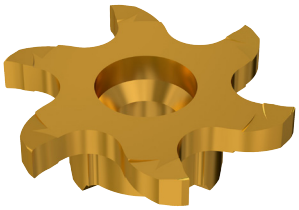
- Suitable shank, see page 314-316
- Cutting data, see page(s) 317 - 320
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	CW	CDX	DCSFMS	LF	RE	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-097100.06Z3-M01	9,7 *0.382*	1,0 *0.039*	1,5 *0.059*	6,0 *0.236*	3,35 *0.132*	0,1 *0.004*	3	■			
R335.14-097150.06Z3-M01	9,7 *0.382*	1,5 *0.059*	1,5 *0.059*	6,0 *0.236*	3,5 *0.138*	0,2 *0.008*	3	■			
R335.14-097200.06Z3-M01	9,7 *0.382*	2,0 *0.079*	1,5 *0.059*	6,0 *0.236*	3,5 *0.138*	0,2 *0.008*	3	■			
R335.14-097250.06Z3-M01	9,7 *0.382*	2,5 *0.098*	1,5 *0.059*	6,0 *0.236*	3,5 *0.138*	0,2 *0.008*	3	■			
R335.14-137100.08Z3-M01	13,7 *0.539*	1,0 *0.039*	2,5 *0.098*	8,0 *0.315*	4,35 *0.171*	0,1 *0.004*	3	■			
R335.14-137150.08Z3-M01	13,7 *0.539*	1,5 *0.059*	2,5 *0.098*	8,0 *0.315*	4,5 *0.177*	0,2 *0.008*	3	■			
R335.14-137200.08Z3-M01	13,7 *0.539*	2,0 *0.079*	2,5 *0.098*	8,0 *0.315*	4,5 *0.177*	0,2 *0.008*	3	■			
R335.14-137250.08Z3-M01	13,7 *0.539*	2,5 *0.098*	2,5 *0.098*	8,0 *0.315*	4,5 *0.177*	0,2 *0.008*	3	■			
R335.14-177150.09Z3-M02	17,7 *0.697*	1,5 *0.059*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,2 *0.008*	3	■			
R335.14-177200.09Z3-M02	17,7 *0.697*	2,0 *0.079*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,2 *0.008*	3	■			
R335.14-177250.09Z3-M02	17,7 *0.697*	2,5 *0.098*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,2 *0.008*	3	■			
R335.14-177300.09Z3-M02	17,7 *0.697*	3,0 *0.118*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,2 *0.008*	3	■			
R335.14-177400.09Z3-M02	17,7 *0.697*	4,0 *0.157*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,2 *0.008*	3	■			
R335.14-217150.12Z3-M03	21,7 *0.854*	1,5 *0.059*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,2 *0.008*	3	■			
R335.14-217200.12Z3-M03	21,7 *0.854*	2,0 *0.079*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,2 *0.008*	3	■			
R335.14-217250.12Z3-M03	21,7 *0.854*	2,5 *0.098*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,2 *0.008*	3	■			
R335.14-217300.12Z3-M03	21,7 *0.854*	3,0 *0.118*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,2 *0.008*	3	■			
R335.14-217400.12Z3-M03	21,7 *0.854*	4,0 *0.157*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,2 *0.008*	3	■			
R335.14-217500.12Z3-M03	21,7 *0.854*	5,0 *0.197*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,2 *0.008*	3	■			
R335.14-277150.14Z3-M03	27,7 *1.091*	1,5 *0.059*	6,5 *0.256*	14,0 *0.551*	6,5 *0.256*	0,2 *0.008*	3	■			
R335.14-277200.14Z3-M03	27,7 *1.091*	2,0 *0.079*	6,5 *0.256*	14,0 *0.551*	6,5 *0.256*	0,2 *0.008*	3	■			
R335.14-277250.14Z3-M03	27,7 *1.091*	2,5 *0.098*	6,5 *0.256*	14,0 *0.551*	6,5 *0.256*	0,2 *0.008*	3	■			

Designation	DC	CW	CDX	DCSFMS	LF	RE	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-277300.14Z3-M03	27,7 *1.091*	3,0 *0.118*	6,5 *0.256*	14,0 *0.551*	6,5 *0.256*	0,2 *0.008*	3	■			
R335.14-277350.14Z3-M03	27,7 *1.091*	3,5 *0.138*	6,5 *0.256*	14,0 *0.551*	6,5 *0.256*	0,2 *0.008*	3	■			
R335.14-277400.14Z3-M03	27,7 *1.091*	4,0 *0.157*	6,5 *0.256*	14,0 *0.551*	6,5 *0.256*	0,2 *0.008*	3	■			
R335.14-277500.14Z3-M03	27,7 *1.091*	5,0 *0.197*	6,5 *0.256*	14,0 *0.551*	6,6 *0.260*	0,2 *0.008*	3	■			
R335.14-277600.14Z3-M03	27,7 *1.091*	6,0 *0.236*	6,5 *0.256*	14,0 *0.551*	6,6 *0.260*	0,2 *0.008*	3	■			

335.14 insert: general grooving

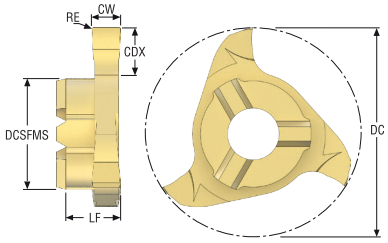




- Suitable shank, see page 314-316
- Cutting data, see page(s) 317 - 320
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	CW	CDX	DCSFMS	LF	RE	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-217150.12Z6-M03	21,7 *0.854*	1,5 *0.059*	4,5 *0.177*	12,0 *0.472*	6,25 *0.246*	0,1 *0.004*	6	■			
R335.14-217200.12Z6-M03	21,7 *0.854*	2,0 *0.079*	4,5 *0.177*	12,0 *0.472*	6,25 *0.246*	0,2 *0.008*	6	■			
R335.14-217250.12Z6-M03	21,7 *0.854*	2,5 *0.098*	4,5 *0.177*	12,0 *0.472*	6,25 *0.246*	0,2 *0.008*	6	■			
R335.14-217300.12Z6-M03	21,7 *0.854*	3,0 *0.118*	4,5 *0.177*	12,0 *0.472*	6,25 *0.246*	0,2 *0.008*	6	■			
R335.14-217400.12Z6-M03	21,7 *0.854*	4,0 *0.157*	4,5 *0.177*	12,0 *0.472*	6,25 *0.246*	0,2 *0.008*	6	■			
R335.14-277150.14Z6-M03	27,7 *1.091*	1,5 *0.059*	6,5 *0.256*	14,0 *0.551*	6,45 *0.254*	0,1 *0.004*	6	■			
R335.14-277200.14Z6-M03	27,7 *1.091*	2,0 *0.079*	6,5 *0.256*	14,0 *0.551*	6,4 *0.252*	0,2 *0.008*	6	■			
R335.14-277250.14Z6-M03	27,7 *1.091*	2,5 *0.098*	6,5 *0.256*	14,0 *0.551*	6,4 *0.252*	0,2 *0.008*	6	■			
R335.14-277300.14Z6-M03	27,7 *1.091*	3,0 *0.118*	6,5 *0.256*	14,0 *0.551*	6,4 *0.252*	0,2 *0.008*	6	■			
R335.14-277400.14Z6-M03	27,7 *1.091*	4,0 *0.157*	6,5 *0.256*	14,0 *0.551*	6,4 *0.252*	0,2 *0.008*	6	■			
R335.14-277500.14Z6-M03	27,7 *1.091*	5,0 *0.197*	6,5 *0.256*	14,0 *0.551*	6,35 *0.250*	0,2 *0.008*	6	■			
R335.14-277600.14Z6-M03	27,7 *1.091*	6,0 *0.236*	6,5 *0.256*	14,0 *0.551*	6,35 *0.250*	0,2 *0.008*	6	■			
R335.14-347150.14Z6-M03	34,7 *1.366*	1,5 *0.059*	10,0 *0.394*	14,0 *0.551*	6,25 *0.246*	0,1 *0.004*	6	■			
R335.14-347200.14Z6-M03	34,7 *1.366*	2,0 *0.079*	10,0 *0.394*	14,0 *0.551*	6,25 *0.246*	0,2 *0.008*	6	■			
R335.14-347250.14Z6-M03	34,7 *1.366*	2,5 *0.098*	10,0 *0.394*	14,0 *0.551*	6,25 *0.246*	0,2 *0.008*	6	■			
R335.14-347300.14Z6-M03	34,7 *1.366*	3,0 *0.118*	10,0 *0.394*	14,0 *0.551*	6,25 *0.246*	0,2 *0.008*	6	■			

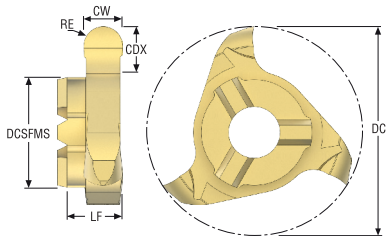
335.14 insert: For circlips groove

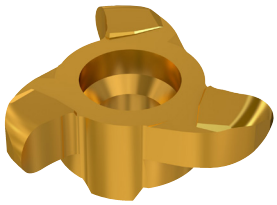


- Suitable shank, see page 314-316
- Cutting data, see page(s) 317 - 320
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	CW	CDX	DCSFMS	LF	RE	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-097070.06Z3-M01	9,7 *0.382*	0,74 *0.029*	1,5 *0.059*	6,0 *0.236*	3,35 *0.132*	0,0 *NaN*	3	■			
R335.14-097080.06Z3-M01	9,7 *0.382*	0,84 *0.033*	1,5 *0.059*	6,0 *0.236*	3,35 *0.132*	0,0 *NaN*	3	■			
R335.14-097090.06Z3-M01	9,7 *0.382*	0,94 *0.037*	1,5 *0.059*	6,0 *0.236*	3,35 *0.132*	0,0 *NaN*	3	■			
R335.14-097110.06Z3-M01	9,7 *0.382*	1,21 *0.048*	1,5 *0.059*	6,0 *0.236*	3,5 *0.138*	0,0 *NaN*	3	■			
R335.14-097130.06Z3-M01	9,7 *0.382*	1,41 *0.056*	1,5 *0.059*	6,0 *0.236*	3,5 *0.138*	0,1 *0.004*	3	■			
R335.14-177110.09Z3-M02	17,7 *0.697*	1,21 *0.048*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,0 *NaN*	3	■			
R335.14-177130.09Z3-M02	17,7 *0.697*	1,41 *0.056*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,1 *0.004*	3	■			
R335.14-177160.09Z3-M02	17,7 *0.697*	1,71 *0.067*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	0,1 *0.004*	3	■			
R335.14-217160.12Z3-M03	21,7 *0.854*	1,71 *0.067*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,1 *0.004*	3	■			
R335.14-217185.12Z3-M03	21,7 *0.854*	1,96 *0.077*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,15 *0.006*	3	■			
R335.14-217215.12Z3-M03	21,7 *0.854*	2,26 *0.089*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,15 *0.006*	3	■			
R335.14-217265.12Z3-M03	21,7 *0.854*	2,76 *0.109*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,15 *0.006*	3	■			
R335.14-217315.12Z3-M03	21,7 *0.854*	3,26 *0.128*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,15 *0.006*	3	■			
R335.14-217415.12Z3-M03	21,7 *0.854*	4,26 *0.168*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,15 *0.006*	3	■			
R335.14-217515.12Z3-M03	21,7 *0.854*	5,26 *0.207*	4,5 *0.177*	12,0 *0.472*	5,7 *0.224*	0,15 *0.006*	3	■			

335.14 insert: Full radius profile

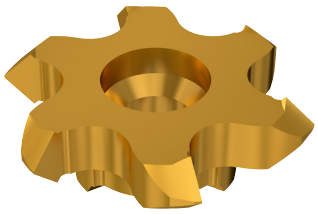


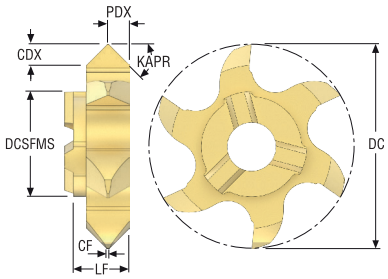


- Suitable shank, see page 314-316
- Cutting data, see page(s) 317 - 320
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	CW	CDX	DCSFMS	LF	RE	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-117R11.06Z3-M01	11,7 *0.461*	2,2 *0.087*	2,5 *0.098*	6,0 *0.236*	3,5 *0.138*	1,1 *0.043*	3	■			
R335.14-177R11.09Z3-M02	17,7 *0.697*	2,2 *0.087*	3,5 *0.138*	9,0 *0.354*	5,75 *0.226*	1,1 *0.043*	3	■			
R335.14-217R05.12Z3-M03	21,7 *0.854*	1,0 *0.039*	4,5 *0.177*	12,0 *0.472*	5,6 *0.220*	0,5 *0.020*	3	■			
R335.14-217R10.12Z3-M03	21,7 *0.854*	2,0 *0.079*	4,5 *0.177*	12,0 *0.472*	5,75 *0.226*	1,0 *0.039*	3	■			
R335.14-217R15.12Z3-M03	21,7 *0.854*	3,0 *0.118*	4,5 *0.177*	12,0 *0.472*	5,75 *0.226*	1,5 *0.059*	3	■			
R335.14-217R20.12Z3-M03	21,7 *0.854*	4,0 *0.157*	4,5 *0.177*	12,0 *0.472*	5,75 *0.226*	2,0 *0.079*	3	■			
R335.14-217R25.12Z3-M03	21,7 *0.854*	5,0 *0.197*	4,5 *0.177*	12,0 *0.472*	5,75 *0.226*	2,5 *0.098*	3	■			

335.14 insert: Top and Bottom chamfering

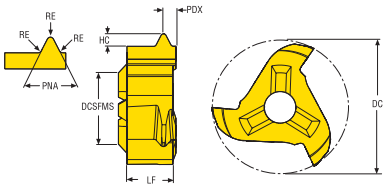


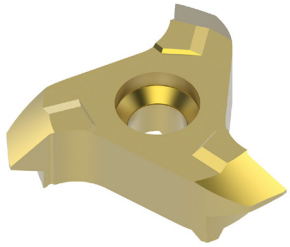


- Suitable shank, see page 314-316
- Cutting data, see page(s) 317 - 320
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	CF	CDX	PDX	DCSFMS	LF	KAPR	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*			F32M			
R335.14-097C45.06Z6-M01	9,7 *0.382*	0,2 *0.008*	1,2 *0.047*	1,5 *0.059*	6,0 *0.236*	3,4 *0.134*	45,0	6	■			
R335.14-137C45.08Z6-M01	13,7 *0.539*	0,2 *0.008*	1,8 *0.071*	2,2 *0.087*	8,0 *0.315*	4,6 *0.181*	45,0	6	■			
R335.14-177C45.09Z6-M02	17,7 *0.697*	0,2 *0.008*	2,2 *0.087*	2,8 *0.110*	9,0 *0.354*	5,8 *0.228*	45,0	6	■			
R335.14-217C45.12Z6-M03	21,7 *0.854*	0,2 *0.008*	2,0 *0.079*	2,3 *0.091*	12,0 *0.472*	6,05 *0.238*	45,0	6	■			

335.14 Insert: Threading profile Whitworth

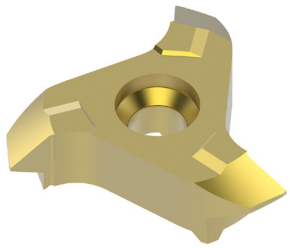


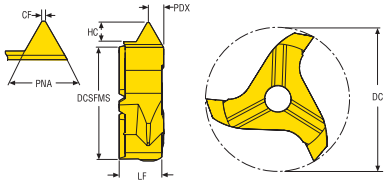


- Suitable shank, see page 314-316
- Cutting data, see page(s) 321
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	HC	PNA	PDX	DCSFMS	LF	RE	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-117WXF11.06Z3	11,7 *0.461*	1,48 *0.058*	55,0 *2.165*	1,6 *0.063*	6,0 *0.236*	3,6 *0.142*	0,31 *0.012*	3	■			
R335.14-117WXF14.06Z3	11,7 *0.461*	1,16 *0.046*	55,0 *2.165*	1,3 *0.051*	6,0 *0.236*	3,6 *0.142*	0,24 *0.009*	3	■			
R335.14-117WXF19.06Z3	11,7 *0.461*	0,86 *0.034*	55,0 *2.165*	1,1 *0.043*	6,0 *0.236*	3,6 *0.142*	0,18 *0.007*	3	■			
R335.14-157WXF14.08Z3	15,7 *0.618*	1,17 *0.046*	55,0 *2.165*	1,5 *0.059*	8,0 *0.315*	4,6 *0.181*	0,24 *0.009*	3	■			
R335.14-177WXF11.09Z3	17,7 *0.697*	1,48 *0.058*	55,0 *2.165*	1,45 *0.057*	9,0 *0.354*	5,85 *0.230*	0,31 *0.012*	3	■			
R335.14-177WXF14.09Z3	17,7 *0.697*	1,16 *0.046*	55,0 *2.165*	1,25 *0.049*	9,0 *0.354*	5,85 *0.230*	0,24 *0.009*	3	■			
R335.14-177WXF19.09Z3	17,7 *0.697*	0,856 *0.034*	55,0 *2.165*	0,95 *0.037*	9,0 *0.354*	5,85 *0.230*	0,18 *0.007*	3	■			

335.14 Insert: Threading Partial profile

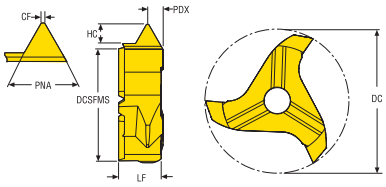


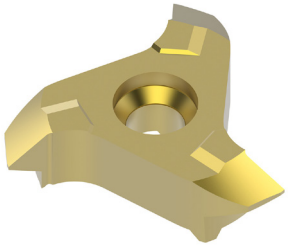


- Suitable shank, see page 314-316
- Cutting data, see page(s) 321
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	HC	CF	PNA	PDX	DCSFMS	LF	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-117MNP100200.06Z3	11,7 *0.461*	1,25 *0.049*	0,13 *0.005*	60,0 *2.362*	0,8 *0.031*	6,0 *0.236*	3,6 *0.142*	3	■			
R335.14-117MNP200300.06Z3	11,7 *0.461*	1,78 *0.070*	0,25 *0.010*	60,0 *2.362*	1,2 *0.047*	6,0 *0.236*	3,6 *0.142*	3	■			
R335.14-157MNP150275.08Z3	15,7 *0.618*	1,67 *0.066*	0,19 *0.007*	60,0 *2.362*	1,1 *0.043*	8,0 *0.315*	4,6 *0.181*	3	■			
R335.14-157MNP250300.08Z3	15,7 *0.618*	1,78 *0.070*	0,31 *0.012*	60,0 *2.362*	1,2 *0.047*	8,0 *0.315*	4,6 *0.181*	3	■			
R335.14-177MNP100200.09Z3	17,7 *0.697*	1,19 *0.047*	0,12 *0.005*	60,0 *2.362*	1,15 *0.045*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177MNP150275.09Z3	17,7 *0.697*	1,62 *0.064*	0,19 *0.007*	60,0 *2.362*	1,25 *0.049*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177MNP200375.09Z3	17,7 *0.697*	2,22 *0.087*	0,25 *0.010*	60,0 *2.362*	1,65 *0.065*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177MNP300550.09Z3	17,7 *0.697*	3,25 *0.128*	0,38 *0.015*	60,0 *2.362*	2,25 *0.089*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-217MNP100200.12Z3	21,7 *0.854*	1,19 *0.047*	0,12 *0.005*	60,0 *2.362*	1,25 *0.049*	12,0 *0.472*	5,85 *0.230*	3	■			
R335.14-217MNP200375.12Z3	21,7 *0.854*	2,22 *0.087*	0,25 *0.010*	60,0 *2.362*	1,65 *0.065*	12,0 *0.472*	5,85 *0.230*	3	■			
R335.14-217MNP250450.12Z3	21,7 *0.854*	2,7 *0.106*	0,25 *0.010*	60,0 *2.362*	2,15 *0.085*	12,0 *0.472*	5,85 *0.230*	3	■			
R335.14-217MNP350600.12Z3	21,7 *0.854*	3,84 *0.151*	0,44 *0.017*	60,0 *2.362*	2,65 *0.104*	12,0 *0.472*	5,85 *0.230*	3	■			
R335.14-277MNP250500.14Z3	27,7 *1.091*	2,93 *0.115*	0,37 *0.015*	60,0 *2.362*	2,6 *0.102*	14,0 *0.551*	6,6 *0.260*	3	■			
R335.14-277MNP400600.14Z3	27,7 *1.091*	4,6 *0.181*	0,5 *0.020*	60,0 *2.362*	3,0 *0.118*	14,0 *0.551*	6,6 *0.260*	3	■			

335.14 Insert: Threading profile UN





- Suitable shank, see page 314-316
- Cutting data, see page(s) 321
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	DC	HC	CF	PNA	PDX	DCSFMS	LF	ZEFP	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		F32M			
R335.14-177UNNF10.09Z3	17,7 *0.697*	1,375 *0.054*	0,32 *0.013*	60,0 *2.362*	1,25 *0.049*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF11.09Z3	17,7 *0.697*	1,249 *0.049*	0,29 *0.011*	60,0 *2.362*	1,05 *0.041*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF12.09Z3	17,7 *0.697*	1,146 *0.045*	0,27 *0.011*	60,0 *2.362*	1,05 *0.041*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF14.09Z3	17,7 *0.697*	0,982 *0.039*	0,23 *0.009*	60,0 *2.362*	0,85 *0.033*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF16.09Z3	17,7 *0.697*	0,859 *0.034*	0,2 *0.008*	60,0 *2.362*	0,85 *0.033*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF18.09Z3	17,7 *0.697*	0,763 *0.030*	0,18 *0.007*	60,0 *2.362*	0,85 *0.033*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF20.09Z3	17,7 *0.697*	0,687 *0.027*	0,16 *0.006*	60,0 *2.362*	0,65 *0.026*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF24.09Z3	17,7 *0.697*	0,572 *0.023*	0,13 *0.005*	60,0 *2.362*	0,65 *0.026*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF6.09Z3	17,7 *0.697*	2,291 *0.090*	0,53 *0.021*	60,0 *2.362*	1,65 *0.065*	9,0 *0.354*	5,85 *0.230*	3	■			
R335.14-177UNNF8.09Z3	17,7 *0.697*	1,718 *0.068*	0,4 *0.016*	60,0 *2.362*	1,45 *0.057*	9,0 *0.354*	5,85 *0.230*	3	■			

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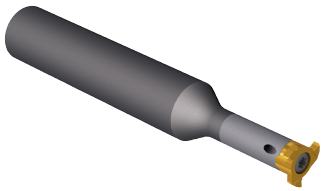
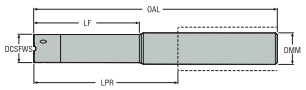
335.14 shank - Cylindrical version – Metric





- Cutting data, see page(s) 317 - 321
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	Item number	DCSFWS	DMM	OAL	LF	LPR	Through coolant	RPMX	Weight	Insert
		mm	mm	mm	mm	mm			kg	
335.14-1006.0-015-060	03042024	6,0	10,0	56,5	11,5	16,5	–	30000	0,1	R335.14...06Z..
335.14-1206.0-021-080-E	03042025	6,0	12,0	76,5	17,5	31,5	✓	30000	0,1	R335.14...06Z..
335.14-1206.0-030-090-E	03042026	6,0	12,0	86,5	26,5	41,5	✓	30000	0,1	R335.14...06Z..
335.14-1206.0-042-100-E	03042027	6,0	12,0	96,5	38,5	51,5	✓	30000	0,1	R335.14...06Z..
335.14-1008.0-017-060	03042040	8,0	10,0	55,5	12,5	15,5	–	30000	0,1	R335.14...08Z..
335.14-1208.0-029-095-E	03042041	8,0	12,0	90,5	24,5	45,5	✓	30000	0,2	R335.14...08Z..
335.14-1208.0-042-110-E	03042042	8,0	12,0	105,5	37,5	60,5	✓	30000	0,2	R335.14...08Z..
335.14-1208.0-056-120-E	03042043	8,0	12,0	115,5	51,5	70,5	✓	30000	0,2	R335.14...08Z..
335.14-1609.0-018-080	03042028	9,0	16,0	74,2	12,2	26,2	✓	30000	0,1	R335.14...09Z..
335.14-1609.0-032-100-E	03042029	9,0	16,0	94,2	26,2	46,2	✓	30000	0,2	R335.14...09Z..
335.14-1609.0-045-110-E	03042030	9,0	16,0	104,2	39,2	56,2	✓	30000	0,2	R335.14...09Z..
335.14-1609.0-064-130-E	03042031	9,0	16,0	124,2	58,2	76,2	✓	30000	0,3	R335.14...09Z..
335.14-1612.0-024-080	03042032	12,0	16,0	74,3	18,3	26,3	✓	30000	0,1	R335.14...12Z..
335.14-1612.0-042-100-E	03042033	12,0	16,0	94,3	36,3	46,3	✓	30000	0,2	R335.14...12Z..
335.14-1612.0-060-130-E	03042034	12,0	16,0	124,3	54,3	76,3	✓	30000	0,3	R335.14...12Z..
335.14-1612.0-085-160-E	03042035	12,0	16,0	154,3	76,3	106,3	✓	30000	0,3	R335.14...12Z..
335.14-1614.0-042-100-E	03042036	14,3	16,0	93,5	35,5	45,5	✓	30000	0,3	R335.14...14Z..
335.14-1614.0-060-130-E	03042037	14,3	16,0	123,5	53,5	75,5	✓	30000	0,3	R335.14...14Z..
335.14-1614.0-085-160-E	03042038	14,3	16,0	153,5	78,5	105,5	✓	30000	0,4	R335.14...14Z..
335.14-2014.0-036-100	03042039	14,0	20,0	93,5	29,2	43,5	✓	30000	0,2	R335.14...14Z..

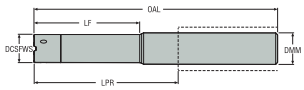
Spare Parts

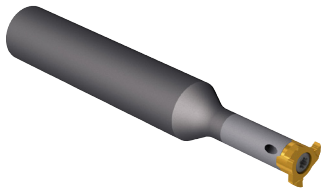
Accessories

For cutter	Insert screw	Torque key	Torque value
335.14-..06	C92608-T08P	T00-08P20	2.0NM
335.14-..08	C93510-T10P	T00-10P35	3.5NM
335.14-..09	C94012-T15P	T00-15P50	5.0NM
335.14-..12/14	C95012-T20P	–	7.0NM

-E = Carbide shank with DMM tolerance = h6
Steel shank: DMM tolerance = g6

335.14 shank - Cylindrical version – Inch





- Cutting data, see page(s) 317 - 321
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	Item number	DCSFWS	DMM	OAL	LF	LPR	Through coolant	RPMX	Weight	Insert
		Inch	Inch	Inch	Inch	Inch			lbs	
335.14-050006.0-083-315-E	03042121	0.236	0.500	3.012	0.689	1.240	✓	30000	0.220	R334.14...06Z..
335.14-050006.0-118-354-E	03042122	0.236	0.500	3.406	1.043	1.634	✓	30000	0.440	R334.14...06Z..
335.14-050006.0-165-394-E	03042107	0.236	0.500	3.799	1.516	2.028	✓	30000	0.440	R334.14...06Z..
335.14-050008.0-114-374-E	03042123	0.315	0.500	3.563	0.965	1.791	✓	30000	0.440	R334.14...08Z..
335.14-050008.0-165-433-E	03042124	0.315	0.500	4.154	1.476	2.382	✓	30000	0.440	R334.14...08Z..
335.14-050008.0-220-472-E	03042119	0.315	0.500	4.547	2.028	2.776	✓	30000	0.440	R334.14...08Z..
335.14-062509.0-071-315	03042108	0.354	0.625	2.921	0.480	1.031	✓	30000	0.220	R334.14...09Z..
335.14-062509.0-126-394-E	03042109	0.354	0.625	3.709	1.031	1.819	✓	30000	0.440	R334.14...09Z..
335.14-062509.0-177-433-E	03042110	0.354	0.625	4.102	1.543	2.213	✓	30000	0.440	R334.14...09Z..
335.14-062509.0-252-512-E	03042111	0.354	0.625	4.890	2.291	3.000	✓	30000	0.660	R334.14...09Z..
335.14-062512.0-094-315	03042112	0.472	0.625	2.925	0.720	1.035	✓	30000	0.220	R334.14...12Z..
335.14-062512.0-165-394-E	03042113	0.472	0.625	3.713	1.429	1.823	✓	30000	0.440	R334.14...12Z..
335.14-062512.0-236-512-E	03042114	0.472	0.625	4.894	2.138	3.004	✓	30000	0.660	R334.14...12Z..
335.14-062512.0-335-630-E	03042115	0.472	0.625	6.075	3.122	4.185	✓	30000	0.660	R334.14...12Z..
335.14-062514.0-165-394-E	03042116	0.551	0.625	3.681	1.398	1.791	✓	30000	0.440	R334.14...14Z..
335.14-062514.0-236-512-E	03042117	0.551	0.625	4.862	2.106	2.972	✓	30000	0.660	R334.14...14Z..
335.14-062514.0-335-630-E	03042118	0.551	0.625	6.043	3.091	4.154	✓	30000	0.880	R334.14...14Z..

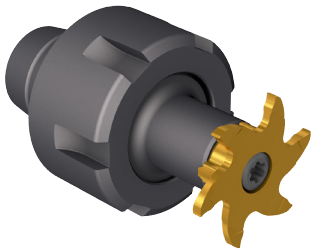
Spare Parts

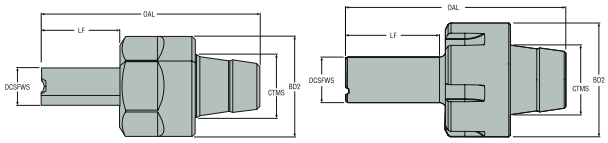
Accessories

For cutter	Insert screw	Torque key	Torque value
335.14-..06	C92608-T08P	T00-08P20	17.7IN.LBS
335.14-..08	C93510-T10P	T00-10P35	31.0IN.LBS
335.14-..09	C94012-T15P	T00-15P50	44.3IN.LBS
335.14-..12/14	C95012-T20P	–	62.0IN.LBS

-E = Carbide shank with DMM tolerance = h6
Steel shank: DMM tolerance = g6

335.14 Shank with ER collet





- Cutting data, see page(s) 317 - 321
- Technical information, see page 322
- For ISO attribute explanation, see page 16

Designation	Item number	DCSFWS	CTMS	OAL	LF	BD2	Through coolant	RPMX	Design	Weight	Insert
		mm	mm	mm	mm	mm				kg	
335.14-ER11-06-016	03042072	6,0	ER 11	34,9	12,5	16,0	–	20000	1	0,1	R335.14...06Z..
335.14-ER11-08-016	03042085	8,0	ER 11	33,8	11,5	16,0	–	20000	1	0,1	R335.14...08Z..
335.14-ER16-08-022	03042086	8,0	ER 16	49,6	17,5	32,0	–	20000	2	0,2	R335.14...08Z..
335.14-ER11-09-022	03042073	9,0	ER 11	38,5	16,2	16,0	–	20000	1	0,1	R335.14...09Z..
335.14-ER16-09-022	03042074	9,0	ER 16	48,3	16,2	32,0	–	20000	2	0,2	R335.14...09Z..
335.14-ER25-09-022	03042075	9,0	ER 25	55,3	16,2	35,0	–	20000	2	0,2	R335.14...09Z..
335.14-ER16-12-030	03042076	12,0	ER 16	56,4	24,3	32,0	–	20000	2	0,2	R335.14...12Z..
335.14-ER25-12-030	03042078	12,0	ER 25	63,4	24,3	35,0	–	20000	2	0,2	R335.14...12Z..
335.14-ER32-12-030	03042079	12,0	ER 32	69,4	24,3	50,0	–	20000	2	0,4	R335.14...12Z..
335.14-ER25-14-019	03042080	14,0	ER 25	52,3	12,5	35,0	–	20000	2	0,2	R335.14...14Z..
335.14-ER25-14-035	03042081	14,0	ER 25	67,6	28,5	35,0	–	20000	2	0,2	R335.14...14Z..
335.14-ER32-14-019	03042082	14,0	ER 32	58,3	12,5	50,0	–	20000	2	0,4	R335.14...14Z..
335.14-ER32-14-035	03042083	14,0	ER 32	73,6	28,5	50,0	–	20000	2	0,4	R335.14...14Z..

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
335.14-ER..-06	C92608-T08P	T00-08P20	2.0NM
335.14-ER..-08	C93510-T10P	T00-10P35	3.5NM
335.14-ER..-09	C94012-T15P	T00-15P50	5.0NM
335.14-ER..-12/14	C95012-T20P	–	7.0NM

R335.14 – Grooving and Chamfering – Insert selection – mm/*Inch*

SMG		f_z		
		15%	10%	5%
P1	R335.14...-M01 F32M	0,036 *0.0014*	0,042 *0.0017*	0,060 *0.0024*
P2	R335.14...-M01 F32M	0,036 *0.0014*	0,042 *0.0017*	0,060 *0.0024*
P3	R335.14...-M01 F32M	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
P4	R335.14...-M01 F32M	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
P5	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
P6	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
P7	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
P8	R335.14...-M01 F32M	0,034 *0.0013*	0,040 *0.0016*	0,055 *0.0022*
P11	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
P12	R335.14...-M01 F32M	0,020 *0.00075*	0,024 *0.00090*	0,032 *0.0013*
M1	R335.14...-M01 F32M	0,036 *0.0014*	0,042 *0.0017*	0,060 *0.0024*
M2	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
M3	R335.14...-M01 F32M	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*
M4	R335.14...-M01 F32M	0,020 *0.00080*	0,025 *0.00095*	0,034 *0.0013*
M5	R335.14...-M01 F32M	0,020 *0.00080*	0,025 *0.00095*	0,034 *0.0013*
K1	R335.14...-M01 F32M	0,036 *0.0014*	0,042 *0.0017*	0,060 *0.0024*
K2	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
K3	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
K4	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
K5	R335.14...-M01 F32M	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*
K6	R335.14...-M01 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
K7	R335.14...-M01 F32M	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*
N1	R335.14...-M01 F32M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
N2	R335.14...-M01 F32M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
N3	R335.14...-M01 F32M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
N11	R335.14...-M01 F32M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S1	R335.14...-M01 F32M	0,020 *0.00080*	0,025 *0.00095*	0,034 *0.0013*
S2	R335.14...-M01 F32M	0,020 *0.00080*	0,025 *0.00095*	0,034 *0.0013*
S3	R335.14...-M01 F32M	0,018 *0.00070*	0,022 *0.00085*	0,030 *0.0012*
S11	R335.14...-M01 F32M	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*
S12	R335.14...-M01 F32M	0,026 *0.0010*	0,030 *0.0012*	0,042 *0.0017*
S13	R335.14...-M01 F32M	0,020 *0.00080*	0,025 *0.00095*	0,034 *0.0013*
H5	R335.14...-M01 F32M	0,020 *0.00075*	0,024 *0.00090*	0,032 *0.0013*
H8	R335.14...-M01 F32M	0,011 *0.00044*	0,014 *0.00055*	0,019 *0.00075*
H11	R335.14...-M01 F32M	0,020 *0.00075*	0,024 *0.00090*	0,032 *0.0013*
H12	R335.14...-M01 F32M	0,011 *0.00044*	0,014 *0.00055*	0,019 *0.00075*
H21	R335.14...-M01 F32M	0,011 *0.00044*	0,014 *0.00055*	0,019 *0.00075*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R335.14 – Grooving and Chamfering – Insert selection – mm/*Inch*

SMG		f_z		
		15%	10%	5%
P1	R335.14...-M02 F32M	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P2	R335.14...-M02 F32M	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
P3	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P4	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P5	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P6	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P7	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P8	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P11	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P12	R335.14...-M02 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
M1	R335.14...-M02 F32M	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
M2	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M3	R335.14...-M02 F32M	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
M4	R335.14...-M02 F32M	0,034 *0.0014*	0,042 *0.0016*	0,055 *0.0022*
M5	R335.14...-M02 F32M	0,034 *0.0014*	0,042 *0.0016*	0,055 *0.0022*
K1	R335.14...-M02 F32M	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
K2	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K3	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K4	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K5	R335.14...-M02 F32M	0,048 *0.0019*	0,060 *0.0024*	0,080 *0.0032*
K6	R335.14...-M02 F32M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
K7	R335.14...-M02 F32M	0,048 *0.0019*	0,060 *0.0024*	0,080 *0.0032*
N1	R335.14...-M02 F32M	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*
N2	R335.14...-M02 F32M	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*
N3	R335.14...-M02 F32M	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*
N11	R335.14...-M02 F32M	0,075 *0.0030*	0,090 *0.0036*	0,13 *0.0050*
S1	R335.14...-M02 F32M	0,034 *0.0014*	0,042 *0.0016*	0,055 *0.0022*
S2	R335.14...-M02 F32M	0,034 *0.0014*	0,042 *0.0016*	0,055 *0.0022*
S3	R335.14...-M02 F32M	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
S11	R335.14...-M02 F32M	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S12	R335.14...-M02 F32M	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*
S13	R335.14...-M02 F32M	0,034 *0.0014*	0,042 *0.0016*	0,055 *0.0022*
H5	R335.14...-M02 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
H8	R335.14...-M02 F32M	0,019 *0.00075*	0,022 *0.00090*	0,032 *0.0012*
H11	R335.14...-M02 F32M	0,032 *0.0013*	0,038 *0.0015*	0,055 *0.0022*
H12	R335.14...-M02 F32M	0,019 *0.00075*	0,022 *0.00090*	0,032 *0.0012*
H21	R335.14...-M02 F32M	0,019 *0.00075*	0,022 *0.00090*	0,032 *0.0012*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R335.14 – Grooving and Chamfering – Insert selection – mm/*Inch*

SMG		f_z			
		20%	15%	10%	5%
P1	R335.14...-M03 F32M	0,065 *0.0026*	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*
P2	R335.14...-M03 F32M	0,065 *0.0026*	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*
P3	R335.14...-M03 F32M	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P4	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
P5	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
P6	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
P7	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
P8	R335.14...-M03 F32M	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
P11	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
P12	R335.14...-M03 F32M	0,036 *0.0014*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*
M1	R335.14...-M03 F32M	0,065 *0.0026*	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*
M2	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
M3	R335.14...-M03 F32M	0,046 *0.0018*	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
M4	R335.14...-M03 F32M	0,038 *0.0015*	0,042 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
M5	R335.14...-M03 F32M	0,038 *0.0015*	0,042 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
K1	R335.14...-M03 F32M	0,065 *0.0026*	0,070 *0.0028*	0,085 *0.0034*	0,12 *0.0048*
K2	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K3	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K4	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K5	R335.14...-M03 F32M	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
K6	R335.14...-M03 F32M	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K7	R335.14...-M03 F32M	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
N1	R335.14...-M03 F32M	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
N2	R335.14...-M03 F32M	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
N3	R335.14...-M03 F32M	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
N11	R335.14...-M03 F32M	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
S1	R335.14...-M03 F32M	0,038 *0.0015*	0,042 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
S2	R335.14...-M03 F32M	0,038 *0.0015*	0,042 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
S3	R335.14...-M03 F32M	0,032 *0.0013*	0,036 *0.0014*	0,042 *0.0017*	0,060 *0.0024*
S11	R335.14...-M03 F32M	0,046 *0.0018*	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
S12	R335.14...-M03 F32M	0,046 *0.0018*	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
S13	R335.14...-M03 F32M	0,038 *0.0015*	0,042 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
H5	R335.14...-M03 F32M	0,036 *0.0014*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*
H8	R335.14...-M03 F32M	0,020 *0.00080*	0,024 *0.00090*	0,028 *0.0011*	0,038 *0.0015*
H11	R335.14...-M03 F32M	0,036 *0.0014*	0,040 *0.0016*	0,046 *0.0018*	0,065 *0.0026*
H12	R335.14...-M03 F32M	0,020 *0.00080*	0,024 *0.00090*	0,028 *0.0011*	0,038 *0.0015*
H21	R335.14...-M03 F32M	0,020 *0.00080*	0,024 *0.00090*	0,028 *0.0011*	0,038 *0.0015*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R335.14 – Grooving and Chamfering – Cutting data v_c = (m/min)/*(sf/min)*

SMG	335.14			
	20%	15%	10%	5%
P1	230 *750*	240 *790*	255 *840*	275 *900*
P2	225 *740*	235 *770*	245 *800*	265 *870*
P3	195 *640*	200 *660*	215 *710*	230 *750*
P4	170 *560*	180 *590*	190 *620*	205 *670*
P5	165 *540*	170 *560*	180 *590*	195 *640*
P6	185 *610*	190 *620*	205 *670*	220 *720*
P7	175 *570*	180 *590*	195 *640*	205 *670*
P8	165 *540*	170 *560*	180 *590*	195 *640*
P11	170 *560*	175 *570*	190 *620*	200 *660*
P12	105 *345*	110 *360*	120 *395*	130 *425*
M1	195 *640*	205 *670*	215 *710*	235 *770*
M2	160 *520*	165 *540*	175 *570*	190 *620*
M3	125 *410*	135 *445*	140 *460*	150 *490*
M4	100 *330*	100 *330*	110 *360*	115 *375*
M5	80 *260*	85 *280*	90 *295*	95 *310*
K1	225 *740*	235 *770*	250 *820*	270 *890*
K2	200 *660*	205 *670*	220 *720*	235 *770*
K3	165 *540*	175 *570*	185 *610*	200 *660*
K4	160 *520*	165 *540*	175 *570*	190 *620*
K5	95 *310*	100 *330*	105 *345*	115 *375*
K6	140 *460*	145 *475*	155 *510*	170 *560*
K7	125 *410*	130 *425*	135 *445*	150 *490*
N1	1000 *3275*	1050 *3450*	1100 *3600*	1200 *3925*
N2	325 *1075*	340 *1125*	355 *1175*	385 *1275*
N3	215 *710*	225 *740*	235 *770*	260 *850*
N11	290 *950*	300 *980*	315 *1025*	345 *1125*
S1	29 *95*	31 *100*	32 *105*	35 *115*
S2	24 *80*	25 *80*	26 *85*	28 *90*
S3	21 *70*	22 *70*	23 *75*	25 *80*
S11	41 *135*	43 *140*	45 *150*	49 *160*
S12	38 *125*	40 *130*	42 *140*	45 *150*
S13	22 *70*	23 *75*	24 *80*	26 *85*
H5	55 *180*	55 *180*	60 *195*	65 *215*
H8	60 *195*	60 *195*	65 *215*	70 *230*
H11	70 *230*	75 *245*	80 *260*	85 *280*
H12	70 *230*	70 *230*	75 *245*	80 *260*
H21	60 *195*	60 *195*	65 *215*	70 *230*

335.14 – Threading – Cutting data v_c = (m/min)/*(sf/min)*

SMG	R335.14	
	f_z	v_c
P1	0,070 *0.0028*	275 *900*
P2	0,070 *0.0028*	270 *890*
P3	0,070 *0.0028*	230 *750*
P4	0,065 *0.0026*	205 *670*
P5	0,065 *0.0026*	195 *640*
P6	0,065 *0.0026*	215 *710*
P7	0,065 *0.0026*	205 *670*
P8	0,070 *0.0028*	195 *640*
P11	0,065 *0.0026*	200 *660*
P12	0,044 *0.0017*	120 *395*
M1	0,070 *0.0028*	215 *710*
M2	0,065 *0.0026*	175 *570*
M3	0,050 *0.0020*	130 *425*
M4	0,046 *0.0018*	100 *330*
M5	0,046 *0.0018*	80 *260*
K1	0,070 *0.0028*	210 *690*
K2	0,065 *0.0026*	185 *610*
K3	0,065 *0.0026*	180 *590*
K4	0,065 *0.0026*	150 *490*
K5	0,060 *0.0024*	90 *295*
K6	0,065 *0.0026*	130 *425*
K7	0,060 *0.0024*	115 *375*
N1	0,090 *0.0036*	970 *3175*
N2	0,090 *0.0036*	620 *2025*
N3	0,090 *0.0036*	415 *1350*
N11	0,090 *0.0036*	475 *1550*
S1	0,046 *0.0018*	50 *165*
S2	0,046 *0.0018*	41 *135*
S3	0,042 *0.0017*	35 *115*
S11	0,050 *0.0020*	65 *215*
S12	0,050 *0.0020*	50 *165*
S13	0,046 *0.0018*	39 *130*
H5	0,044 *0.0017*	43 *140*
H8	0,034 *0.0013*	45 *150*
H11	0,044 *0.0017*	60 *195*
H12	0,034 *0.0013*	55 *180*
H21	0,034 *0.0013*	45 *150*

Technical information – Threading

Recommendation for circular interpolation

To avoid vibration and insert damage when working with internal circular interpolation, we recommend a progressive entrance into the material. The circular arc angle for the progressive immersion should be between 45° and 180°

When calculating cutting datas for circular interpolation please be aware of the real radial depth of cut and the feed speed related to the centre of the cutter- See page [XXX] for more info

Milling insert with 6 cutting edges

If vibrations appear when working with milling insert with 6 cutting edges please reduce the radial depth of cut to reduce the number of teeth into contact with the material , an alternative is to choose an insert with 3 cutting edges instead.

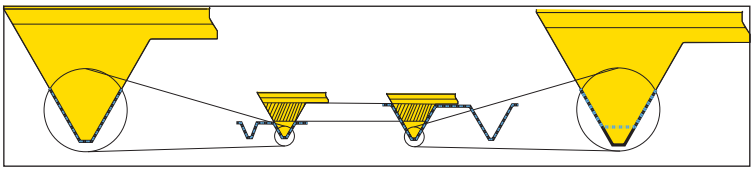
Holder recommendation

For best result in terms of stability, precision and reliability, it is recommended to use the following SECO-Tooling holders
-High precision collet chucks ERHP 5672
-Shrink fit Holder SFD 5603, SFR 5600 and SFS 5801
-ER Collet chuck ER 5675
-Power Milling Chuck, PMC

Please see SECO Tooling System catalogue for more information.

Technical information – Threading

Pitch (as of/up to)



Actual Thread

Standard thread form

Thread milling by circular interpolation can cause thread profi le violation when using insert for partial thread. Keep this in mind during the process of selecting tool. The tool diameter need to be small enough compare to the hole diameter. The pitch also needs to be considered.

Insert with partial profile for Metric ISO-Threads are multi tools. That means that each insert could machine different pitches. The insert is designed to meet the minimum pitch size (TPN); Machining this pitch will result in a standard conform thread form.

The given maximum pitch size (TPX) can be machined also with this insert at the expense of standard conformity: The result will be a slightly deeper thread than the standard. The deeper thread is normally accepted, but the application and use needs to be evaluated.

Following table is a recommendation over maximum tool diameter in relation to the thread size and pitch:

ISO-Thread, partial profile											
Pitch	M12	M16	M20	M24	M27	M30	M36	M42	M48	M56	M60
1	10	14	18	22	25	28	34	40	45	53	57
1,5	8	12	16	20	24	26	32	37	43	51	55
2	7	10	14	18	22	24	30	35	40	48	52
2,5	6	8	12	16	20	22	28	32	37	45	48
3		6	10	14	18	20	26	30	36	43	47
3,5				12	16	18	24	29	35	42	46
4							22	27	32	39	43
4,5								24	30	37	40
5								22	27	34	37
5,5								20	25	31	35
6								19	23	29	32

Code keys - Metric - Fixed pockets cutters

Arbor or arbor hole type

R	335	.	25	-	080	.	15	.	22	-	4	-	NA
1	2		3		4		5		6		7		8

1.	2.	3.
For stub arbor mounting /right hand rotation	Disc milling cutters	System
4.	**5.**	**6.**
Cutter diameter	Cutter width	Dimension of arbor bore
7.	**8.**	
4 = ZEFP value	N=Three side cutting A = Through coolant supply	

Shank type (Cylindrical or Combimaster type)

R	335	.	18	-	16	50	.	RE	-	10	.	3	-	NA
1	2		3		4	5		6		7		8		9

1.	2.	3.
Right hand rotation	Disc milling cutter	System
4.	**5.**	**6.**
-DMM value for Cyl. version -M value (thread) for Combimaster version	Cutter diameter	-RE for Combimaster -.0 for Cyl. shanks
7.	**8.**	
3=ZEFP Value	N=Three side cutting A = Through coolant supply	

Code keys - Metric - Adjustable cutters

For adjustable disc milling cutters

R	335	.	18	-	200	.	12	15	XL	.	40	-	8N	-	R6
1	2		3		4		5	6	7		8		9		10

1.	2.	3.
For stub arbor mounting/ right hand rotation	Disc milling cutters	System
4.	**5.**	**6.**
Cutter diameter	Minimum cutter width (adjustable cassettes)	Maximum cutter width (adjustable cassettes)
7.	**8.**	**9.**
Enlarged chip space	Dimension of arbor bore	8=ZEFP value N=Three side cutting R=Right hand version for two side cutting L=Left hand version for two side cutting
10.		
Insert radius if round inserts used		

Code keys - Inch - Fixed pockets cutters

Arbor or arbor hole type

R	335	.	18	-	03.00	-	0.37F	-	4N
1	2		3		4		5		6

1.	2.	3.
For stub arbor mounting /right hand rotation	Disc milling cutters	System
4.	**5.**	**6.**
Cutter diameter	Cutter width (0.37 = 0.375 inch) F = fixed width, manufacturer's option	4 = ZEFP value N = Three side cutting A = Through coolant supply

Shank type (Cylindrical or Combimaster type)

R	335	.	18	-	02.00	-	RE	-	3NA
1	2		3		4		5		6

1.	2.	3.
Right hand rotation	Disc milling cutter	System
4.	**5.**	**6.**
Cutter diameter	.RE = Combimaster, connection size .0 = for Cylindrical shanks	3 = ZEFP value N=Three side cutting A = Through coolant supply

Code keys - Inch - Adjustable cutters

For adjustable disc milling cutters

R	335	.	18	-	08.00	-	XL0809N	-	R6
1	2		3		4		5		6

1.	2.	3.
For stub arbor mounting/ right hand rotation	Disc milling cutters	System
4.	**5.**	**6.**
Cutter diameter	08 Cutter body width min (16ths of an inch) 09 Cutter body width max (16ths of an inch) XL: For enlarged chip space, manufacturer's option N = Three side cutting R = Right-hand version, two side cutting L = Left-hand version, two side cutting	R6 Insert radius in mm if round inserts used

Selection – Metric

Full side and face - fixed pocket design

System	Insert	a_p	Application	Diameters (mm) available and max depth of cut (mm)												Max no. of cutting edges	Radii available (mm)	See page
				24	32	40	50	63	80	100	125	160	200	250	315			
335.15	335.15	1,1 - 2,65	Circlip grooves	3	3			3								2	-	[XXX]
		3,15 - 5,15						5										
335.10	150.10	2,25/2,5				12	15	15	24	30	34	39				1	R0,15/R0,3	332
		3,1				12	15	15	24	30	43	39	59	84	117			
		4,1						16	22	29	34	39	59	84	117			
335.19	SNHQ / 335.19	4				11	14	17	26	32	45	42				4	R0,2/R0,4/R0,8/R1,2/ R1,6/R2,0/R2,4/R3,0/ R3,1/R3,5/ R4,0/ R5,0/R6,0	337
		5				11	14	17	26	32	45	43						
		6					14	17	26	32	31	43	61	86				
		7/ 8						17	26	26	32	44	62	87				
		10								27	33	46	63	88				
		12								27	29	45	64	89				
335.18 LNK	LNKT	8			9	12	15	15	23	27	34					4	R0,4/R0,8/R1,6/R2,0/ R2,4/R3,1/R4,0	349
		10			9	12	15	15	24	28	34							
		12					15	15	24	28	34							
		14						15	23	26	34	51						
		17							24	26	33	50						
		20							24	26	34	51						
335.25	XNHQ	15							22	25	32	52	64			4	R0,4,/R0,8/R1,2/ R1,6/R2,0/R2,4/R3,1/ R4,0/R5,0/R6,0	365
		20								25	32	51	64	88				
		25									33	50	62	87				

Full radius profile – fixed pocket design

System	Insert	a_p	Application	Diameters (mm) available and max depth of cut (mm)												Max no. of cutting edges	Radii available (mm)	See page
				25	32	40	50	63	80	100	125	160	200	250	315			
335.19	SNHQ / 335.19	4				11	14	17	26	32	45	42				4	R2,0/R3,0/R3,5/ R4,0/R5,0/R6,0	349
		6					14	17	26	32	31	43	61	86				
		7/8						17	26	32	32	44	62	87				
		10								27	33	46	63	88				
		12								27	29	45	64	89				
335.29	Round insert	5		6	8	10	12									4	R2,5/R3,0/R3,5/ R4,0/R5,0/R6,0	412
		6		6	8	10	12	15										
		7			8	10	12	15										
		8			8	10	12	15	20									
		10					12	15	20									
		12	Full radius				12	15	20									

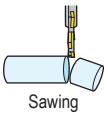
Basic choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm)

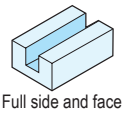
X

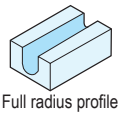
Alternative choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm))

X

Circlip groove and shallow slotting


Sawing


Full side and face


Full radius profile

Selection – Metric

Full side and and face - adjustable in width

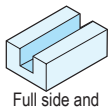
System	Insert	a_p	Applica-tion	Diameters (mm) available and max depth of cut (mm)							Max no. of cutting edges	Radii available (mm)	See page
				80	100	125	160	200	250	315			
335.18 LNK	LNK	8 - 10		14	27	32	50	63	88	121	4	R0,4/R0,8/R1,6/R2,0/ R2,4/R3,1/R4,0	365
		10 - 12		14	27	32	50	63	88	121			
		12 - 15		14	27	32	50	63	88	121			
335.25	XNHQ	13.5 - 17			24	32	50	63	88	121	4	R0,4/R0,8/R1,2/R1,6/ R2,0/R2,4/R3,1/R4,0/ R5,0/R6,0	390
		17 - 21			24	32	50	63	88	121			
		21 - 26				32	50	63	88	113			
		26 - 32					50	63	88	113			
335.18/335.25	Round insert	8 - 10	Full radius	15	28	33	51	63	88	121	4	R4,0	365-390
		10 - 12		15	28	33	51	63	88	121		R5,0	
		12 - 15		15	28	33	51	63	88	121		R6,0	
		16 - 17			28	36	54	67	92	124		R8,0	
		20 - 21							92	124		R10,0	

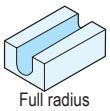
Half side and face

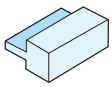
System	Insert	a_p	Applica-tion	Diameters (mm) available and max depth of cut (mm)							Max no. of cutting edges	Radii available (mm)	See page
				80	100	125	160	200	250	315			
335.18 LNK	LNK	≤5		14	27	32	50	63	88	121	2+2	R0,4/R0,8/R1,6/R2,0/ R2,4/R3,1/R4,0	365
		≤6		14	27	32	50	63	88	121			
		≤7.5		14	27	32	50	63	88	121			
335.25	XNHQ	≤8,5			24	32	50	63	88	121	2+2	R0,4/R0,8/R1,2/R1,6/ R2,0/R2,4/R3,1/R4,0/ R5,0/R6,0	390
		≤11			24	32	50	63	88	121			
		≤13				32	50	63	88	113			
		≤16					50	63	88	113			
335.18/335.25	Round insert	≤4	Full radius	15	28	33	51	63	88	121	4	R4,0	365-390
		≤5		15	28	33	51	63	88	121		R5,0	
		≤6		15	28	33	51	63	88	121		R6,0	
		≤8			28	36	54	67	92	124		R8,0	
		≤10							92	124		R10,0	

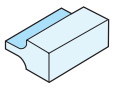
Basic choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm) — X

Alternative choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm) — X


Full side and face


Full radius profile


Half side and face


Half radius profile

Selection – Inch

Full side and face - fixed pocket design

System	Insert	a_p	Application	Diameters available and max depth of cut* (inch)											Max no. cutting edges	Radii range RE (inch)	Page
				1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00			
335.15	335.15	.124-.203	Circlip grooves					0.22							2	–	332
335.10	150.10	.089-.098				0.47	0.62	0.63	0.73	1.06	1.36	1.41			1	.006 .012	337
		0.122				0.47	0.62	0.63	0.73	1.06	1.36	1.41					
335.19	SNHQ / 335.19	0.156				0.45	0.6	0.7	0.95	1.32					4	.008 / .016 .031 / .047 .063 / .079 .094 / .118 .122 / .138 .157 / .197 .236	349
		0.187				0.45	0.6	0.7	0.95	1.32	1.41	1.91					
		0.250					0.6	0.7	0.95	1.32	1.45	1.95	2.51				
		0.313						0.56	0.81	1.07	1.45	1.95					
		0.375						0.56	0.81	1.11	1.49	2.02					
		0.500								1.13	1.52	2.00					
335.18 LNK	LNKT	0.312			0.35	0.41	0.59	0.63	0.71	1.06	1.38				4	.016 / .031 .063 / .079 .094 / .122 .157	365
		0.375			0.35	0.41	0.59	0.63	0.71	1.06	1.38						
		0.500					0.59	0.62	0.87	1.14	1.38	1.81					
		0.625							0.71	1.06							
		0.750							0.71	1.06	1.38						
335.25	XNHQ	0.750									1.33	1.83	2.48		4	.031 / .047 .063 / .079 .094 / .122 .157 / .197 .236	390
		1.00									1.35	1.85	2.43	3.43			

Full radius profile – fixed pocket design

System	Insert	a_p	Application	Diameters available and max depth of cut* (inch)											Max no. cutting edges	Radii range r_ε (inch)	Page
				1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00			
335.29	Round insert	0.236	Full radius			0.30	0.41								4	0.118 0.157 0.197	412
		0.315					0.41	0.60									
		0.394						0.59	0.70								

Basic choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm) — X

Alternative choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm)) — X

Circlip groove and shallow slotting

Sawing

Full side and face

Full radius profile

Selection – Inch

Full side and and face - adjustable in width

System	Insert	a_p	Applica-tion	Diameters (inch) available and max depth of cut* (inch)						Max no. of cutting edges	Radii range (inch)	Page
				4.00	5.00	6.00	8.00	10.00	12.00			
335.18 LNK	LNK	.315 - .394		1.1	1.34	1.77	2.42	3.39	4.39	4	.0157 / .031 .063 / .079 .094 / .122 .157	365
		.394 - .472		1.01	1.33	1.77	2.42	3.39	4.39			
		.472 - .591		1.01	1.33	1.77	2.42	3.39	4.39			
335.25	XNHQ	.53 - .67		1.01	1.33	1.80	2.42	3.42	4.46	4	.016 / .031 .063 / .079 .094 / .122 .157 / .197 .236	390
		.67 - .83		1.01	1.33	1.80	2.42	3.42	4.46			
		.83 - 1.02			1.33	1.79	2.41	3.41	4.41			
		1.02 - 1.26				1.79	2.41	3.41	4.41			
335.18	Round insert	.315 - .394	Full radius	1.14	1.38	1.77	2.42	3.39	4.39	4		365
		.394 - .472		1.06	1.38	1.81	2.42	3.39	4.39			
		.472 - .591		1.05	1.37	1.83	2.42	3.39	4.39			
		.630 - .669			1.41	1.91	2.54	3.54	4.58			
		.789 - .827						3.54	4.54			

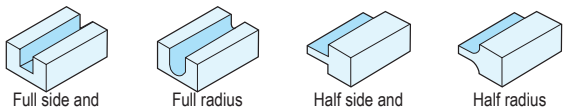
Half side and face

System	Insert	a_p	Applica-tion	Diameters available and max depth of cut* (inch)						Max no. of cutting edges	Radii range RE (inch)	Page
				4.00	5.00	6.00	8.00	10.00	12.00			
335.18 LNK	LNK	≤0.197		1.10	1.34	1.77	2.42	3.39	4.39	2+2	.016 / .031 .063 / .079 .094 / .122 .157	365
		≤0.236		1.01	1.33	1.77	2.42	3.39	4.39			
		≤0.295		1.01	1.33	1.79	2.42	3.39	4.39			
335.25	XNHQ	≤0.354		1.01	1.33	1.80	2.42	3.42	4.46	2+2	.016 / .031 .063 / .079 .094 / .122 .157 / .197 .236	390
		≤0.437		1.01	1.33	1.80	2.42	3.42	4.46			
		≤0.512			1.33	1.79	2.41	3.41	4.41			
		≤0.630				1.79	2.41	3.41	4.41			
335.18	Round insert	≤0.157	Full radius	1.14	1.38	1.77	2.42	3.39	4.39	4	.157	365
		≤0.197		1.06	1.38	1.81	2.42	3.39	4.39		.157	
		≤0.236		1.05	1.37	1.83	2.42	3.39	4.39		.197	
		≤0.315			1.41	1.91	2.54	3.54	4.58		.315	
		≤0.393						3.54	4.54		.315	

*** Not all mounting types reach max depth of cut and a_p,** see product pages for exact data and cutting recommendations.

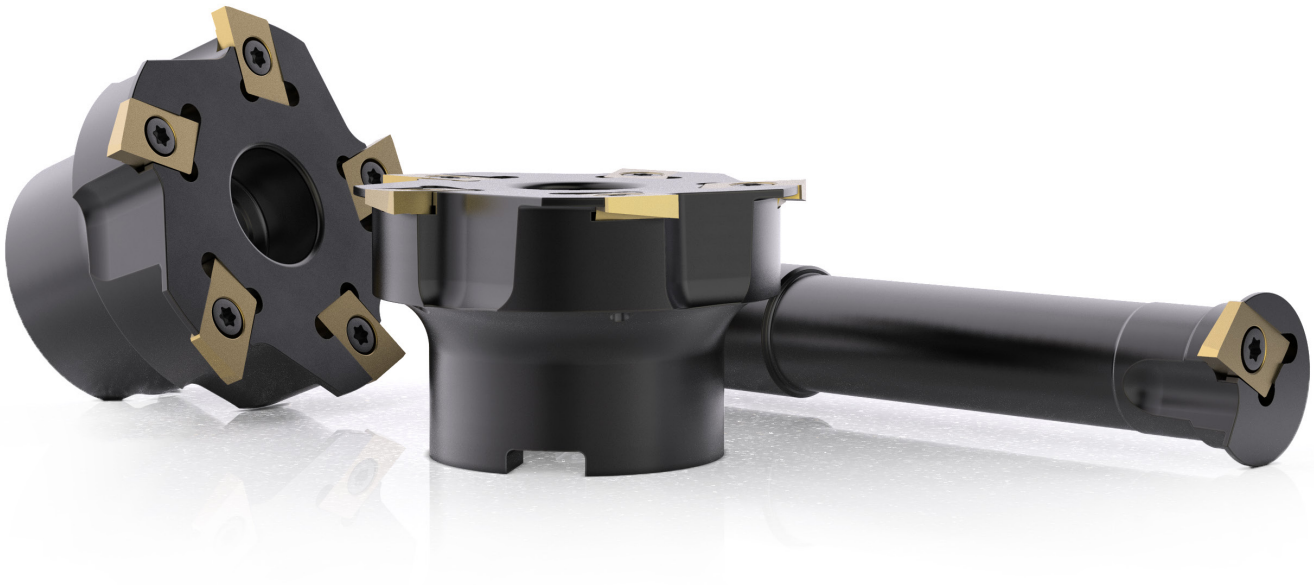
Basic choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm) — X

Alternative choice (X indicates the maximum radial depth of cut "CDX" in slotting in mm) — X



Full side and face | Full radius profile | Half side and face | Half radius profile

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

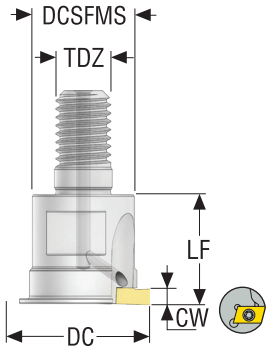


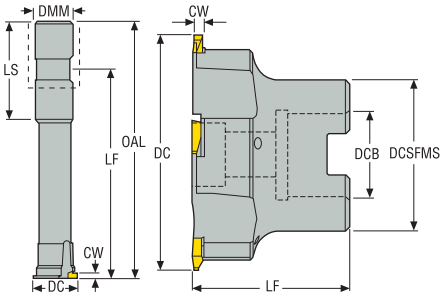
335.15

Disc Milling cutter system designed to generate circle snap-ring grooves and shallow slotting grooves

- Width of cut 1.1-5.15 mm (.043 - .202 inch)
- Cutter range diameter 24-63 mm (1 - 2.5 inch)
- Available with Weldon, Arbor and Combimaster with through coolant connection
- Economical light cutting insert with 2 cutting edges design
- Insert width precision +0/+0.05mm - +0/+0.002”

For circlip grooves milling cutter R335.15 – Metric





- For insert selection and cutting data recommendations, see page(s) 335 - 336
- For complete insert programme, see page(s) 792
- For ISO attribute explanation, see page 16

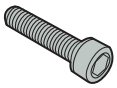
Designation	Item number	Type of mounting	DC	CWN	CWX	ZEFP	DCB	DCSFMS	DMM	LS	LF	OAL	TDZ	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm	mm	mm			kg	
R335.15-20024.3-03-1	75002642	Weldon	24,0	1,1	2,65	1	–	–	20,0	50,0	105,05	130,0	–	28200	0,3	R335.15-13..
R335.15-1024.RE-03.1A	03329402	Combimaster	24,0	1,1	2,65	1	–	18,5	–	–	20,0	–	M10	28200	0,5	R335.15-13..
R335.15-25034.3-03-2	75002643	Weldon	34,0	1,1	2,65	2	–	–	25,0	56,0	98,05	130,0	–	23600	0,5	R335.15-13..
R335.15-1234.RE-03.2A	03329403	Combimaster	34,0	1,1	2,65	2	–	23,0	–	–	30,0	–	M12	23600	0,9	R335.15-13..
R335.15-063-03.22-5	75011752	Arbor	63,0	1,1	2,65	5	22,0	40,0	–	–	40,0	–	–	17300	0,5	R335.15-13..
R335.15-063-05.22-5	75011753	Arbor	63,0	3,15	5,15	5	22,0	40,0	–	–	40,0	–	–	17300	0,4	R335.15-18..

CW depends on the insert width

For groove depth (CDX), please see insert pages [XXX]

Spare Parts

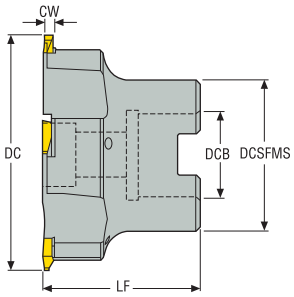
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R335.15 DC = 24/34	–	C03509-T15P	T00-15P30	3.0NM
R335.15 DC = 63	220.17-692	C03509-T15P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

For circlip grooves milling cutter R335.15 – Inch

Width 0.043 - 0.202 Inch



- For insert selection and cutting data recommendations, see page(s) 335 - 336
- For complete insert programme, see page(s) 792
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CWN	CWX	ZEFP	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch		lbs	
R335.15-02.50-18	75072222	Arbor	2.500	0.124	0.203	5	0.750	1.571	1.571	17300	1.100	R335.15-18...

CW depends on the insert width

For groove depth (CDX), please see insert pages [XXX]

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R335.15-02.50-..	UC6S3/8UNFX1-1/4	C03509-T15P	T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829

R335.15– Insert selection – mm/*Inch*

SMG			f_z		
			10%	5%	2%
P1	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,19 *0.0075*	0,26 *0.010*	0,42 *0.017*
P2	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,19 *0.0075*	0,26 *0.010*	0,42 *0.017*
P3	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,18 *0.0070*	0,25 *0.010*	0,40 *0.016*
P4	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,18 *0.0070*	0,25 *0.010*	0,40 *0.016*
P5	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
P6	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
P7	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
P8	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,18 *0.0070*	0,25 *0.010*	0,40 *0.016*
P11	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
P12	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
M1	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,19 *0.0075*	0,26 *0.010*	0,42 *0.017*
M2	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
M3	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,14 *0.0055*	0,19 *0.0075*	0,30 *0.012*
M4	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
M5	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
K1	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,19 *0.0075*	0,26 *0.010*	0,42 *0.017*
K2	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
K3	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
K4	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
K5	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,16 *0.0065*	0,22 *0.0085*	0,34 *0.013*
K6	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,17 *0.0065*	0,24 *0.0095*	0,38 *0.015*
K7	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,16 *0.0065*	0,22 *0.0085*	0,34 *0.013*
N1	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,24 *0.0095*	0,34 *0.013*	0,55 *0.022*
N2	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,24 *0.0095*	0,34 *0.013*	0,55 *0.022*
N3	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,24 *0.0095*	0,34 *0.013*	0,55 *0.022*
N11	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,24 *0.0095*	0,34 *0.013*	0,55 *0.022*
S1	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
S2	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
S3	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,11 *0.0044*	0,16 *0.0065*	0,25 *0.010*
S11	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,14 *0.0055*	0,19 *0.0075*	0,30 *0.012*
S12	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,14 *0.0055*	0,19 *0.0075*	0,30 *0.012*
S13	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,17 *0.0065*	0,26 *0.010*
H5	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
H8	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H11	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,12 *0.0048*	0,16 *0.0065*	0,26 *0.010*
H12	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*
H21	R335.15-13..FG-E08 F40M	R335.15-18..FG-M12 F40M	0,090 *0.0036*	0,12 *0.0048*	0,20 *0.0080*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R335.15 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M		
	10%	5%	2%
P1	260 *850*	285 *940*	280 *920*
P2	255 *840*	275 *900*	275 *900*
P3	220 *720*	240 *790*	240 *790*
P4	195 *640*	210 *690*	210 *690*
P5	190 *620*	205 *670*	205 *670*
P6	210 *690*	230 *750*	230 *750*
P7	200 *660*	215 *710*	215 *710*
P8	185 *610*	200 *660*	200 *660*
P11	195 *640*	210 *690*	210 *690*
P12	125 *410*	135 *445*	135 *445*
M1	205 *670*	225 *740*	220 *720*
M2	170 *560*	185 *610*	185 *610*
M3	135 *445*	150 *490*	150 *490*
M4	105 *345*	115 *375*	115 *375*
M5	90 *295*	95 *310*	95 *310*
K1	200 *660*	220 *720*	220 *720*
K2	180 *590*	195 *640*	195 *640*
K3	150 *490*	165 *540*	165 *540*
K4	145 *475*	155 *510*	155 *510*
K5	90 *295*	95 *310*	95 *310*
K6	130 *425*	140 *460*	140 *460*
K7	110 *360*	120 *395*	120 *395*
N1	1500 *4925*	1625 *5325*	1600 *5250*
N2	600 *1975*	650 *2125*	650 *2125*
N3	405 *1325*	435 *1425*	430 *1400*
N11	460 *1500*	495 *1625*	495 *1625*
S1	49 *160*	55 *180*	55 *180*
S2	40 *130*	43 *140*	43 *140*
S3	35 *115*	37 *120*	37 *120*
S11	70 *230*	75 *245*	75 *245*
S12	60 *195*	65 *215*	65 *215*
S13	34 *110*	36 *120*	36 *120*
H5	41 *135*	45 *150*	45 *150*
H8	44 *145*	48 *155*	47 *155*
H11	55 *180*	60 *195*	55 *180*
H12	50 *165*	55 *180*	55 *180*
H21	44 *145*	48 *155*	47 *155*

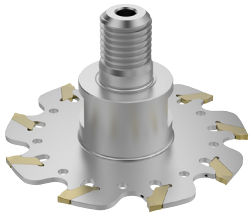
335.10

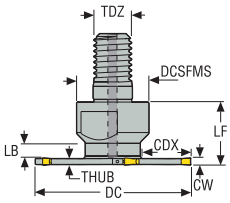
Easy to use and reliable disc milling cutter system dedicated for slim slotting and cut-off operations.

- Self-clamping carbide insert design, the insert is retained by the spring action of the steel part of the cutter
- Width of cut 2.25-4.1 mm (.088 - .161 inch)
- Cutter range diameter 40-315 mm (1.5 - 6.0 inch)
- Available with Weldon, Combimaster, Arbor and Arbor hole connection
- Large cutter diameter with HSS cutter body material for high rigidity and reliability
- Small cutter diameter with internal coolant and close pitch design for high productivity
- Insert width precision from +/- 0.05 to 0.08mm - +/-0.002 to 0.003”

Cutter 335.10 - Insert 150.10 – Metric

Width 2,25/2,5/3,1 mm – full side – close pitch design with internal coolant

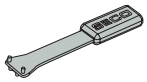




- For insert selection and cutting data recommendations, see page(s) 347-348
- For complete insert programme, see page(s) 786
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	TDZ	DCSFMS	THUB	LF	LB	Through coolant	RPMX	Weight	Insert 150.10
			mm	mm	mm	mm			mm	mm	mm	mm			kg	
R335.10-1040.RE-02-4A	02926773	Combimaster	40,0	2,25	2,5	12,7	4	M10	18,5	1,9	20,0	5,3	✓	3970	0,1	-2.25N/2.5N
R335.10-1250.RE-02-5A	02926774	Combimaster	50,0	2,25	2,5	15,4	5	M12	23,0	1,9	20,0	5,3	✓	3180	0,1	-2.25N/2.5N
R335.10-1663.RE-02-7A	03054405	Combimaster	63,0	2,25	2,5	15,7	7	M16	30,0	1,9	23,0	–	✓	2520	0,2	-2.25N/2.5N
R335.10-1680.RE-02-9A	03054406	Combimaster	80,0	2,25	2,5	24,1	9	M16	30,0	1,9	23,0	–	✓	1980	0,2	-2.25N/2.5N
R335.10-20100.RE-02-11A	03054407	Combimaster	100,0	2,25	2,5	30,4	11	M20	36,5	1,9	25,0	–	✓	1580	0,4	-2.25N/2.5N
R335.10-1040.RE-03-4A	02926776	Combimaster	40,0	3,1	3,1	12,9	4	M10	18,5	2,4	20,0	4,3	✓	3970	0,1	-3N
R335.10-1250.RE-03-5A	02926777	Combimaster	50,0	3,1	3,1	15,6	5	M12	23,0	2,4	20,0	4,3	✓	3180	0,1	-3N
R335.10-1663.RE-03-7A	03054398	Combimaster	63,0	3,1	3,1	15,9	7	M16	30,0	2,4	23,0	–	✓	2520	0,2	-3N
R335.10-1680.RE-03-9A	03054399	Combimaster	80,0	3,1	3,1	24,3	9	M16	30,0	2,4	23,0	–	✓	1980	0,2	-3N
R335.10-20100.RE-03-11A	03054400	Combimaster	100,0	3,1	3,1	30,6	11	M20	36,5	2,4	25,0	–	✓	1580	0,4	-3N
R335.10-20125.RE-03-13A	03279546	Combimaster	125,0	3,1	3,1	43,1	13	M20	36,5	2,4	25,0	0,0	✓	1270	0,7	-3N

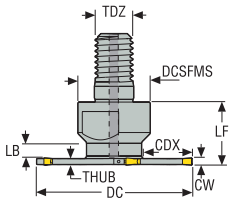
Spare Parts

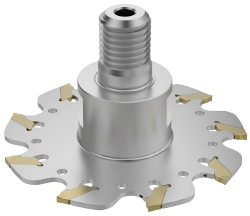
For cutter	Insert key
	
R335.10-..	335.10-155
R335.10-Ø125	150.10-150

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Width 0.089/0.098/0.122 Inch – full side – close pitch design with internal coolant

Cutter 335.10 - Insert 150.10 – Inch

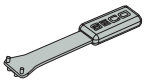




- For insert selection and cutting data recommendations, see page(s) 347-348
- For complete insert programme, see page(s) 786
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	TDZ	DCSFMS	THUB	LF	LB	Through coolant	RPMX	Weight	Insert 150.10
			Inch	Inch	Inch	Inch			Inch	Inch	Inch	Inch			lbs	
R335.10-01.50-10RE-02-4A	03054408	Combimaster	1.500	0.089	0.098	0.469	4	M10	0.728	0.075	0.787	0.201	✓	3970	0.220	-2.25N/2.5N
R335.10-02.00-12RE-02-5A	03054409	Combimaster	2.000	0.089	0.098	0.622	5	M12	0.906	0.075	0.787	0.209	✓	3180	0.220	-2.25N/2.5N
R335.10-02.50-16RE-02-7A	03054410	Combimaster	2.500	0.089	0.098	0.626	7	M16	1.181	0.075	0.906	–	✓	2520	0.440	-2.25N/2.5N
R335.10-02.00-12RE-03-5A	03054402	Combimaster	2.000	0.122	0.122	0.630	5	M12	0.906	0.094	0.787	0.169	✓	3180	0.220	-3N

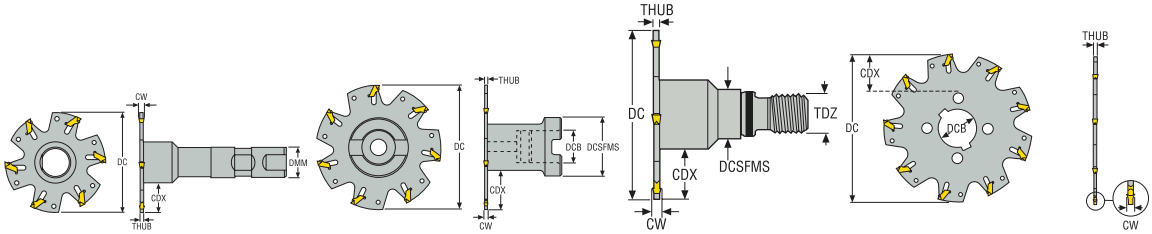
Spare Parts

For cutter	Insert key
	
	335.10-155

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Cutter 335.10 - Insert 150.10 – Metric

Width 2,25/2,5/3,1 mm – full side – HSS body



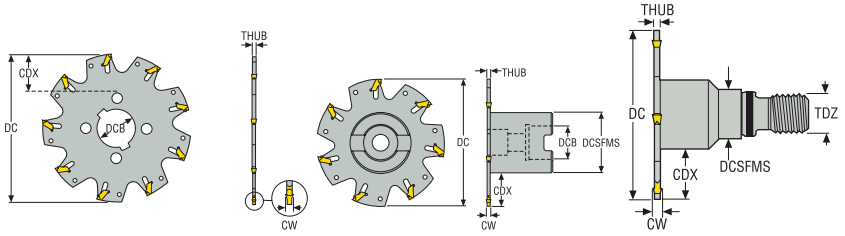
- For insert selection and cutting data recommendations, see page(s) 347-348
- For complete insert programme, see page(s) 786
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	DMM	TDZ	DCB	DCSFMS	THUB	RPMX	Weight	Insert 150.10
			mm	mm	mm	mm		mm		mm	mm	mm		kg	
R335.10-25063.3-02-5	75034462	Weldon	63,0	2,25	2,5	15,0	5	25,0	–	–	–	1,9	4000	0,6	-2.25N/2.5N
R335.10-063-02.22-5	75034464	Arbor	63,0	2,25	2,5	15,0	5	–	–	22,0	32,0	1,9	4000	0,5	-2.25N/2.5N
R335.10-1663.RE-02-5	02731371	Combimaster	63,0	2,25	2,5	16,0	5	–	M16	–	30,0	1,9	4000	0,3	-2.25N/2.5N
R335.10-32080.3-02-6	75034463	Weldon	80,0	2,25	2,5	19,5	6	32,0	–	–	–	1,9	3500	1,1	-2.25N/2.5N
R335.10-080-02.22-6	75034465	Arbor	80,0	2,25	2,5	19,5	6	–	–	22,0	40,0	1,9	3500	0,5	-2.25N/2.5N
335.10-080-02.22-6	75034458	Arbor hole	80,0	2,25	2,5	22,5	6	–	–	22,0	–	1,9	3500	0,1	-2.25N/2.5N
R335.10-1680.RE-02-6	02731373	Combimaster	80,0	2,25	2,5	19,5	6	–	M16	–	30,0	1,9	3500	0,4	-2.25N/2.5N
R335.10-100-02.27-7	75034466	Arbor	100,0	2,25	2,5	25,5	7	–	–	27,0	48,0	1,9	3200	0,9	-2.25N/2.5N
335.10-100-02.27-7	75034459	Arbor hole	100,0	2,25	2,5	29,0	7	–	–	27,0	–	1,9	3200	0,1	-2.25N/2.5N
R335.10-125-02.32-9	75034467	Arbor	125,0	2,25	2,5	33,0	9	–	–	32,0	58,0	1,9	2800	1,1	-2.25N/2.5N
335.10-125-02.32-9	75028096	Arbor hole	125,0	2,25	2,5	34,5	9	–	–	32,0	–	1,9	2800	0,2	-2.25N/2.5N
R335.10-160-02.40-12	75034468	Arbor	160,0	2,25	2,5	39,5	12	–	–	40,0	80,0	1,9	2400	2,4	-2.25N/2.5N
335.10-160-02.40-12	75034460	Arbor hole	160,0	2,25	2,5	39,5	12	–	–	40,0	–	1,9	2400	0,3	-2.25N/2.5N
R335.10-25063.3-03-5	75027293	Weldon	63,0	3,1	3,1	15,0	5	25,0	–	–	–	2,4	4000	0,5	-3N
R335.10-063-03.22-5	75027298	Arbor	63,0	3,1	3,1	15,0	5	–	–	22,0	32,0	2,4	4000	0,4	-3N
R335.10-1663.RE-03-5	02731375	Combimaster	63,0	3,1	3,1	16,0	5	–	M16	–	30,0	2,4	4000	0,3	-3N
R335.10-32080.3-03-6	75027296	Weldon	80,0	3,1	3,1	19,5	6	32,0	–	–	–	2,4	3500	1,1	-3N
R335.10-080-03.22-6	75027301	Arbor	80,0	3,1	3,1	19,5	6	–	–	22,0	40,0	2,4	3500	0,5	-3N
335.10-080-03.22-6	75012752	Arbor hole	80,0	3,1	3,1	22,5	6	–	–	22,0	–	2,4	3500	0,1	-3N
R335.10-1680.RE-03-6	02731378	Combimaster	80,0	3,1	3,1	19,5	6	–	M16	–	30,0	2,4	3500	0,5	-3N
R335.10-100-03.27-7	75027303	Arbor	100,0	3,1	3,1	25,5	7	–	–	27,0	48,0	2,4	3200	0,7	-3N
335.10-100-03.27-7	75012754	Arbor hole	100,0	3,1	3,1	29,0	7	–	–	27,0	–	2,4	3200	0,2	-3N
R335.10-125-03.32-9	75027307	Arbor	125,0	3,1	3,1	33,0	9	–	–	32,0	58,0	2,4	2800	1,4	-3N
335.10-125-03.32-9	75012756	Arbor hole	125,0	3,1	3,1	34,5	9	–	–	32,0	–	2,4	2800	0,3	-3N
R335.10-160-03.40-12	75027311	Arbor	160,0	3,1	3,1	39,5	12	–	–	40,0	80,0	2,4	2400	2,4	-3N
335.10-160-03.40-12	75012758	Arbor hole	160,0	3,1	3,1	39,5	12	–	–	40,0	–	2,4	2400	0,3	-3N
335.10-200-03.40-14	75027697	Arbor hole	200,0	3,1	3,1	59,5	14	–	–	40,0	–	2,4	2200	0,5	-3N
335.10-250-03.40-18	75028688	Arbor hole	250,0	3,1	3,1	84,5	18	–	–	40,0	–	2,4	2000	1,0	-3N
335.10-315-03.40-24	75005264	Arbor hole	315,0	3,1	3,1	117,0	24	–	–	40,0	–	2,4	1700	1,3	-3N

For Arbor hole type cutters 335.10-..., no drive holes for cutter dia 80-100 mm. For cutter dia > 100 mm, please use Seco drive rings,see page 343
Note: For R335.10-... cutter types, the blade is assembled on the holder in the delivery

Width 4,1 mm – full side – HSS body

Cutter 335.10 - Insert 150.10 – Metric



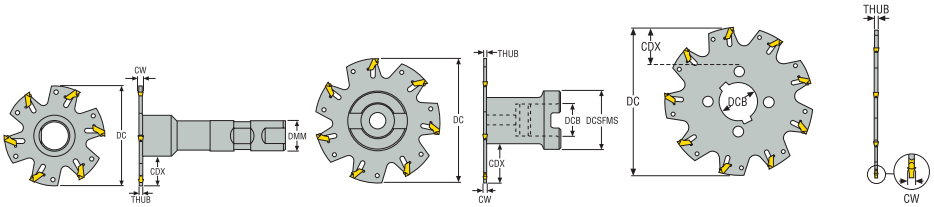
- For insert selection and cutting data recommendations, see page(s) 347-348
- For complete insert programme, see page(s) 786
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	THUB	RPMX	Weight	Insert 150.10
			mm	mm	mm	mm			mm		mm	mm	mm		kg	
R335.10-25063.3-04-5	75027294	Weldon	63,0	4,1	4,1	15,0	5	5	25,0	–	–	–	3,4	4000	0,5	-4N
R335.10-063-04.22-5	75027299	Arbor	63,0	4,1	4,1	15,0	5	5	–	–	22,0	32,0	3,4	4000	0,4	-4N
R335.10-1663.RE-04-5	02731380	Combimaster	63,0	4,1	4,1	16,0	5	5	–	M16	–	30,0	3,4	4000	0,3	-4N
R335.10-32080.3-04-6	75027297	Weldon	80,0	4,1	4,1	19,5	6	6	32,0	–	–	–	3,4	3500	1,1	-4N
R335.10-080-04.22-6	75027302	Arbor	80,0	4,1	4,1	19,5	6	6	–	–	22,0	40,0	3,4	3500	0,5	-4N
335.10-080-04.22-6	75012753	Arbor hole	80,0	4,1	4,1	22,5	6	6	–	–	22,0	–	3,4	3500	0,1	-4N
R335.10-1680.RE-04-6	02731382	Combimaster	80,0	4,1	4,1	19,5	6	6	–	M16	–	30,0	3,4	3500	0,5	-4N
R335.10-100-04.27-7	75027304	Arbor	100,0	4,1	4,1	25,5	7	7	–	–	27,0	48,0	3,4	3200	0,7	-4N
335.10-100-04.27-7	75012755	Arbor hole	100,0	4,1	4,1	29,0	7	7	–	–	27,0	–	3,4	3200	0,2	-4N
R335.10-125-04.32-9	75027309	Arbor	125,0	4,1	4,1	33,0	9	9	–	–	32,0	58,0	3,4	2800	1,3	-4N
335.10-125-04.32-9	75012757	Arbor hole	125,0	4,1	4,1	34,5	9	9	–	–	32,0	–	3,4	2800	0,4	-4N
R335.10-160-04.40-12	75027312	Arbor	160,0	4,1	4,1	39,5	12	12	–	–	40,0	80,0	3,4	2400	2,5	-4N
335.10-160-04.40-12	75012759	Arbor hole	160,0	4,1	4,1	39,5	12	12	–	–	40,0	–	3,4	2400	0,5	-4N
335.10-200-04.40-14	75027826	Arbor hole	200,0	4,1	4,1	59,5	14	14	–	–	40,0	–	3,4	2200	0,9	-4N
335.10-250-04.40-18	75028689	Arbor hole	250,0	4,1	4,1	84,5	18	18	–	–	40,0	–	3,4	2000	1,2	-4N
335.10-315-04.40-24	75034461	Arbor hole	315,0	4,1	4,1	117,0	24	24	–	–	40,0	–	3,4	1700	1,9	-4N

For Arbor hole type cutters 335.10-..., no drive holes for cutter dia 80-100 mm. For cutter dia > 100 mm, please use Seco drive rings,see page 343
Note: For R335.10-... cutter types, the blade is assembled on the holder in the delivery

Cutter 335.10 - Insert 150.10 – Inch

Width 0.089/0.098/0.122 Inch – full side – HSS body



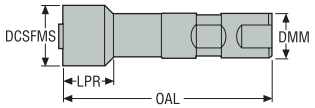
- For insert selection and cutting data recommendations, see page(s) 347-348
- For complete insert programme, see page(s) 786
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	DMM	TDZ	DCB	DCSFMS	THUB	RPMX	Weight	Insert 150.10
			Inch	Inch	Inch	Inch		Inch		Inch	Inch	Inch		lbs	
R335.10-02.50-3-2	75054664	Weldon	2.500	0.089	0.098	0.602	5	1.000	–	–	–	0.075	4000	0.440	2.25N/2.5N
R335.10-02.50-2B	75054670	Arbor	2.500	0.089	0.098	0.600	5	–	–	0.750	1.575	0.075	4000	1.100	2.25N/2.5N
R335.10-03.00-3-2	75054665	Weldon	3.000	0.089	0.098	0.728	6	1.250	–	–	–	0.075	3500	2.430	2.25N/2.5N
R335.10-03.00-2B	75054671	Arbor	3.000	0.089	0.098	0.693	6	–	–	0.750	1.575	0.075	3500	1.760	2.25N/2.5N
335.10-03.00-2	75054743	Arbor hole	3.000	0.089	0.098	0.669	6	–	–	1.000	–	0.075	3500	0.440	2.25N/2.5N
R335.10-04.00-2B	75054680	Arbor	4.000	0.089	0.098	1.035	7	–	–	1.000	1.890	0.075	3200	1.540	2.25N/2.5N
335.10-04.00-2	75054744	Arbor hole	4.000	0.089	0.098	1.161	7	–	–	1.000	–	0.075	3200	0.660	2.25N/2.5N
R335.10-05.00-2B	75054681	Arbor	5.000	0.089	0.098	1.339	9	–	–	1.250	2.283	0.075	2800	3.750	2.25N/2.5N
335.10-05.00-2	75054745	Arbor hole	5.000	0.089	0.098	1.398	9	–	–	1.250	–	0.075	2800	0.880	2.25N/2.5N
R335.10-06.00-2B	75054682	Arbor	6.000	0.089	0.098	1.406	12	–	–	1.500	3.150	0.075	2400	6.170	2.25N/2.5N
335.10-06.00-2	75054746	Arbor hole	6.000	0.089	0.098	1.555	12	–	–	1.250	–	0.075	2400	0.880	2.25N/2.5N
R335.10-02.50-3-3	75054666	Weldon	2.500	0.122	0.122	0.602	5	1.000	–	–	–	0.094	4000	1.540	3N
R335.10-02.50-3B	75054672	Arbor	2.500	0.122	0.122	0.600	5	–	–	0.750	1.575	0.094	4000	1.760	3N
R335.10-03.00-3-3	75054667	Weldon	3.000	0.122	0.122	0.728	6	1.250	–	–	–	0.094	3500	2.650	3N
R335.10-03.00-3B	75054673	Arbor	3.000	0.122	0.122	0.693	6	–	–	0.750	1.575	0.094	3500	1.980	3N
335.10-03.00-3	75070139	Arbor hole	3.000	0.122	0.122	0.669	6	–	–	1.000	–	0.094	3500	0.220	3N
R335.10-04.00-3B	75054683	Arbor	4.000	0.122	0.122	1.035	7	–	–	1.000	1.890	0.094	3200	2.650	3N
335.10-04.00-3	75014456	Arbor hole	4.000	0.122	0.122	1.161	7	–	–	1.000	–	0.094	3200	0.440	3N
R335.10-05.00-3B	75054684	Arbor	5.000	0.122	0.122	1.339	9	–	–	1.250	2.283	0.094	2800	3.970	3N
335.10-05.00-3	75014458	Arbor hole	5.000	0.122	0.122	1.398	9	–	–	1.250	–	0.094	2800	0.660	3N
R335.10-06.00-3B	75054685	Arbor	6.000	0.122	0.122	1.406	12	–	–	1.500	3.150	0.094	2400	5.510	3N
335.10-06.00-3	75014460	Arbor hole	6.000	0.122	0.122	1.555	12	–	–	1.250	–	0.094	2400	0.880	3N

For Arbor hole type cutters 335.10..., no drive holes for cutter dia 3-4". For cutter dia > 4", please use Seco drive rings, see page 345
Note: For R335.10-... cutter types, the blade is assembled on the holder in the delivery

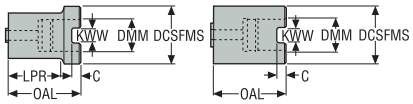
Spare parts – Metric

Holder for Weldon type



Designation	DMM	DCSFMS	OAL	LPR
335.10-25.3	25	32	106	25
335.10-32.3	32	40	150	30

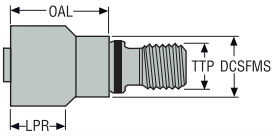
Holder for Arbor type



Designation	DMM	DCSFMS	OAL	LPR	KWW	C
335.10-2232	22	40	50	36	10,4	6,3
335.10-2240	22	40	50	–	10,4	6,3
335.10-2748	27	48	50	–	12,4	7
335.10-3258	32	58	63	–	14,4	8
335.10-4080	40	80	63	–	16,4	9

Note: assembly screws delivered with Weldon, Arbor and Combimaster holders

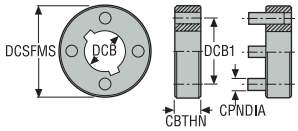
Combimaster type



Designation	LPR	TDZ	DCSFMS	OAL
335.10-16RE-10	28	M16	30	30
335.10-16RE-18	28	M16	30	40

Note: assembly screws delivered with Weldon, Arbor and Combimaster holders

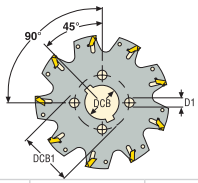
Drive rings for Arbor hole type



Designation	DCB	DCSFMS	CBTHN	DCB1	CPNDIA
335.10-14532	32	55	10	45	5,7
335.10-16340	40	80	12	63	10,7

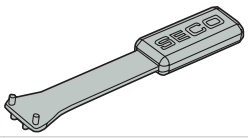
Drive ring to be ordered separately

Arbor hole type



Designation	DCB	DCB1	D1		
335.10-080	22	–	–		
335.10-100	27	–	–		
335.10-125	32	45	6		
335.10-160-315	40	63	11		

Spare parts (key included in delivery)



For cutter	Insert removal key
R335.10-..	150.10-150

Assembly components/Standard parts – metric

Weldon type cutters

Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque Nm
R335.10-25063.3-02-5	B-R335.10-063.10-02	335.10-25.3	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-32080.3-02-6	B-R335.10-080.18-02	335.10-32.3	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-25063.3-03-5	B-R335.10-063.10-03	335.10-25.3	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-32080.3-03-6	B-R335.10-080.18-03	335.10-32.3	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-25063.3-04-5	B-R335.10-063.10-04	335.10-25.3	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-32080.3-04-6	B-R335.10-080.18-04	335.10-32.3	3 x 335.10-0516-T15P	H6B-T15P	5 Nm

Arbor type cutters

Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque Nm	Arbor screw
R335.10-063-02.22-5	B-R335.10-063.10-02	335.10-2232	3 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-696
R335.10-080-02.22-6	B-R335.10-080.18-02	335.10-2240	3 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-696
R335.10-063-03.22-5	B-R335.10-063.10-03	335.10-2232	3 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-696
R335.10-080-03.22-6	B-R335.10-080.18-03	335.10-2240	3 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-696
R335.10-063-04.22-5	B-R335.10-063.10-04	335.10-2232	3 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-696
R335.10-080-04.22-6	B-R335.10-080.18-04	335.10-2240	3 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-696

Arbor type cutters

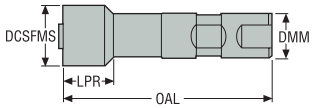
Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque Nm	Arbor screw
R335.10-100-02.27-7	B-R335.10-100.27-02	335.10-2748	4 x 335.10-0516-T15P	H6B-T15P	5 Nm	MC6S 12x40
R335.10-100-03.27-7	B-R335.10-100.27-03	335.10-2748	4 x 335.10-0516-T15P	H6B-T15P	5 Nm	MC6S 12x40
R335.10-100-04.27-7	B-R335.10-100.27-04	335.10-2748	4 x 335.10-0516-T15P	H6B-T15P	5 Nm	MC6S 12x40
R335.10-125-02.32-9	B-R335.10-125.32-02	335.10-3258	4 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-694
R335.10-125-03.32-9	B-R335.10-125.32-03	335.10-3258	4 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-694
R335.10-125-04.32-9	B-R335.10-125.32-04	335.10-3258	4 x 335.10-0516-T15P	H6B-T15P	5 Nm	220.17-694
R335.10-160-02.40-12	B-R335.10-160.40-02	335.10-4080	4 x 335.10-1030-T30P	H6B-T30PL	5 Nm	MC6S 20x40
R335.10-160-03.40-12	B-R335.10-160.40-03	335.10-4080	4 x 335.10-1030-T30P	H6B-T30PL	5 Nm	MC6S 20x40
R335.10-160-04.40-12	B-R335.10-160.40-04	335.10-4080	4 x 335.10-1030-T30P	H6B-T30PL	5 Nm	MC6S 20x40

Combimaster

Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque Nm
R335.10-1663.RE-02-5	B-R335.10-063.10-02	335.10-16RE-10	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-1680.RE-02-6	B-R335.10-080.18-02	335.10-16RE-18	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-1663.RE-03-5	B-R335.10-063.10-03	335.10-16RE-10	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-1680.RE-03-6	B-R335.10-080.18-03	335.10-16RE-18	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-1663.RE-04-5	B-R335.10-063.10-04	335.10-16RE-10	3 x 335.10-0516-T15P	H6B-T15P	5 Nm
R335.10-1680.RE-04-6	B-R335.10-080.18-04	335.10-16RE-18	3 x 335.10-0516-T15P	H6B-T15P	5 Nm

Spare parts – Inch

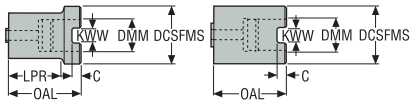
Holder for Weldon type



Designation	DMM	DCSFMS	OAL	LPR
335.10-01.00-3-A	1.00	1.25	4.17	1.00
335.10-01.25-3-A	1.25	1.50	5.90	1.18

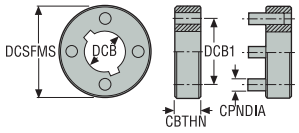
Note: assembly screws delivered with Weldon and arbor holders

Holder for Arbor type



Designation	DMM	DCSFMS	OAL	LPR	KWW	C
335.10-00.75-1.25B-A	0.75	1.26	1.969	1.50	0.32	0.20
335.10-00.75-1.50B-A	0.75	1.58	1.969	–	0.32	0.20
335.10-01.00-1.89B-A	1.00	1.89	1.969	–	0.38	0.23
335.10-01.25-2.28B-A	1.25	2.28	2.480	–	0.51	0.28
335.10-01.50-3.15B-A	1.50	3.15	2.480	–	0.63	0.38

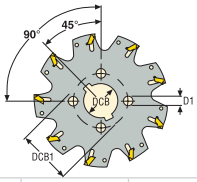
Drive rings for Arbor hole type



Designation	DCB	DCSFMS	CBTHN	DCB1	CPNDIA
335.10-14531	2.16	1.25	1.77	0.22	0.39
335.10-15531	2.83	1.25	2.16	0.42	0.47
335.10-17451	3.50	2.00	2.91	0.42	0.47

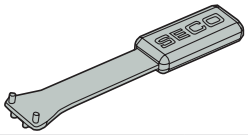
Drive ring to be ordered separately

Arbor hole type



Designation	DCB	DCB1	D1		
335.10-03.00-04.00	1.00	–	–		
335.10-05.00	1.25	1.77	0.24		
335.10-06.00	1.25	2.16	0.43		
335.10-08.00-12.00	2.00	2.91	0.43		

Spare parts (key included in delivery)



For cutter	Insert removal key		
R335.10-..	150.10-150		

Assembly components/Standard parts – inch

Weldon type cutters

Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque in/lbs
R335.10-02.50-3-2	R335.10-02.50-2	335.10-01.00-3-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs
R335.10-02.50-3-3	R335.10-02.50-3	335.10-01.00-3-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs
R335.10-03.00-3-2	R335.10-03.00-2	335.10-01.25-3-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs
R335.10-03.00-3-3	R335.10-03.00-3	335.10-01.25-3-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs

Arbor type cutters

Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque in/lbs	Arbor screw
R335.10-02.50-2B	R335.10-02.50-2	335.10-00.75-1.25B-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs	220.17-695
R335.10-02.50-3B	R335.10-02.50-3	335.10-00.75-1.25B-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs	220.17-695
R335.10-03.00-2B	R335.10-03.00-2	335.10-00.75-1.50B-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs	220.17-695
R335.10-03.00-3B	R335.10-03.00-3	335.10-00.75-1.50B-A	335.10-0516-T15P(3X)	T15P-3	57.5 in.lbs	220.17-695

Arbor type cutters

Part No.	Cutter body Part No.	Holder Part No.	Assembly screw	Insert key	Torque in/lbs	Arbor screw
R335.10-04.00-2B	R335.10-04.00-2	335.10-01.00-1.89B-A	335.10-0516-T15P(4X)	T15P-3	57.5 in.lbs	UC6S1/2UNFX1-1/2
R335.10-04.00-3B	R335.10-04.00-3	335.10-01.00-1.89B-A	335.10-0516-T15P(4X)	T15P-3	57.5 in.lbs	UC6S1/2UNFX1-1/2
R335.10-05.00-2B	R335.10-05.00-2	335.10-01.25-2.28B-A	335.10-0516-T15P(4X)	T15P-3	57.5 in.lbs	UC6S5/8UNFX11/2
R335.10-05.00-3B	R335.10-05.00-3	335.10-01.25-2.28B-A	335.10-0516-T15P(4X)	T15P-3	57.5 in.lbs	UC6S5/8UNFX11/2
R335.10-06.00-2B	R335.10-06.00-2	335.10-01.50-3-15B-A	335.10-1030-T30P(4X)	T30P-4	70.8 in.lbs	UC6S3/4UNFX1-1/4
R335.10-06.00-3B	R335.10-06.00-3	335.10-01.50-3-15B-A	335.10-1030-T30P(4X)	T30P-4	70.8 in.lbs	UC6S3/4UNFX1-1/4

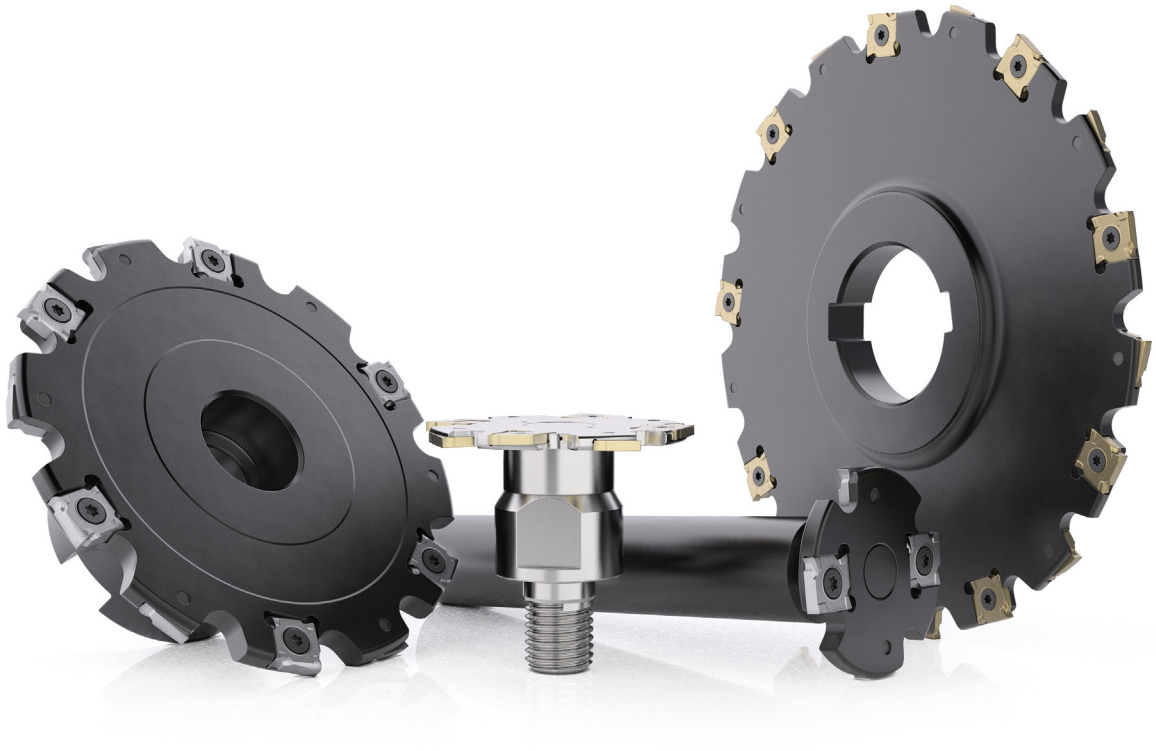
335.10– Insert selection – mm/*Inch*

SMG					f_z			
					30%	20%	10%	5%
P1	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,10 *0.0040*	0,11 *0.0044*	0,15 0.0060	0,20 0.0080
P2	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,10 *0.0040*	0,11 *0.0044*	0,15 0.0060	0,22 0.0085
P3	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,095 *0.0038*	0,11 *0.0044*	0,14 0.0055	0,20 0.0080
P4	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,090 *0.0036*	0,11 *0.0044*	0,14 0.0055	0,19 0.0075
P5	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
P6	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
P7	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
P8	150.10-2.25N-14 CP500	150.10-2.5N-14 CP500	*150.10-3N-14 CP500*	*150.10-4N-14 CP500*	0,095 *0.0038*	0,11 *0.0044*	0,14 0.0055	0,20 0.0080
P11	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
P12	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,060 *0.0024*	0,070 *0.0028*	0,095 0.0038	0,13 0.0050
M1	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,10 *0.0040*	0,11 *0.0044*	0,15 0.0060	0,22 0.0085
M2	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
M3	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,070 *0.0028*	0,085 *0.0034*	0,11 0.0044	0,15 0.0060
M4	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,065 *0.0026*	0,075 *0.0030*	0,095 0.0038	0,13 0.0050
M5	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,065 *0.0026*	0,075 *0.0030*	0,095 0.0038	0,13 0.0050
K1	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,10 *0.0040*	0,11 *0.0044*	0,15 0.0060	0,22 0.0085
K2	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
K3	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
K4	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
K5	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,080 *0.0032*	0,095 *0.0038*	0,12 0.0048	0,17 0.0065
K6	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,090 *0.0036*	0,10 *0.0040*	0,14 0.0055	0,19 0.0075
K7	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,080 *0.0032*	0,095 *0.0038*	0,12 0.0048	0,17 0.0065
N1	150.10-2.25N-14 CP500	150.10-2.5N-12 CP500	*150.10-3N-12 CP500*	*150.10-4N-12 CP500*	0,12 *0.0048*	0,14 *0.0055*	0,19 0.0075	0,26 0.010
N2	150.10-2.25N-14 CP500	150.10-2.5N-12 CP500	*150.10-3N-12 CP500*	*150.10-4N-12 CP500*	0,12 *0.0048*	0,14 *0.0055*	0,19 0.0075	0,26 0.010
N3	150.10-2.25N-14 CP500	150.10-2.5N-12 CP500	*150.10-3N-12 CP500*	*150.10-4N-12 CP500*	0,12 *0.0048*	0,14 *0.0055*	0,19 0.0075	0,26 0.010
N11	150.10-2.25N-14 CP500	150.10-2.5N-12 CP500	*150.10-3N-12 CP500*	*150.10-4N-12 CP500*	0,12 *0.0048*	0,14 *0.0055*	0,19 0.0075	0,26 0.010
S1	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,065 *0.0026*	0,075 *0.0030*	0,095 0.0038	0,13 0.0050
S2	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,065 *0.0026*	0,075 *0.0030*	0,095 0.0038	0,13 0.0050
S3	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,060 *0.0024*	0,065 *0.0026*	0,090 0.0036	0,12 0.0048
S11	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,070 *0.0028*	0,085 *0.0034*	0,11 0.0044	0,15 0.0060
S12	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,070 *0.0028*	0,085 *0.0034*	0,11 0.0044	0,15 0.0060
S13	150.10-2.25N-14 CP600	150.10-2.5N-14 CP600	*150.10-3N-14 CP600*	*150.10-4N-14 CP600*	0,065 *0.0026*	0,075 *0.0030*	0,095 0.0038	0,13 0.0050
H5	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,060 *0.0024*	0,070 *0.0028*	0,095 0.0038	0,13 0.0050
H8	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-3N-14 TGP45*	0,048 *0.0019*	0,055 *0.0022*	0,070 0.0028	0,10 0.0040
H11	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,060 *0.0024*	0,070 *0.0028*	0,095 0.0038	0,13 0.0050
H12	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,048 *0.0019*	0,055 *0.0022*	0,070 0.0028	0,10 0.0040
H21	150.10-2.25N-14 TGP45	150.10-2.5N-14 TGP45	*150.10-3N-14 TGP45*	*150.10-4N-14 TGP45*	0,048 *0.0019*	0,055 *0.0022*	0,070 0.0028	0,10 0.0040

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	TGP45				T350M				CP500				CP600				HX			
	30%	20%	10%	5%	30%	20%	10%	5%	30%	20%	10%	5%	30%	20%	10%	5%	30%	20%	10%	5%
P1	250	270	295	325	215	235	260	280	195	210	230	250	185	200	220	240	—	—	—	—
	820	*890*	*970*	*1075*	*710*	*770*	*850*	*920*	*640*	*690*	*750*	*820*	*610*	*660*	*720*	*790*	—	—	—	—
P2	240	260	290	310	210	225	250	270	190	205	225	245	180	195	215	235	—	—	—	—
	790	*850*	*950*	*1025*	*690*	*740*	*820*	*890*	*620*	*670*	*740*	*800*	*590*	*640*	*710*	*770*	—	—	—	—
P3	215	225	250	270	185	195	220	235	165	180	200	215	155	170	190	205	—	—	—	—
	710	*740*	*820*	*890*	*610*	*640*	*720*	*770*	*540*	*590*	*660*	*710*	*510*	*560*	*620*	*670*	—	—	—	—
P4	185	200	220	240	165	175	195	210	150	160	175	190	140	150	165	180	—	—	—	—
	610	*660*	*720*	*790*	*540*	*570*	*640*	*690*	*490*	*520*	*570*	*620*	*460*	*490*	*540*	*590*	—	—	—	—
P5	180	195	215	235	155	170	185	205	140	150	165	180	135	145	160	170	—	—	—	—
	590	*640*	*710*	*770*	*510*	*560*	*610*	*670*	*460*	*490*	*540*	*590*	*445*	*475*	*520*	*560*	—	—	—	—
P6	200	215	240	260	175	190	210	230	160	170	190	205	150	160	180	195	—	—	—	—
	660	*710*	*790*	*850*	*570*	*620*	*690*	*750*	*520*	*560*	*620*	*670*	*490*	*520*	*590*	*640*	—	—	—	—
P7	190	205	225	245	165	180	200	215	150	160	175	190	145	150	170	180	—	—	—	—
	620	*670*	*740*	*800*	*540*	*590*	*660*	*710*	*490*	*520*	*570*	*620*	*475*	*490*	*560*	*590*	—	—	—	—
P8	180	190	210	230	155	165	185	200	140	150	165	180	130	145	160	170	—	—	—	—
	590	*620*	*690*	*750*	*510*	*540*	*610*	*660*	*460*	*490*	*540*	*590*	*425*	*475*	*520*	*560*	—	—	—	—
P11	185	200	220	240	160	175	190	210	145	155	170	185	140	150	165	175	—	—	—	—
	610	*660*	*720*	*790*	*520*	*570*	*620*	*690*	*475*	*510*	*560*	*610*	*460*	*490*	*540*	*570*	—	—	—	—
P12	120	125	140	155	105	110	125	135	95	100	110	120	90	95	105	115	—	—	—	—
	395	*410*	*460*	*510*	*345*	*360*	*410*	*445*	*310*	*330*	*360*	*395*	*295*	*310*	*345*	*375*	—	—	—	—
M1	175	185	205	225	165	175	195	210	155	165	180	200	145	155	175	190	105	110	120	130
	570	*610*	*670*	*740*	*540*	*570*	*640*	*690*	*510*	*540*	*590*	*660*	*475*	*510*	*570*	*620*	*345*	*360*	*395*	*425*
M2	145	155	170	185	135	145	160	175	125	135	150	165	120	130	145	155	85	90	100	105
	475	*510*	*560*	*610*	*445*	*475*	*520*	*570*	*410*	*445*	*490*	*540*	*395*	*425*	*475*	*510*	*280*	*295*	*330*	*345*
M3	115	125	140	150	110	115	130	140	105	110	120	130	100	105	115	125	70	75	80	85
	375	*410*	*460*	*490*	*360*	*375*	*425*	*460*	*345*	*360*	*395*	*425*	*330*	*345*	*375*	*410*	*230*	*245*	*260*	*280*
M4	90	95	105	115	85	90	100	105	80	85	95	100	75	80	90	95	55	55	60	65
	295	*310*	*345*	*375*	*280*	*295*	*330*	*345*	*260*	*280*	*310*	*330*	*245*	*260*	*295*	*310*	*180*	*180*	*195*	*215*
M5	75	80	90	95	70	75	85	90	65	70	80	85	65	70	75	80	45	47	50	55
	245	*260*	*295*	*310*	*230*	*245*	*280*	*295*	*215*	*230*	*260*	*280*	*215*	*230*	*245*	*260*	*150*	*155*	*165*	*180*
K1	190	205	230	245	165	180	200	215	150	165	180	195	145	155	170	185	95	100	110	120
	620	*670*	*750*	*800*	*540*	*590*	*660*	*710*	*490*	*540*	*590*	*640*	*475*	*510*	*560*	*610*	*310*	*330*	*360*	*395*
K2	170	185	205	220	150	160	175	190	135	145	160	170	130	135	150	165	85	90	100	105
	560	*610*	*670*	*720*	*490*	*520*	*570*	*620*	*445*	*475*	*520*	*560*	*425*	*445*	*490*	*540*	*280*	*295*	*330*	*345*
K3	145	155	170	185	125	135	150	165	115	120	135	145	110	115	130	140	75	80	85	90
	475	*510*	*560*	*610*	*410*	*445*	*490*	*540*	*375*	*395*	*445*	*475*	*360*	*375*	*425*	*460*	*245*	*260*	*280*	*295*
K4	135	150	165	180	120	130	145	155	110	115	130	140	105	110	120	130	70	75	80	85
	445	*490*	*540*	*590*	*395*	*425*	*475*	*510*	*360*	*375*	*425*	*460*	*345*	*360*	*395*	*425*	*230*	*245*	*260*	*280*
K5	85	90	100	110	75	80	85	95	65	70	80	85	65	70	75	80	43	45	49	55
	280	*295*	*330*	*360*	*245*	*260*	*280*	*310*	*215*	*230*	*260*	*280*	*215*	*230*	*245*	*260*	*140*	*150*	*160*	*180*
K6	120	130	145	155	105	115	125	135	95	100	115	120	90	95	105	115	60	65	70	75
	395	*425*	*475*	*510*	*345*	*375*	*410*	*445*	*310*	*330*	*375*	*395*	*295*	*310*	*345*	*375*	*195*	*215*	*230*	*245*
K7	110	115	125	140	95	100	110	120	85	90	100	110	80	85	95	105	55	60	60	65
	360	*375*	*410*	*460*	*310*	*330*	*360*	*395*	*280*	*295*	*330*	*360*	*260*	*280*	*310*	*345*	*180*	*195*	*195*	*215*
N1	—	—	—	—	—	—	—	—	900	970	1050	1150	850	920	1000	1100	580	610	670	710
	—	—	—	—	—	—	—	—	*2950*	*3175*	*3450*	*3775*	*2800*	*3025*	*3275*	*3600*	*1900*	*2000*	*2200*	*2325*
N2	—	—	—	—	—	—	—	—	450	490	530	580	430	465	510	550	230	245	270	285
	—	—	—	—	—	—	—	—	*1475*	*1600*	*1750*	*1900*	*1400*	*1525*	*1675*	*1800*	*750*	*800*	*890*	*940*
N3	—	—	—	—	—	—	—	—	300	325	355	390	285	310	340	370	155	165	180	190
	—	—	—	—	—	—	—	—	*980*	*1075*	*1175*	*1275*	*940*	*1025*	*1125*	*1225*	*510*	*540*	*590*	*620*
N11	—	—	—	—	—	—	—	—	345	370	405	445	330	355	390	425	175	190	205	215
	—	—	—	—	—	—	—	—	*1125*	*1225*	*1325*	*1450*	*1075*	*1175*	*1275*	*1400*	*570*	*620*	*670*	*710*
S1	—	—	—	—	39	42	47	50	37	40	44	48	35	38	42	45	20	22	24	25
	—	—	—	—	*130*	*140*	*155*	*165*	*120*	*130*	*145*	*155*	*115*	*125*	*140*	*150*	*65*	*70*	*80*	*80*
S2	—	—	—	—	32	34	38	40	30	32	35	38	28	31	34	37	16	17	19	20
	—	—	—	—	*105*	*110*	*125*	*130*	*100*	*105*	*115*	*125*	*90*	*100*	*110*	*120*	*50*	*55*	*60*	*65*
S3	—	—	—	—	28	29	32	35	26	28	31	33	25	27	29	32	14	15	16	17
	—	—	—	—	*90*	*95*	*105*	*115*	*85*	*90*	*100*	*110*	*80*	*90*	*95*	*105*	*46*	*49*	*50*	*55*
S11	—	—	—	—	55	60	65	70	50	55	60	65	45	48	55	60	—	—	—	—
	—	—	—	—	*180*	*195*	*215*	*230*	*165*	*180*	*195*	*215*	*150*	*155*	*180*	*195*	—	—	—	—
S12	—	—	—	—	46	49	55	60	37	39	43	47	42	44	49	55	—	—	—	—
	—	—	—	—	*150*	*160*	*180*	*195*	*120*	*130*	*140*	*155*	*140*	*145*	*160*	*180*	—	—	—	—
S13	—	—	—	—	27	29	32	34	21	23	25	27	24	26	28	31	—	—	—	—
	—	—	—	—	*90*	*95*	*105*	*110*	*70*	*75*	*80*	*90*	*80*	*85*	*90*	*100*	—	—	—	—
H5	36	38	43	46	34	37	41	44	31	34	37	40	30	32	35	38	32	33	36	39
	120	*125*	*140*	*150*	*110*	*120*	*135*	*145*	*100*	*110*	*120*	*130*	*100*	*105*	*115*	*125*	*105*	*110*	*120*	*130*
H8	38	41	45	48	37	39	43	46	33	36	39	43	31	34	38	41	—	—	—	—
	125	*135*	*150*	*155*	*120*	*130*	*140*	*150*	*110*	*120*	*130*	*140*	*100*	*110*	*125*	*135*	—	—	—	—
H11	46	49	55	60	44	47	50	55	40	43	47	50	38	41	45	48	—	—	—	—
	150	*160*	*180*	*195*	*145*	*155*	*165*	*180*	*130*	*140*	*155*	*165*	*125*	*135*	*150*	*155*	—	—	—	—
H12	44	47	50	55	65	70	75	85	38	42	46	50	37	40	44	47	—	—	—	—
	145	*155*	*165*	*180*	*215*	*230*	*245*	*280*	*125*	*140*	*150*	*165*	*120*	*130*	*145*	*155*	—	—	—	—
H21	38	41	45	48	37	39	43	46	33	36	39	43	31	34	38	41	—	—	—	—
	125	*135*	*150*	*155*	*120*	*130*	*140*	*150*	*110*	*120*	*130*	*140*	*100*	*110*	*125*	*135*	—	—	—	—



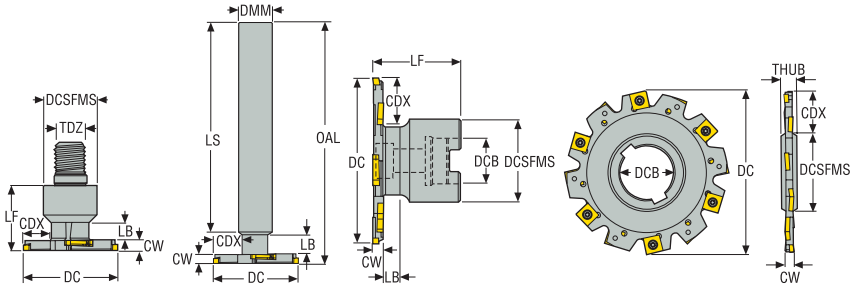
335.19

Economical, precise and free-cutting disc milling cutter system dedicated for small width of cut slotting and cutting off operations

- Width of cut 4-12 mm (.157 - .500 inch) - Flat bottom slot with SNHQ inserts.
- Cutter range diameter 40-250 mm (1.5 - 8 inch)
- Available with Cylindrical, Arbor, Arbor hole and Combimaster connection, with through coolant and close pitch option
- High insert precision with built-in wiper lat and corner radii range 0.2-6 mm (.008 - 0.236 inch)
- Economical solution with up to 4 cutting edges per inserts
- Basic tolerance of the slot -0.02 /+0.08mm - -0.001 / +0.003”

Cutter 335.19 - Insert SNHQ – Metric

Width 4 mm - full side

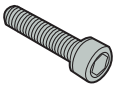


- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	SNHQ..R	SNHQ..L
			mm	mm	mm			mm		mm	mm	mm	mm	mm	mm	mm		kg		
R335.19-1040.RE-04.2NA	03277857	Combimaster	40,0	4,0	11,6	2	4	–	M10	–	18,5	–	–	23,0	–	8,26	21500	0,1	1102	1102
R335.19-2550.0-04.2	02565023	Cylindrical	50,0	4,0	13,9	2	4	25,0	–	–	–	150,0	–	–	132,2	11,0	19100	0,6	1102	1102
R335.19-1250.RE-04.3NA	03277859	Combimaster	50,0	4,0	14,9	3	6	–	M12	–	23,0	–	–	28,0	–	10,26	19100	0,2	1102	1102
R335.19-1663.RE-04.4NA	03277862	Combimaster	63,0	4,0	17,7	4	8	–	M16	–	30,0	–	–	35,0	–	11,26	17100	0,3	1102	1102
R335.19-3263.0-04.4	02565024	Cylindrical	63,0	4,0	13,9	4	8	32,0	–	–	–	170,0	–	–	148,6	0,0	17100	1,2	1102	1102
R335.19-063.04.22-3	75011447	Arbor	63,0	4,0	13,9	3	6	–	–	22,0	40,0	–	–	50,0	–	11,3	17100	0,4	1102	1102
R335.19-063.04.16-4	02565016	Arbor	63,0	4,0	13,9	4	8	–	–	16,0	33,0	–	–	35,0	–	–	17100	0,3	1102	1102
335.19-063.04.22-4	02565012	Arbor hole	63,0	4,0	13,6	4	8	–	–	22,0	33,0	–	8,0	–	–	–	17100	0,1	1102	1102
R335.19-080.04.22-4	75066088	Arbor	80,0	4,0	22,4	4	8	–	–	22,0	40,0	–	–	50,0	–	11,3	15200	0,4	1102	1102
R335.19-1680.RE-04.5NA	03277866	Combimaster	80,0	4,0	26,2	5	10	–	M16	–	30,0	–	–	35,0	–	11,26	15200	0,3	1102	1102
R335.19-080.04.22-5	02565017	Arbor	80,0	4,0	22,4	5	10	–	–	22,0	40,0	–	–	50,0	–	11,3	15200	0,5	1102	1102
R335.19-100.04.27-6	75011449	Arbor	100,0	4,0	22,1	6	12	–	–	27,0	48,0	–	–	50,0	–	–	13500	0,7	1102	1102
335.19-100.04.27-6	75090131	Arbor hole	100,0	4,0	24,6	6	12	–	–	27,0	41,0	–	12,0	–	–	–	13500	0,3	1102	1102
R335.19-20100.RE-04.7NA	03277870	Combimaster	100,0	4,0	32,7	7	14	–	M20	–	36,5	–	–	35,0	–		13500	0,5	1102	1102
R335.19-125.04.32-7	02565018	Arbor	125,0	4,0	29,6	7	14	–	–	32,0	58,0	–	–	50,0	–	–	12200	1,1	1102	1102
335.19-125.04.40-7	75090190	Arbor hole	125,0	4,0	30,1	7	14	–	–	40,0	55,0	–	12,0	–	–	–	12200	0,4	1102	1102
R335.19-20125.RE-04.8NA	03277873	Combimaster	125,0	4,0	45,2	8	16	–	M20	–	36,5	–	–	35,0	–		12200	0,6	1102	1102
R335.19-160.04.40-9	02565020	Arbor	160,0	4,0	41,1	9	18	–	–	40,0	70,0	–	–	50,0	–	–	10700	1,2	1102	1102
335.19-160.04.40-9	75090137	Arbor hole	160,0	4,0	42,6	9	18	–	–	40,0	65,0	–	12,0	–	–	–	10700	0,6	1102	1102

Spare Parts

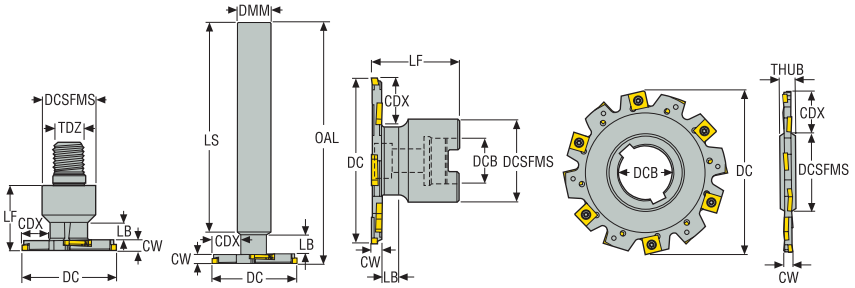
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
335/R335.19 RE	–	C93504-T09P	T00-09P20	2.0NM
R335.19 DCB=22	MC6S10X40	C93504-T09P	T00-09P20	2.0NM
R335.19 DCB=16	TCEI0825	C93504-T09P	T00-09P20	2.0NM
R335.19 DCB=40	–	C93504-T09P	T00-09P20	2.0NM
R335.19 DCB=27	MC6S12X35	C93504-T09P	T00-09P20	2.0NM
R335.19 DCB=32	220.17-694	C93504-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Width 5 mm - full side

Cutter 335.19 - Insert SNHQ

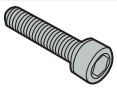


- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	SNHQ..R	SNHQ..L
			mm	mm	mm			mm		mm	mm	mm	mm	mm	mm	mm		kg		
R335.19-1040.RE-05.2NA	03277858	Combimaster	40,0	5,0	11,6	2	4	–	M10	–	18,5	–	–	23,0	–	7,275	18700	0,1	1103	1103
R335.19-1250.RE-05.3NA	03277860	Combimaster	50,0	5,0	14,9	3	6	–	M12	–	23,0	–	–	28,0	–	9,275	16800	0,2	1103	1103
R335.19-2550.0-05.2	02565034	Cylindrical	50,0	5,0	13,9	2	4	25,0	–	–	–	150,0	–	–	132,2	10,0	16800	0,6	1103	1103
R335.19-1663.RE-05.4NA	03277863	Combimaster	63,0	5,0	17,6	4	8	–	M16	–	30,0	–	–	35,0	–		14900	0,3	1103	1103
R335.19-063.05.22-3	75011452	Arbor	63,0	5,0	13,9	3	6	–	–	22,0	40,0	–	–	50,0	–	10,3	14900	0,4	1103	1103
R335.19-1680.RE-05.5NA	03277867	Combimaster	80,0	5,0	26,1	5	10	–	M16	–	30,0	–	–	35,0	–		13200	0,3	1103	1103
R335.19-3280.0-05.5	02565036	Cylindrical	80,0	5,0	22,5	5	10	32,0	–	–	–	170,0	–	–	148,6	–	13200	1,2	1103	1103
R335.19-080.05.22-5	02565029	Arbor	80,0	5,0	22,4	5	10	–	–	22,0	40,0	–	–	50,0	–	10,3	13200	0,5	1103	1103
R335.19-080.05.22-4	75066089	Arbor	80,0	5,0	22,4	4	8	–	–	22,0	40,0	–	–	50,0	–	10,3	13200	0,5	1103	1103
335.19-080.05.22-5	02565027	Arbor hole	80,0	5,0	19,6	5	10	–	–	22,0	33,0	–	12,0	–	–	–	13200	0,2	1103	1103
R335.19-20100.RE-05.7NA	03277871	Combimaster	100,0	5,0	32,6	7	14	–	M20	–	36,5	–	–	35,0	–		11800	0,5	1103	1103
R335.19-100.05.27-6	75011453	Arbor	100,0	5,0	22,1	6	12	–	–	27,0	48,0	–	–	50,0	–	–	11800	0,7	1103	1103
335.19-100.05.27-6	75090132	Arbor hole	100,0	5,0	25,6	6	12	–	–	27,0	41,0	–	12,0	–	–	–	11800	0,3	1103	1103
R335.19-20125.RE-05.8NA	03277874	Combimaster	125,0	5,0	45,1	8	16	–	M20	–	36,5	–	–	35,0	–		10700	0,6	1103	1103
335.19-125.05.40-7	75090191	Arbor hole	125,0	5,0	31,1	7	14	–	–	40,0	55,0	–	12,0	–	–	–	10700	0,4	1103	1103
R335.19-125.05.32-7	02565031	Arbor	125,0	5,0	29,6	7	14	–	–	32,0	58,0	–	–	50,0	–	–	10700	1,1	1103	1103
335.19-160.05.40-9	75090138	Arbor hole	160,0	5,0	43,6	9	18	–	–	40,0	65,0	–	12,0	–	–	–	9300	0,7	1103	1103
R335.19-160.05.40-9	02565032	Arbor	160,0	5,0	41,1	9	18	–	–	40,0	70,0	–	–	50,0	–	–	9300	1,3	1103	1103

Spare Parts

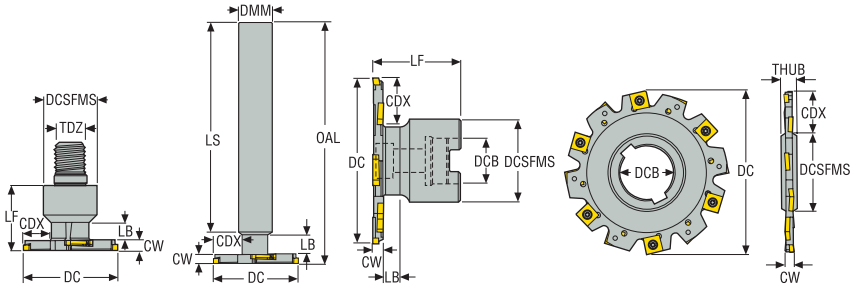
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
335/R335.19 RE/Cyl	–	C93505-T09P	T00-09P20	2.0NM
R335.19 DCB=22	MC6S10X40	C93505-T09P	T00-09P20	2.0NM
R335.19 DCB=27	MC6S12X35	C93505-T09P	T00-09P20	2.0NM
R335.19 DCB=40	–	C93505-T09P	T00-09P20	2.0NM
R335.19 DCB=32	220.17-694	C93505-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Cutter 335.19 - Insert SNHQ – Metric

Width 6 mm - full side

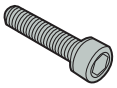


- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	SNHQ..R	SNHQ..L
			mm	mm	mm			mm		mm	mm	mm	mm	mm	mm	mm		kg		
R335.19-1250.RE-06.2NA	03277861	Combimaster	50,0	6,0	14,9	2	4	–	M12	–	23,0	–	–	28,0	–	8,285	12300	0,2	1203	1203
R335.19-2550.0-06.2	02565041	Cylindrical	50,0	6,0	13,9	2	4	25,0	–	–	–	150,0	–	–	132,2	9,0	12300	0,6	1203	1203
R335.19-1663.RE-06.3NA	03277864	Combimaster	63,0	6,0	17,6	3	6	–	M16	–	30,0	–	–	35,0	–	9,285	10900	0,3	1203	1203
R335.19-3263.0-06.3	02565042	Cylindrical	63,0	6,0	14,0	3	6	32,0	–	–	–	170,0	–	–	148,6	–	10900	1,2	1203	1203
R335.19-063.06.16-3	02565038	Arbor	63,0	6,0	13,9	3	6	–	–	16,0	33,0	–	–	35,0	–	–	10900	0,3	1203	1203
R335.19-063.06.22-3	75011448	Arbor	63,0	6,0	13,9	3	6	–	–	22,0	40,0	–	–	50,0	–	9,3	10900	0,5	1203	1203
335.19-063.06.22-3	02565037	Arbor hole	63,0	6,0	13,6	3	6	–	–	22,0	33,0	–	12,0	–	–	–	10900	0,1	1203	1203
R335.19-1680.RE-06.4NA	03277868	Combimaster	80,0	6,0	26,3	4	8	–	M16	–	30,0	–	–	35,0	–	9,285	9700	0,3	1203	1203
R335.19-3280.0-06.4	02565043	Cylindrical	80,0	6,0	22,5	4	8	32,0	–	–	–	170,0	–	–	148,6	0,0	9700	1,2	1203	1203
R335.19-080.06.22-4	75066090	Arbor	80,0	6,0	22,4	4	8	–	–	22,0	40,0	–	–	50,0	–	9,3	9700	0,5	1203	1203
R335.19-20100.RE-06.6NA	03277872	Combimaster	100,0	6,0	32,8	6	12	–	M20	–	36,5	–	–	35,0	–		8700	0,5	1203	1203
R335.19-100.06.27-5	75011450	Arbor	100,0	6,0	22,0	5	10	–	–	27,0	48,0	–	–	50,0	–	–	8700	0,8	1203	1203
335.19-100.06.27-5	75011284	Arbor hole	100,0	6,0	25,6	5	10	–	–	27,0	41,0	–	12,0	–	–	–	8700	0,3	1203	1203
R335.19-125.06.32-6	02565039	Arbor	125,0	6,0	29,0	6	12	–	–	32,0	58,0	–	–	50,0	–	–	7700	1,1	1203	1203
335.19-125.06.40-6	75011289	Arbor hole	125,0	6,0	31,1	6	12	–	–	40,0	55,0	–	12,0	–	–	–	7700	0,5	1203	1203
R335.19-160.06.40-8	75012913	Arbor	160,0	6,0	41,1	8	16	–	–	40,0	70,0	–	–	50,0	–	–	6800	1,4	1203	1203
335.19-160.06.40-8	75011294	Arbor hole	160,0	6,0	43,6	8	16	–	–	40,0	65,0	–	12,0	–	–	–	6800	0,8	1203	1203
335.19-200.06.50-9	75090141	Arbor hole	200,0	6,0	61,6	9	18	–	–	50,0	69,0	–	12,0	–	–	–	6300	1,4	1203	1203
335.19-250.06.50-12	75012301	Arbor hole	250,0	6,0	86,6	12	24	–	–	50,0	69,0	–	12,0	–	–	–	5600	1,9	1203	1203

Spare Parts

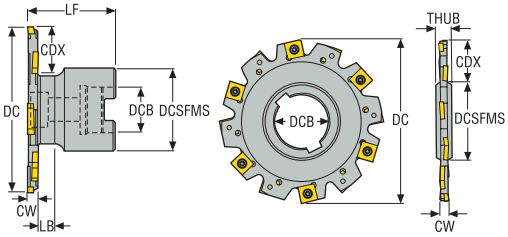
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
335/R335.19 RE/Cyl	–	C94005-T15P	T00-15P35	3.5NM
R335.19 DCB=16	TCEI0825	C94005-T15P	T00-15P35	3.5NM
R335.19 DCB=22	MC6S10X40	C94005-T15P	T00-15P35	3.5NM
R335.19 DCB=27	MC6S12X35	C94005-T15P	T00-15P35	3.5NM
R335.19 DCB=32	220.17-694	C94005-T15P	T00-15P35	3.5NM
R335.19 DCB=40	–	C94005-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Width 7/8/10 mm - full side

Cutter 335.19 - Insert SNHQ – Metric



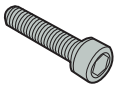
- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	TDZ	DCB	DCSFMS	THUB	LF	LS	LB	RPMX	Weight	SNHQ..R	SNHQ..L
			mm	mm	mm				mm	mm	mm	mm	mm	mm		kg		
R335.19-1663.RE-07.3NA	03277865	Combimaster	63,0	7,0	17,6	3	6	M16	–	30,0	–	35,0	–	8,285	9400	0,3	1204/12045*	1204/12045*
R335.19-063.07.16-3	02565044	Arbor	63,0	7,0	13,8	3	6	–	16,0	33,0	–	35,0	–	–	9400	0,3	1204/12045*	1204/12045*
R335.19-063.07.22-3	75012680	Arbor	63,0	7,0	13,8	3	6	–	22,0	40,0	–	50,0	–	8,3	9400	0,4	1204/12045*	1204/12045*
R335.19-1680.RE-07.4NA	03277869	Combimaster	80,0	7,0	26,3	4	8	M16	–	30,0	–	35,0	–	8,285	8400	0,4	1204/12045*	1204/12045*
R335.19-080.07.22-4	75066091	Arbor	80,0	7,0	22,0	4	8	–	22,0	40,0	–	50,0	–	8,3	8400	0,5	1204/12045*	1204/12045*
335.19-080.07.22-4	00088988	Arbor hole	80,0	7,0	20,6	4	8	–	22,0	33,0	12,0	–	–	–	8400	0,2	1204/12045*	1204/12045*
R335.19-100.07.27-5	75012681	Arbor	100,0	7,0	22,0	5	10	–	27,0	48,0	–	50,0	–	–	7500	0,9	1204/12045*	1204/12045*
335.19-100.07.27-5	75012670	Arbor hole	100,0	7,0	26,6	5	10	–	27,0	41,0	12,0	–	–	–	7500	0,3	1204/12045*	1204/12045*
R335.19-125.07.32-6	02565045	Arbor	125,0	7,0	29,5	6	12	–	32,0	58,0	–	50,0	–	–	6700	1,2	1204/12045*	1204/12045*
335.19-125.07.40-6	75012672	Arbor hole	125,0	7,0	32,1	6	12	–	40,0	55,0	12,0	–	–	–	6700	0,5	1204/12045*	1204/12045*
R335.19-160.07.40-8	75012685	Arbor	160,0	7,0	41,1	8	16	–	40,0	70,0	–	50,0	–	–	5900	1,5	1204/12045*	1204/12045*
335.19-160.07.40-8	75012674	Arbor hole	160,0	7,0	44,6	8	16	–	40,0	65,0	12,0	–	–	–	5900	0,9	1204/12045*	1204/12045*
335.19-200.07.50-9	75012676	Arbor hole	200,0	7,0	62,6	9	18	–	50,0	69,0	12,0	–	–	–	5200	1,4	1204/12045*	1204/12045*
335.19-250.07.50-12	75012678	Arbor hole	250,0	7,0	87,6	12	24	–	50,0	69,0	12,0	–	–	–	4700	2,1	1204/12045*	1204/12045*
R335.19-100.10.27-5	75011451	Arbor	100,0	10,0	22,0	5	10	–	27,0	48,0	–	50,0	–	–	6600	0,9	1205	1205
335.19-100.10.27-5	75011288	Arbor hole	100,0	10,0	27,6	5	10	–	27,0	41,0	12,0	–	–	–	6600	0,4	1205	1205
R335.19-125.10.32-6	02565046	Arbor	125,0	10,0	29,5	6	12	–	32,0	58,0	–	50,0	–	–	6000	1,3	1205	1205
335.19-125.10.40-6	75011293	Arbor hole	125,0	10,0	33,1	6	12	–	40,0	55,0	12,0	–	–	–	6000	0,6	1205	1205
R335.19-160.10.40-8	75012914	Arbor	160,0	10,0	41,1	8	16	–	40,0	70,0	–	50,0	–	–	5200	1,8	1205	1205
335.19-160.10.40-8	75011298	Arbor hole	160,0	10,0	46,2	8	16	–	40,0	65,0	12,0	–	–	–	5200	1,2	1205	1205
335.19-200.10.50-9	75011373	Arbor hole	200,0	10,0	63,6	9	18	–	50,0	69,0	12,0	–	–	–	4700	1,9	1205	1205
335.19-250.10.50-12	75012210	Arbor hole	250,0	10,0	88,6	12	24	–	50,0	69,0	12,0	–	–	–	4200	3,0	1205	1205

*To generate CW=8mm use insert SNHQ12045..., LF=50,5mm and 35,5mm

Spare Parts

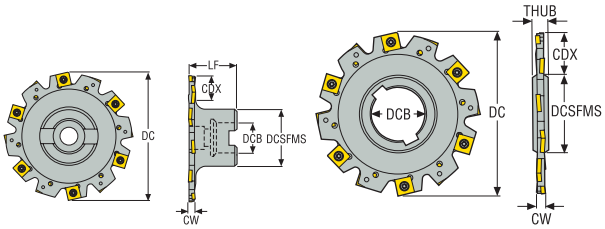
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
335/R335.19 RE CW7	–	C94006-T15P	T00-15P35	3.5NM
R335.19 DCB=16 CW7	TCEI0825	C94006-T15P	T00-15P35	3.5NM
R335.19 DCB=22 CW7	MC6S10X40	C94006-T15P	T00-15P35	3.5NM
R335.19 DCB=27 CW7	MC6S12X35	C94006-T15P	T00-15P35	3.5NM
R335.19 DCB=32 CW7	220.17-694	C94006-T15P	T00-15P35	3.5NM
R335.19 DCB=40 CW7	–	C94006-T15P	T00-15P35	3.5NM
R335.19 DCB=27 CW10	MC6S12X35	C94008-T15P	T00-15P35	3.5NM
335.19 CW10	–	C94008-T15P	T00-15P35	3.5NM
R335.19 DCB=32 CW10	220.17-694	C94008-T15P	T00-15P35	3.5NM
R335.19 DCB=40 CW10	–	C94008-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Width 12 mm - full side

Cutter 335.19 - Insert SNHQ – Metric

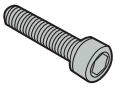


- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	SNHQ..R	SNHQ..L
			mm	mm	mm			mm	mm	mm	mm		kg		
R335.19-100.12.27-5	75012682	Arbor	100,0	12,0	22,0	5	10	27,0	48,0	–	50,0	6000	0,9	1207	1207
335.19-100.12.27-5	75012671	Arbor hole	100,0	12,0	27,9	5	10	27,0	41,0	12,0	–	6000	0,5	1207	1207
R335.19-125.12.32-6	02565047	Arbor	125,0	12,0	29,5	6	12	32,0	58,0	–	50,0	5300	1,5	1207	1207
335.19-125.12.40-6	75012673	Arbor hole	125,0	12,0	33,9	6	12	40,0	55,0	12,0	–	5300	0,7	1207	1207
R335.19-160.12.40-8	75012686	Arbor	160,0	12,0	41,1	8	16	40,0	70,0	–	50,0	4700	1,9	1207	1207
335.19-160.12.40-8	75012339	Arbor hole	160,0	12,0	45,9	8	16	40,0	65,0	12,0	–	4700	1,3	1207	1207
335.19-200.12.50-9	75012677	Arbor hole	200,0	12,0	64,2	9	18	50,0	69,0	12,0	–	4200	2,2	1207	1207
335.19-250.12.50-11	75012679	Arbor hole	250,0	12,0	89,2	11	22	50,0	69,0	12,0	–	3700	3,7	1207	1207

Spare Parts

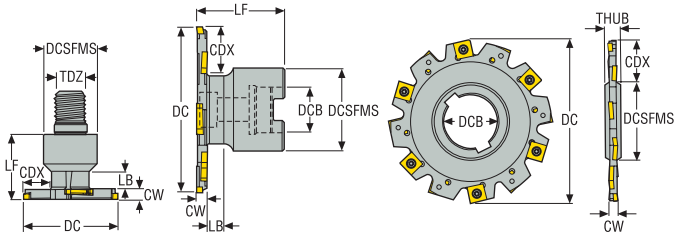
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R335.19 DCB=27	MC6S12X35	C94010-T15P	T00-15P35	3.5NM
335.19	–	C94010-T15P	T00-15P35	3.5NM
R335.19 DCB=32	220.17-694	C94010-T15P	T00-15P35	3.5NM
R335.19 DCB=40	–	C94010-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Cutter 335.19 - Insert SNHQ – Inch

Width 0,156 / 0,187 / 0,250 Inch – full side



- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	LB	RPMX	Weight	SNHQ..R	SNHQ..L
			Inch	Inch	Inch			Inch	Inch	Inch	Inch	Inch		lbs		
R335.19-01.50-RE-0.15-2NA	03277875	Combimaster	1.500	0.156	0.445	2	4	–	0.728	–	0.906	0.326	22000	0.220	1102	1102
R335.19-02.00-RE-0.15-3NA	03277877	Combimaster	2.000	0.156	0.602	3	6	–	0.906	–	1.102	0.405	19100	0.440	1102	1102
R335.19-02.50-0.15-4	02881176	Arbor	2.500	0.156	0.559	4	8	0.750	1.575	–	2.000	0.445	17100	0.880	1102	1102
R335.19-02.50-RE-0.15-4NA	03277880	Combimaster	2.500	0.156	0.705	4	8	–	1.181	–	1.378	0.444	17100	0.660	1102	1102
R335.19-03.00-0.15-5	02881184	Arbor	3.000	0.156	0.807	5	10	0.750	1.575	–	2.000	0.445	15200	0.880	1102	1102
R335.19-03.00-RE-0.15-5NA	03277883	Combimaster	3.000	0.156	0.957	5	10	–	1.181	–	1.378	0.444	15200	0.880	1102	1102
R335.19-04.00-RE-0.15-7NA	03277886	Combimaster	4.000	0.156	1.319	7	14	–	1.437	–	1.378	0.444	13500	1.320	1102	1102
R335.19-01.50-RE-0.18-2NA	03277876	Combimaster	1.500	0.187	0.445	2	4	–	0.728	–	0.906	0.295	19100	0.220	1103	1103
R335.19-02.00-RE-0.18-3NA	03277878	Combimaster	2.000	0.187	0.602	3	6	–	0.906	–	1.102	0.374	16800	0.440	1103	1103
R335.19-02.50-0.18-4	02881177	Arbor	2.500	0.187	0.555	4	8	0.750	1.575	–	2.000	0.413	14900	0.880	1103	1103
R335.19-02.50-RE-0.18-4NA	03277881	Combimaster	2.500	0.187	0.705	4	8	–	1.181	–	1.378	0.414	14900	0.660	1103	1103
R335.19-03.00-0.18-5	02881185	Arbor	3.000	0.187	0.807	5	10	0.750	1.575	–	2.000	0.413	13200	1.100	1103	1103
R335.19-03.00-RE-0.18-5NA	03277884	Combimaster	3.000	0.187	0.953	5	10	–	1.181	–	1.378	0.414	13200	0.880	1103	1103
335.19-04.00-0.18-6	02869718	Arbor hole	4.000	0.187	1.035	6	12	1.000	1.625	0.500	–	–	11800	0.660	1103	1103
R335.19-04.00-0.18-6	02869759	Arbor	4.000	0.187	0.906	6	12	1.000	1.880	–	2.000	–	11800	1.540	1103	1103
R335.19-04.00-RE-0.18-7NA	03277887	Combimaster	4.000	0.187	1.315	7	14	–	1.437	–	1.378	0.414	11800	1.540	1103	1103
335.19-05.00-0.18-7	02869719	Arbor hole	5.000	0.187	1.409	7	14	1.250	1.875	0.500	–	–	10700	0.880	1103	1103
335.19-06.00-0.18-9	02869720	Arbor hole	6.000	0.187	1.909	9	18	1.250	1.875	0.500	–	–	9300	1.320	1103	1103
R335.19-02.00-RE-0.25-2NA	03277879	Combimaster	2.000	0.250	0.602	2	4	–	0.906	–	1.102	0.312	12300	0.440	1204	1204
R335.19-02.50-0.25-3	02881178	Arbor	2.500	0.250	0.555	3	6	0.750	1.575	–	2.000	0.350	9400	0.880	1204	1204
R335.19-02.50-RE-0.25-3NA	03277882	Combimaster	2.500	0.250	0.705	3	6	–	1.181	–	1.378	0.352	9400	0.880	1204	1204
R335.19-03.00-0.25-4	02881186	Arbor	3.000	0.250	0.807	4	8	0.750	1.575	–	2.000	0.350	8400	1.100	1204	1204
R335.19-03.00-RE-0.25-4NA	03277885	Combimaster	3.000	0.250	0.961	4	8	–	1.181	–	1.378	0.352	8400	1.100	1204	1204
R335.19-04.00-RE-0.25-6NA	03277888	Combimaster	4.000	0.250	1.323	6	12	–	1.437	–	1.378	0.352	7500	1.540	1204	1204
R335.19-04.00-0.25-5	02869760	Arbor	4.000	0.250	0.906	5	10	1.000	1.880	–	2.000	–	7500	1.760	1204	1204
335.19-04.00-0.25-5	02869721	Arbor hole	4.000	0.250	1.075	5	10	1.000	1.625	0.500	–	–	7500	0.660	1204	1204
335.19-05.00-0.25-6	02869722	Arbor hole	5.000	0.250	1.449	6	12	1.250	1.875	0.500	–	–	6700	1.100	1204	1204
R335.19-05.00-0.25-6	02869761	Arbor	5.000	0.250	1.220	6	12	1.250	2.250	–	2.000	–	6700	2.430	1204	1204
335.19-06.00-0.25-7	02869723	Arbor hole	6.000	0.250	1.949	7	14	1.250	1.875	0.500	–	–	5900	1.540	1204	1204
R335.19-06.00-0.25-7	02869762	Arbor	6.000	0.250	1.220	7	14	1.500	2.750	–	2.000	–	5900	3.530	1204	1204
335.19-08.00-0.25-9	02869724	Arbor hole	8.000	0.250	2.512	9	18	1.500	2.750	0.500	–	–	5200	0.880	1204	1204

Spare Parts

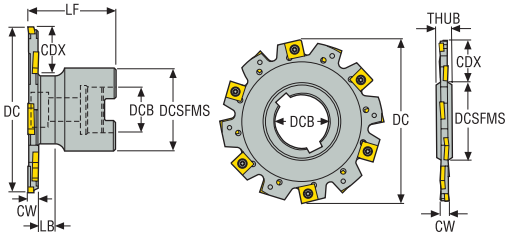
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R335.19RE CW=0.156	–	C93504-T09P	T00-09P20	17.7IN.LBS
R335.19 DCB=0.75 CW=156	UC6S3/8UNFX1-3/4	C93504-T09P	T00-09P20	17.7IN.LBS
335.19, R335.19RE CW=0.187	–	C93505-T09P	T00-09P20	17.7IN.LBS
R335.19 DCB=0.75 CW=0.187	UC6S3/8UNFX1-3/4	C93505-T09P	T00-09P20	17.7IN.LBS
R335.19 DCB=1.00CW=0.187	UC6S1/2UNFX1-1/2	C93505-T09P	T00-09P20	17.7IN.LBS
335.19, R335.19RE CW=0.25	–	C94055-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=0.75 CW=0.25	UC6S3/8UNFX1-3/4	C94055-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.00 CW=0.25	UC6S1/2UNFX1-1/2	C94055-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.25 CW=0.25	UC6S5/8UNFX11/2	C94055-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.5 CW=0.25	ULC6S3/4UNFX11/2	C94055-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Cutter 335.19 - Insert SNHQ – Inch

Width 0,313 / 0,375 / 0,5 Inch – full side



- For insert selection and cutting data recommendations, see page(s) 363-364
- For complete insert programme, see page(s) 758, 759, 765
- For spare parts and technical information, see page 359-360

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	LB	RPMX	Weight	SNHQ..R	SNHQ..L
			Inch	Inch	Inch			Inch	Inch	Inch	Inch	Inch		lbs		
R335.19-02.50-0.31-3	02881179	Arbor	2.500	0.313	0.555	3	6	0.750	1.575	–	2.000	0.287	9400	1.100	12045	12045
R335.19-03.00-0.31-4	02881187	Arbor	3.000	0.313	0.807	4	8	0.750	1.575	–	2.000	0.287	8400	1.100	12045	12045
R335.19-04.00-0.31-5	02869763	Arbor	4.000	0.313	0.906	5	10	1.000	1.880	–	2.000	–	7500	1.760	12045	12045
335.19-05.00-0.31-6	02869727	Arbor hole	5.000	0.313	1.449	6	12	1.250	1.875	0.500	–	–	6700	1.320	12045	12045
335.19-06.00-0.31-7	02869728	Arbor hole	6.000	0.313	1.949	7	14	1.250	1.875	0.500	–	–	5900	1.980	12045	12045
R335.19-02.50-0.37-3	02881180	Arbor	2.500	0.375	0.555	3	6	0.750	1.575	–	2.000	0.224	8400	1.100	1205	1205
R335.19-03.00-0.37-4	02881188	Arbor	3.000	0.375	0.807	4	8	0.750	1.575	–	2.000	0.224	8400	1.100	1205	1205
R335.19-04.00-0.37-5	02869766	Arbor	4.000	0.375	0.906	5	10	1.000	1.880	–	2.000	–	6600	1.980	1205	1205
335.19-04.00-0.37-5	02869731	Arbor hole	4.000	0.375	1.114	5	10	1.000	1.625	0.500	–	–	6600	0.880	1205	1205
R335.19-05.00-0.37-6	02869767	Arbor	5.000	0.375	1.220	6	12	1.250	2.250	–	2.000	–	6000	2.650	1205	1205
335.19-05.00-0.37-6	02869732	Arbor hole	5.000	0.375	1.488	6	12	1.250	1.875	0.500	–	–	6000	1.320	1205	1205
335.19-06.00-0.37-7	02869733	Arbor hole	6.000	0.375	2.020	7	14	1.250	1.875	0.500	–	–	5200	2.200	1205	1205
R335.19-04.00-0.50-5	02869769	Arbor	4.000	0.500	0.906	5	10	1.000	1.880	–	2.000	–	6000	2.200	1207	1207
335.19-04.00-0.50-5	02869736	Arbor hole	4.000	0.500	1.126	5	10	1.000	1.625	0.500	–	–	6000	1.100	1207	1207
R335.19-05.00-0.50-6	02869770	Arbor	5.000	0.500	1.220	6	12	1.250	2.250	–	2.000	–	5300	3.090	1207	1207
335.19-05.00-0.50-6	02869737	Arbor hole	5.000	0.500	1.520	6	12	1.250	1.875	0.500	–	–	5300	1.760	1207	1207
335.19-06.00-0.50-7	02869738	Arbor hole	6.000	0.500	2.000	7	14	1.250	1.875	0.500	–	–	4700	2.870	1207	1207

Spare Parts

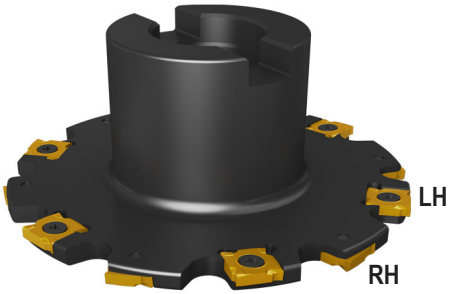
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R335.19 DCB=0.75 CW=0.313	UC6S3/8UNFX1-3/4	C94006-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.00 CW=0.313	UC6S1/2UNFX1-1/2	C94006-T15P	T00-15P35	31.0IN.LBS
335.19- CW=0.313	–	C94006-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=0.75 CW=0.375	UC6S3/8UNFX1-3/4	C94008-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.00 CW=0.375	UC6S1/2UNFX1-1/2	C94008-T15P	T00-15P35	31.0IN.LBS
335.19 CW=0.375	–	C94008-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.25 CW=0.375	UC6S5/8UNFX11/2	C94008-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.00 CW=0.5	UC6S1/2UNFX1-1/2	C94010-T15P	T00-15P35	31.0IN.LBS
335.19 CW=0.5	–	C94010-T15P	T00-15P35	31.0IN.LBS
R335.19 DCB=1.25 CW=0.5	UC6S5/8UNFX11/2	C94010-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Disc milling cutter 335.19 – Technical information

Cutter side



LH = Left hand insert
RH = Right hand insert

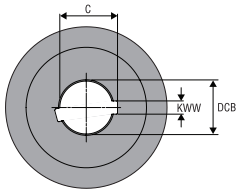
SNHQ insert choice: Width of cut and corner radius choice

Inserts	a_p	R 0,2	R 0,4	R 0,8	R1,0	R 1,2	R 1,6	R 2,0	R 2,4	R 3,0	R 3,1	R 3,5	R 4,0	R 5,0	R 6,0
SNHQ 1102	4	■	■	■		■	■	■							
SNHQ 1103	5	■	■	■		■	■	■							
SNHQ 1203	6	■	■	■	■	■	■	■	x	o					
SNHQ 1204	7	■	■	■		■	■	■	x		x	o			
SNHQ 12045	8	■	■	■		■	■	■	x		x		o		
SNHQ 1205	10	■	■	■	■	■	■	■	x		x		x	o	
SNHQ 1207	12		■	■		■	■	■	x		x		x	x	o

Inserts	a_p	.008	.016	.031	.039	.047	.063	.079	.094	.118	.122	.138	.157	.197	.236
SNHQ 1102	.156	■	■	■		■	■	■							
SNHQ 1103	.187	■	■	■		■	■	■							
SNHQ 1204	.250	■	■	■		■	■	■	x		x				
SNHQ 12045	.313	■	■	■		■	■	■	x		x				
SNHQ 1205	.375	■	■	■	■	■	■	■	x		x		x		
SNHQ 1207	.500		■	■		■	■	■	x		x		x	x	x

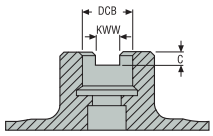
■ = SNHQ 4 edges
x= SNHQ 2 edges
o= Full radius possibillities

Keyway for Arbor hole type and Arbor type cutter



Dimensions in mm		
DCB	KWW	C
22	6	24,15
27	7	29,9
40	10	43,6
50	12	53,6

Dimensions in inch		
DCB	KWW	C
1.00	*0.250*	*1.110*
1.25	*0.312*	*1.393*
1.50	*0.375*	*1.673*
2.00	*0.500*	*2.198*



Dimensions in mm		
DCB	KWW	C
16	8,4	5,6
22	10,4	6,3
27	12,4	7
32	14,4	8
40	16,4	9

Dimensions in inch		
DCB	KWW	C
0.75	*0.32*	*0.19*
1.00	*0.38*	*0.22*
1.25	*0.51*	*0.28*
1.50	*0.63*	*0.38*

SNHQ– Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	SNHQ...-M07 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P2	SNHQ...-M07 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
P3	SNHQ...-M07 F40M	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
P4	SNHQ...-M07 F40M	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
P5	SNHQ...-M07 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P6	SNHQ...-M07 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P7	SNHQ...-M07 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P8	SNHQ...-M07 F30M	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
P11	SNHQ...-M07 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P12	SNHQ...-M07 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
M1	SNHQ...-M07 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
M2	SNHQ...-M07 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M3	SNHQ...-M07 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
M4	SNHQ...-M07 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
M5	SNHQ...-M07 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
K1	SNHQ...-M07 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
K2	SNHQ...-M07 MP2501	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K3	SNHQ...-M07 MP2501	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K4	SNHQ...-M07 MP2501	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K5	SNHQ...-M07 MP2501	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
K6	SNHQ...-M07 MP2501	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K7	SNHQ...-M07 MP2501	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
N1	SNHQ...-E05 H25	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N2	SNHQ...-E05 H25	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N3	SNHQ...-E05 H25	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N11	SNHQ...-E05 H25	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
S1	SNHQ...-M07 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S2	SNHQ...-M07 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S3	SNHQ...-M07 F40M	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
S11	SNHQ...-M07 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S12	SNHQ...-M07 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S13	SNHQ...-M07 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
H5	SNHQ...-M07 F30M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
H8	SNHQ...-M07 F30M	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
H11	SNHQ...-M07 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
H12	SNHQ...-M07 F40M	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
H21	SNHQ...-M07 F30M	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

SNHQ – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			F30M			F40M			H25		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	245 *800*	260 *850*	285 *940*	195 *640*	205 *670*	230 *750*	185 *610*	195 *640*	215 *710*	— —	— —	— —
P2	235 *770*	255 *840*	280 *920*	185 *610*	200 *660*	220 *720*	175 *570*	190 *620*	210 *690*	— —	— —	— —
P3	205 *670*	220 *720*	245 *800*	165 *540*	175 *570*	195 *640*	155 *510*	165 *540*	185 *610*	— —	— —	— —
P4	180 *590*	195 *640*	215 *710*	145 *475*	155 *510*	170 *560*	135 *445*	150 *490*	165 *540*	— —	— —	— —
P5	175 *570*	185 *610*	210 *690*	140 *460*	150 *490*	165 *540*	135 *445*	140 *460*	155 *510*	— —	— —	— —
P6	200 *660*	210 *690*	235 *770*	155 *510*	165 *540*	185 *610*	150 *490*	160 *520*	175 *570*	— —	— —	— —
P7	185 *610*	200 *660*	220 *720*	150 *490*	160 *520*	175 *570*	140 *460*	150 *490*	165 *540*	— —	— —	— —
P8	170 *560*	185 *610*	205 *670*	135 *445*	145 *475*	165 *540*	130 *425*	140 *460*	155 *510*	— —	— —	— —
P11	180 *590*	190 *620*	215 *710*	145 *475*	155 *510*	170 *560*	135 *445*	145 *475*	160 *520*	— —	— —	— —
P12	115 *375*	125 *410*	135 *445*	95 *310*	100 *330*	110 *360*	90 *295*	95 *310*	105 *345*	— —	— —	— —
M1	170 *560*	185 *610*	200 *660*	150 *490*	165 *540*	180 *590*	140 *460*	155 *510*	170 *560*	— —	— —	— —
M2	140 *460*	150 *490*	165 *540*	125 *410*	135 *445*	150 *490*	120 *395*	125 *410*	140 *460*	— —	— —	— —
M3	115 *375*	120 *395*	135 *445*	100 *330*	110 *360*	120 *395*	95 *310*	105 *345*	115 *375*	— —	— —	— —
M4	85 *280*	95 *310*	105 *345*	80 *260*	85 *280*	90 *295*	75 *245*	80 *260*	90 *295*	— —	— —	— —
M5	75 *245*	80 *260*	85 *280*	65 *215*	70 *230*	75 *245*	60 *195*	65 *215*	75 *245*	— —	— —	— —
K1	185 *610*	200 *660*	220 *720*	145 *475*	160 *520*	175 *570*	140 *460*	150 *490*	170 *560*	— —	— —	— —
K2	165 *540*	175 *570*	195 *640*	135 *445*	140 *460*	155 *510*	125 *410*	135 *445*	150 *490*	— —	— —	— —
K3	140 *460*	150 *490*	165 *540*	115 *375*	120 *395*	135 *445*	105 *345*	115 *375*	125 *410*	— —	— —	— —
K4	135 *445*	145 *475*	160 *520*	105 *345*	115 *375*	125 *410*	100 *330*	110 *360*	120 *395*	— —	— —	— —
K5	80 *260*	85 *280*	95 *310*	65 *215*	70 *230*	75 *245*	60 *195*	65 *215*	75 *245*	— —	— —	— —
K6	120 *395*	125 *410*	140 *460*	95 *310*	100 *330*	110 *360*	90 *295*	95 *310*	105 *345*	— —	— —	— —
K7	105 *345*	110 *360*	125 *410*	85 *280*	90 *295*	100 *330*	80 *260*	85 *280*	95 *310*	— —	— —	— —
N1	— —	— —	— —	1100 *3600*	1175 *3850*	1300 *4275*	1050 *3450*	1125 *3700*	1250 *4100*	1025 *3375*	1100 *3600*	1200 *3925*
N2	— —	— —	— —	445 *1450*	480 *1575*	530 *1750*	425 *1400*	455 *1500*	500 *1650*	415 *1350*	440 *1450*	485 *1600*
N3	— —	— —	— —	295 *970*	320 *1050*	355 *1175*	280 *920*	305 *1000*	335 *1100*	275 *900*	295 *970*	325 *1075*
N11	— —	— —	— —	340 *1125*	365 *1200*	405 *1325*	320 *1050*	345 *1125*	385 *1275*	315 *1025*	335 *1100*	370 *1225*
S1	42 *140*	46 *150*	50 *165*	36 *120*	39 *130*	43 *140*	35 *115*	37 *120*	41 *135*	— —	— —	— —
S2	34 *110*	37 *120*	41 *135*	29 *95*	31 *100*	35 *115*	28 *90*	30 *100*	33 *110*	— —	— —	— —
S3	30 *100*	32 *105*	36 *120*	26 *85*	27 *90*	30 *100*	24 *80*	26 *85*	29 *95*	— —	— —	— —
S11	60 *195*	65 *215*	70 *230*	50 *165*	55 *180*	60 *195*	49 *160*	50 *165*	55 *180*	— —	— —	— —
S12	50 *165*	55 *180*	60 *195*	36 *120*	38 *125*	42 *140*	41 *135*	44 *145*	48 *155*	— —	— —	— —
S13	29 *95*	31 *100*	34 *110*	21 *70*	22 *70*	24 *80*	24 *80*	25 *80*	28 *90*	— —	— —	— —
H5	35 *115*	37 *120*	41 *135*	31 *100*	33 *110*	36 *120*	29 *95*	31 *100*	34 *110*	— —	— —	— —
H8	37 *120*	39 *130*	44 *145*	32 *105*	34 *110*	38 *125*	31 *100*	33 *110*	36 *120*	— —	— —	— —
H11	45 *150*	48 *155*	55 *180*	39 *130*	42 *140*	46 *150*	37 *120*	40 *130*	44 *145*	— —	— —	— —
H12	43 *140*	46 *150*	50 *165*	38 *125*	40 *130*	45 *150*	36 *120*	38 *125*	42 *140*	— —	— —	— —
H21	37 *120*	39 *130*	44 *145*	32 *105*	34 *110*	38 *125*	31 *100*	33 *110*	36 *120*	— —	— —	— —

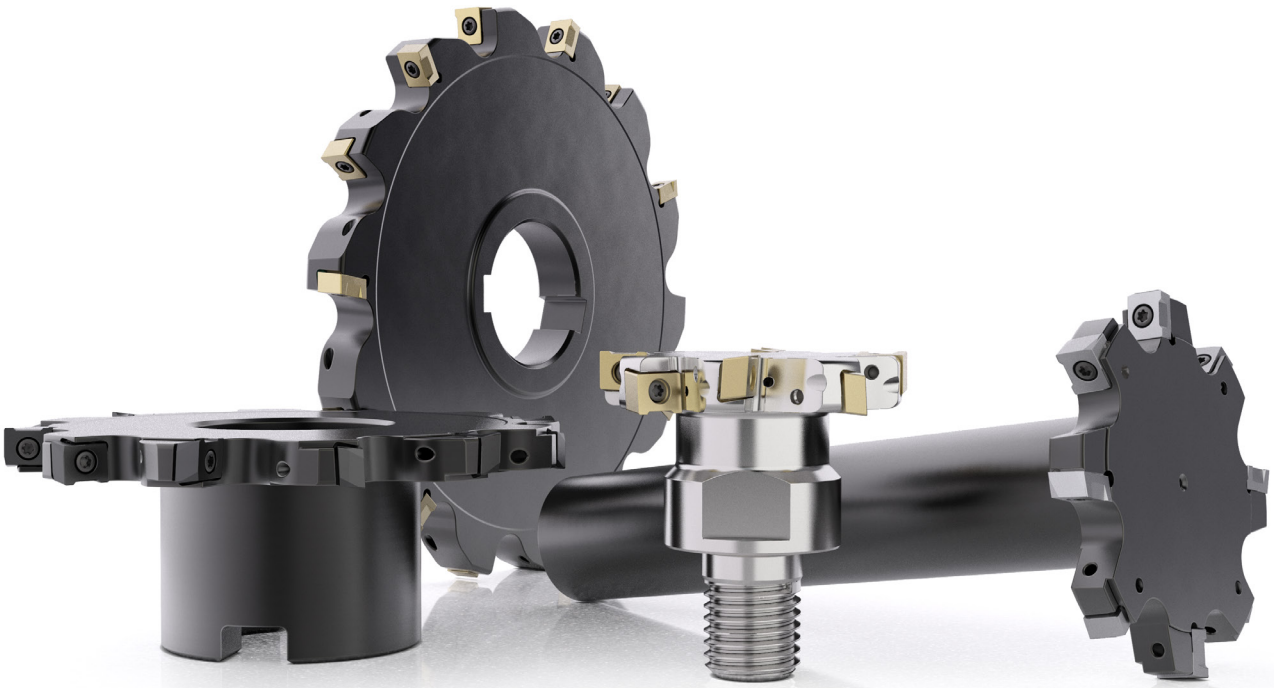
335.19 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	335.19-...-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P2	335.19-...-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P3	335.19-...-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
P4	335.19-...-M08 F40M	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
P5	335.19-...-M08 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P6	335.19-...-M08 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P7	335.19-...-M08 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P8	335.19-...-MD09 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
P11	335.19-...-M08 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P12	335.19-...-M08 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
M1	335.19-...-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
M2	335.19-...-M08 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M3	335.19-...-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
M4	335.19-...-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
M5	335.19-...-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
K1	335.19-...-MD09 F40M	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
K2	335.19-...-MD09 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K3	335.19-...-MD09 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K4	335.19-...-MD09 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K5	335.19-...-MD09 F40M	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*
K6	335.19-...-MD09 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K7	335.19-...-MD09 F40M	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*
S1	335.19-...-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S2	335.19-...-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S3	335.19-...-M08 F40M	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
S11	335.19-...-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S12	335.19-...-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S13	335.19-...-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
H5	335.19-...-MD09 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
H8	335.19-...-MD09 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
H11	335.19-...-MD09 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
H12	335.19-...-MD09 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
H21	335.19-...-MD09 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.19 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			F40M		
	30%	20%	10%	30%	20%	10%
P1	220 *720*	240 *790*	260 *850*	175 *570*	185 *610*	205 *670*
P2	215 *710*	230 *750*	255 *840*	170 *560*	180 *590*	200 *660*
P3	190 *620*	205 *670*	225 *740*	145 *475*	155 *510*	175 *570*
P4	165 *540*	180 *590*	200 *660*	130 *425*	140 *460*	155 *510*
P5	160 *520*	170 *560*	190 *620*	125 *410*	135 *445*	150 *490*
P6	180 *590*	195 *640*	215 *710*	140 *460*	150 *490*	165 *540*
P7	170 *560*	185 *610*	205 *670*	135 *445*	140 *460*	160 *520*
P8	160 *520*	170 *560*	190 *620*	125 *410*	130 *425*	145 *475*
P11	165 *540*	180 *590*	195 *640*	130 *425*	140 *460*	155 *510*
P12	110 *360*	115 *375*	125 *410*	85 *280*	90 *295*	100 *330*
M1	155 *510*	165 *540*	185 *610*	135 *445*	145 *475*	160 *520*
M2	130 *425*	135 *445*	150 *490*	115 *375*	120 *395*	135 *445*
M3	105 *345*	110 *360*	120 *395*	90 *295*	100 *330*	105 *345*
M4	80 *260*	85 *280*	95 *310*	70 *230*	75 *245*	85 *280*
M5	65 *215*	70 *230*	80 *260*	60 *195*	65 *215*	70 *230*
K1	170 *560*	185 *610*	200 *660*	135 *445*	145 *475*	160 *520*
K2	150 *490*	160 *520*	180 *590*	120 *395*	125 *410*	140 *460*
K3	130 *425*	135 *445*	150 *490*	100 *330*	110 *360*	120 *395*
K4	120 *395*	130 *425*	145 *475*	95 *310*	105 *345*	115 *375*
K5	75 *245*	80 *260*	90 *295*	60 *195*	60 *195*	70 *230*
K6	110 *360*	115 *375*	125 *410*	85 *280*	90 *295*	100 *330*
K7	95 *310*	105 *345*	115 *375*	75 *245*	80 *260*	90 *295*
N1	— —	— —	— —	990 *3250*	1075 *3525*	1175 *3850*
N2	— —	— —	— —	400 *1300*	430 *1400*	475 *1550*
N3	— —	— —	— —	265 *870*	285 *940*	315 *1025*
N11	— —	— —	— —	305 *1000*	325 *1075*	365 *1200*
S1	— —	— —	— —	33 *110*	35 *115*	39 *130*
S2	— —	— —	— —	26 *85*	28 *90*	31 *100*
S3	— —	— —	— —	23 *75*	25 *80*	27 *90*
S11	— —	— —	— —	46 *150*	50 *165*	55 *180*
S12	— —	— —	— —	39 *130*	42 *140*	46 *150*
S13	— —	— —	— —	22 *70*	24 *80*	27 *90*
H5	— —	— —	— —	28 *90*	30 *100*	33 *110*
H8	— —	— —	— —	29 *95*	31 *100*	35 *115*
H11	— —	— —	— —	36 *120*	38 *125*	42 *140*
H12	— —	— —	— —	34 *110*	36 *120*	40 *130*
H21	— —	— —	— —	29 *95*	31 *100*	35 *115*



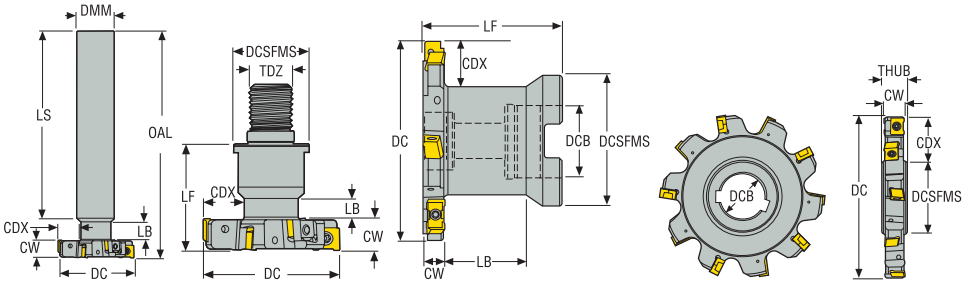
335.18

Highly economical, versatile and free-cutting disc milling cutter system dedicated for medium width of cut slotting, or half side and face cutting operations

- Width of cut 8-20 mm (.312 - .7500 inch) - slot with flat bottom
- Cutter range diameter 32-315 mm (1.25 - 12 inch)
- Fixed or adjustable cutting width with replaceable cassettes
- Available with Cylindrical, Arbor, Arbor hole and Combimaster connection, with through coolant and close pitch option
- Corner radii range 0.4-4 mm (.016 - 0.16 inch), and possibility to apply round insert dia 8/10/12mm in adjustable system
- Economical solution with up to 4 cutting edges per insert
- Basic tolerance of the slot: Fixed pocket cutters: +/-0.08mm (+/-0.003”),Adjustable cutter: +/-0.07mm (+/-0.0025”)

Cutter 335.18 - Insert LNK. – Metric

Width 8/10 mm - full side - Fixed pocket

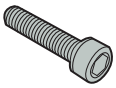


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	Insert
			mm	mm	mm			mm		mm	mm	mm	mm	mm	mm	mm		kg	
R335.18-1632.0-08.1N	02541821	Cylindrical	32,0	8,0	9,0	1	2	16,0	–	–	–	140,0	–	–	108,0	23,0	17300	0,3	LNK.05..
R335.18-1032.RE-08.2NA	03277891	Combimaster	32,0	8,0	8,4	2	4	–	M10	–	18,5	–	–	28,0	–	8,89	17300	0,1	LNK.05..
R335.18-2040.0-08.2N	02541822	Cylindrical	40,0	8,0	12,0	2	4	20,0	–	–	–	140,0	–	–	108,0	22,0	15400	0,4	LNK.05..
R335.18-1240.RE-08.2NA	03277893	Combimaster	40,0	8,0	11,2	2	4	–	M12	–	23,0	–	–	30,0	–	8,39	15400	0,2	LNK.05..
R335.18-1650.RE-08.3NA	03277895	Combimaster	50,0	8,0	14,2	3	6	–	M16	–	30,0	–	–	35,0	–	10,59	13800	0,2	LNK.05..
R335.18-2550.0-08.3N	02541829	Cylindrical	50,0	8,0	15,0	3	6	25,0	–	–	–	150,0	–	–	110,0	29,5	13800	0,6	LNK.05..
R335.18-2063.RE-08.4NA	03277897	Combimaster	63,0	8,0	15,0	4	8	–	M20	–	36,5	–	–	40,0	–	14,89	12300	0,4	LNK.05..
R335.18-3263.0-08.3N	02541831	Cylindrical	63,0	8,0	15,5	3	6	32,0	–	–	–	170,0	–	–	155,0	–	12300	1,2	LNK.05..
R335.18-063.08.22-3N	02541815	Arbor	63,0	8,0	15,0	3	6	–	–	22,0	40,0	–	–	50,0	–	28,9	12300	0,4	LNK.05..
R335.18-080.08.22-4N	02541817	Arbor	80,0	8,0	23,5	4	8	–	–	22,0	40,0	–	–	50,0	–	28,9	10900	0,5	LNK.05..
R335.18-100.08.27-5N	02541818	Arbor	100,0	8,0	25,0	5	10	–	–	27,0	48,0	–	–	50,0	–	0,0	9700	0,8	LNK.05..
335.18-100.08.27-5N	02541812	Arbor hole	100,0	8,0	27,9	5	10	–	–	27,0	41,0	–	15,0	–	–	–	9700	0,4	LNK.05..
R335.18-125.08.32-6N	02541819	Arbor	125,0	8,0	34,0	6	12	–	–	32,0	58,0	–	–	50,0	–	0,0	8400	1,0	LNK.05..
R335.18-1032.RE-10.2NA	03277892	Combimaster	32,0	10,0	8,5	2	4	–	M10	–	18,5	–	–	28,0	–	6,89	17300	0,1	LNK.05..
R335.18-1632.0-10.1N-LN05	02541833	Cylindrical	32,0	10,0	9,0	1	2	16,0	–	–	–	140,0	–	–	108,0	21,0	17300	0,3	LNK.05..
R335.18-1240.RE-10.2NA	03277894	Combimaster	40,0	10,0	11,5	2	4	–	M12	–	23,0	–	–	30,0	–	6,39	15400	0,2	LNK.05..
R335.18-2040.0-10.2N-LN05	02541834	Cylindrical	40,0	10,0	12,0	2	4	20,0	–	–	–	140,0	–	–	108,0	20,0	15400	0,4	LNK.05..
R335.18-2040.0-10.2N	02449072	Cylindrical	40,0	10,0	12,0	2	4	20,0	–	–	–	140,0	–	–	108,0	20,0	14900	0,4	LNK.06..
R335.18-1650.RE-10.3NA	03279026	Combimaster	50,0	10,0	14,4	3	6	–	M16	–	30,0	–	–	35,0	–	8,59	13400	0,3	LNK.06..
R335.18-2550.0-10.3N	02449095	Cylindrical	50,0	10,0	15,0	3	6	25,0	–	–	–	150,0	–	–	110,0	27,5	13400	0,6	LNK.06..
R335.18-2063.RE-10.4NA	03277898	Combimaster	63,0	10,0	15,1	4	8	–	M20	–	36,5	–	–	40,0	–	12,89	11900	0,4	LNK.06..
R335.18-3263.0-10.3N	02449097	Cylindrical	63,0	10,0	15,5	3	6	32,0	–	–	–	170,0	–	–	155,0	–	11900	1,2	LNK.06..
R335.18-063.10.22-3N	00039922	Arbor	63,0	10,0	15,0	3	6	–	–	22,0	40,0	–	–	50,0	–	27,0	11900	0,4	LNK.06..
R335.18-3280.0-10.4N	02449098	Cylindrical	80,0	10,0	24,0	4	8	32,0	–	–	–	170,0	–	–	155,0	–	10500	1,3	LNK.06..
R335.18-080.10.22-4N	00039923	Arbor	80,0	10,0	23,5	4	8	–	–	22,0	40,0	–	–	50,0	–	27,0	10500	0,5	LNK.06..
335.18-080.10.27-4N	02449039	Arbor hole	80,0	10,0	19,0	4	8	–	–	27,0	41,0	–	15,0	–	–	–	10500	0,3	LNK.06..
R335.18-100.10.27-5N	00039924	Arbor	100,0	10,0	26,0	5	10	–	–	27,0	48,0	–	–	50,0	–	–	9400	0,9	LNK.06..
335.18-100.10.27-5N	02449040	Arbor hole	100,0	10,0	28,0	5	10	–	–	27,0	41,0	–	15,0	–	–	–	9400	0,4	LNK.06..
R335.18-125.10.32-6N	02448768	Arbor	125,0	10,0	34,0	6	12	–	–	32,0	58,0	–	–	50,0	–	0,0	8400	1,1	LNK.06..

Spare Parts

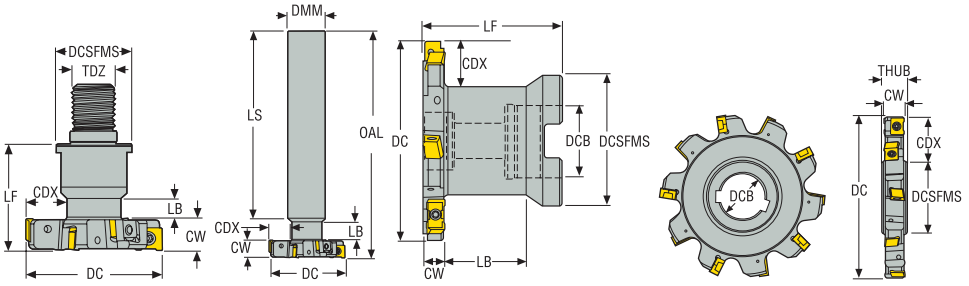
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
335.18 / R335.18 .RE / R335.18 .0 CW=8	–	C02508-T08P	T00-08P12	1.2NM
R335.18 DCB=22 CW=08	MC6S10X40	C02508-T08P	T00-08P12	1.2NM
R335.18 DCB=27 CW=08	MC6S12X40	C02508-T08P	T00-08P12	1.2NM
R335.18 DCB=32 CW=08	–	C02508-T08P	T00-08P12	1.2NM
R335.18 .RE / R335.18 .0 CW=10 LN..05	–	C02508-T08P	T00-08P12	1.2NM
335.18 / R335.18 .RE / R335.18 .0 CW=10 LN..06	–	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=22 CW=10	MC6S10X40	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=27 CW=10	MC6S12X40	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=32 CW=10	–	C73007-T09P	T00-09P20	2.0NM

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Cutter 335.18 - Insert LNK. – Metric

Width 12/14 mm - full side - Fixed pocket

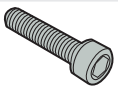


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	Insert
			mm	mm	mm			mm		mm	mm	mm	mm	mm	mm	mm		kg	
R335.18-2550.0-12.3N	02449125	Cylindrical	50,0	12,0	15,0	3	6	25,0	–	–	–	150,0	–	–	110,0	25,5	13400	0,6	LNK.06..
R335.18-1650.RE-12.3NA	03277896	Combimaster	50,0	12,0	14,5	3	6	–	M16	–	30,0	–	–	35,0	–	6,59	13400	0,3	LNK.06..
R335.18-3263.0-12.3N	02449176	Cylindrical	63,0	12,0	15,5	3	6	32,0	–	–	–	170,0	–	–	155,0	–	11900	1,2	LNK.06..
R335.18-063.12.22-3N	00039925	Arbor	63,0	12,0	15,0	3	6	–	–	22,0	40,0	–	–	50,0	–	25,0	11900	0,4	LNK.06..
R335.18-2063.RE-12.4NA	03277899	Combimaster	63,0	12,0	14,9	4	8	–	M20	–	36,5	–	–	40,0	–	10,47	11900	0,4	LNK.06..
R335.18-3280.0-12.4N	02449178	Cylindrical	80,0	12,0	24,0	4	8	32,0	–	–	–	170,0	–	–	155,0	–	10500	1,3	LNK.06..
R335.18-080.12.22-4N	00039926	Arbor	80,0	12,0	23,5	4	8	–	–	22,0	40,0	–	–	50,0	–	25,0	10500	0,8	LNK.06..
335.18-080.12.27-4N	02449043	Arbor hole	80,0	12,0	19,0	4	8	–	–	27,0	41,0	–	15,0	–	–	–	10500	0,3	LNK.06..
R335.18-100.12.27-5N	00039927	Arbor	100,0	12,0	26,0	5	10	–	–	27,0	48,0	–	–	50,0	–	0,0	9400	0,9	LNK.06..
335.18-100.12.27-5N	02449044	Arbor hole	100,0	12,0	28,0	5	10	–	–	27,0	41,0	–	15,0	–	–	–	9400	0,5	LNK.06..
R335.18-125.12.32-6N	02448769	Arbor	125,0	12,0	34,0	6	12	–	–	32,0	58,0	–	–	50,0	–	0,0	8400	1,1	LNK.06..
335.18-125.12.40-6N	02449045	Arbor hole	125,0	12,0	33,0	6	12	–	–	40,0	55,0	–	15,0	–	–	–	8400	0,8	LNK.06..
R335.18-063.14.22-3N	00039928	Arbor	63,0	14,0	15,0	3	6	–	–	22,0	40,0	–	–	50,0	–	23,0	11900	0,4	LNK.08..
R335.18-080.14.22-4N	00039929	Arbor	80,0	14,0	23,5	4	8	–	–	22,0	40,0	–	–	50,0	–	23,0	10500	0,6	LNK.08..
R335.18-100.14.27-5N	00039930	Arbor	100,0	14,0	26,0	5	10	–	–	27,0	48,0	–	–	50,0	–	0,0	9400	1,0	LNK.08..
R335.18-125.14.32-6N	02448771	Arbor	125,0	14,0	34,0	6	12	–	–	32,0	58,0	–	–	50,0	–	0,0	8400	1,3	LNK.08..
335.18-160.14.40-7N	02449047	Arbor hole	160,0	14,0	51,0	7	14	–	–	40,0	55,0	–	15,0	–	–	–	7500	1,6	LNK.08..

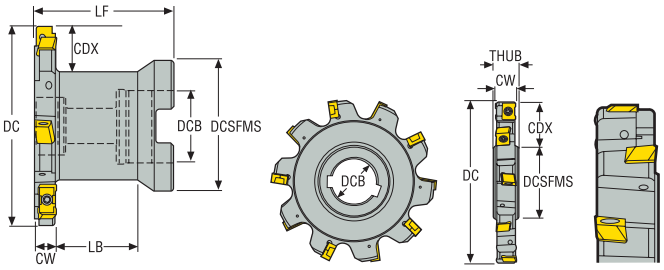
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
335.18 / R335.18 .RE/R335.18 .0	–	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=22	MC6S10X40	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=27	MC6S12X40	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=32	–	C73007-T09P	T00-09P20	2.0NM

Width 17/20 mm - full side - Fixed pocket

Cutter 335.18 - Insert LNK. – Metric

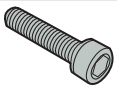


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	LB	RPMX	Weight	Insert
			mm	mm	mm			mm	mm	mm	mm	mm		kg	
R335.18-080.17.22-3N	02469590	Arbor	80,0	17,0	24,0	3	9	22,0	40,0	–	50,0	20,0	10500	0,6	LNK.06..
R335.18-125.17.32-4N	02469592	Arbor	125,0	17,0	33,5	4	12	32,0	58,0	–	50,0	0,0	8400	1,4	LNK.06..
335.18-125.17.40-4N	02469602	Arbor hole	125,0	17,0	33,0	4	12	40,0	55,0	20,0	–	–	8400	1,1	LNK.06..
R335.18-160.17.40-5N	02469593	Arbor	160,0	17,0	45,0	5	15	40,0	70,0	–	50,0	0,0	7500	2,4	LNK.06..
335.18-160.17.40-5N	02469603	Arbor hole	160,0	17,0	50,7	5	15	40,0	55,0	20,0	–	–	7500	1,9	LNK.06..
R335.18-080.20.22-4N	02469597	Arbor	80,0	20,0	24,0	4	12	22,0	40,0	–	50,0	16,9	10500	0,7	LNK.08..
R335.18-100.20.27-5N	02469598	Arbor	100,0	20,0	26,0	5	15	27,0	48,0	–	50,0	0,0	9400	1,2	LNK.08..
R335.18-125.20.32-6N	02469599	Arbor	125,0	20,0	33,5	6	18	32,0	58,0	–	50,0	0,0	8400	1,6	LNK.08..
335.18-125.20.40-6N	02469604	Arbor hole	125,0	20,0	34,0	6	18	40,0	55,0	20,0	–	–	8400	1,2	LNK.08..
R335.18-160.20.40-7N	02469600	Arbor	160,0	20,0	45,0	7	21	40,0	70,0	–	50,0	0,0	7500	2,7	LNK.08..

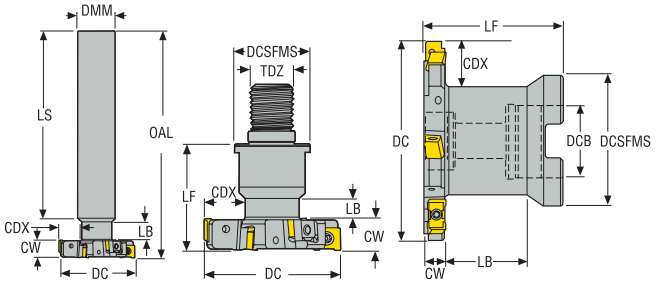
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R335.18 DCB=22	MC6S10X40	C73007-T09P	T00-09P20	2.0NM
335.18 DCB=40 / R335.18 DCB=32/40	–	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=27	MC6S12X40	C73007-T09P	T00-09P20	2.0NM

Cutter 335.18 - Insert LNK. – Inch

Width 0.312-0.375” - full side - Fixed pocket



- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	TDZ	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	Insert
			Inch	Inch	Inch			Inch		Inch	Inch	Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-01.25-RE-0.31F-2NA	03277900	Combimaster	1.250	0.312	0.323	2	4	–	M10	–	0.728	–	–	1.102	–	0.353	17300	0.440	LNK.05..
R335.18-1.25-0-0.31F-1N	02541852	Cylindrical	1.250	0.312	0.350	1	2	0.625	–	–	–	5.500	–	–	4.398	0.748	17300	0.660	LNK.05
R335.18-01.50-RE-0.31F-2NA	03277902	Combimaster	1.500	0.312	0.406	2	4	–	M12	–	0.906	–	–	1.181	–	0.333	15400	0.440	LNK.05..
R335.18-1.50-0-0.31F-2N	02541853	Cylindrical	1.500	0.312	0.409	2	4	0.750	–	–	–	5.500	–	–	4.398	0.748	15400	0.880	LNK.05
R335.18-02.00-RE-0.31F-3NA	03277904	Combimaster	2.000	0.312	0.575	3	6	–	M16	–	1.181	–	–	1.378	–	0.420	13800	0.660	LNK.05..
R335.18-2.00-0-0.31F-3N	02541854	Cylindrical	2.000	0.312	0.591	3	6	1.000	–	–	–	6.000	–	–	4.398	1.197	13800	1.540	LNK.05
R335.18-02.50-0.31F-3N	02541842	Arbor	2.500	0.312	0.598	3	6	–	–	0.750	1.580	–	–	2.000	–	1.209	12300	0.880	LNK.05
R335.18-2.50-0-0.31F-3N	02541856	Cylindrical	2.500	0.312	0.626	3	6	1.250	–	–	–	6.750	–	–	6.437	–	12300	2.650	LNK.05
R335.18-03.00-0.31F-4N	02541843	Arbor	3.000	0.312	0.713	4	8	–	–	1.000	1.880	–	–	2.000	–	1.150	10900	1.320	LNK.05
R335.18-04.00-0.31F-5N	02541844	Arbor	4.000	0.312	1.059	5	10	–	–	1.000	1.880	–	–	2.000	–	–	9700	1.980	LNK.05
R335.18-05.00-0.31F-6N	02541845	Arbor	5.000	0.312	1.378	6	12	–	–	1.250	2.250	–	–	2.000	–	–	8400	2.200	LNK.05
R335.18-01.25-RE-0.37F-2NA	03277901	Combimaster	1.250	0.375	0.331	2	4	–	M10	–	0.728	–	–	1.102	–	0.290	17300	0.440	LNK.05..
R335.18-1.25-0-0.37F-1N	02541858	Cylindrical	1.250	0.375	0.350	1	2	0.625	–	–	–	5.500	–	–	4.398	0.685	17300	0.660	LNK.05
R335.18-01.50-RE-0.37F-2NA	03277903	Combimaster	1.500	0.375	0.413	2	4	–	M12	–	0.906	–	–	1.181	–	0.270	15400	0.440	LNK.05..
R335.18-1.50-0-0.37F-2N	02541859	Cylindrical	1.500	0.375	0.413	2	4	0.750	–	–	–	5.500	–	–	4.398	0.685	15400	0.880	LNK.05
R335.18-02.00-RE-0.37F-3NA	03277905	Combimaster	2.000	0.375	0.587	3	6	–	M16	–	1.181	–	–	1.378	–	0.357	13800	0.660	LNK.05..
R335.18-2.00-0-0.37F-3N	02541860	Cylindrical	2.000	0.375	0.591	3	6	1.000	–	–	–	6.000	–	–	4.398	1.134	13800	1.540	LNK.05
R335.18-02.50-0.37F-3N	02541846	Arbor	2.500	0.375	0.598	3	6	–	–	0.750	1.580	–	–	2.000	–	1.146	12300	0.880	LNK.05
R335.18-2.50-0-0.37F-3N	02541861	Cylindrical	2.500	0.375	0.626	3	6	1.250	–	–	–	6.750	–	–	6.437	–	12300	2.650	LNK.05
R335.18-03.00-0.37F-4N	02541847	Arbor	3.000	0.375	0.713	4	8	–	–	1.000	1.880	–	–	2.000	–	1.087	10900	1.320	LNK.05
R335.18-04.00-0.37F-5N	02541848	Arbor	4.000	0.375	1.059	5	10	–	–	1.000	1.880	–	–	2.000	–	–	9700	2.200	LNK.05
R335.18-05.00-0.37F-6N	02541849	Arbor	5.000	0.375	1.378	6	12	–	–	1.250	2.250	–	–	2.000	–	–	8400	2.200	LNK.05

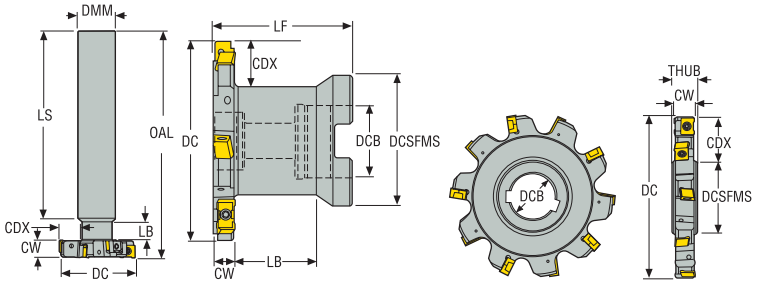
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R335 -RE- / R335.18 -0-	–	C02508-T08P	T00-08P12	1.2NM
R335.18 DCB=0.750	UC6S3/8UNFX1-3/4	C02508-T08P	T00-08P12	1.2NM
R335.18 DCB=1.000	UC6S1/2UNFX1-1/2	C02508-T08P	T00-08P12	1.2NM
R335.18 DCB=1.250	–	C02508-T08P	T00-08P12	1.2NM

Width 0.500/0,625/ 0.750” - full side - Fixed pocket

Cutter 335.18 - Insert LNK. – Inch



- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DMM	DCB	DCSFMS	OAL	THUB	LF	LS	LB	RPMX	Weight	Insert
			Inch	Inch	Inch			Inch	Inch	Inch	Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-02.00-0-0.50F-3N	02479049	Cylindrical	2.000	0.500	0.591	3	6	1.000	–	–	6.000	–	–	4.402	1.008	13400	1.540	LNK.08
R335.18-02.00-RE-0.5F-3NA	03277906	Combimaster	2.000	0.500	0.587	3	6	–	–	1.181	–	–	1.378	–	0.232	13400	0.660	LNK.08..
R335.18-02.50-0-0.50F-3N	02479056	Cylindrical	2.500	0.500	0.626	3	6	1.250	–	–	6.750	–	–	6.142	–	11900	2.870	LNK.08
R335.18-02.50-0.50F-3N	02478983	Arbor	2.500	0.500	0.598	3	6	–	0.750	1.580	–	–	2.000	–	1.024	12300	1.100	LNK.08
R335.18-03.00-0-0.50F-4N	02479063	Cylindrical	3.000	0.500	0.874	4	8	1.250	–	–	6.750	–	–	6.142	–	10500	2.870	LNK.08
R335.18-03.00-0.50F-4N	02478988	Arbor	3.000	0.500	0.713	4	8	–	1.000	1.880	–	–	2.000	–	0.961	10500	1.540	LNK.08
335.18-03.00-0.50F-4N	02478872	Arbor hole	3.000	0.500	0.709	4	8	–	1.000	1.630	–	0.625	–	–	–	10900	0.660	LNK.08
R335.18-04.00-0.50F-5N	02478994	Arbor	4.000	0.500	1.059	5	10	–	1.000	1.880	–	–	2.000	–	–	9400	2.200	LNK.08
335.18-04.00-0.50F-5N	02478880	Arbor hole	4.000	0.500	1.142	5	10	–	1.000	1.630	–	0.625	–	–	–	9400	1.320	LNK.08
R335.18-05.00-0.50F-6N	02478999	Arbor	5.000	0.500	1.378	6	12	–	1.250	2.250	–	–	2.000	–	–	8400	2.650	LNK.08
335.18-05.00-0.50F-6N	02478886	Arbor hole	5.000	0.500	1.299	6	12	–	1.500	2.252	–	0.625	–	–	–	8400	1.980	LNK.08
335.18-06.00-0.50F-7N	02478901	Arbor hole	6.000	0.500	1.811	7	14	–	1.500	2.252	–	0.625	–	–	–	7500	2.870	LNK.08
R335.18-03.00-0.62F-3N	02479006	Arbor	3.000	0.625	0.709	3	9	–	1.000	1.880	–	–	2.000	–	0.827	10500	1.540	LNK.06
R335.18-04.00-0.62F-3N	02479012	Arbor	4.000	0.625	1.059	3	9	–	1.000	1.880	–	–	2.000	–	–	9400	2.650	LNK.06
R335.18-03.00-0.75F-3N	02479024	Arbor	3.000	0.750	0.709	3	9	–	1.000	1.880	–	–	2.000	–	0.709	10500	1.760	LNK.08
R335.18-04.00-0.75F-3N	02479032	Arbor	4.000	0.750	1.059	3	9	–	1.000	1.880	–	–	2.000	–	–	9400	2.870	LNK.08
R335.18-05.00-0.75F-4N	02479041	Arbor	5.000	0.750	1.378	4	12	–	1.250	2.250	–	–	2.000	–	–	8400	3.530	LNK.08

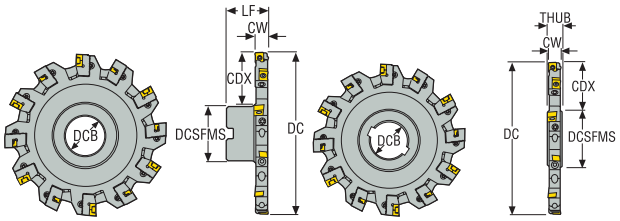
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
335.18 / R335 -RE- / R335.18 -0-	–	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=0.750	UC6S3/8UNFX1-3/4	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=1.000	UC6S1/2UNFX1-1/2	C73007-T09P	T00-09P20	2.0NM
R335.18 DCB=1.250/1.500	–	C73007-T09P	T00-09P20	2.0NM

Cutter 335.18 - Insert LNK. – Metric

Width 8-12 mm - full side - Adjustable design



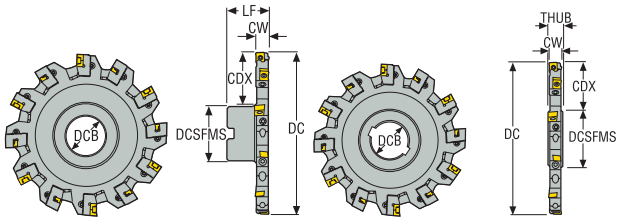
- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm	mm			mm	mm	mm	mm		kg	
R335.18-080.0810.27-3N	02611694	Arbor	80,0	8,0	10,0	14,8	3	6	27,0	48,0	–	50,0	10900	0,7	LNK.05..
R335.18-100.0810.27-4N	02576013	Arbor	100,0	8,0	10,0	24,8	4	8	27,0	48,0	–	50,0	9400	0,8	LNK.05..
335.18-100.0810.27-4N	02575751	Arbor hole	100,0	8,0	10,0	27,2	4	8	27,0	41,0	15,0	–	9400	0,4	LNK.05..
R335.18-125.0810.32-5N	02576014	Arbor	125,0	8,0	10,0	32,3	5	10	32,0	58,0	–	50,0	8400	1,0	LNK.05..
335.18-125.0810.40-5N	02575752	Arbor hole	125,0	8,0	10,0	32,7	5	10	40,0	55,0	15,0	–	8400	0,6	LNK.05..
R335.18-160.0810.40-6N	02576015	Arbor	160,0	8,0	10,0	43,8	6	12	40,0	70,0	–	50,0	7500	1,6	LNK.05..
335.18-160.0810.40-6N	02575753	Arbor hole	160,0	8,0	10,0	50,2	6	12	40,0	55,0	15,0	–	7500	1,0	LNK.05..
R335.18-200.0810XL.40-7N	02713370	Arbor	200,0	8,0	10,0	53,5	7	14	40,0	90,0	–	50,0	6700	2,6	LNK.05..
335.18-200.0810XL.50-7N	02712923	Arbor hole	200,0	8,0	10,0	63,5	7	14	50,0	69,0	15,0	–	6700	1,4	LNK.05..
R335.18-250.0810XL.40-9N	02713381	Arbor	250,0	8,0	10,0	78,0	18	18	40,0	90,0	–	50,0	6000	4,4	LNK.05..
335.18-250.0810XL.50-9N	02712939	Arbor hole	250,0	8,0	10,0	88,5	9	18	50,0	69,0	15,0	–	6000	2,3	LNK.05..
335.18-315.0810XL.50-12N	02712948	Arbor hole	315,0	8,0	10,0	121,0	12	24	50,0	69,0	15,0	–	5300	2,4	LNK.05..
R335.18-080.1012.27-3N	00018581	Arbor	80,0	10,0	12,0	14,8	3	6	27,0	48,0	–	50,0	10500	0,7	LNK.06..
R335.18-100.1012.27-4N	00018597	Arbor	100,0	10,0	12,0	24,8	4	8	27,0	48,0	–	50,0	9400	0,9	LNK.06..
335.18-100.1012.27-4N	00018408	Arbor hole	100,0	10,0	12,0	27,2	4	8	27,0	41,0	15,0	–	9400	0,4	LNK.06..
R335.18-125.1012.32-5N	00018613	Arbor	125,0	10,0	12,0	32,3	5	10	32,0	58,0	–	50,0	8400	1,1	LNK.06..
335.18-125.1012.40-5N	00018417	Arbor hole	125,0	10,0	12,0	32,7	5	10	40,0	55,0	15,0	–	8400	0,7	LNK.06..
R335.18-160.1012.40-6N	00018641	Arbor	160,0	10,0	12,0	43,8	6	12	40,0	70,0	–	50,0	7500	1,7	LNK.06..
335.18-160.1012.40-6N	00018427	Arbor hole	160,0	10,0	12,0	50,2	6	12	40,0	55,0	15,0	–	7500	1,2	LNK.06..
R335.18-200.1012XL.40-7N	02713374	Arbor	200,0	10,0	12,0	53,5	7	14	40,0	90,0	–	50,0	6700	2,1	LNK.06..
335.18-200.1012XL.50-7N	02712930	Arbor hole	200,0	10,0	12,0	63,5	7	14	50,0	69,0	15,0	–	6700	2,1	LNK.06..
R335.18-250.1012XL.40-9N	02713382	Arbor	250,0	10,0	12,0	78,0	9	18	40,0	90,0	–	50,0	6000	2,3	LNK.06..
335.18-250.1012XL.50-9N	02712940	Arbor hole	250,0	10,0	12,0	88,5	9	18	50,0	69,0	15,0	–	6000	2,8	LNK.06..
335.18-315.1012XL.50-12N	02712950	Arbor hole	315,0	10,0	12,0	121,0	12	24	50,0	69,0	15,0	–	5300	4,5	LNK.06..

Adjustable cutter may be ordered with the cutting width set to any value within its range, see techical data for more info.
All adj. cutters are set to the minimum cutter width, +/- 0,02 mm.

Width 12-15 mm - full side - Adjustable design

Cutter 335.18 - Insert LNK. – Metric



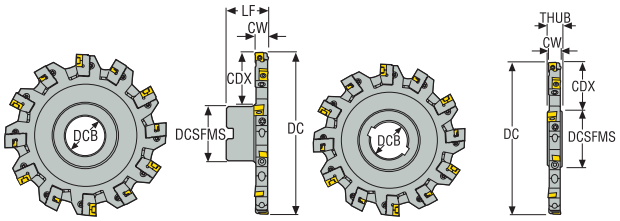
- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm	mm			mm	mm	mm	mm		kg	
R335.18-080.1215.27-3N	00018712	Arbor	80,0	12,0	15,0	14,8	3	6	27,0	48,0	–	50,0	10500	0,7	LNK.08..
R335.18-100.1215.27-4N	00018734	Arbor	100,0	12,0	15,0	24,8	4	8	27,0	48,0	–	50,0	9400	0,9	LNK.08..
335.18-100.1215.27-4N	00018513	Arbor hole	100,0	12,0	15,0	27,2	4	8	27,0	41,0	15,0	–	9400	0,6	LNK.08..
R335.18-125.1215.32-5N	00018763	Arbor	125,0	12,0	15,0	32,3	5	10	32,0	58,0	–	50,0	8400	1,2	LNK.08..
335.18-125.1215.40-5N	00018535	Arbor hole	125,0	12,0	15,0	32,7	5	10	40,0	55,0	15,0	–	8400	0,8	LNK.08..
R335.18-160.1215.40-6N	00018782	Arbor	160,0	12,0	15,0	43,8	6	12	40,0	70,0	–	50,0	7500	1,9	LNK.08..
335.18-160.1215.40-6N	00018543	Arbor hole	160,0	12,0	15,0	50,2	6	12	40,0	55,0	15,0	–	7500	1,4	LNK.08..
R335.18-200.1215XL.40-7N	02713376	Arbor	200,0	12,0	15,0	53,5	7	14	40,0	90,0	–	50,0	6700	3,1	LNK.08..
335.18-200.1215XL.50-7N	02712932	Arbor hole	200,0	12,0	15,0	63,5	7	14	50,0	69,0	15,0	–	6700	2,0	LNK.08..
R335.18-250.1215XL.40-9N	02713383	Arbor	250,0	12,0	15,0	78,0	9	18	40,0	90,0	–	50,0	6000	4,4	LNK.08..
335.18-250.1215XL.50-9N	02712941	Arbor hole	250,0	12,0	15,0	88,5	9	18	50,0	69,0	15,0	–	6000	3,3	LNK.08..
335.18-315.1215XL.50-12N	02712951	Arbor hole	315,0	12,0	15,0	121,0	12	24	50,0	69,0	15,0	–	5300	5,5	LNK.08..

Adjustable cutter may be ordered with the cutting width set to any value within its range, see techical data for more info.
All adj. cutters are set to the minimum cutter width, +/- 0,02 mm.

Cutter 335.18 - Insert LNK. – Inch

Width 0.313-0.591” - full side - Adjustable design



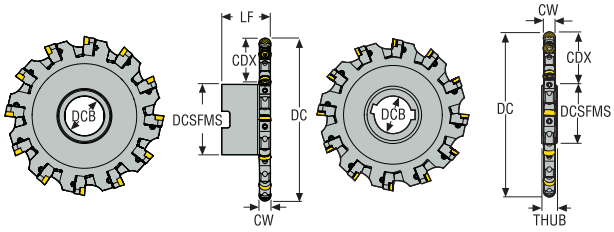
- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	LB	RPMX	Weight	Insert
			Inch	Inch	Inch	Inch			Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-04.00-0506N	02834763	Arbor	4.000	0.313	0.394	1.024	4	8	1.000	1.880	–	2.000	–	9400	1.760	LNK.05
335.18-04.00-0506N	02834805	Arbor hole	4.000	0.313	0.394	1.102	4	8	1.000	1.551	0.625	–	–	9400	0.880	LNK.05
R335.18-05.00-0506N	02834764	Arbor	5.000	0.313	0.394	1.339	5	10	1.250	2.250	–	2.000	–	8400	2.650	LNK.05
335.18-05.00-0506N	02834810	Arbor hole	5.000	0.313	0.394	1.299	5	10	1.500	2.252	0.625	–	–	8400	1.320	LNK.05
R335.18-06.00-0506N	02834765	Arbor	6.000	0.313	0.394	1.575	6	12	1.500	2.750	–	2.000	–	7500	3.310	LNK.05
335.18-06.00-0506N	02834762	Arbor hole	6.000	0.313	0.394	1.772	6	12	1.500	2.252	0.625	–	–	7500	1.980	LNK.05
R335.18-08.00-XL0506N	02740895	Arbor	8.000	0.313	0.394	2.224	7	14	1.500	3.500	–	2.000	–	6700	6.170	LNK.05
335.18-08.00-XL0506N	02740202	Arbor hole	8.000	0.313	0.394	2.421	7	14	2.000	3.000	0.625	–	–	6700	3.310	LNK.05
R335.18-10.00-XL0506N	02741525	Arbor	10.000	0.313	0.394	3.209	9	18	1.500	3.500	–	2.000	–	6000	17.640	LNK.05
335.18-10.00-XL0506N	02740460	Arbor hole	10.000	0.313	0.394	3.386	9	18	2.000	3.000	0.625	–	–	6000	5.510	LNK.05
335.18-12.00-XL0506N	02740860	Arbor hole	12.000	0.313	0.394	4.390	11	22	2.000	3.000	0.625	–	–	5300	7.940	LNK.05
R335.18-04.00-0708N	00079782	Arbor	4.000	0.394	0.472	1.014	4	8	1.000	1.880	–	2.000	–	9400	2.200	LNK.06
R335.18-05.00-0708N	00079783	Arbor	5.000	0.394	0.472	1.329	5	10	1.250	2.250	–	2.000	–	8400	3.090	LNK.06
335.18-05.00-0708N	00079701	Arbor hole	5.000	0.394	0.472	1.258	5	10	1.500	2.252	0.625	–	–	8400	1.760	LNK.06
R335.18-06.00-0708N	00079784	Arbor	6.000	0.394	0.472	1.534	6	12	1.500	2.750	–	2.000	–	7500	3.750	LNK.06
335.18-06.00-0708N	00079702	Arbor hole	6.000	0.394	0.472	1.766	6	12	1.500	2.252	0.625	–	–	7500	2.430	LNK.06
R335.18-08.00-XL0708N	02740896	Arbor	8.000	0.394	0.472	2.224	7	14	1.500	3.500	–	2.000	–	6700	6.830	LNK.06
335.18-08.00-XL0708N	02740235	Arbor hole	8.000	0.394	0.472	2.421	7	14	2.000	3.000	0.625	–	–	6700	3.970	LNK.06
R335.18-10.00-XL0708N	02741541	Arbor	10.000	0.394	0.472	3.209	9	18	1.500	3.500	–	2.000	–	6000	18.960	LNK.06
335.18-10.00-XL0708N	02740497	Arbor hole	10.000	0.394	0.472	3.386	9	18	2.000	3.000	0.625	–	–	6000	9.260	LNK.06
335.18-12.00-XL0708N	02740866	Arbor hole	12.000	0.394	0.472	4.390	11	22	2.000	3.000	0.625	–	–	5300	9.700	LNK.06
R335.18-04.00-0809N	00079963	Arbor	4.000	0.472	0.591	1.014	4	8	1.000	1.880	–	2.000	–	9400	2.430	LNK.08
R335.18-05.00-0809N	00079964	Arbor	5.000	0.472	0.591	1.329	5	10	1.250	2.250	–	2.000	–	8400	3.530	LNK.08
335.18-05.00-0809N	00079932	Arbor hole	5.000	0.472	0.591	1.285	5	10	1.500	2.252	0.625	–	–	8400	1.980	LNK.08
R335.18-06.00-0809N	00079965	Arbor	6.000	0.472	0.591	1.585	6	12	1.500	2.750	–	2.000	–	7500	4.190	LNK.08
335.18-06.00-0809N	00079933	Arbor hole	6.000	0.472	0.591	1.790	6	12	1.500	2.252	0.625	–	–	7500	2.870	LNK.08
R335.18-08.00-XL0809N	02740897	Arbor	8.000	0.472	0.591	2.224	7	14	1.500	3.500	–	2.000	–	6700	8.600	LNK.08
335.18-08.00-XL0809N	02740236	Arbor hole	8.000	0.472	0.591	2.421	7	14	2.000	3.000	0.625	–	–	6700	7.280	LNK.08
R335.18-10.00-XL0809N	02741544	Arbor	10.000	0.472	0.591	3.209	9	18	1.500	3.500	–	2.000	–	6000	10.800	LNK.08
335.18-10.00-XL0809N	02740498	Arbor hole	10.000	0.472	0.591	3.386	9	18	2.000	3.000	0.625	–	–	6000	7.940	LNK.08
335.18-12.00-XL0809N	02740867	Arbor hole	12.000	0.472	0.591	4.390	11	22	2.000	3.000	0.625	–	–	5300	11.900	LNK.08

Adjustable cutter may be ordered with the cutting width set to any value within its range, see techical data for more info.
All adj. cutters are set to the minimum cutter width, +/- 0,02 mm.

Width 8-12 mm - full side - radius profile - Adjustable design

Cutter 335.18 - Insert RD..08/RD..10T3 – Metric

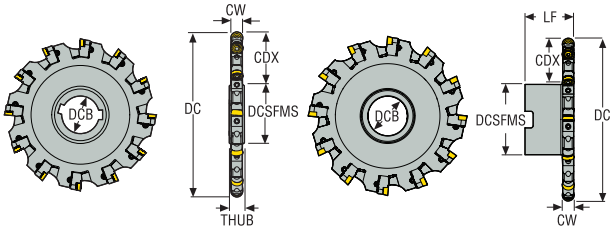


- For insert selection and cutting data recommendations, see page(s) 439-440, 442-444
- For complete insert programme, see page(s) 746
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm	mm		mm	mm	mm	mm		kg	
R335.18-080.0810.27-6N-R4	02611700	Arbor	82,0	8,0	10,0	15,8	6	27,0	48,0	–	50,0	10500	0,7	RD..08..
R335.18-100.0810.27-8N-R4	02576017	Arbor	102,0	8,0	10,0	25,8	8	27,0	48,0	–	50,0	9400	0,8	RD..08..
335.18-100.0810.27-8N-R4	02575800	Arbor hole	102,0	8,0	10,0	28,2	8	27,0	41,0	15,0	–	9400	0,4	RD..08..
R335.18-125.0810.32-10N-R4	02576018	Arbor	127,0	8,0	10,0	32,3	10	32,0	58,0	–	50,0	8400	1,0	RD..08..
335.18-125.0810.40-10N-R4	02575801	Arbor hole	127,0	8,0	10,0	33,7	10	40,0	55,0	15,0	–	8400	0,6	RD..08..
R335.18-160.0810.40-12N-R4	02576020	Arbor	162,0	8,0	10,0	44,8	12	40,0	70,0	–	50,0	7500	1,6	RD..08..
335.18-160.0810.40-12N-R4	02575802	Arbor hole	162,0	8,0	10,0	51,2	12	40,0	55,0	15,0	–	7500	1,0	RD..08..
R335.18-200.0810XL.40-14N-R4	02713377	Arbor	200,0	8,0	10,0	53,5	14	40,0	90,0	–	50,0	6700	2,6	RD..08..
335.18-200.0810XL.50-14N-R4	02712934	Arbor hole	200,0	8,0	10,0	63,5	14	50,0	69,0	15,0	–	6700	1,4	RD..08..
R335.18-250.0810XL.40-18N-R4	02713384	Arbor	250,0	8,0	10,0	78,0	18	40,0	90,0	–	50,0	6000	3,5	RD..08..
335.18-250.0810XL.50-18N-R4	02712943	Arbor hole	250,0	8,0	10,0	88,5	18	50,0	69,0	15,0	–	6000	2,3	RD..08..
335.18-315.0810XL.50-24N-R4	02712952	Arbor hole	315,0	8,0	10,0	121,0	24	50,0	69,0	15,0	–	5300	3,7	RD..08..
R335.18-080.1012.27-3N-R5	00030352	Arbor	82,0	10,0	12,0	15,8	3	27,0	48,0	–	50,0	10500	0,7	RD..10T3
R335.18-100.1012.27-4N-R5	00030355	Arbor	102,0	10,0	12,0	25,8	4	27,0	48,0	–	50,0	9400	0,9	RD..10T3
335.18-100.1012.27-4N-R5	00030328	Arbor hole	102,0	10,0	12,0	28,2	4	27,0	41,0	15,0	–	9400	0,6	RD..10T3
R335.18-125.1012.32-5N-R5	00030359	Arbor	127,0	10,0	12,0	33,3	5	32,0	58,0	–	50,0	8400	1,1	RD..10T3
335.18-125.1012.40-5N-R5	00030340	Arbor hole	127,0	10,0	12,0	33,7	5	40,0	55,0	15,0	–	8400	0,7	RD..10T3
R335.18-160.1012.40-6N-R5	00030362	Arbor	162,0	10,0	12,0	44,8	6	40,0	70,0	–	50,0	7500	1,7	RD..10T3
335.18-160.1012.40-6N-R5	00030343	Arbor hole	162,0	10,0	12,0	51,2	6	40,0	55,0	15,0	–	7500	1,3	RD..10T3
R335.18-200.1012XL.40-7N-R5	02713379	Arbor	200,0	10,0	12,0	53,5	7	40,0	90,0	–	50,0	6700	2,2	RD..10T3
335.18-200.1012XL.50-7N-R5	02712935	Arbor hole	200,0	10,0	12,0	63,5	7	50,0	69,0	15,0	–	6700	1,7	RD..10T3
R335.18-250.1012XL.40-9N-R5	02713386	Arbor	250,0	10,0	12,0	78,0	9	40,0	90,0	–	50,0	6000	4,0	RD..10T3
335.18-250.1012XL.50-9N-R5	02712946	Arbor hole	250,0	10,0	12,0	88,5	9	50,0	69,0	15,0	–	6000	1,7	RD..10T3
335.18-315.1012XL.50-12N-R5	02712954	Arbor hole	315,0	10,0	12,0	121,0	12	50,0	69,0	15,0	–	5300	4,6	RD..10T3

Cutter 335.18 - Insert RP..1204 – Metric

Width 12-15 mm - full side - radius profile - Adjustable design



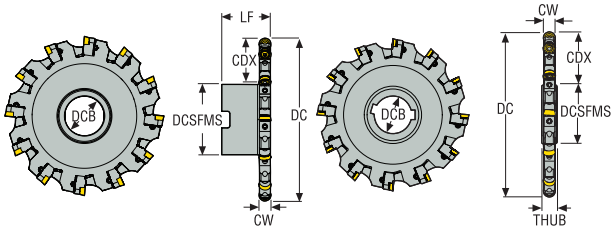
- For insert selection and cutting data recommendations, see page(s) 445-447
- For complete insert programme, see page(s) 749
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm	mm		mm	mm	mm	mm		kg	
R335.18-080.1215.27-3N-R6	00030404	Arbor	82,0	12,0	15,0	15,8	3	27,0	48,0	–	50,0	10000	0,7	RP..1204
R335.18-100.1215.27-4N-R6	00030412	Arbor	102,0	12,0	15,0	25,8	4	27,0	48,0	–	50,0	9400	0,9	RP..1204
335.18-100.1215.27-4N-R6	00030370	Arbor hole	102,0	12,0	15,0	28,2	4	27,0	41,0	15,0	–	9400	0,8	RP..1204
R335.18-125.1215.32-5N-R6	00030417	Arbor	127,0	12,0	15,0	33,3	5	32,0	58,0	–	50,0	8400	1,2	RP..1204
335.18-125.1215.40-5N-R6	00030374	Arbor hole	127,0	12,0	15,0	33,7	5	40,0	55,0	15,0	–	8400	0,9	RP..1204
R335.18-160.1215.40-6N-R6	00030420	Arbor	162,0	12,0	15,0	44,8	6	40,0	70,0	–	50,0	7500	1,9	RP..1204
335.18-160.1215.40-6N-R6	00030377	Arbor hole	162,0	12,0	15,0	51,2	6	40,0	55,0	15,0	–	7500	1,5	RP..1204
R335.18-200.1215XL.40-7N-R6	02713380	Arbor	200,0	12,0	15,0	53,5	7	40,0	90,0	–	50,0	6700	3,2	RP..1204
335.18-200.1215XL.50-7N-R6	02712937	Arbor hole	200,0	12,0	15,0	63,5	7	50,0	69,0	15,0	–	6700	2,0	RP..1204
R335.18-250.1215XL.40-9N-R6	02713387	Arbor	250,0	12,0	15,0	78,0	9	40,0	90,0	–	50,0	6000	4,5	RP..1204
335.18-250.1215XL.50-9N-R6	02712947	Arbor hole	250,0	12,0	15,0	88,5	9	50,0	69,0	15,0	–	6000	3,4	RP..1204
335.18-315.1215XL.50-12N-R6	02712955	Arbor hole	315,0	12,0	15,0	121,0	12	50,0	69,0	15,0	–	5300	5,5	RP..1204

Adjustable cutter may be ordered with the cutting width set to any value within its range, see techical data for more info.
All adj. cutters are set to the minimum cutter width, +/- 0,02 mm.

Width 0.315-0.472” - full side - radius profile - Adjustable design

Cutter 335.18 - Insert RD..08/RP..12 – Inch



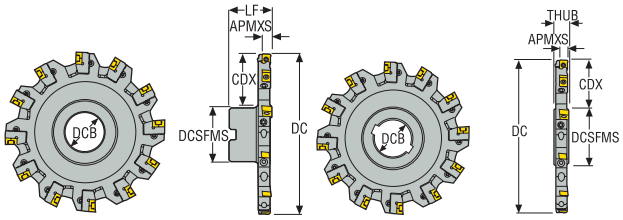
- For insert selection and cutting data recommendations, see page(s) 439-444
- For complete insert programme, see page(s) 746
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs	
R335.18-04.00-0506N-R4	02834713	Arbor	4.079	0.315	0.394	1.063	4	1.000	1.880	–	2.000	9400	1.760	RD..08
335.18-04.00-0506N-R4	02834707	Arbor hole	4.079	0.315	0.394	1.142	4	1.000	1.551	0.625	–	9400	0.880	RD..08
R335.18-05.00-0506N-R4	02834714	Arbor	5.079	0.315	0.394	1.378	5	1.250	2.250	–	2.000	8400	2.650	RD..08
335.18-05.00-0506N-R4	02834708	Arbor hole	5.079	0.315	0.394	1.299	5	1.500	2.252	0.625	–	8400	1.320	RD..08
R335.18-06.00-0506N-R4	02834715	Arbor	6.079	0.315	0.394	1.614	6	1.500	2.750	–	2.000	7500	3.310	RD..08
335.18-06.00-0506N-R4	02834709	Arbor hole	6.079	0.315	0.394	1.772	6	1.500	2.252	0.625	–	7500	1.980	RD..08
R335.18-08.00-XL0506N-R4	02740898	Arbor	8.000	0.315	0.394	2.224	7	1.500	3.500	–	2.000	6700	6.170	RD..08
335.18-08.00-XL0506N-R4	02740237	Arbor hole	8.000	0.315	0.394	2.421	14	2.000	3.000	0.625	–	6700	3.310	RD..08
R335.18-10.00-XL0506N-R4	02741547	Arbor	10.000	0.315	0.394	3.209	9	1.500	3.500	–	2.000	6000	8.160	RD..08
335.18-10.00-XL0506N-R4	02740500	Arbor hole	10.000	0.315	0.394	3.386	9	2.000	3.000	0.625	–	6000	5.510	RD..08
335.18-12.00-XL0506N-R4	02740869	Arbor hole	12.000	0.315	0.394	4.390	11	2.000	3.000	0.625	–	5300	7.940	RD..08
R335.18-04.00-0708N-R5	00079997	Arbor	4.079	0.394	0.472	1.063	4	1.000	1.880	–	2.000	9400	2.650	RD..10
R335.18-05.00-0708N-R5	00079998	Arbor	5.079	0.394	0.472	1.378	5	1.250	2.250	–	2.000	8400	3.090	RD..10
335.18-05.00-0708N-R5	00079978	Arbor hole	5.079	0.394	0.472	1.295	5	1.500	2.252	0.625	–	8400	1.760	RD..10
R335.18-06.00-0708N-R5	00079999	Arbor	6.079	0.394	0.472	1.614	6	1.500	2.750	–	2.000	7500	3.750	RD..10
335.18-06.00-0708N-R5	00079979	Arbor hole	6.079	0.394	0.472	1.811	6	1.500	2.252	0.625	–	7500	2.430	RD..10
R335.18-08.00-XL0708N-R5	02740899	Arbor	8.000	0.394	0.472	2.224	7	1.500	3.500	–	2.000	6700	6.830	RD..10
335.18-08.00-XL0708N-R5	02740238	Arbor hole	8.000	0.394	0.472	2.421	7	2.000	3.000	0.625	–	6700	3.970	RD..10
R335.18-10.00-XL0708N-R5	02741551	Arbor	10.000	0.394	0.472	3.209	9	1.500	3.500	–	2.000	6000	9.260	RD..10
335.18-10.00-XL0708N-R5	02740502	Arbor hole	10.000	0.394	0.472	3.386	9	2.000	3.000	0.625	–	6000	6.610	RD..10
335.18-12.00-XL0708N-R5	02740870	Arbor hole	12.000	0.394	0.472	4.390	11	2.000	3.000	0.625	–	5300	9.700	RD..10
R335.18-04.00-0809N-R6	00080158	Arbor	4.079	0.472	0.591	1.053	4	1.000	1.880	–	2.000	9400	2.430	RP..12
R335.18-05.00-0809N-R6	00080160	Arbor	5.079	0.472	0.591	1.368	5	1.250	2.250	–	2.000	8400	3.530	RP..12
335.18-05.00-0809N-R6	00080035	Arbor hole	5.079	0.472	0.591	1.339	5	1.500	2.252	0.625	–	8400	1.980	RP..12
R335.18-06.00-0809N-R6	00080181	Arbor	6.079	0.472	0.591	1.624	6	1.500	2.750	–	2.000	7500	5.070	RP..12
335.18-06.00-0809N-R6	00080045	Arbor hole	6.079	0.472	0.591	1.829	6	1.500	2.252	0.625	–	7500	2.870	RP..12
R335.18-08.00-XL0809N-R6	02740900	Arbor	8.000	0.472	0.591	2.224	7	1.500	3.500	–	2.000	6700	7.720	RP..12
335.18-08.00-XL0809N-R6	02740240	Arbor hole	8.000	0.472	0.591	2.421	7	2.000	3.000	0.625	–	6700	4.850	RP..12
R335.18-10.00-XL0809N-R6	02741552	Arbor	10.000	0.472	0.591	3.209	9	1.500	3.500	–	2.000	6000	10.800	RP..12
335.18-10.00-XL0809N-R6	02740503	Arbor hole	10.000	0.472	0.591	3.386	9	2.000	3.000	0.625	–	6000	7.940	RP..12
335.18-12.00-XL0809N-R6	02740872	Arbor hole	12.000	0.472	0.591	4.390	11	2.000	3.000	0.625	–	5300	15.430	RP..12

Adjustable cutter may be ordered with the cutting width set to any value within its range, see techical data for more info.
All adj. cutters are set to the minimum cutter width, +/- 0,02 mm.

Cutter 335.18 - Insert LNK. – Metric

Width max 5-6 mm - Half side - Right hand with cassette

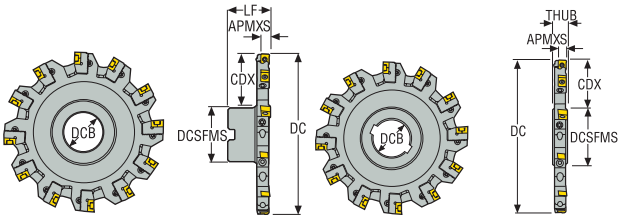


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm	mm		kg	
R335.18-080.0810.27-6R	02611697	Arbor	80,0	5,0	14,8	6	48,0	27,0	48,0	–	50,0	10500	0,7	LNK.05..
R335.18-100.0810.27-8R	02576023	Arbor	100,0	5,0	24,8	8	48,0	27,0	48,0	–	50,0	9400	0,8	LNK.05..
335.18-100.0810.27-8R	02575757	Arbor hole	100,0	5,0	27,2	8	41,0	27,0	41,0	15,0	–	9400	0,4	LNK.05..
R335.18-125.0810.32-10R	02576025	Arbor	125,0	5,0	32,3	10	58,0	32,0	58,0	–	50,0	8400	1,0	LNK.05..
335.18-125.0810.40-10R	02575758	Arbor hole	125,0	5,0	32,7	10	55,0	40,0	55,0	15,0	–	8400	0,6	LNK.05..
R335.18-160.0810.40-12R	02576026	Arbor	160,0	5,0	43,8	12	70,0	40,0	70,0	–	50,0	7500	1,5	LNK.05..
335.18-160.0810.40-12R	02575759	Arbor hole	160,0	5,0	50,2	12	55,0	40,0	55,0	15,0	–	7500	1,0	LNK.05..
R335.18-200.0810XL.40-14R	02713422	Arbor	200,0	5,0	53,5	14	90,0	40,0	90,0	–	50,0	6700	2,6	LNK.05..
335.18-200.0810XL.50-14R	02713151	Arbor hole	200,0	5,0	63,5	14	69,0	50,0	69,0	15,0	–	6700	1,7	LNK.05..
R335.18-250.0810XL.40-18R	02713432	Arbor	250,0	5,0	78,0	18	90,0	40,0	90,0	–	50,0	6000	3,1	LNK.05..
335.18-250.0810XL.50-18R	02713163	Arbor hole	250,0	5,0	88,5	18	69,0	50,0	69,0	15,0	–	6000	1,7	LNK.05..
335.18-315.0810XL.50-24R	02713172	Arbor hole	315,0	5,0	121,0	24	69,0	50,0	69,0	15,0	–	5300	1,9	LNK.05..
R335.18-080.1012.27-6R	00018584	Arbor	80,0	6,0	14,8	6	48,0	27,0	48,0	–	50,0	10500	0,8	LNK.06..
R335.18-100.1012.27-8R	00018603	Arbor	100,0	6,0	24,8	8	48,0	27,0	48,0	–	50,0	9400	1,2	LNK.06..
335.18-100.1012.27-8R	00018409	Arbor hole	100,0	6,0	27,2	8	41,0	27,0	41,0	15,0	–	9400	0,4	LNK.06..
R335.18-125.1012.32-10R	00018618	Arbor	125,0	6,0	32,3	10	58,0	32,0	58,0	–	50,0	8400	1,0	LNK.06..
335.18-125.1012.40-10R	00018421	Arbor hole	125,0	6,0	32,7	10	55,0	40,0	55,0	15,0	–	8400	0,7	LNK.06..
R335.18-160.1012.40-12R	00018674	Arbor	160,0	6,0	43,8	12	70,0	40,0	70,0	–	50,0	7500	1,9	LNK.06..
335.18-160.1012.40-12R	00018431	Arbor hole	160,0	6,0	50,2	12	55,0	40,0	55,0	15,0	–	7500	1,5	LNK.06..
R335.18-200.1012XL.40-14R	02713423	Arbor	200,0	6,0	53,5	14	90,0	40,0	90,0	–	50,0	6700	2,9	LNK.06..
335.18-200.1012XL.50-14R	02713154	Arbor hole	200,0	6,0	63,5	14	69,0	50,0	69,0	15,0	–	6700	1,7	LNK.06..
R335.18-250.1012XL.40-18R	02713435	Arbor	250,0	6,0	78,0	18	90,0	40,0	90,0	–	50,0	6000	4,0	LNK.06..
335.18-250.1012XL.50-18R	02713165	Arbor hole	250,0	6,0	88,5	18	69,0	50,0	69,0	15,0	–	6000	2,8	LNK.06..
335.18-315.1012XL.50-24R	02713177	Arbor hole	315,0	6,0	121,0	24	69,0	50,0	69,0	15,0	–	5300	1,9	LNK.06..

Width max 7,5 mm - Half side - Right hand with cassette

Cutter 335.18 - Insert LNK. – Metric

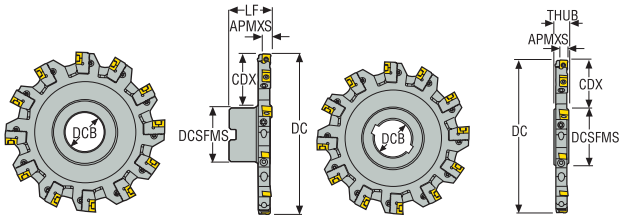


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm	mm		kg	
R335.18-080.1215.27-6R	00018723	Arbor	80,0	7,5	14,8	6	48,0	27,0	48,0	–	50,0	10500	1,1	LNK.08..
R335.18-100.1215.27-8R	00018754	Arbor	100,0	7,5	24,8	8	48,0	27,0	48,0	–	50,0	9400	0,9	LNK.08..
335.18-100.1215.27-8R	00018515	Arbor hole	100,0	7,5	27,2	8	41,0	27,0	41,0	15,0	–	9400	0,5	LNK.08..
R335.18-125.1215.32-10R	00018766	Arbor	125,0	7,5	32,3	10	58,0	32,0	58,0	–	50,0	8400	1,2	LNK.08..
335.18-125.1215.40-10R	00018540	Arbor hole	125,0	7,5	32,7	10	55,0	40,0	55,0	15,0	–	8400	0,9	LNK.08..
R335.18-160.1215.40-12R	00018784	Arbor	160,0	7,5	43,8	12	70,0	40,0	70,0	–	50,0	7500	2,7	LNK.08..
335.18-160.1215.40-12R	00018546	Arbor hole	160,0	7,5	50,2	12	55,0	40,0	55,0	15,0	–	7500	1,5	LNK.08..
R335.18-200.1215XL.40-14R	02713424	Arbor	200,0	7,5	53,5	14	90,0	40,0	90,0	–	50,0	6700	3,6	LNK.08..
335.18-200.1215XL.50-14R	02713155	Arbor hole	200,0	7,5	63,5	14	69,0	50,0	69,0	15,0	–	6700	1,7	LNK.08..
R335.18-250.1215XL.40-18R	02713437	Arbor	250,0	7,5	78,0	18	90,0	40,0	90,0	–	50,0	6000	4,5	LNK.08..
335.18-250.1215XL.50-18R	02713166	Arbor hole	250,0	7,5	88,5	18	69,0	50,0	69,0	15,0	–	6000	2,5	LNK.08..
335.18-315.1215XL.50-24R	02713178	Arbor hole	315,0	7,5	121,0	24	69,0	50,0	69,0	15,0	–	5300	2,2	LNK.08..

Cutter 335.18 - Insert LNK. – Inch

Width max 0.197-0.236” - Half side - Right hand with cassette

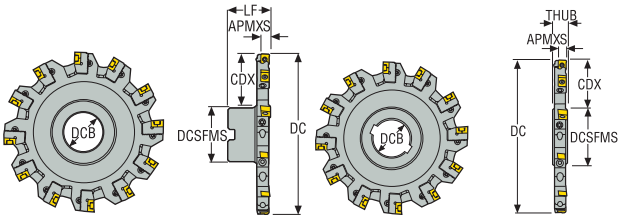


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMX	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-04.00-0506R	02834790	Arbor	4.000	0.197	1.024	8	1.880	1.000	1.880	–	2.000	9400	1.760	LNK.05
335.18-04.00-0506R	02834787	Arbor hole	4.000	0.197	1.102	8	1.550	1.000	1.550	0.625	–	9400	0.880	LNK.05
R335.18-05.00-0506R	02834791	Arbor	5.000	0.197	1.339	10	2.250	1.250	2.250	–	2.000	8400	2.650	LNK.05
335.18-05.00-0506R	02834788	Arbor hole	5.000	0.197	1.299	10	2.252	1.500	2.252	0.625	–	8400	1.320	LNK.05
R335.18-06.00-0506R	02834792	Arbor	6.000	0.197	1.575	12	2.750	1.500	2.750	–	2.000	7500	3.310	LNK.05
335.18-06.00-0506R	02834789	Arbor hole	6.000	0.197	1.772	12	2.252	1.500	2.252	0.625	–	7500	1.980	LNK.05
R335.18-08.00-XL0506R	02740901	Arbor	8.000	0.197	2.224	14	3.500	1.500	3.500	–	2.000	6700	6.170	LNK.05
335.18-08.00-XL0506R	02740241	Arbor hole	8.000	0.197	2.421	14	3.000	2.000	3.000	0.625	–	6700	3.310	LNK.05
R335.18-10.00-XL0506R	02741554	Arbor	10.000	0.197	3.209	18	3.500	1.500	3.500	–	2.000	6000	8.160	LNK.05
335.18-10.00-XL0506R	02740505	Arbor hole	10.000	0.197	3.386	18	3.000	2.000	3.000	0.625	–	6000	5.510	LNK.05
335.18-12.00-XL0506R	02740874	Arbor hole	12.000	0.197	4.390	22	3.000	2.000	3.000	0.625	–	5300	7.940	LNK.05
R335.18-04.00-0708R	00079792	Arbor	4.000	0.236	1.014	8	1.880	1.000	1.880	–	2.000	9400	2.200	LNK.06
R335.18-05.00-0708R	00079832	Arbor	5.000	0.236	1.329	10	2.250	1.250	2.250	–	2.000	8400	3.090	LNK.06
335.18-05.00-0708R	00079766	Arbor hole	5.000	0.236	1.258	10	2.252	1.500	2.252	0.625	–	8400	1.760	LNK.06
R335.18-06.00-0708R	00079833	Arbor	6.000	0.236	1.534	12	2.750	1.500	2.750	–	2.000	7500	3.750	LNK.06
335.18-06.00-0708R	00079767	Arbor hole	6.000	0.236	1.766	12	2.252	1.500	2.252	0.625	–	7500	2.430	LNK.06
R335.18-08.00-XL0708R	02740902	Arbor	8.000	0.236	2.224	14	3.500	1.500	3.500	–	2.000	6700	6.830	LNK.06
335.18-08.00-XL0708R	02740242	Arbor hole	8.000	0.236	2.421	14	3.000	2.000	3.000	0.625	–	6700	3.970	LNK.06
R335.18-10.00-XL0708R	02741556	Arbor	10.000	0.236	3.209	18	3.500	1.500	3.500	–	2.000	6000	9.260	LNK.06
335.18-10.00-XL0708R	02740506	Arbor hole	10.000	0.236	3.386	18	3.000	2.000	3.000	0.625	–	6000	6.610	LNK.06
335.18-12.00-XL0708R	02740875	Arbor hole	12.000	0.236	4.390	22	3.000	2.000	3.000	0.625	–	5300	9.700	LNK.06

Width max 0.295” - Half side - Right hand with cassette

Cutter 335.18 - Insert LNK. – Inch

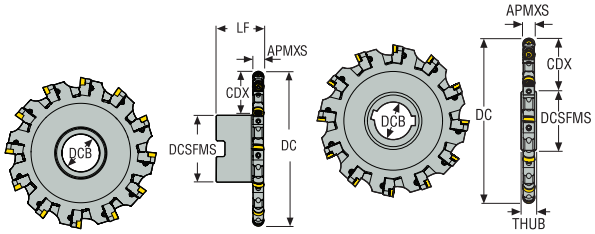


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMX	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-04.00-0809R	00079968	Arbor	4.000	0.295	1.014	8	1.880	1.000	1.880	–	2.000	9400	2.430	LNK.08
R335.18-05.00-0809R	00079969	Arbor	5.000	0.295	1.329	10	2.250	1.250	2.250	–	2.000	8400	3.530	LNK.08
335.18-05.00-0809R	00079951	Arbor hole	5.000	0.295	1.285	10	2.252	1.500	2.252	0.625	–	8400	1.980	LNK.08
R335.18-06.00-0809R	00079970	Arbor	6.000	0.295	1.585	12	2.750	1.500	2.750	–	2.000	7500	4.190	LNK.08
335.18-06.00-0809R	00079952	Arbor hole	6.000	0.295	1.790	12	2.252	1.500	2.252	0.625	–	7500	2.870	LNK.08
R335.18-08.00-XL0809R	02740903	Arbor	8.000	0.295	2.224	14	3.500	1.500	3.500	–	2.000	6700	7.720	LNK.08
335.18-08.00-XL0809R	02740244	Arbor hole	8.000	0.295	2.421	14	3.000	2.000	3.000	0.625	–	6700	4.850	LNK.08
R335.18-10.00-XL0809R	02741557	Arbor	10.000	0.295	3.209	18	3.500	1.500	3.500	–	2.000	6000	10.800	LNK.08
335.18-10.00-XL0809R	02740507	Arbor hole	10.000	0.295	3.386	18	3.000	2.000	3.000	0.625	–	6000	7.940	LNK.08
335.18-12.00-XL0809R	02740876	Arbor hole	12.000	0.295	4.390	22	3.000	2.000	3.000	0.625	–	5300	11.900	LNK.08

Cutter 335.18 - Insert RD..10T3/RP..1204 – Metric

Half side - Right hand - Radius profile with cassette

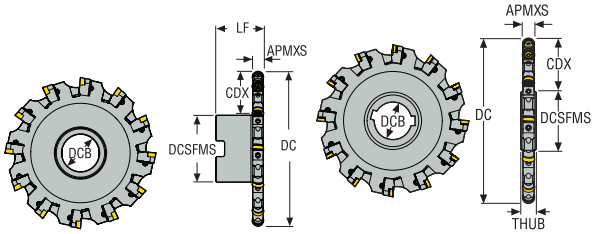


- For insert selection and cutting data recommendations, see page(s) 442-447
- For complete insert programme, see page(s) 746, 749
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm		kg	
R335.18-080.1012.27-6R-R5	00030353	Arbor	82,0	5,0	15,8	6	27,0	48,0	–	50,0	10500	0,8	RD..10T3
R335.18-100.1012.27-8R-R5	00030357	Arbor	102,0	5,0	25,8	8	27,0	48,0	–	50,0	9400	1,0	RD..10T3
335.18-100.1012.27-8R-R5	00030329	Arbor hole	102,0	5,0	28,2	8	27,0	41,0	15,0	–	9400	0,4	RD..10T3
R335.18-125.1012.32-10R-R5	00030360	Arbor	127,0	5,0	33,3	10	32,0	58,0	–	50,0	8400	1,2	RD..10T3
335.18-125.1012.40-10R-R5	00030341	Arbor hole	127,0	5,0	33,7	10	40,0	55,0	15,0	–	8400	0,7	RD..10T3
R335.18-160.1012.40-12R-R5	00030364	Arbor	162,0	5,0	44,8	12	40,0	70,0	–	50,0	7500	0,1	RD..10T3
335.18-160.1012.40-12R-R5	00030344	Arbor hole	162,0	5,0	51,2	12	40,0	55,0	15,0	–	7500	1,5	RD..10T3
R335.18-200.1012XL.40-14R-R5	02713429	Arbor	200,0	5,0	53,5	14	40,0	90,0	–	50,0	6700	2,9	RD..10T3
335.18-200.1012XL.50-14R-R5	02713159	Arbor hole	200,0	5,0	63,5	14	50,0	69,0	15,0	–	6700	1,7	RD..10T3
R335.18-250.1012XL.40-18R-R5	02713438	Arbor	250,0	5,0	78,0	18	40,0	90,0	–	50,0	6000	4,0	RD..10T3
335.18-250.1012XL.50-18R-R5	02713169	Arbor hole	250,0	5,0	88,5	18	50,0	69,0	15,0	–	6000	3,8	RD..10T3
335.18-315.1012XL.50-24R-R5	02713180	Arbor hole	315,0	5,0	121,0	24	50,0	69,0	15,0	–	5300	4,6	RD..10T3
R335.18-080.1215.27-6R-R6	00030407	Arbor	82,0	6,0	14,8	6	27,0	48,0	–	50,0	10500	0,7	RP..1204
R335.18-100.1215.27-8R-R6	00030414	Arbor	102,0	6,0	25,8	8	27,0	48,0	–	50,0	9400	1,1	RP..1204
335.18-100.1215.27-8R-R6	00030372	Arbor hole	102,0	6,0	28,2	8	27,0	41,0	15,0	–	9400	0,7	RP..1204
R335.18-125.1215.32-10R-R6	00030418	Arbor	127,0	6,0	33,3	10	32,0	58,0	–	50,0	8400	1,4	RP..1204
335.18-125.1215.40-10R-R6	00030375	Arbor hole	127,0	6,0	33,7	10	40,0	55,0	15,0	–	8400	0,9	RP..1204
R335.18-160.1215.40-12R-R6	00030421	Arbor	162,0	6,0	44,8	12	40,0	70,0	–	50,0	7500	1,9	RP..1204
335.18-160.1215.40-12R-R6	00030378	Arbor hole	162,0	6,0	51,2	12	40,0	55,0	15,0	–	7500	1,5	RP..1204
R335.18-200.1215XL.40-14R-R6	02713431	Arbor	200,0	6,0	53,5	14	40,0	90,0	–	50,0	6700	4,3	RP..1204
335.18-200.1215XL.50-14R-R6	02713162	Arbor hole	200,0	6,0	63,5	14	50,0	69,0	15,0	–	6700	2,0	RP..1204
R335.18-250.1215XL.40-18R-R6	02713441	Arbor	250,0	6,0	78,0	18	40,0	90,0	–	50,0	6000	4,5	RP..1204
335.18-250.1215XL.50-18R-R6	02713170	Arbor hole	250,0	6,0	88,5	18	50,0	69,0	15,0	–	6000	2,0	RP..1204
335.18-315.1215XL.50-24R-R6	02713182	Arbor hole	315,0	6,0	121,0	24	50,0	69,0	15,0	–	5300	5,7	RP..1204

Half side - Right hand - Radius profile with cassette

Cutter 335.18 - Insert RD..10T3/RP..1204 – Inch

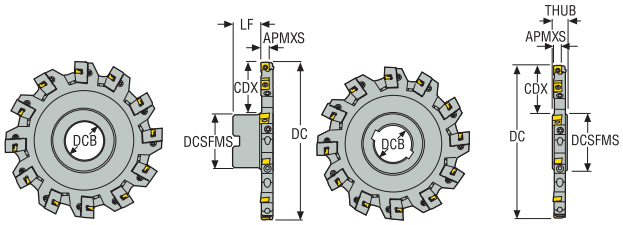


- For insert selection and cutting data recommendations, see page(s) 442-447
- For complete insert programme, see page(s) 746, 749
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs	
R335.18-08.00-XL0708R-R5	02740905	Arbor	8.000	0.197	2.264	14	1.500	3.500	–	2.000	6700	6.830	RD..10
335.18-08.00-XL0708R-R5	02740245	Arbor hole	8.000	0.197	2.421	14	2.000	3.000	0.625	–	6700	3.970	RD..10
R335.18-10.00-XL0708R-R5	02741559	Arbor	10.000	0.197	3.248	18	1.500	3.500	–	2.000	6000	9.260	RD..10
335.18-10.00-XL0708R-R5	02740508	Arbor hole	10.000	0.197	3.386	18	2.000	3.000	0.625	–	6000	6.610	RD..10
335.18-12.00-XL0708R-R5	02740883	Arbor hole	12.000	0.197	4.390	22	2.000	3.000	0.625	–	5300	9.700	RD..10
R335.18-04.00-0809R-R6	02599486	Arbor	4.079	0.236	1.053	8	1.000	1.880	–	2.000	9400	2.650	RP..12
R335.18-05.00-0809R-R6	02599487	Arbor	5.079	0.236	1.368	10	1.250	2.250	–	2.000	8400	3.530	RP..12
335.18-05.00-0809R-R6	02599495	Arbor hole	5.079	0.236	1.324	10	1.500	2.252	0.625	–	8400	1.980	RP..12
R335.18-06.00-0809R-R6	02599488	Arbor	6.079	0.236	1.624	12	1.500	2.750	–	2.000	7500	4.190	RP..12
335.18-06.00-0809R-R6	02599496	Arbor hole	6.079	0.236	1.829	12	1.500	2.252	0.625	–	7500	2.870	RP..12
R335.18-08.00-XL0809R-R6	02740906	Arbor	8.000	0.236	2.264	14	1.500	3.500	–	2.000	6700	8.600	RP..12
335.18-08.00-XL0809R-R6	02740246	Arbor hole	8.000	0.236	2.421	14	2.000	3.000	0.625	–	6700	4.850	RP..12
R335.18-10.00-XL0809R-R6	02741561	Arbor	10.000	0.236	3.248	18	1.500	3.500	–	2.000	6000	10.800	RP..12
335.18-10.00-XL0809R-R6	02740527	Arbor hole	10.000	0.236	3.386	18	2.000	3.000	0.625	–	6000	7.940	RP..12
335.18-12.00-XL0809R-R6	02740884	Arbor hole	12.000	0.236	4.390	22	2.000	3.000	0.625	–	5300	11.900	RP..12

Cutter 335.18 - Insert LNK. – Metric

Width max 5-6 mm - Half side - Left hand with cassette

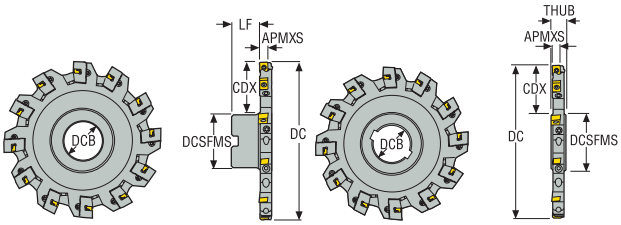


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm	mm		kg	
R335.18-080.0810.27-6L	02611696	Arbor	80,0	5,0	14,8	6	48,0	27,0	48,0	–	42,0	10500	0,7	LNK.05..
R335.18-100.0810.27-8L	02576028	Arbor	100,0	5,0	24,8	8	48,0	27,0	48,0	–	42,0	9400	0,8	LNK.05..
335.18-100.0810.27-8L	02575778	Arbor hole	100,0	5,0	27,2	8	41,0	27,0	41,0	15,0	–	9400	0,4	LNK.05..
R335.18-125.0810.32-10L	02576029	Arbor	125,0	5,0	32,3	10	58,0	32,0	58,0	–	42,0	8400	1,0	LNK.05..
335.18-125.0810.40-10L	02575787	Arbor hole	125,0	5,0	32,7	10	55,0	40,0	55,0	15,0	–	8400	0,6	LNK.05..
R335.18-160.0810.40-12L	02576030	Arbor	160,0	5,0	43,8	12	70,0	40,0	70,0	–	42,0	7500	1,6	LNK.05..
335.18-160.0810.40-12L	02575796	Arbor hole	160,0	5,0	50,2	12	55,0	40,0	55,0	15,0	–	7500	1,0	LNK.05..
R335.18-200.0810XL.40-14L	02713444	Arbor	200,0	5,0	53,5	14	90,0	40,0	90,0	–	42,0	6700	2,7	LNK.05..
335.18-200.0810XL.50-14L	02713344	Arbor hole	200,0	5,0	63,5	14	69,0	50,0	69,0	15,0	–	6700	1,7	LNK.05..
R335.18-250.0810XL.40-18L	02713466	Arbor	250,0	5,0	78,0	18	90,0	40,0	90,0	–	42,0	6000	3,5	LNK.05..
335.18-250.0810XL.50-18L	02713355	Arbor hole	250,0	5,0	88,5	18	69,0	50,0	69,0	15,0	–	6000	1,7	LNK.05..
335.18-315.0810XL.50-24L	02713361	Arbor hole	315,0	5,0	121,0	24	69,0	50,0	69,0	15,0	–	5300	1,9	LNK.05..
R335.18-080.1012.27-6L	00018592	Arbor	80,0	6,0	14,8	6	48,0	27,0	48,0	–	40,0	10500	1,0	LNK.06..
R335.18-100.1012.27-8L	00018612	Arbor	100,0	6,0	24,8	8	48,0	27,0	48,0	–	40,0	9400	0,9	LNK.06..
335.18-100.1012.27-8L	00018412	Arbor hole	100,0	6,0	27,2	8	41,0	27,0	41,0	15,0	–	9400	0,4	LNK.06..
R335.18-125.1012.32-10L	00018624	Arbor	125,0	6,0	32,3	10	58,0	32,0	58,0	–	40,0	8400	1,0	LNK.06..
335.18-125.1012.40-10L	00018426	Arbor hole	125,0	6,0	32,7	10	55,0	40,0	55,0	15,0	–	8400	0,8	LNK.06..
R335.18-160.1012.40-12L	00018687	Arbor	160,0	6,0	43,8	12	70,0	40,0	70,0	–	40,0	7500	1,3	LNK.06..
335.18-160.1012.40-12L	00018439	Arbor hole	160,0	6,0	50,2	12	55,0	40,0	55,0	15,0	–	7500	1,5	LNK.06..
R335.18-200.1012XL.40-14L	02713459	Arbor	200,0	6,0	53,5	14	90,0	40,0	90,0	–	40,0	6700	2,9	LNK.06..
335.18-200.1012XL.50-14L	02713348	Arbor hole	200,0	6,0	63,5	14	69,0	50,0	69,0	15,0	–	6700	1,7	LNK.06..
R335.18-250.1012XL.40-18L	02713467	Arbor	250,0	6,0	78,0	18	90,0	40,0	90,0	–	40,0	6000	3,9	LNK.06..
335.18-250.1012XL.50-18L	02713356	Arbor hole	250,0	6,0	88,5	18	69,0	50,0	69,0	15,0	–	6000	1,8	LNK.06..
335.18-315.1012XL.50-24L	02713363	Arbor hole	315,0	6,0	121,0	24	69,0	50,0	69,0	15,0	–	5300	2,0	LNK.06..

Width max 7,5 mm - Half side - Left hand with cassette

Cutter 335.18 - Insert LNK. – Metric

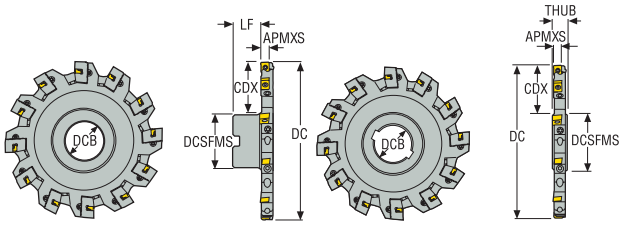


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCSFMS	DCB	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm		kg	
R335.18-080.1215.27-6L	00018729	Arbor	80,0	7,5	14,8	6	48,0	27,0	–	38,0	10500	0,8	LNK.08..
R335.18-100.1215.27-8L	00018756	Arbor	100,0	7,5	24,8	8	48,0	27,0	–	38,0	9400	1,1	LNK.08..
335.18-100.1215.27-8L	00018530	Arbor hole	100,0	7,5	27,2	8	41,0	27,0	15,0	–	9400	0,6	LNK.08..
R335.18-125.1215.32-10L	00018777	Arbor	125,0	7,5	33,3	10	58,0	32,0	–	38,0	8400	1,0	LNK.08..
335.18-125.1215.40-10L	00018542	Arbor hole	125,0	7,5	32,7	10	55,0	40,0	15,0	–	8400	0,9	LNK.08..
R335.18-160.1215.40-12L	00018788	Arbor	160,0	7,5	43,8	12	70,0	40,0	–	38,0	7500	2,1	LNK.08..
335.18-160.1215.40-12L	00018548	Arbor hole	160,0	7,5	50,2	12	55,0	40,0	15,0	–	7500	1,4	LNK.08..
R335.18-200.1215XL.40-14L	02713461	Arbor	200,0	7,5	53,5	14	90,0	40,0	–	38,0	6700	3,5	LNK.08..
335.18-200.1215XL.50-14L	02713349	Arbor hole	200,0	7,5	63,5	14	69,0	50,0	15,0	–	6700	2,0	LNK.08..
R335.18-250.1215XL.40-18L	02713470	Arbor	250,0	7,5	78,0	18	90,0	40,0	–	90,0	6000	4,5	LNK.08..
335.18-250.1215XL.50-18L	02713357	Arbor hole	250,0	7,5	88,5	18	69,0	50,0	15,0	–	6000	3,2	LNK.08..
335.18-315.1215XL.50-24L	02713364	Arbor hole	315,0	7,5	121,0	24	69,0	50,0	15,0	–	5300	5,6	LNK.08..

Cutter 335.18 - Insert LNK. – Inch

Width max 0.197-0.236” - Half side - Left hand with cassette

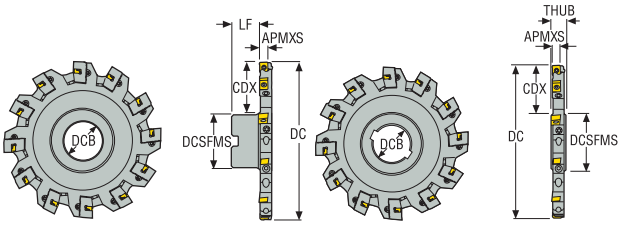


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 740-741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMX	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-04.00-0506L	02834741	Arbor	4.000	0.236	1.024	8	1.880	1.000	1.880	–	1.685	9400	1.760	LNK.05
335.18-04.00-0506L	02834738	Arbor hole	4.000	0.197	1.102	8	1.550	1.000	1.550	0.625	–	9400	0.880	LNK.05
R335.18-05.00-0506L	02834742	Arbor	5.000	0.197	1.339	10	2.250	1.250	2.250	–	1.685	8400	2.650	LNK.05
335.18-05.00-0506L	02834739	Arbor hole	5.000	0.197	1.299	10	2.252	1.500	2.252	0.625	–	8400	1.320	LNK.05
R335.18-06.00-0506L	02834743	Arbor	6.000	0.197	1.575	12	2.750	1.500	2.750	–	1.685	7500	3.310	LNK.05
335.18-06.00-0506L	02834740	Arbor hole	6.000	0.197	1.772	12	2.252	1.500	2.252	0.625	–	7500	1.980	LNK.05
R335.18-08.00-XL0506L	02740907	Arbor	8.000	0.197	2.224	14	3.500	1.500	3.500	–	1.685	6700	6.170	LNK.05
335.18-08.00-XL0506L	02740247	Arbor hole	8.000	0.197	2.421	14	3.000	2.000	3.000	0.625	–	6700	3.310	LNK.05
R335.18-10.00-XL0506L	02741562	Arbor	10.000	0.197	3.209	18	3.500	1.500	3.500	–	1.685	6000	8.160	LNK.05
335.18-10.00-XL0506L	02740528	Arbor hole	10.000	0.197	3.386	18	3.000	2.000	3.000	0.625	–	6000	5.510	LNK.05
335.18-12.00-XL0506L	02740885	Arbor hole	12.000	0.197	4.390	22	3.000	2.000	3.000	0.625	–	5300	7.940	LNK.05
R335.18-04.00-0708L	00079837	Arbor	4.000	0.236	1.014	8	1.880	1.000	1.880	–	1.606	9400	2.200	LNK.06
R335.18-05.00-0708L	00079838	Arbor	5.000	0.236	1.329	10	2.250	1.250	2.250	–	1.606	8400	3.090	LNK.06
335.18-05.00-0708L	00079776	Arbor hole	5.000	0.236	1.258	10	2.252	1.500	2.252	0.625	–	8400	1.760	LNK.06
R335.18-06.00-0708L	00079839	Arbor	6.000	0.236	1.534	12	2.750	1.500	2.750	–	1.606	7500	3.750	LNK.06
335.18-06.00-0708L	00079777	Arbor hole	6.000	0.236	1.766	12	2.252	1.500	2.252	0.625	–	7500	2.430	LNK.06
R335.18-08.00-XL0708L	02740908	Arbor	8.000	0.236	2.224	14	3.500	1.500	3.500	–	1.606	6700	6.830	LNK.06
335.18-08.00-XL0708L	02740248	Arbor hole	8.000	0.236	2.421	14	3.000	2.000	3.000	0.625	–	6700	3.970	LNK.06
R335.18-10.00-XL0708L	02741564	Arbor	10.000	0.236	3.209	18	3.500	1.500	3.500	–	1.606	6000	9.260	LNK.06
335.18-10.00-XL0708L	02740530	Arbor hole	10.000	0.236	3.386	18	3.000	2.000	3.000	0.625	–	6000	6.610	LNK.06
335.18-12.00-XL0708L	02740887	Arbor hole	12.000	0.236	4.390	22	3.000	2.000	3.000	0.625	–	5300	9.700	LNK.06

Width max 0.295” - Half side - Half side - Left hand with cassette

Cutter 335.18 - Insert LNK. – Inch

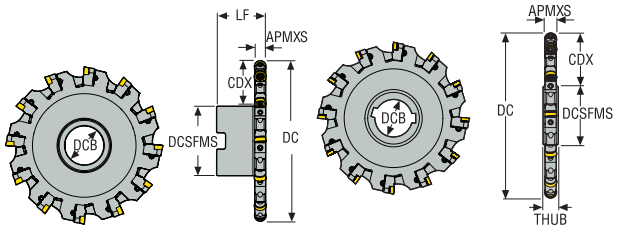


- For insert selection and cutting data recommendations, see page(s) 423-424
- For complete insert programme, see page(s) 741
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMX	CDX	ZEFP	DCSFMS	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch	Inch		lbs	
R335.18-04.00-0809L	00079973	Arbor	4.000	0.295	1.014	8	1.880	1.000	1.880	–	1.528	9400	2.430	LNK.08
R335.18-05.00-0809L	00079974	Arbor	5.000	0.295	1.329	10	2.250	1.250	2.250	–	1.528	8400	3.530	LNK.08
335.18-05.00-0809L	00079957	Arbor hole	5.000	0.295	1.285	10	2.252	1.500	2.252	0.625	–	8400	1.980	LNK.08
R335.18-06.00-0809L	00079975	Arbor	6.000	0.295	1.585	12	2.750	1.500	2.750	–	1.528	7500	4.190	LNK.08
335.18-06.00-0809L	00079958	Arbor hole	6.000	0.295	1.790	12	2.252	1.500	2.252	0.625	–	7500	2.870	LNK.08
R335.18-08.00-XL0809L	02740909	Arbor	8.000	0.295	2.224	14	3.500	1.500	3.500	–	1.528	6700	7.720	LNK.08
335.18-08.00-XL0809L	02740249	Arbor hole	8.000	0.295	2.421	14	3.000	2.000	3.000	0.625	–	6700	4.850	LNK.08
R335.18-10.00-XL0809L	02741566	Arbor	10.000	0.295	3.209	18	3.500	1.500	3.500	–	1.528	6000	10.800	LNK.08
335.18-10.00-XL0809L	02740531	Arbor hole	10.000	0.295	3.386	18	3.000	2.000	3.000	0.625	–	6000	7.940	LNK.08
335.18-12.00-XL0809L	02740888	Arbor hole	12.000	0.295	4.390	22	3.000	2.000	3.000	0.625	–	5300	11.900	LNK.08

Cutter 335.18 - Insert RD..10T3/RP..1204 – Metric

Half side - Left hand - Radius profile with cassette

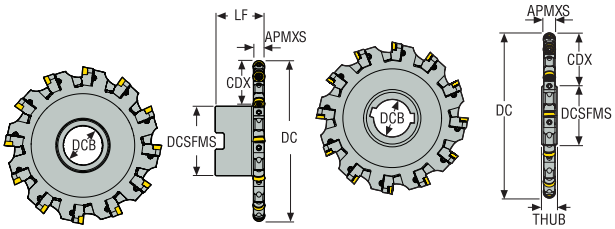


- For insert selection and cutting data recommendations, see page(s) 442-447
- For complete insert programme, see page(s) 746, 749
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm		kg	
R335.18-080.1012.27-6L-R5	00030354	Arbor	82,0	5,0	15,8	6	27,0	48,0	–	40,0	10500	0,8	RD..10T3
R335.18-100.1012.27-8L-R5	00030358	Arbor	102,0	5,0	25,8	8	27,0	48,0	–	40,0	9400	1,0	RD..10T3
335.18-100.1012.27-8L-R5	00030339	Arbor hole	102,0	5,0	28,2	8	27,0	41,0	15,0	–	9400	0,4	RD..10T3
R335.18-125.1012.32-10L-R5	00030361	Arbor	127,0	5,0	33,3	10	32,0	58,0	–	42,0	8400	1,2	RD..10T3
335.18-125.1012.40-10L-R5	00030342	Arbor hole	127,0	5,0	33,7	10	40,0	55,0	15,0	–	8400	0,8	RD..10T3
R335.18-160.1012.40-12L-R5	00030366	Arbor	162,0	5,0	44,8	12	40,0	70,0	–	40,0	7500	2,3	RD..10T3
335.18-160.1012.40-12L-R5	00030345	Arbor hole	162,0	5,0	51,2	12	40,0	55,0	15,0	–	7500	11,0	RD..10T3
R335.18-200.1012XL.40-14L-R5	02713464	Arbor	200,0	5,0	53,5	14	40,0	90,0	–	40,0	6700	2,9	RD..10T3
335.18-200.1012XL.50-14L-R5	02713352	Arbor hole	200,0	5,0	63,5	14	50,0	69,0	15,0	–	6700	1,7	RD..10T3
R335.18-250.1012XL.40-18L-R5	02713476	Arbor	250,0	5,0	78,0	18	40,0	90,0	–	40,0	6000	8,0	RD..10T3
335.18-250.1012XL.50-18L-R5	02713359	Arbor hole	250,0	5,0	88,5	18	50,0	69,0	15,0	–	6000	1,8	RD..10T3
335.18-315.1012XL.50-24L-R5	02713367	Arbor hole	315,0	5,0	121,0	24	50,0	69,0	15,0	–	5300	2,0	RD..10T3
R335.18-080.1215.27-6L-R6	00030408	Arbor	82,0	6,0	15,8	6	27,0	48,0	–	38,0	10500	0,7	RP..1204
R335.18-100.1215.27-8L-R6	00030416	Arbor	102,0	6,0	25,8	8	27,0	48,0	–	38,0	9400	1,1	RP..1204
335.18-100.1215.27-8L-R6	00030373	Arbor hole	102,0	6,0	28,2	8	27,0	41,0	15,0	–	9400	0,6	RP..1204
R335.18-125.1215.32-10L-R6	00030419	Arbor	127,0	6,0	32,3	10	32,0	58,0	–	38,0	8400	1,1	RP..1204
335.18-125.1215.40-10L-R6	00030376	Arbor hole	127,0	6,0	33,7	10	40,0	55,0	15,0	–	8400	0,9	RP..1204
R335.18-160.1215.40-12L-R6	00030422	Arbor	162,0	6,0	44,8	12	40,0	70,0	–	38,0	7500	2,0	RP..1204
335.18-160.1215.40-12L-R6	00030380	Arbor hole	162,0	6,0	51,2	12	40,0	55,0	15,0	–	7500	1,5	RP..1204
R335.18-200.1215XL.40-14L-R6	02713465	Arbor	200,0	6,0	53,5	14	40,0	90,0	–	38,0	6700	3,4	RP..1204
335.18-200.1215XL.50-14L-R6	02713354	Arbor hole	200,0	6,0	63,5	14	50,0	69,0	15,0	–	6700	1,9	RP..1204
R335.18-250.1215XL.40-18L-R6	02713478	Arbor	250,0	6,0	78,0	18	40,0	90,0	–	38,0	6000	4,4	RP..1204
335.18-250.1215XL.50-18L-R6	02713360	Arbor hole	250,0	6,0	88,5	18	50,0	69,0	15,0	–	6000	2,0	RP..1204
335.18-315.1215XL.50-24L-R6	02713368	Arbor hole	315,0	6,0	121,0	24	50,0	69,0	15,0	–	5300	2,2	RP..1204

Half side - Left hand - Radius profile with cassette

Cutter 335.18 - Insert RD..10T3/RP..1204 – Inch



- For insert selection and cutting data recommendations, see page(s) 442-447
- For complete insert programme, see page(s) 746, 749
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs	
335.18-08.00-XL0708L-R5	02740251	Arbor hole	8.000	0.197	2.421	14	2.000	3.000	0.625	–	6700	3.970	RD..10
335.18-10.00-XL0708L-R5	02740532	Arbor hole	10.000	0.197	3.386	18	2.000	3.000	0.625	–	6000	6.610	RD..10
335.18-12.00-XL0708L-R5	02740889	Arbor hole	12.000	0.197	4.390	22	2.000	3.000	0.625	–	5300	9.700	RD..10
R335.18-08.00-XL0708L-R5	02740910	Arbor	8.000	0.197	2.224	14	1.500	3.500	–	1.606	6700	6.830	RD..10
R335.18-10.00-XL0708L-R5	02741572	Arbor	10.000	0.197	3.248	18	1.500	3.500	–	1.606	6000	9.260	RD..10
335.18-05.00-0809L-R6	02599499	Arbor hole	5.079	0.236	1.324	10	1.500	2.252	0.625	–	8400	1.980	RP..12
335.18-06.00-0809L-R6	02599500	Arbor hole	6.079	0.236	1.829	12	1.500	2.252	0.625	–	7500	2.870	RP..12
335.18-08.00-XL0809L-R6	02740252	Arbor hole	8.000	0.236	2.421	14	2.000	3.000	0.625	–	6700	4.850	RP..12
335.18-10.00-XL0809L-R6	02740534	Arbor hole	10.000	0.236	3.386	18	2.000	3.000	0.625	–	6000	7.940	RP..12
335.18-12.00-XL0809L-R6	02740891	Arbor hole	12.000	0.236	4.390	22	2.000	3.000	0.625	–	5300	11.900	RP..12
R335.18-08.00-XL0809L-R6	02740911	Arbor	8.000	0.236	2.224	14	1.500	3.500	–	1.528	6700	7.720	RP..12
R335.18-10.00-XL0809L-R6	02741574	Arbor	10.000	0.236	3.248	18	1.500	3.500	–	1.528	6000	10.800	RP..12
R335.18-04.00-0809L-R6	02599491	Arbor	4.079	0.236	1.063	4	1.000	1.880	–	1.528	9400	2.430	RP..12
R335.18-05.00-0809L-R6	02599492	Arbor	5.079	0.236	1.368	10	1.250	2.250	–	1.528	8400	3.530	RP..12
R335.18-06.00-0809L-R6	02599493	Arbor	6.079	0.236	1.624	12	1.500	2.750	–	1.528	7500	4.190	RP..12

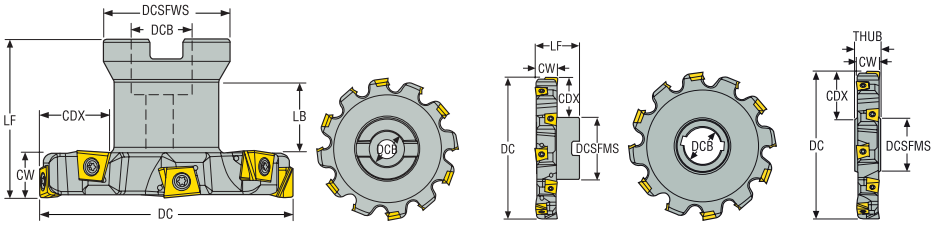
335.25

Easy to use, strong and free-cutting disc milling cutter system dedicated for large width of cut slotting, or half side and face cutting operations

- Width of cut 13.5-32 mm (.512 - 1.25 inch) - slot with flat bottom
- Cutter range diameter 80-315 mm (4.0 - 12 inch)
- Fixed or adjustable cutting width with replaceable cassettes
- Available with Arbor or Arbor hole connection , with through coolant option up to diameter 160mm
- Corner radii range 0.4-6 mm (.016 - 0.236 inch), and possibility to apply round insert dia 16/20 mm on adjustable system
- Economical solution with 4 cutting edges per insert
- Basic tolerance of the slot: Fixed pocket cutters: +/-0.08mm (+/-0.003”),Adjustable cutter: +/-0.07mm (+/-0.0025”)

Width 15/20/25 mm - Full side and face - Fixed pocket

Cutter 335.25 - Insert XNHQ/LNHQ – Metric

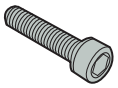


- For insert selection and cutting data recommendations, see page(s) 425-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	LB	Through coolant	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			mm	mm	mm			mm	mm	mm	mm	mm			kg		
R335.25-080.15.22-4NA	02989533	Arbor	80,0	15,0	22,7	4	8	22,0	40,0	–	50,0	21,4	✓	10200	0,6	XNHQ09...	–
R335.25-100.15.27-5NA	02989535	Arbor	100,0	15,0	25,3	5	10	27,0	48,0	–	50,0	0,0	✓	9200	1,0	XNHQ09...	–
R335.25-125.15.32-6NA	02989541	Arbor	125,0	15,0	32,8	6	12	32,0	58,0	–	50,0	0,0	✓	8200	1,5	XNHQ09...	–
R335.25-160.15.40-7NA	02989542	Arbor	160,0	15,0	44,3	7	14	40,0	70,0	–	50,0	0,0	✓	7200	2,4	XNHQ09...	–
335.25-160.15.40-7N	02989544	Arbor hole	160,0	15,0	52,0	7	14	40,0	55,0	15,0	–	–	–	7200	1,7	XNHQ09...	–
R335.25-200.15.40-8N	02989543	Arbor	200,0	15,0	54,3	8	16	40,0	90,0	–	50,0	–	–	6500	3,6	XNHQ09...	–
335.25-200.15.50-8N	02989545	Arbor hole	200,0	15,0	64,5	8	16	50,0	69,0	15,0	–	–	–	6500	2,6	XNHQ09...	–
R335.25-100.20.27-4NA	02953594	Arbor	100,0	20,0	25,3	4	8	27,0	48,0	–	50,0	0,0	✓	7200	1,2	XNHQ12...	–
R335.25-125.20.32-5NA	02953595	Arbor	125,0	20,0	32,8	5	10	32,0	58,0	–	50,0	0,0	✓	6500	1,8	XNHQ12...	–
R335.25-160.20.40-6NA	02953596	Arbor	160,0	20,0	44,3	6	12	40,0	70,0	–	50,0	0,0	✓	5700	2,9	XNHQ12...	–
335.25-160.20.40-6N	02961517	Arbor hole	160,0	20,0	51,5	6	12	40,0	55,0	20,0	–	–	–	5600	2,2	XNHQ12...	–
R335.25-200.20.40-7N	02953597	Arbor	200,0	20,0	54,3	7	14	40,0	90,0	–	50,0	49,0	–	5100	4,3	XNHQ12...	–
335.25-200.20.50-7N	02961518	Arbor hole	200,0	20,0	64,3	7	14	50,0	69,0	20,0	–	–	–	5100	3,5	XNHQ12...	–
R335.25-250.20.60-9N	02953598	Arbor	250,0	20,0	59,3	9	18	60,0	130,0	–	50,0	–	–	4600	7,2	XNHQ12...	–
335.25-250.20.50-9N	02961519	Arbor hole	250,0	20,0	88,5	9	18	50,0	71,0	20,0	–	–	–	4600	5,8	XNHQ12...	–
R335.25-125.25.32-5NA	02788023	Arbor	125,0	25,0	33,0	5	10	32,0	58,0	–	50,0	0,0	✓	4900	1,9	XNHQ1407...	LNHQ1407...
R335.25-160.25.40-6NA	02788024	Arbor	160,0	25,0	44,4	6	12	40,0	70,0	–	50,0	0,0	✓	4400	3,1	XNHQ1407...	LNHQ1407...
335.25-160.25.40-6N	02788027	Arbor hole	160,0	25,0	50,7	6	12	40,0	55,0	32,0	–	–	–	4400	2,7	XNHQ1407...	LNHQ1407...
R335.25-200.25.40-7N	02788025	Arbor	200,0	25,0	54,5	7	14	40,0	90,0	–	50,0	–	–	3900	5,0	XNHQ1407...	LNHQ1407...
335.25-200.25.50-7N	02788028	Arbor hole	200,0	25,0	62,7	7	14	50,0	71,0	32,0	–	–	–	3900	4,3	XNHQ1407...	LNHQ1407...
335.25-250.25.50-9N	02788029	Arbor hole	250,0	25,0	87,7	9	18	50,0	71,0	32,0	–	–	–	3500	7,3	XNHQ1407...	LNHQ1407...
R335.25-250.25.60-9N	02788026	Arbor	250,0	25,0	59,5	9	18	60,0	130,0	–	50,0	–	–	3500	8,3	XNHQ1407...	LNHQ1407...

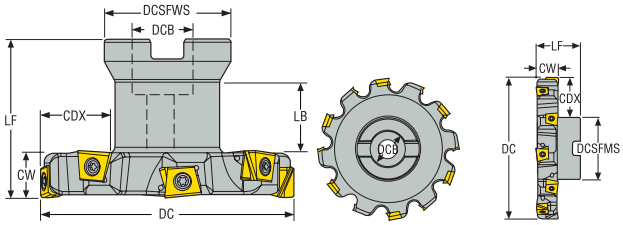
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R335.25 CW=15 DC=80	MLC6S10X45	C03509-T10P	T00-10P30	3.0NM
R335.25 CW=15 DC=100	MLC6S12X50	C03509-T10P	T00-10P30	3.0NM
R335.25 CW=15 DC=125	950E1645	C03509-T10P	T00-10P30	3.0NM
R335.25 CW=15 DC=160	MLC6S20X40	C03509-T10P	T00-10P30	3.0NM
335.25 CW=15	–	C03509-T10P	T00-10P30	3.0NM
R335.25 CW=15 DC=200	–	C03509-T10P	T00-10P30	3.0NM
R335.25 CW=20 DC=100	MLC6S12X50	C03511-T10P	T00-10P30	3.0NM
R335.25 CW=20 DC=125	950E1645	C03511-T10P	T00-10P30	3.0NM
R335.25 CW=20 DC=160	MLC6S20X40	C03511-T10P	T00-10P30	3.0NM
335.25 CW=20	–	C03511-T10P	T00-10P30	3.0NM
R335.25 CW=20 DC=200	–	C03511-T10P	T00-10P30	3.0NM
R335.25 CW=20 DC=250	–	C03511-T10P	T00-10P30	3.0NM
R335.25 CW=25 DC=125	MLC6S16X35	C04013-T15P	T00-15P50	5.0NM
R335.25 CW=25 DC=160	MLC6S20X40	C04013-T15P	T00-15P50	5.0NM
335.25 CW=25	–	C04013-T15P	T00-15P50	5.0NM
R335.25 CW=25 DC=200-250	–	C04013-T15P	T00-15P50	5.0NM

Width 0,750/1,000" - Full side and face - Fixed pocket

Cutter 335.25 - Insert XNHQ/LNHQ – Inch

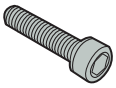


- For insert selection and cutting data recommendations, see page(s) 425-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	LB	Through coolant	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			Inch	Inch	Inch			Inch	Inch	Inch	Inch	Inch			lbs		
R335.25-05.00-0.75-5NA	02989512	Arbor	5.000	0.750	1.331	5	10	1.250	2.283	–	2.000	–	✓	6500	4.190	XNHQ12	–
R335.25-06.00-0.75-6NA	02989513	Arbor	6.000	0.750	1.595	6	12	1.500	2.756	–	2.000	–	✓	5700	5.950	XNHQ12	–
R335.25-05.00-1.000-5NA	02788030	Arbor	5.000	1.000	1.350	5	10	1.250	2.250	–	2.000	–	✓	4900	4.190	XNHQ14	LNHQ14
R335.25-06.00-1.000-6NA	02788031	Arbor	6.000	1.000	1.598	6	12	1.500	2.750	–	2.000	–	✓	4400	6.390	XNHQ14	LNHQ14
335.25-06.00-1.000-6N	02788034	Arbor hole	6.000	1.000	1.846	6	12	1.500	2.252	1.250	–	–	–	4400	6.390	XNHQ14	LNHQ14
R335.25-08.00-1.000-7N	02788032	Arbor	8.000	1.000	2.224	7	14	1.500	3.500	–	2.000	–	–	3900	11.680	XNHQ14	LNHQ14
335.25-08.00-1.000-7N	02788035	Arbor hole	8.000	1.000	2.429	7	14	2.000	3.000	1.250	–	–	–	3900	10.140	XNHQ14	LNHQ14
335.25-10.00-1.000-9N	02788036	Arbor hole	10.000	1.000	3.429	9	18	2.000	3.000	1.250	–	–	–	3500	16.530	XNHQ14	LNHQ14

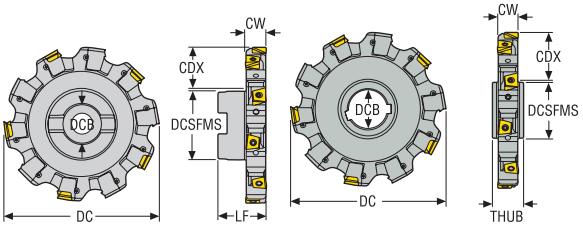
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R335.25 CW 0.750 DC=5.000	ULC6S5/8UNFX11/2	C03511-T10P	T00-10P30	3.0NM
R335.25 CW 0.750 DC=6.000	ULC6S3/4UNFX11/2	C03511-T10P	T00-10P30	3.0NM
R335.25 CW 1.000 DC=5.000	ULC6S5/8UNFX11/2	C04013-T15P	T00-15P50	5.0NM
R335.25 CW 1.000 DC=6.000	ULC6S5/8UNFX11/2	C04013-T15P	T00-15P50	5.0NM
335.25 CW 1.000	–	C04013-T15P	T00-15P50	5.0NM
R335.25 CW 1.000 DC=8.000	–	C04013-T15P	T00-15P50	5.0NM

Cutter 335.25 - Insert XNHQ – Metric

Width 13,5 - 21 mm - Full side and face - Adjustable design

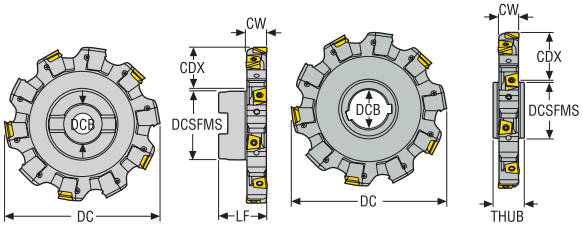


- For insert selection and cutting data recommendations, see page(s) 425-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm	mm			mm	mm	mm	mm		kg	
R335.25-100.1317.27-3N	02993725	Arbor	100,0	13,5	17,0	24,8	3	6	27,0	48,0	–	50,0	9200	1,0	XNHQ09..
R335.25-125.1317.32-4N	02993726	Arbor	125,0	13,5	17,0	32,3	4	8	32,0	58,0	–	50,0	8200	1,4	XNHQ09..
335.25-125.1317.40-4N	02993731	Arbor hole	125,0	13,5	17,0	32,9	4	8	40,0	55,0	17,0	–	8200	0,9	XNHQ09..
R335.25-160.1317.40-6N	02993727	Arbor	160,0	13,5	17,0	43,8	6	12	40,0	70,0	–	50,0	7200	2,3	XNHQ09..
335.25-160.1317.40-6N	02993732	Arbor hole	160,0	13,5	17,0	50,5	6	12	40,0	55,0	17,0	–	7200	1,5	XNHQ09..
R335.25-200.1317.40-7N	02993728	Arbor	200,0	13,5	17,0	54,0	7	14	40,0	90,0	–	50,0	6500	3,6	XNHQ09..
335.25-200.1317.50-7N	02993733	Arbor hole	200,0	13,5	17,0	63,5	7	14	50,0	69,0	17,0	–	6500	2,5	XNHQ09..
R335.25-250.1317XL.60-8N	02993729	Arbor	250,0	13,5	17,0	59,0	8	16	60,0	130,0	–	50,0	5800	6,0	XNHQ09..
335.25-250.1317XL.50-8N	02993734	Arbor hole	250,0	13,5	17,0	88,5	8	16	50,0	69,0	17,0	–	5800	3,9	XNHQ09..
R335.25-315.1317XL.60-10N	02993730	Arbor	315,0	13,5	17,0	91,5	10	20	60,0	130,0	–	50,0	5200	8,6	XNHQ09..
335.25-315.1317XL.50-10N	02993735	Arbor hole	315,0	13,5	17,0	121,0	10	20	50,0	69,0	17,0	–	5200	6,5	XNHQ09..
R335.25-100.1721.27-3N	02993714	Arbor	100,0	17,0	21,0	24,8	3	6	27,0	48,0	–	50,0	7200	1,1	XNHQ12..
R335.25-125.1721.32-4N	02993715	Arbor	125,0	17,0	21,0	32,3	4	8	32,0	58,0	–	50,0	6500	1,6	XNHQ12..
335.25-125.1721.40-4N	02993720	Arbor hole	125,0	17,0	21,0	32,9	4	8	40,0	55,0	21,0	–	8200	1,1	XNHQ12..
R335.25-160.1721.40-5N	02993716	Arbor	160,0	17,0	21,0	43,8	5	10	40,0	70,0	–	50,0	5700	2,7	XNHQ12..
335.25-160.1721.40-5N	02993721	Arbor hole	160,0	17,0	21,0	50,5	5	10	40,0	55,0	21,0	–	7200	1,9	XNHQ12..
R335.25-200.1721.40-6N	02993717	Arbor	200,0	17,0	21,0	54,0	6	12	40,0	90,0	–	50,0	5100	4,1	XNHQ12..
335.25-200.1721.50-6N	02993722	Arbor hole	200,0	17,0	21,0	63,5	6	12	50,0	69,0	21,0	–	5100	3,2	XNHQ12..
R335.25-250.1721XL.60-8N	02993718	Arbor	250,0	17,0	21,0	59,0	8	16	60,0	130,0	–	50,0	4600	6,7	XNHQ12..
335.25-250.1721XL.50-8N	02993723	Arbor hole	250,0	17,0	21,0	88,5	8	16	50,0	69,0	21,0	–	5800	4,9	XNHQ12..
R335.25-315.1721XL.60-10N	02993719	Arbor	315,0	17,0	21,0	91,5	10	20	60,0	130,0	–	50,0	4100	10,0	XNHQ12..
335.25-315.1721XL.50-10N	02993724	Arbor hole	315,0	17,0	21,0	121,0	10	20	50,0	69,0	21,0	–	5200	8,2	XNHQ12..

Width 21 - 32 mm - Full side and face - Adjustable design

Cutter 335.25 - Insert XNHQ/LNHQ – Metric

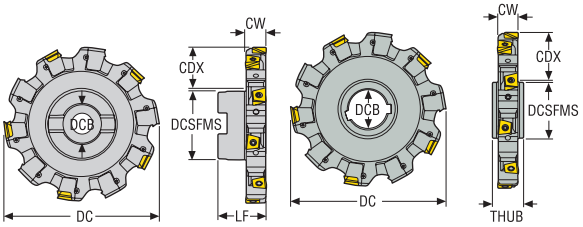


- For insert selection and cutting data recommendations, see page(s) 425-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			mm	mm	mm	mm			mm	mm	mm	mm		kg		
R335.25-125.2126.32-4N	02814578	Arbor	125,0	21,0	26,0	32,3	4	8	32,0	58,0	–	50,0	4900	1,7	XNHQ1407...	LNHQ1407...
335.25-125.2126.40-4N	02814599	Arbor hole	125,0	21,0	26,0	32,7	4	8	40,0	55,0	32,0	–	4900	1,3	XNHQ1407...	LNHQ1407...
R335.25-160.2126.40-5N	02814582	Arbor	160,0	21,0	26,0	43,8	5	10	40,0	70,0	–	50,0	4400	2,9	XNHQ1407...	LNHQ1407...
335.25-160.2126.40-5N	02814603	Arbor hole	160,0	21,0	26,0	50,3	5	10	40,0	55,0	32,0	–	4400	2,3	XNHQ1407...	LNHQ1407...
R335.25-200.2126.40-6N	02814586	Arbor	200,0	21,0	26,0	54,0	6	12	40,0	90,0	–	50,0	3900	4,6	XNHQ1407...	LNHQ1407...
335.25-200.2126.50-6N	02814607	Arbor hole	200,0	21,0	26,0	63,3	6	12	50,0	69,0	32,0	–	3900	3,9	XNHQ1407...	LNHQ1407...
R335.25-250.2126XL.60-7N	02814590	Arbor	250,0	21,0	26,0	59,0	7	14	60,0	130,0	–	50,0	3500	7,3	XNHQ1407...	LNHQ1407...
335.25-250.2126XL.50-7N	02814611	Arbor hole	250,0	21,0	26,0	88,3	7	14	50,0	69,0	32,0	–	3500	6,0	XNHQ1407...	LNHQ1407...
R335.25-315.2126XL.60-9N	02814594	Arbor	315,0	21,0	26,0	91,5	9	18	60,0	130,0	–	50,0	3100	11,3	XNHQ1407...	LNHQ1407...
335.25-315.2126XL.60-9N	02814615	Arbor hole	315,0	21,0	26,0	113,3	9	18	60,0	84,0	32,0	–	3100	10,0	XNHQ1407...	LNHQ1407...
R335.25-160.2632.40-5N	02827411	Arbor	160,0	26,0	32,0	43,8	5	10	40,0	70,0	–	50,0	4600	3,4	XNHQ1707...	LNHQ1707...
335.25-160.2632.40-5N	02829065	Arbor hole	160,0	26,0	32,0	50,3	5	10	40,0	55,0	32,0	–	4600	2,9	XNHQ1707...	LNHQ1707...
R335.25-200.2632.40-6N	02827415	Arbor	200,0	26,0	32,0	54,0	6	12	40,0	90,0	–	50,0	4100	5,3	XNHQ1707...	LNHQ1707...
335.25-200.2632.50-6N	02827441	Arbor hole	200,0	26,0	32,0	63,3	6	12	50,0	69,0	32,0	–	4100	4,8	XNHQ1707...	LNHQ1707...
R335.25-250.2632XL.60-7N	02827419	Arbor	250,0	26,0	32,0	59,0	7	14	60,0	130,0	–	50,0	3700	8,4	XNHQ1707...	LNHQ1707...
335.25-250.2632XL.50-7N	02827445	Arbor hole	250,0	26,0	32,0	88,3	7	14	50,0	69,0	32,0	–	3700	7,4	XNHQ1707...	LNHQ1707...
R335.25-315.2632XL.60-9N	02827423	Arbor	315,0	26,0	32,0	91,5	9	18	60,0	130,0	–	50,0	3300	13,4	XNHQ1707...	LNHQ1707...
335.25-315.2632XL.60-9N	02827449	Arbor hole	315,0	26,0	32,0	113,3	9	18	60,0	84,0	32,0	–	3300	12,3	XNHQ1707...	LNHQ1707...

Cutter 335.25 - Insert XNHQ – Inch

Width 0.53-0.83” - Full side and face - Adjustable design

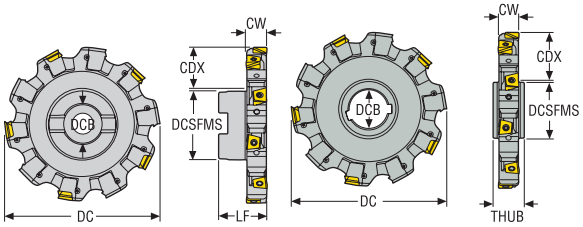


- For insert selection and cutting data recommendations, see page(s) 425-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch	Inch			Inch	Inch	Inch	Inch		lbs	
R335.25-04.00-0911N	02993907	Arbor	4.000	0.531	0.669	1.014	3	6	1.000	1.880	–	2.000	9200	2.870	XNHQ09
R335.25-05.00-0911N	02993911	Arbor	5.000	0.531	0.669	1.329	4	8	1.250	2.250	–	2.000	8200	18.740	XNHQ09
335.25-05.00-0911N	02993931	Arbor hole	5.000	0.531	0.669	1.289	4	8	1.500	2.250	0.750	–	8200	1.980	XNHQ09
R335.25-06.00-0911N	02993915	Arbor	6.000	0.531	0.669	1.579	5	10	1.500	2.750	–	2.000	7200	4.850	XNHQ09
335.25-06.00-0911N	02993935	Arbor hole	6.000	0.531	0.669	1.795	5	10	1.500	2.250	0.750	–	7200	3.750	XNHQ09
R335.25-08.00-0911N	02993919	Arbor	8.000	0.531	0.669	2.210	7	14	1.500	3.500	–	2.000	6500	9.260	XNHQ09
335.25-08.00-0911N	02993939	Arbor hole	8.000	0.531	0.669	2.420	7	14	2.000	3.000	0.750	–	6500	5.730	XNHQ09
R335.25-10.00-XL0911N	02993923	Arbor	10.000	0.531	0.669	2.400	8	16	2.500	5.120	–	2.000	5800	13.450	XNHQ09
335.25-10.00-XL0911N	02993943	Arbor hole	10.000	0.531	0.669	3.420	8	16	2.000	3.000	0.750	–	5800	9.040	XNHQ09
R335.25-12.00-XL0911N	02993927	Arbor	12.000	0.531	0.669	3.400	10	20	2.500	5.120	–	2.000	5200	17.860	XNHQ09
335.25-12.00-XL0911N	02993947	Arbor hole	12.000	0.531	0.669	4.460	10	20	2.000	3.000	0.750	–	5200	13.450	XNHQ09
R335.25-04.00-1113N	02993850	Arbor	4.000	0.669	0.827	1.014	3	6	1.000	1.880	–	2.000	7200	2.430	XNHQ12
R335.25-05.00-1113N	02993854	Arbor	5.000	0.669	0.827	1.329	4	8	1.250	2.250	–	2.000	6500	3.750	XNHQ12
335.25-05.00-1113N	02993881	Arbor hole	5.000	0.669	0.827	1.289	4	8	1.500	2.250	1.000	–	6500	2.650	XNHQ12
R335.25-06.00-1113N	02993858	Arbor	6.000	0.669	0.827	1.579	5	10	1.500	2.750	–	2.000	5700	5.510	XNHQ12
335.25-06.00-1113N	02993885	Arbor hole	6.000	0.669	0.827	1.795	5	10	1.500	2.250	1.000	–	5700	3.970	XNHQ12
R335.25-08.00-1113N	02993862	Arbor	8.000	0.669	0.827	2.210	6	12	1.500	3.500	–	2.000	5100	10.800	XNHQ12
335.25-08.00-1113N	02993889	Arbor hole	8.000	0.669	0.827	2.420	6	12	2.000	3.000	1.000	–	5100	7.500	XNHQ12
R335.25-10.00-XL1113N	02993866	Arbor	10.000	0.669	0.827	2.400	8	16	2.500	5.120	–	2.000	4600	15.210	XNHQ12
335.25-10.00-XL1113N	02993893	Arbor hole	10.000	0.669	0.827	3.420	8	16	2.000	3.000	1.000	–	4600	11.460	XNHQ12
R335.25-12.00-XL1113N	02993870	Arbor	12.000	0.669	0.827	3.400	10	20	2.500	5.120	–	2.000	4100	20.720	XNHQ12
335.25-12.00-XL1113N	02993897	Arbor hole	12.000	0.669	0.827	4.420	10	20	2.000	3.000	1.000	–	4100	16.980	XNHQ12

Width 0.83-1.26” - Full side and face - Adjustable design

Cutter 335.25 - Insert XNHQ/LNHQ – Inch

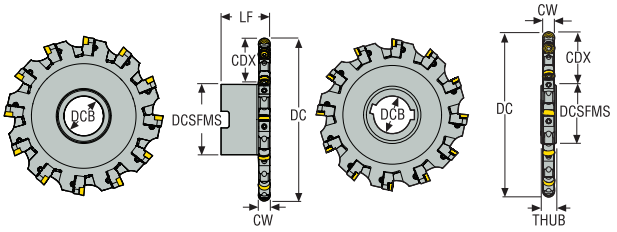


- For insert selection and cutting data recommendations, see page(s) 425-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			Inch	Inch	Inch	Inch			Inch	Inch	Inch	Inch		lbs		
R335.25-05.00-1316N	02814619	Arbor	5.000	0.827	1.024	1.327	4	8	1.250	2.250	–	2.000	4900	3.970	XNHQ14	LNHQ14
335.25-05.00-1316N	02814639	Arbor hole	5.000	0.827	1.024	1.291	4	8	1.500	2.250	1.250	–	4900	3.090	XNHQ14	LNHQ14
R335.25-06.00-1316N	02814623	Arbor	6.000	0.827	1.024	1.579	5	10	1.500	2.750	–	2.000	4500	5.950	XNHQ14	LNHQ14
335.25-06.00-1316N	02814643	Arbor hole	6.000	0.827	1.024	1.791	5	10	1.500	2.250	1.250	–	4500	4.630	XNHQ14	LNHQ14
R335.25-08.00-1316N	02814627	Arbor	8.000	0.827	1.024	2.209	6	12	1.500	3.500	–	2.000	3900	10.800	XNHQ14	LNHQ14
335.25-08.00-1316N	02814647	Arbor hole	8.000	0.827	1.024	2.413	6	12	2.000	3.000	1.250	–	3900	9.040	XNHQ14	LNHQ14
R335.25-10.00-XL1316N	02814631	Arbor	10.000	0.827	1.024	2.402	7	14	2.500	5.118	–	2.000	3500	16.530	XNHQ14	LNHQ14
335.25-10.00-XL1316N	02814651	Arbor hole	10.000	0.827	1.024	3.413	7	14	2.000	3.000	1.250	–	3500	13.890	XNHQ14	LNHQ14
R335.25-12.00-XL1316N	02814635	Arbor	12.000	0.827	1.024	3.402	9	18	2.500	5.118	–	2.000	3200	23.150	XNHQ14	LNHQ14
335.25-12.00-XL1316N	02814655	Arbor hole	12.000	0.827	1.024	4.413	9	18	2.000	3.000	1.250	–	3200	20.500	XNHQ14	LNHQ14
R335.25-06.00-1620N	02827713	Arbor	6.000	1.024	1.260	1.579	5	10	1.500	2.750	–	2.000	4700	6.830	XNHQ17	LNHQ17
335.25-06.00-1620N	02827735	Arbor hole	6.000	1.024	1.260	1.791	5	10	1.500	2.250	1.250	–	4700	5.730	XNHQ17	LNHQ17
R335.25-08.00-1620N	02827717	Arbor	8.000	1.024	1.260	2.209	6	12	1.500	3.500	–	2.000	4100	12.570	XNHQ17	LNHQ17
335.25-08.00-1620N	02827740	Arbor hole	8.000	1.024	1.260	2.413	6	12	2.000	3.000	1.250	–	4100	11.020	XNHQ17	LNHQ17
R335.25-10.00-XL1620N	02827721	Arbor	10.000	1.024	1.260	2.402	7	14	2.500	5.118	–	2.000	3600	18.960	XNHQ17	LNHQ17
335.25-10.00-XL1620N	02827744	Arbor hole	10.000	1.024	1.260	3.413	7	14	2.000	3.000	1.250	–	3600	16.980	XNHQ17	LNHQ17
R335.25-12.00-XL1620N	02827725	Arbor	12.000	1.024	1.260	3.402	9	18	2.500	5.118	–	2.000	3300	27.120	XNHQ17	LNHQ17
335.25-12.00-XL1620N	02827748	Arbor hole	12.000	1.024	1.260	4.413	9	18	2.000	3.000	1.250	–	3300	25.350	XNHQ17	LNHQ17

Cutter 335.25 - Insert RP..1605/RP..2006 – Metric

Width 16-21 mm - full side - radius profile - Adjustable design

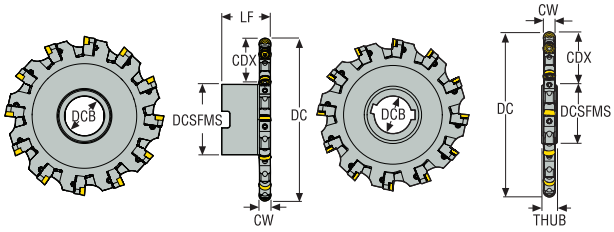


- For insert selection and cutting data recommendations, see page(s) 448-453
- For complete insert programme, see page(s) 750
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm	mm			mm	mm	mm	mm		kg	
R335.25-100.1317.27-3N-R8	02993815	Arbor	105,0	16,03	17,0	28,0	3	6	27,0	48,0	–	51,265	9200	1,0	RP..1605
R335.25-125.1317.32-4N-R8	02993818	Arbor	130,0	16,03	17,0	35,5	4	8	32,0	58,0	–	51,265	8200	1,4	RP..1605
335.25-125.1317.40-4N-R8	02993833	Arbor hole	130,0	16,03	17,0	36,0	4	8	40,0	55,0	17,0	–	8200	0,9	RP..1605
R335.25-160.1317.40-6N-R8	02993821	Arbor	165,0	16,03	17,0	47,0	6	12	40,0	70,0	–	51,265	7200	2,3	RP..1605
335.25-160.1317.40-6N-R8	02993836	Arbor hole	165,0	16,03	17,0	53,5	6	12	40,0	55,0	17,0	–	7200	1,5	RP..1605
R335.25-200.1317.40-7N-R8	02993824	Arbor	205,0	16,03	17,0	57,0	7	14	40,0	90,0	–	51,265	6500	3,8	RP..1605
335.25-200.1317.50-7N-R8	02993839	Arbor hole	205,0	16,03	17,0	66,5	7	14	50,0	69,0	17,0	–	6500	2,4	RP..1605
R335.25-250.1317XL.60-8N-R8	02993827	Arbor	255,0	16,03	17,0	62,0	8	16	60,0	130,0	–	51,265	5800	6,0	RP..1605
335.25-250.1317XL.50-8N-R8	02993842	Arbor hole	255,0	16,03	17,0	91,5	8	16	50,0	69,0	17,0	–	5800	3,9	RP..1605
R335.25-315.1317XL.60-10N-R8	02993830	Arbor	320,0	16,03	17,0	94,5	10	20	60,0	130,0	–	51,265	5200	8,6	RP..1605
335.25-315.1317XL.50-10N-R8	02993845	Arbor hole	320,0	16,03	17,0	124,0	10	20	50,0	69,0	17,0	–	5200	6,6	RP..1605
R335.25-250.1721XL.60-8N-R10	02993754	Arbor	255,0	20,03	21,0	62,0	8	16	60,0	130,0	–	51,515	4600	6,6	RP..2006
335.25-250.1721XL.50-8N-R10	02993775	Arbor hole	255,0	20,03	21,0	91,5	8	16	50,0	69,0	21,0	–	4600	4,9	RP..2006
R335.25-315.1721XL.60-10N-R10	02993757	Arbor	320,0	20,03	21,0	94,5	10	20	60,0	130,0	–	51,515	4100	9,9	RP..2006
335.25-315.1721XL.50-10N-R10	02993778	Arbor hole	320,0	20,03	21,0	124,1	10	20	50,0	69,0	21,0	–	4100	8,2	RP..2006

Width 0.631-0.827” - full side - radius profile - Adjustable design

Cutter 335.25 - Insert RP..1605/RP..2006 – Inch

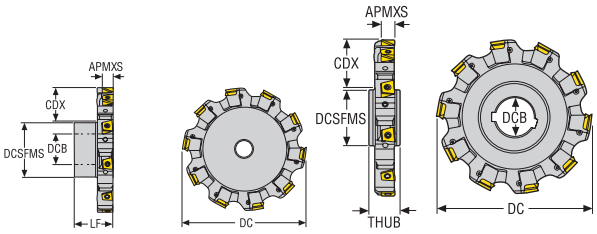


- For insert selection and cutting data recommendations, see page(s) 448-438
- For complete insert programme, see page(s) 750
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CWN	CWX	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch	Inch			Inch	Inch	Inch	Inch		lbs	
335.25-05.00-0911N-R8	02993969	Arbor hole	5.197	0.631	0.669	1.415	4	8	1.500	2.250	0.750	–	8200	2.200	RP..1605
335.25-06.00-0911N-R8	02993972	Arbor hole	6.197	0.631	0.669	1.914	5	10	1.500	2.250	0.750	–	7200	3.090	RP..1605
335.25-08.00-0911N-R8	02993975	Arbor hole	8.197	0.631	0.669	2.539	7	14	2.000	3.000	0.750	–	6500	5.730	RP..1605
335.25-10.00-XL0911N-R8	02993978	Arbor hole	10.197	0.631	0.669	3.539	8	16	2.000	3.000	0.750	–	5800	9.260	RP..1605
335.25-12.00-XL0911N-R8	02993981	Arbor hole	12.197	0.631	0.669	4.579	10	20	2.000	3.000	0.750	–	5200	13.670	RP..1605
R335.25-12.00-XL0911N-R8	02993966	Arbor	12.197	0.631	0.669	3.519	10	20	2.500	5.120	–	2.050	5200	31.530	RP..1605
R335.25-06.00-0911N-R8	02993957	Arbor	6.197	0.631	0.669	1.704	5	10	1.500	2.750	–	2.050	7200	4.850	RP..1605
R335.25-04.00-0911N-R8	02993951	Arbor	4.197	0.631	0.669	1.139	3	6	1.000	1.880	–	2.050	9200	2.200	RP..1605
R335.25-05.00-0911N-R8	02993954	Arbor	5.197	0.631	0.669	1.454	4	8	1.250	2.250	–	2.050	8200	3.310	RP..1605
R335.25-08.00-0911N-R8	02993960	Arbor	8.197	0.631	0.669	2.329	7	14	1.500	3.500	–	2.050	6500	8.160	RP..1605
R335.25-10.00-XL0911N-R8	02993963	Arbor	10.197	0.631	0.669	2.519	8	16	2.500	5.120	–	2.050	5800	13.670	RP..1605
335.25-10.00-XL1113N-R10	02993901	Arbor hole	10.197	0.789	0.827	3.539	8	16	2.000	3.000	1.000	–	4600	11.460	RP..1605
335.25-12.00-XL1113N-R10	02993904	Arbor hole	12.197	0.789	0.827	4.539	10	20	2.000	3.000	1.000	–	4100	17.200	RP..1605
R335.25-10.00-XL1113N-R10	02993874	Arbor	10.197	0.789	0.827	2.519	8	16	2.500	5.120	–	2.060	4600	15.210	RP..1605
R335.25-12.00-XL1113N-R10	02993878	Arbor	12.197	0.789	0.827	3.519	10	20	2.500	5.120	–	2.060	4100	20.720	RP..1605

Cutter 335.25 - Insert XNHQ – Metric

Max depth of cut 9-11,1 mm - Half side - Right hand with cassette

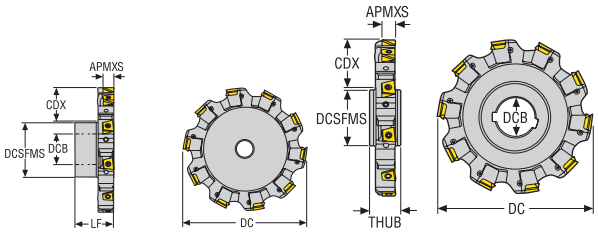


- For insert selection and cutting data recommendations, see page(s) 425-428
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm		kg	
R335.25-100.1317.27-6R	02993783	Arbor	100,0	9,0	24,8	6	27,0	48,0	–	50,0	9200	1,2	XNHQ09..
R335.25-125.1317.32-8R	02993786	Arbor	125,0	9,0	32,3	8	32,0	58,0	–	50,0	8200	1,4	XNHQ09..
335.25-125.1317.40-8R	02993801	Arbor hole	125,0	9,0	32,9	8	40,0	55,0	17,0	–	8200	0,9	XNHQ09..
R335.25-160.1317.40-12R	02993789	Arbor	160,0	9,0	43,8	12	40,0	70,0	–	50,0	7200	2,3	XNHQ09..
335.25-160.1317.40-12R	02993804	Arbor hole	160,0	8,5	50,5	12	40,0	55,0	17,0	–	7200	1,5	XNHQ09..
R335.25-200.1317.40-14R	02993792	Arbor	200,0	9,0	54,0	14	40,0	90,0	–	50,0	6500	3,6	XNHQ09..
335.25-200.1317.50-14R	02993807	Arbor hole	200,0	8,5	63,5	14	50,0	69,0	17,0	–	6500	3,1	XNHQ09..
R335.25-250.1317XL.60-16R	02993795	Arbor	250,0	9,0	59,0	16	60,0	130,0	–	50,0	5800	6,0	XNHQ09..
335.25-250.1317XL.50-16R	02993810	Arbor hole	250,0	9,0	88,5	16	50,0	69,0	17,0	–	5800	3,8	XNHQ09..
R335.25-315.1317XL.60-20R	02993798	Arbor	315,0	9,0	91,5	20	60,0	130,0	–	50,0	5200	8,5	XNHQ09..
335.25-315.1317XL.50-20R	02993813	Arbor hole	315,0	9,0	121,0	20	50,0	69,0	17,0	–	5200	6,4	XNHQ09..
R335.25-100.1721.27-6R	02993737	Arbor	100,0	11,1	24,8	6	27,0	48,0	–	50,0	7200	1,1	XNHQ12..
R335.25-125.1721.32-8R	02993740	Arbor	125,0	11,1	32,3	8	32,0	58,0	–	50,0	6500	1,6	XNHQ12..
335.25-125.1721.40-8R	02993761	Arbor hole	125,0	11,1	32,9	8	40,0	55,0	21,0	–	6500	1,0	XNHQ12..
R335.25-160.1721.40-10R	02993743	Arbor	160,0	11,1	43,8	10	40,0	70,0	–	50,0	5700	3,2	XNHQ12..
335.25-160.1721.40-10R	02993764	Arbor hole	160,0	11,1	50,5	10	40,0	55,0	21,0	–	5700	1,9	XNHQ12..
R335.25-200.1721.40-12R	02993746	Arbor	200,0	11,1	54,0	12	40,0	90,0	–	50,0	5100	4,1	XNHQ12..
335.25-200.1721.50-12R	02993767	Arbor hole	200,0	11,1	63,5	12	50,0	69,0	21,0	–	5100	3,1	XNHQ12..
R335.25-250.1721XL.60-16R	02993749	Arbor	250,0	11,1	59,0	16	60,0	130,0	–	50,0	4600	6,7	XNHQ12..
335.25-250.1721XL.50-16R	02993770	Arbor hole	250,0	11,1	88,5	16	50,0	69,0	21,0	–	4600	8,2	XNHQ12..
R335.25-315.1721XL.60-20R	02993752	Arbor	315,0	11,1	91,5	20	60,0	130,0	–	50,0	4100	9,9	XNHQ12..
335.25-315.1721XL.50-20R	02993773	Arbor hole	315,0	11,1	121,0	20	50,0	69,0	21,0	–	4100	8,1	XNHQ12..

Max depth of cut 13-16 mm - Half side - Right hand with cassette

Cutter 335.25 - Insert XNHQ/LNHQ – Metric

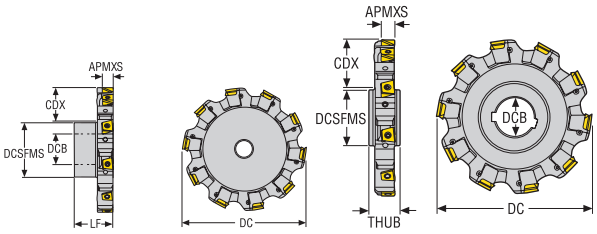


- For insert selection and cutting data recommendations, see page(s) 429-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			mm	mm	mm		mm	mm	mm	mm		kg		
R335.25-125.2126.32-8R	02814580	Arbor	125,0	13,0	32,3	8	32,0	58,0	–	50,0	4900	1,7	XNHQ1407...	LNHQ1407...
335.25-125.2126.40-8R	02814601	Arbor hole	125,0	13,0	32,7	8	40,0	55,0	32,0	–	4900	1,3	XNHQ1407...	LNHQ1407...
R335.25-160.2126.40-10R	02814584	Arbor	160,0	13,0	43,8	10	40,0	70,0	–	50,0	4400	2,9	XNHQ1407...	LNHQ1407...
335.25-160.2126.40-10R	02814605	Arbor hole	160,0	13,0	50,3	10	40,0	55,0	32,0	–	4400	2,3	XNHQ1407...	LNHQ1407...
R335.25-200.2126.40-12R	02814588	Arbor	200,0	13,0	54,0	12	40,0	90,0	–	50,0	3900	4,6	XNHQ1407...	LNHQ1407...
335.25-200.2126.50-12R	02814609	Arbor hole	200,0	13,0	63,3	12	50,0	69,0	32,0	–	3900	3,9	XNHQ1407...	LNHQ1407...
R335.25-250.2126XL.60-14R	02814592	Arbor	250,0	13,0	59,0	14	60,0	130,0	–	50,0	3500	7,3	XNHQ1407...	LNHQ1407...
335.25-250.2126XL.50-14R	02814613	Arbor hole	250,0	13,0	88,3	14	50,0	69,0	32,0	–	3500	6,0	XNHQ1407...	LNHQ1407...
R335.25-315.2126XL.60-18R	02814597	Arbor	315,0	13,0	91,5	18	60,0	130,0	–	50,0	3100	11,3	XNHQ1407...	LNHQ1407...
335.25-315.2126XL.60-18R	02814617	Arbor hole	315,0	13,0	113,3	18	60,0	84,0	32,0	–	3100	10,0	XNHQ1407...	LNHQ1407...
R335.25-160.2632.40-10R	02827413	Arbor	160,0	16,0	43,8	10	40,0	70,0	–	50,0	4600	3,4	XNHQ1707...	LNHQ1707...
335.25-160.2632.40-10R	02829067	Arbor hole	160,0	16,0	50,3	10	40,0	55,0	32,0	–	4600	2,9	XNHQ1707...	LNHQ1707...
R335.25-200.2632.40-12R	02827417	Arbor	200,0	16,0	54,0	12	40,0	90,0	–	50,0	4100	5,4	XNHQ1707...	LNHQ1707...
335.25-200.2632.50-12R	02827443	Arbor hole	200,0	16,0	63,3	12	50,0	69,0	32,0	–	4100	5,2	XNHQ1707...	LNHQ1707...
R335.25-250.2632XL.60-14R	02827421	Arbor	250,0	16,0	59,0	14	60,0	130,0	–	50,0	3700	8,4	XNHQ1707...	LNHQ1707...
335.25-250.2632XL.50-14R	02827447	Arbor hole	250,0	16,0	88,3	14	50,0	69,0	32,0	–	3700	7,4	XNHQ1707...	LNHQ1707...
R335.25-315.2632XL.60-18R	02827425	Arbor	315,0	16,0	91,5	18	60,0	130,0	–	50,0	3300	13,4	XNHQ1707...	LNHQ1707...
335.25-315.2632XL.60-18R	02827451	Arbor hole	315,0	16,0	113,3	18	60,0	84,0	32,0	–	3300	12,3	XNHQ1707...	LNHQ1707...

Cutter 335.25 - Insert XNHQ – Inch

Max depth of cut 0.354 - 0.437” - Half side - Right hand with cassette

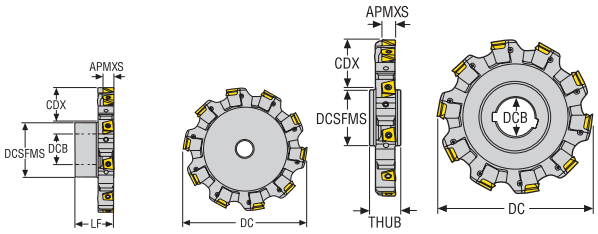


- For insert selection and cutting data recommendations, see page(s) 425-428
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs	
R335.25-04.00-0911R	02993909	Arbor	4.000	0.354	1.014	6	1.000	1.880	–	2.000	9200	2.200	XNHQ09
R335.25-05.00-0911R	02993913	Arbor	5.000	0.354	1.329	8	1.250	2.250	–	2.000	8200	3.310	XNHQ09
335.25-05.00-0911R	02993933	Arbor hole	5.000	0.354	1.289	8	1.500	2.250	0.750	–	8200	2.200	XNHQ09
R335.25-06.00-0911R	02993917	Arbor	6.000	0.354	1.579	10	1.500	2.750	–	2.000	7200	6.390	XNHQ09
335.25-06.00-0911R	02993937	Arbor hole	6.000	0.354	1.795	10	1.500	2.250	0.750	–	7200	3.090	XNHQ09
R335.25-08.00-0911R	02993921	Arbor	8.000	0.354	2.210	14	1.500	3.500	–	2.000	6500	8.160	XNHQ09
335.25-08.00-0911R	02993941	Arbor hole	8.000	0.354	2.420	14	2.000	3.000	0.750	–	6500	5.730	XNHQ09
R335.25-10.00-XL0911R	02993925	Arbor	10.000	0.354	2.400	16	2.500	5.120	–	2.000	5800	13.450	XNHQ09
335.25-10.00-XL0911R	02993945	Arbor hole	10.000	0.354	3.420	16	2.000	3.000	0.750	–	5800	9.040	XNHQ09
R335.25-12.00-XL0911R	02993929	Arbor	12.000	0.354	3.400	20	2.500	5.120	–	2.000	5200	17.860	XNHQ09
335.25-12.00-XL0911R	02993949	Arbor hole	12.000	0.354	4.460	20	2.000	3.000	0.750	–	5200	13.450	XNHQ09
R335.25-04.00-1113R	02993852	Arbor	4.000	0.437	1.014	6	1.000	1.880	–	2.000	7200	2.430	XNHQ12
R335.25-05.00-1113R	02993856	Arbor	5.000	0.437	1.329	8	1.250	2.250	–	2.000	6500	3.750	XNHQ12
335.25-05.00-1113R	02993883	Arbor hole	5.000	0.437	1.289	8	1.500	2.250	1.000	–	6500	2.650	XNHQ12
R335.25-06.00-1113R	02993860	Arbor	6.000	0.437	1.579	10	1.500	2.750	–	2.000	5700	5.510	XNHQ12
335.25-06.00-1113R	02993887	Arbor hole	6.000	0.437	1.795	10	1.500	2.250	1.000	–	5700	3.970	XNHQ12
R335.25-08.00-1113R	02993864	Arbor	8.000	0.437	2.210	12	1.500	3.500	–	2.000	5100	9.700	XNHQ12
335.25-08.00-1113R	02993891	Arbor hole	8.000	0.437	2.420	12	2.000	3.000	1.000	–	5100	7.500	XNHQ12
R335.25-10.00-XL1113R	02993868	Arbor	10.000	0.437	2.400	16	2.500	5.120	–	2.000	4600	15.210	XNHQ12
335.25-10.00-XL1113R	02993895	Arbor hole	10.000	0.437	3.420	16	2.000	3.000	1.000	–	4600	11.460	XNHQ12
R335.25-12.00-XL1113R	02993872	Arbor	12.000	0.437	3.400	20	2.500	5.120	–	2.000	4100	20.720	XNHQ12
335.25-12.00-XL1113R	02993899	Arbor hole	12.000	0.437	4.420	20	2.000	3.000	1.000	–	4100	16.980	XNHQ12

Max depth of cut 0.512 - 0.630” - Half side - Right hand with cassette

Cutter 335.25 - Insert XNHQ/LNHQ – Inch

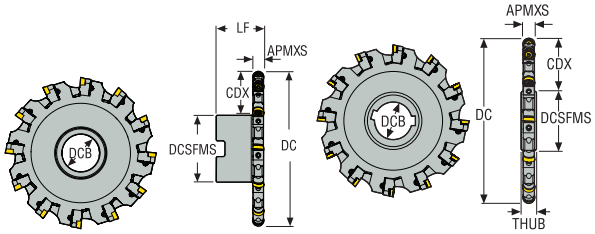


- For insert selection and cutting data recommendations, see page(s) 429-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs		
R335.25-05.00-1316R	02814621	Arbor	5.000	0.512	1.327	8	1.250	2.250	–	2.000	4900	3.970	XNHQ14	LNHQ14
335.25-05.00-1316R	02814641	Arbor hole	5.000	0.512	1.291	8	1.500	2.250	1.250	–	4900	3.090	XNHQ14	LNHQ14
R335.25-06.00-1316R	02814625	Arbor	6.000	0.512	1.579	10	1.500	2.750	–	2.000	4500	5.950	XNHQ14	LNHQ14
335.25-06.00-1316R	02814645	Arbor hole	6.000	0.512	1.791	10	1.500	2.250	1.250	–	4500	4.850	XNHQ14	LNHQ14
R335.25-08.00-1316R	02814629	Arbor	8.000	0.512	2.209	12	1.500	3.500	–	2.000	3900	12.130	XNHQ14	LNHQ14
335.25-08.00-1316R	02814649	Arbor hole	8.000	0.512	2.413	12	2.000	3.000	1.250	–	3900	9.040	XNHQ14	LNHQ14
R335.25-10.00-XL1316R	02814633	Arbor	10.000	0.512	2.402	14	2.500	5.118	–	2.000	3500	16.530	XNHQ14	LNHQ14
335.25-10.00-XL1316R	02814653	Arbor hole	10.000	0.512	3.413	14	2.000	3.000	1.250	–	3500	13.890	XNHQ14	LNHQ14
R335.25-12.00-XL1316R	02814637	Arbor	12.000	0.512	3.402	18	2.500	5.118	–	2.000	3200	23.150	XNHQ14	LNHQ14
335.25-12.00-XL1316R	02814657	Arbor hole	12.000	0.512	4.413	18	2.000	3.000	1.250	–	3200	20.720	XNHQ14	LNHQ14
R335.25-06.00-1620R	02827715	Arbor	6.000	0.630	1.579	10	1.500	2.750	–	2.000	4700	6.830	XNHQ17	LNHQ17
335.25-06.00-1620R	02827738	Arbor hole	6.000	0.630	1.791	10	1.500	2.250	1.250	–	4700	5.730	XNHQ17	LNHQ17
R335.25-08.00-1620R	02827719	Arbor	8.000	0.630	2.209	12	1.500	3.500	–	2.000	4100	12.570	XNHQ17	LNHQ17
335.25-08.00-1620R	02827742	Arbor hole	8.000	0.630	2.413	12	2.000	3.000	1.250	–	4100	11.020	XNHQ17	LNHQ17
R335.25-10.00-XL1620R	02827723	Arbor	10.000	0.630	2.402	14	2.500	5.118	–	2.000	3600	18.740	XNHQ17	LNHQ17
335.25-10.00-XL1620R	02827746	Arbor hole	10.000	0.630	3.413	14	2.000	3.000	1.250	–	3600	16.980	XNHQ17	LNHQ17
R335.25-12.00-XL1620R	02827727	Arbor	12.000	0.630	3.402	18	2.500	5.118	–	2.000	3300	27.340	XNHQ17	LNHQ17
335.25-12.00-XL1620R	02827750	Arbor hole	12.000	0.630	4.413	18	2.000	3.000	1.250	–	3300	25.350	XNHQ17	LNHQ17

Cutter 335.25 - Insert RP..1605/RP..2006 – Metric

Half side - Right hand - Radius profile with cassette

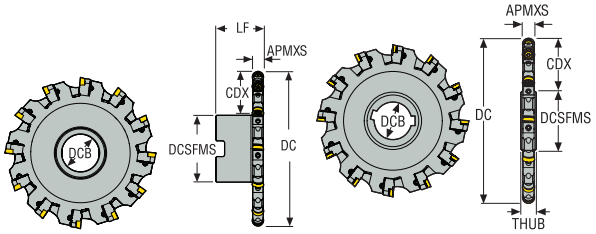


- For insert selection and cutting data recommendations, see page(s) 448-453
- For complete insert programme, see page(s) 750
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm			mm	mm	mm	mm		kg	
R335.25-100.1317.27-6R-R8	02993816	Arbor	105,0	8,0	28,0	6	6	27,0	48,0	–	51,265	9200	1,0	RP..1605
R335.25-125.1317.32-8R-R8	02993819	Arbor	130,0	8,0	35,5	8	8	32,0	58,0	–	51,265	8200	1,4	RP..1605
335.25-125.1317.40-8R-R8	02993834	Arbor hole	130,0	8,0	36,1	8	8	40,0	55,0	17,0	–	8200	0,9	RP..1605
R335.25-160.1317.40-12R-R8	02993822	Arbor	165,0	8,0	47,0	12	12	40,0	70,0	–	51,265	7200	2,3	RP..1605
335.25-160.1317.40-12R-R8	02993837	Arbor hole	165,0	8,0	53,6	12	12	40,0	55,0	17,0	–	7200	1,5	RP..1605
R335.25-200.1317.40-14R-R8	02993825	Arbor	205,0	8,0	57,0	14	14	40,0	90,0	–	51,265	6500	3,5	RP..1605
335.25-200.1317.50-14R-R8	02993840	Arbor hole	205,0	8,0	66,6	14	14	50,0	69,0	17,0	–	6500	2,4	RP..1605
R335.25-250.1317XL.60-16R-R8	02993828	Arbor	255,0	8,0	62,0	16	16	60,0	130,0	–	51,265	5800	6,0	RP..1605
335.25-250.1317XL.50-16R-R8	02993843	Arbor hole	255,0	8,0	91,6	16	16	50,0	69,0	17,0	–	5800	4,0	RP..1605
R335.25-315.1317XL.60-20R-R8	02993831	Arbor	320,0	8,0	94,5	20	20	60,0	130,0	–	51,265	5200	8,6	RP..1605
335.25-315.1317XL.50-20R-R8	02993846	Arbor hole	320,0	8,0	124,1	20	20	50,0	69,0	17,0	–	5200	6,6	RP..1605
R335.25-250.1721XL.60-16R-R10	02993755	Arbor	255,0	10,0	62,0	16	16	60,0	130,0	–	51,515	4600	6,7	RP..2006
335.25-250.1721XL.50-16R-R10	02993776	Arbor hole	255,0	10,0	91,6	16	16	50,0	69,0	21,0	–	4600	5,0	RP..2006
R335.25-315.1721XL.60-20R-R10	02993758	Arbor	320,0	10,0	94,5	20	20	60,0	130,0	–	51,515	4100	10,0	RP..2006
335.25-315.1721XL.50-20R-R10	02993779	Arbor hole	320,0	10,0	124,1	20	20	50,0	69,0	21,0	–	4100	8,2	RP..2006

Half side - Right hand - Radius profile with cassette

Cutter 335.25 - Insert RP..1605/RP..2006 – Inch

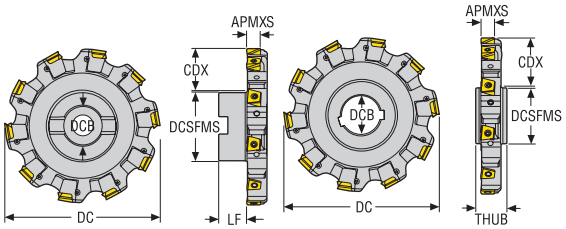


- For insert selection and cutting data recommendations, see page(s) 448-453
- For complete insert programme, see page(s) 750
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch			Inch	Inch	Inch	Inch		lbs	
R335.25-04.00-0911R-R8	02993952	Arbor	4.197	0.315	1.138	6	6	1.000	1.880	–	2.050	9200	2.200	RP..1605
R335.25-05.00-0911R-R8	02993955	Arbor	5.197	0.315	1.453	8	8	1.250	2.250	–	2.050	8200	3.310	RP..1605
335.25-05.00-0911R-R8	02993970	Arbor hole	5.197	0.315	1.414	8	8	1.500	2.250	0.750	–	8200	2.200	RP..1605
R335.25-06.00-0911R-R8	02993958	Arbor	6.197	0.315	1.703	10	10	1.500	2.750	–	2.050	7200	4.850	RP..1605
335.25-06.00-0911R-R8	02993973	Arbor hole	6.197	0.315	1.914	10	10	1.500	2.250	0.750	–	7200	3.090	RP..1605
R335.25-08.00-0911R-R8	02993961	Arbor	8.197	0.315	2.329	14	14	1.500	3.500	–	2.050	6500	8.160	RP..1605
335.25-08.00-0911R-R8	02993976	Arbor hole	8.197	0.315	2.539	14	14	2.000	3.000	0.750	–	6500	5.730	RP..1605
R335.25-10.00-XL0911R-R8	02993964	Arbor	10.197	0.315	2.519	16	16	2.500	5.120	–	2.050	5800	13.670	RP..1605
335.25-10.00-XL0911R-R8	02993979	Arbor hole	10.197	0.315	3.539	16	16	2.000	3.000	0.750	–	5800	9.260	RP..1605
R335.25-12.00-XL0911R-R8	02993967	Arbor	12.197	0.315	3.519	20	20	2.500	5.120	–	2.050	5200	18.080	RP..1605
335.25-12.00-XL0911R-R8	02993982	Arbor hole	12.197	0.315	4.579	20	20	2.000	3.000	0.750	–	5200	13.450	RP..1605
R335.25-10.00-XL1113R-R10	02993875	Arbor	10.197	0.394	2.519	16	16	2.500	5.120	–	2.060	4600	15.210	RP..2006
335.25-10.00-XL1113R-R10	02993902	Arbor hole	10.197	0.394	3.539	16	16	2.000	3.000	1.000	–	4600	11.460	RP..2006
R335.25-12.00-XL1113R-R10	02993879	Arbor	12.197	0.394	3.519	20	20	2.500	5.120	–	2.060	4100	20.720	RP..2006
335.25-12.00-XL1113R-R10	02993905	Arbor hole	12.197	0.394	4.539	20	20	2.000	3.000	1.000	–	4100	17.200	RP..2006

Cutter 335.25 - Insert XNHQ – Metric

Max depth of cut 9-11,1 mm – Half side – Left hand with cassette

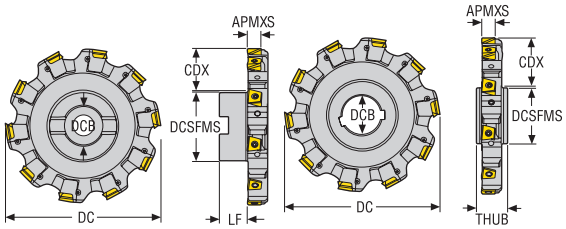


- For insert selection and cutting data recommendations, see page(s) 425-428
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm		mm	mm	mm	mm		kg	
R335.25-100.1317.27-6L	02993784	Arbor	100,0	9,0	24,8	6	27,0	48,0	–	50,0	9200	1,4	XNHQ09..
R335.25-125.1317.32-8L	02993787	Arbor	125,0	9,0	32,3	8	32,0	58,0	–	50,0	8200	1,4	XNHQ09..
335.25-125.1317.40-8L	02993802	Arbor hole	125,0	9,0	32,9	8	40,0	55,0	17,0	–	8200	0,9	XNHQ09..
R335.25-160.1317.40-12L	02993790	Arbor	160,0	9,0	43,8	12	40,0	70,0	–	50,0	7200	2,3	XNHQ09..
335.25-160.1317.40-12L	02993805	Arbor hole	160,0	9,0	50,5	12	40,0	55,0	17,0	–	7200	1,5	XNHQ09..
R335.25-200.1317.40-14L	02993793	Arbor	200,0	9,0	54,0	14	40,0	90,0	–	50,0	6500	3,5	XNHQ09..
335.25-200.1317.50-14L	02993808	Arbor hole	200,0	9,0	63,5	14	50,0	69,0	17,0	–	6500	3,1	XNHQ09..
R335.25-250.1317XL.60-16L	02993796	Arbor	250,0	9,0	59,0	16	60,0	130,0	–	50,0	5800	5,9	XNHQ09..
335.25-250.1317XL.50-16L	02993811	Arbor hole	250,0	9,0	88,5	16	50,0	69,0	17,0	–	5800	3,8	XNHQ09..
R335.25-315.1317XL.60-20L	02993799	Arbor	315,0	9,0	91,5	20	60,0	130,0	–	50,0	5200	8,5	XNHQ09..
335.25-315.1317XL.50-20L	02993814	Arbor hole	315,0	9,0	121,0	20	50,0	69,0	17,0	–	5200	6,5	XNHQ09..
R335.25-100.1721.27-6L	02993738	Arbor	100,0	11,1	24,8	6	27,0	48,0	–	50,0	7200	1,1	XNHQ12..
R335.25-125.1721.32-8L	02993741	Arbor	125,0	11,1	32,3	8	32,0	58,0	–	50,0	6500	1,9	XNHQ12..
335.25-125.1721.40-8L	02993762	Arbor hole	125,0	11,1	32,9	8	40,0	55,0	21,0	–	6500	1,1	XNHQ12..
R335.25-160.1721.40-10L	02993744	Arbor	160,0	11,1	43,8	10	40,0	70,0	–	50,0	5700	2,8	XNHQ12..
335.25-160.1721.40-10L	02993765	Arbor hole	160,0	11,1	50,5	10	40,0	55,0	21,0	–	5700	1,9	XNHQ12..
R335.25-200.1721.40-12L	02993747	Arbor	200,0	11,1	54,0	12	40,0	90,0	–	50,0	5100	4,5	XNHQ12..
335.25-200.1721.50-12L	02993768	Arbor hole	200,0	11,1	63,5	12	50,0	69,0	21,0	–	5100	3,2	XNHQ12..
R335.25-250.1721XL.60-16L	02993750	Arbor	250,0	11,1	59,0	16	60,0	130,0	–	50,0	4600	6,7	XNHQ12..
335.25-250.1721XL.50-16L	02993771	Arbor hole	250,0	11,1	88,5	16	50,0	69,0	21,0	–	4600	4,9	XNHQ12..
R335.25-315.1721XL.60-20L	02993753	Arbor	315,0	11,1	91,5	20	60,0	130,0	–	50,0	4100	10,0	XNHQ12..
335.25-315.1721XL.50-20L	02993774	Arbor hole	315,0	11,1	121,0	20	50,0	69,0	21,0	–	4100	8,1	XNHQ12..

Max depth of cut 13-16 mm – Half side – Left hand with cassette

Cutter 335.25 - Insert XNHQ/LNHQ – Metric

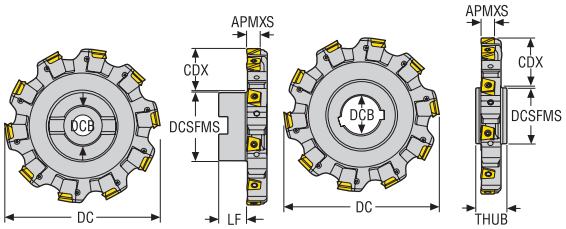


- For insert selection and cutting data recommendations, see page(s) 429-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			mm	mm	mm		mm	mm	mm	mm		kg		
R335.25-125.2126.32-8L	02814581	Arbor	125,0	13,0	32,3	8	32,0	58,0	–	29,0	4900	1,7	XNHQ1407...	LNHQ1407...
335.25-125.2126.40-8L	02814602	Arbor hole	125,0	13,0	32,7	8	40,0	55,0	32,0	–	4900	1,3	XNHQ1407...	LNHQ1407...
R335.25-160.2126.40-10L	02814585	Arbor	160,0	13,0	43,8	10	40,0	70,0	–	29,0	4400	2,9	XNHQ1407...	LNHQ1407...
335.25-160.2126.40-10L	02814606	Arbor hole	160,0	13,0	50,3	10	40,0	55,0	32,0	–	4400	2,3	XNHQ1407...	LNHQ1407...
R335.25-200.2126.40-12L	02814589	Arbor	200,0	13,0	54,0	12	40,0	90,0	–	29,0	3900	5,1	XNHQ1407...	LNHQ1407...
335.25-200.2126.50-12L	02814610	Arbor hole	200,0	13,0	63,3	12	50,0	69,0	32,0	–	3900	3,9	XNHQ1407...	LNHQ1407...
R335.25-250.2126XL.60-14L	02814593	Arbor	250,0	13,0	59,0	14	60,0	130,0	–	29,0	3500	7,3	XNHQ1407...	LNHQ1407...
335.25-250.2126XL.50-14L	02814614	Arbor hole	250,0	13,0	88,3	14	50,0	69,0	32,0	–	3500	6,0	XNHQ1407...	LNHQ1407...
R335.25-315.2126XL.60-18L	02814598	Arbor	315,0	13,0	91,5	18	60,0	130,0	–	29,0	3100	11,3	XNHQ1407...	LNHQ1407...
335.25-315.2126XL.60-18L	02814618	Arbor hole	315,0	13,0	113,3	18	60,0	84,0	32,0	–	3100	10,0	XNHQ1407...	LNHQ1407...
R335.25-160.2632.40-10L	02827414	Arbor	160,0	16,0	43,8	10	40,0	70,0	–	24,0	4600	3,4	XNHQ1707...	LNHQ1707...
335.25-160.2632.40-10L	02829068	Arbor hole	160,0	16,0	50,3	10	40,0	55,0	32,0	–	4600	2,9	XNHQ1707...	LNHQ1707...
R335.25-200.2632.40-12L	02827418	Arbor	200,0	16,0	54,0	12	40,0	90,0	–	24,0	4100	5,4	XNHQ1707...	LNHQ1707...
335.25-200.2632.50-12L	02827444	Arbor hole	200,0	16,0	63,3	12	50,0	69,0	32,0	–	4100	4,8	XNHQ1707...	LNHQ1707...
R335.25-250.2632XL.60-14L	02827422	Arbor	250,0	16,0	59,0	14	60,0	130,0	–	24,0	3700	8,4	XNHQ1707...	LNHQ1707...
335.25-250.2632XL.50-14L	02827448	Arbor hole	250,0	16,0	88,3	14	50,0	69,0	32,0	–	3700	7,4	XNHQ1707...	LNHQ1707...
R335.25-315.2632XL.60-18L	02827426	Arbor	315,0	16,0	91,5	18	60,0	130,0	–	24,0	3300	13,4	XNHQ1707...	LNHQ1707...
335.25-315.2632XL.60-18L	02827452	Arbor hole	315,0	16,0	113,3	18	60,0	84,0	32,0	–	3300	12,3	XNHQ1707...	LNHQ1707...

Cutter 335.25 - Insert XNHQ – Inch

Max depth of cut 0.354-0.437” – Half side – Left hand with cassette

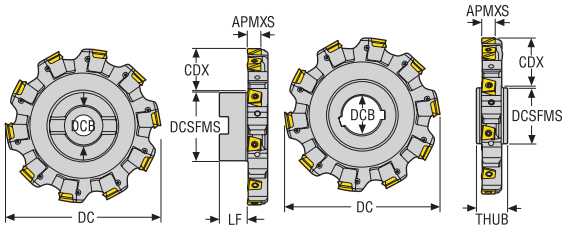


- For insert selection and cutting data recommendations, see page(s) 425-428
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs	
R335.25-04.00-0911L	02993910	Arbor	4.000	0.354	1.014	6	1.000	1.880	–	2.000	9200	2.200	XNHQ09
R335.25-05.00-0911L	02993914	Arbor	5.000	0.354	1.329	8	1.250	2.250	–	2.000	8200	3.310	XNHQ09
335.25-05.00-0911L	02993934	Arbor hole	5.000	0.354	1.289	8	1.500	2.250	0.750	–	8200	2.200	XNHQ09
R335.25-06.00-0911L	02993918	Arbor	6.000	0.354	1.579	10	1.500	2.750	–	2.000	7200	4.850	XNHQ09
335.25-06.00-0911L	02993938	Arbor hole	6.000	0.354	1.795	10	1.500	2.250	0.750	–	7200	3.090	XNHQ09
R335.25-08.00-0911L	02993922	Arbor	8.000	0.354	2.210	14	1.500	3.500	–	2.000	6500	8.160	XNHQ09
335.25-08.00-0911L	02993942	Arbor hole	8.000	0.354	2.420	14	2.000	3.000	0.750	–	6500	5.730	XNHQ09
R335.25-10.00-XL0911L	02993926	Arbor	10.000	0.354	2.400	16	2.500	5.120	–	2.000	5800	13.450	XNHQ09
335.25-10.00-XL0911L	02993946	Arbor hole	10.000	0.354	3.420	16	2.000	3.000	0.750	–	5800	9.040	XNHQ09
R335.25-12.00-XL0911L	02993930	Arbor	12.000	0.354	3.400	20	2.500	5.120	–	2.000	5200	17.860	XNHQ09
335.25-12.00-XL0911L	02993950	Arbor hole	12.000	0.354	4.460	20	2.000	3.000	0.750	–	5200	13.450	XNHQ09
R335.25-04.00-1113L	02993853	Arbor	4.000	0.437	1.014	6	1.000	1.880	–	2.000	7200	2.430	XNHQ12
R335.25-05.00-1113L	02993857	Arbor	5.000	0.437	1.329	8	1.250	2.250	–	2.000	6500	3.750	XNHQ12
335.25-05.00-1113L	02993884	Arbor hole	5.000	0.437	1.289	8	1.500	2.250	1.000	–	6500	2.650	XNHQ12
R335.25-06.00-1113L	02993861	Arbor	6.000	0.437	1.579	10	1.500	2.750	–	2.000	5700	5.510	XNHQ12
335.25-06.00-1113L	02993888	Arbor hole	6.000	0.437	1.795	10	1.500	2.250	1.000	–	5700	3.970	XNHQ12
R335.25-08.00-1113L	02993865	Arbor	8.000	0.437	2.210	12	1.500	3.500	–	2.000	5100	9.700	XNHQ12
335.25-08.00-1113L	02993892	Arbor hole	8.000	0.437	2.420	12	2.000	3.000	1.000	–	5100	7.500	XNHQ12
R335.25-10.00-XL1113L	02993869	Arbor	10.000	0.437	2.400	16	2.500	5.120	–	2.000	4600	15.210	XNHQ12
335.25-10.00-XL1113L	02993896	Arbor hole	10.000	0.437	3.420	16	2.000	3.000	1.000	–	4600	11.460	XNHQ12
R335.25-12.00-XL1113L	02993873	Arbor	12.000	0.437	3.400	20	2.500	5.120	–	2.000	4100	20.720	XNHQ12
335.25-12.00-XL1113L	02993900	Arbor hole	12.000	0.437	4.420	20	2.000	3.000	1.000	–	4100	16.980	XNHQ12

Max depth of cut 0.512-0.630” – Half side – Left hand with cassette

Cutter 335.25 - Insert XNHQ/LNHQ – Inch

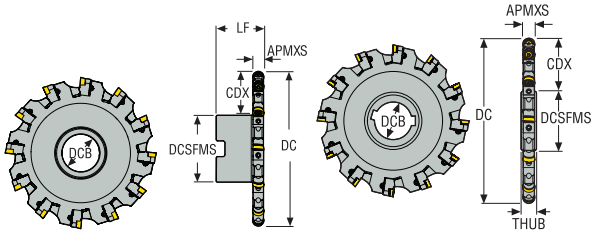


- For insert selection and cutting data recommendations, see page(s) 429-432
- For complete insert programme, see page(s) 773, 774
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert: First choice	Insert: Alternative choice
			Inch	Inch	Inch		Inch	Inch	Inch	Inch		lbs		
R335.25-05.00-1316L	02814622	Arbor	5.000	0.512	1.327	8	1.250	2.250	–	1.173	4900	3.970	XNHQ14	LNHQ14
335.25-05.00-1316L	02814642	Arbor hole	5.000	0.512	1.291	8	1.500	2.250	1.250	–	4900	3.090	XNHQ14	LNHQ14
R335.25-06.00-1316L	02814626	Arbor	6.000	0.512	1.579	10	1.500	2.750	–	1.173	4500	5.950	XNHQ14	LNHQ14
335.25-06.00-1316L	02814646	Arbor hole	6.000	0.512	1.791	10	1.500	2.250	1.250	–	4500	4.850	XNHQ14	LNHQ14
R335.25-08.00-1316L	02814630	Arbor	8.000	0.512	2.209	12	1.500	3.500	–	1.173	3900	10.800	XNHQ14	LNHQ14
335.25-08.00-1316L	02814650	Arbor hole	8.000	0.512	2.413	12	2.000	3.000	1.250	–	3900	9.040	XNHQ14	LNHQ14
R335.25-10.00-XL1316L	02814634	Arbor	10.000	0.512	2.402	14	2.500	5.120	–	1.173	3500	16.530	XNHQ14	LNHQ14
335.25-10.00-XL1316L	02814654	Arbor hole	10.000	0.512	3.413	14	2.000	3.000	1.250	–	3500	13.890	XNHQ14	LNHQ14
R335.25-12.00-XL1316L	02814638	Arbor	12.000	0.512	3.402	18	2.500	5.120	–	1.173	3200	23.150	XNHQ14	LNHQ14
335.25-12.00-XL1316L	02814658	Arbor hole	12.000	0.512	4.413	18	2.000	3.000	1.250	–	3200	20.720	XNHQ14	LNHQ14
R335.25-06.00-1620L	02827716	Arbor	6.000	0.630	1.579	10	1.500	2.750	–	0.976	4700	6.830	XNHQ17	LNHQ17
335.25-06.00-1620L	02827739	Arbor hole	6.000	0.630	1.791	10	1.500	2.250	1.250	–	4700	5.730	XNHQ17	LNHQ17
R335.25-08.00-1620L	02827720	Arbor	8.000	0.630	2.209	12	1.500	3.500	–	0.976	4100	12.570	XNHQ17	LNHQ17
335.25-08.00-1620L	02827743	Arbor hole	8.000	0.630	2.413	12	2.000	3.000	1.250	–	4100	11.020	XNHQ17	LNHQ17
R335.25-10.00-XL1620L	02827724	Arbor	10.000	0.630	2.402	14	2.500	5.120	–	0.976	3600	18.740	XNHQ17	LNHQ17
335.25-10.00-XL1620L	02827747	Arbor hole	10.000	0.630	3.413	14	2.000	3.000	1.250	–	3600	16.980	XNHQ17	LNHQ17
R335.25-12.00-XL1620L	02827728	Arbor	12.000	0.630	3.402	18	2.500	5.120	–	0.976	3300	27.340	XNHQ17	LNHQ17
335.25-12.00-XL1620L	02827751	Arbor hole	12.000	0.630	4.413	18	2.000	3.000	1.250	–	3300	25.350	XNHQ17	LNHQ17

Cutter 335.25 - Insert RP..1605/RP..2006 – Metric

Half side - Left hand - Radius profile with cassette

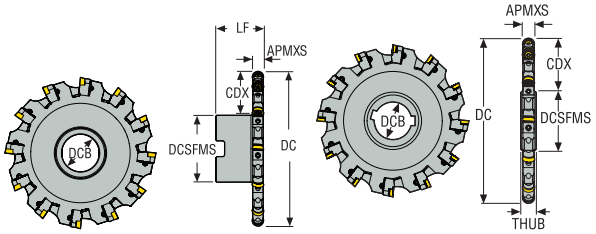


- For insert selection and cutting data recommendations, see page(s) 448-453
- For complete insert programme, see page(s) 750
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			mm	mm	mm			mm	mm	mm	mm		kg	
R335.25-100.1317.27-6L-R8	02993817	Arbor	105,0	8,0	28,0	6	6	27,0	48,0	–	51,265	9200	1,0	RP..1605
R335.25-125.1317.32-8L-R8	02993820	Arbor	130,0	8,0	35,5	8	8	32,0	58,0	–	51,265	8200	1,4	RP..1605
335.25-125.1317.40-8L-R8	02993835	Arbor hole	130,0	8,0	36,1	8	8	40,0	55,0	17,0	–	8200	0,9	RP..1605
R335.25-160.1317.40-12L-R8	02993823	Arbor	165,0	8,0	47,0	12	12	40,0	70,0	–	51,265	7200	2,3	RP..1605
335.25-160.1317.40-12L-R8	02993838	Arbor hole	165,0	8,0	53,6	12	12	40,0	55,0	17,0	–	7200	1,5	RP..1605
R335.25-200.1317.40-14L-R8	02993826	Arbor	205,0	8,0	57,0	14	14	40,0	90,0	–	51,265	6500	3,5	RP..1605
335.25-200.1317.50-14L-R8	02993841	Arbor hole	205,0	8,0	66,6	14	14	50,0	69,0	17,0	–	6500	2,5	RP..1605
R335.25-250.1317XL.60-16L-R8	02993829	Arbor	255,0	8,0	62,0	16	16	60,0	130,0	–	51,265	5800	6,1	RP..1605
335.25-250.1317XL.50-16L-R8	02993844	Arbor hole	255,0	8,0	91,6	16	16	50,0	69,0	17,0	–	5800	4,0	RP..1605
R335.25-315.1317XL.60-20L-R8	02993832	Arbor	320,0	8,0	94,5	20	20	60,0	130,0	–	51,265	5200	8,6	RP..1605
335.25-315.1317XL.50-20L-R8	02993847	Arbor hole	320,0	8,0	124,1	20	20	50,0	69,0	17,0	–	5200	6,5	RP..1605
R335.25-250.1721XL.60-16L-R10	02993756	Arbor	255,0	10,0	62,0	16	16	60,0	130,0	–	51,515	4600	6,7	RP..2006
335.25-250.1721XL.50-16L-R10	02993777	Arbor hole	255,0	10,0	91,6	16	16	50,0	69,0	21,0	–	4600	5,0	RP..2006
R335.25-315.1721XL.60-20L-R10	02993759	Arbor	320,0	10,0	94,5	20	20	60,0	130,0	–	51,515	4100	10,0	RP..2006
335.25-315.1721XL.50-20L-R10	02993780	Arbor hole	320,0	10,0	124,1	20	20	50,0	69,0	21,0	–	4100	8,2	RP..2006

Half side - Left hand - Radius profile with cassette

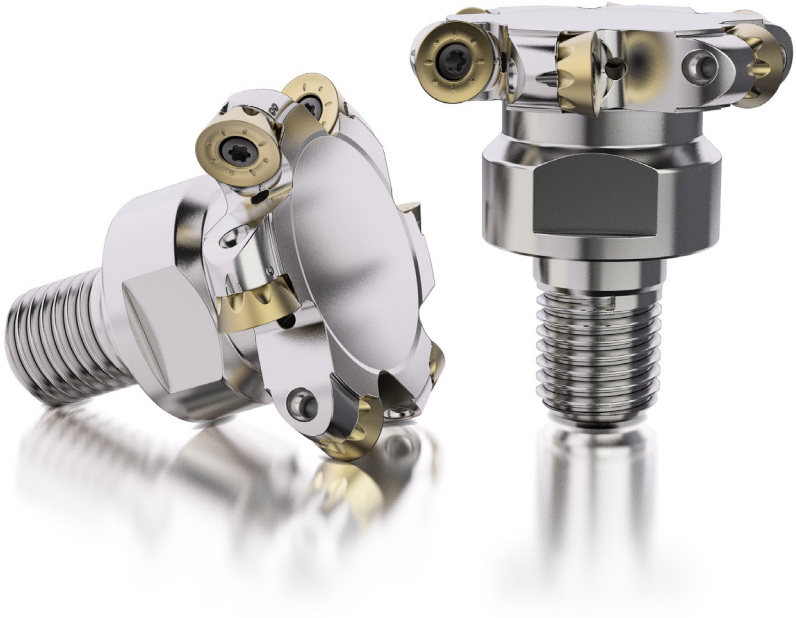
Cutter 335.25 - Insert RP..1605/RP..2006 – Inch



- For insert selection and cutting data recommendations, see page(s) 448-453
- For complete insert programme, see page(s) 750
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	APMXS	CDX	ZEFP	ZNP	DCB	DCSFMS	THUB	LF	RPMX	Weight	Insert
			Inch	Inch	Inch			Inch	Inch	Inch	Inch		lbs	
R335.25-04.00-0911L-R8	02993953	Arbor	4.197	0.315	1.138	6	6	1.000	1.880	–	2.050	9200	2.200	RP..1605
R335.25-05.00-0911L-R8	02993956	Arbor	5.197	0.315	1.453	8	8	1.250	2.250	–	2.050	8200	3.310	RP..1605
335.25-05.00-0911L-R8	02993971	Arbor hole	5.197	0.315	1.414	8	8	1.500	2.250	0.750	–	8200	2.200	RP..1605
R335.25-06.00-0911L-R8	02993959	Arbor	6.197	0.315	1.703	10	10	1.500	2.750	–	2.050	7200	4.850	RP..1605
335.25-06.00-0911L-R8	02993974	Arbor hole	6.197	0.315	1.914	10	10	1.500	2.250	0.750	–	7200	3.090	RP..1605
R335.25-08.00-0911L-R8	02993962	Arbor	8.197	0.315	2.329	14	14	1.500	3.500	–	2.050	6500	8.160	RP..1605
335.25-08.00-0911L-R8	02993977	Arbor hole	8.197	0.315	2.539	14	14	2.000	3.000	0.750	–	6500	18.080	RP..1605
R335.25-10.00-XL0911L-R8	02993965	Arbor	10.197	0.315	2.519	16	16	2.500	5.120	–	2.050	5800	13.670	RP..1605
335.25-10.00-XL0911L-R8	02993980	Arbor hole	10.197	0.315	3.539	16	16	2.000	3.000	0.750	–	5800	9.260	RP..1605
R335.25-12.00-XL0911L-R8	02993968	Arbor	12.197	0.315	3.519	20	20	2.500	5.120	–	2.050	5200	18.080	RP..1605
335.25-12.00-XL0911L-R8	02993983	Arbor hole	12.197	0.315	4.579	20	20	2.000	3.000	0.750	–	5200	13.670	RP..1605
R335.25-10.00-XL1113L-R10	02993877	Arbor	10.197	0.394	2.519	16	16	2.500	5.120	–	2.060	4600	15.210	RP..2006
335.25-10.00-XL1113L-R10	02993903	Arbor hole	10.197	0.394	3.539	16	16	2.000	3.000	1.000	–	4600	11.460	RP..2006
R335.25-12.00-XL1113L-R10	02993880	Arbor	12.197	0.394	3.519	20	20	2.500	5.120	–	2.060	4100	20.720	RP..2006
335.25-12.00-XL1113L-R10	02993906	Arbor hole	12.197	0.394	4.539	20	20	2.000	3.000	1.000	–	4100	17.200	RP..2006

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts



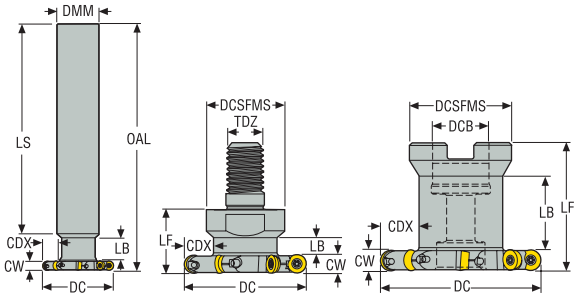
335.29

Free-cutting disc milling cutter system equipped with round inserts dedicated for slotting with full radius or 3D profiling operation

- Width of cut 5-12 mm (.236 - .394 inch)
- Cutter range diameter 25-80 mm (1.5 - 3.0 inch)
- Available with Cylindrical, Arbor, and Combimaster connection, with through coolant capability
- Economical solution with 4 cutting edges per insert

Width 5/6/7/8/10/12 mm - full side - radius profile - Fixed pocket

Cutter 335.29 - Round insert – Metric



- For insert selection and cutting data recommendations, see page(s) 433-447
- For complete insert programme, see page(s) 746, 749
- For spare parts and technical information, see page 420-418

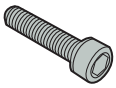
Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	DMM	TDZ	DCB	DCSFMS	OAL	LF	LS	LB	RPMX	Weight	Insert
			mm	mm	mm		mm		mm	mm	mm	mm	mm	mm		kg	
R335.29-1225.0-05.4N-R25A	02628056	Cylindrical	25,0	5,0	6,9	4	12,0	–	–	–	110,0	–	94,0	10,0	44800	0,1	RD..0501
R335.29-1632.0-05.5N-R25A	02628063	Cylindrical	32,0	5,0	8,4	5	16,0	–	–	–	130,0	–	114,0	10,0	39600	0,2	RD..0501
R335.29-2040.0-05.6N-R25A	02628067	Cylindrical	40,0	5,0	10,4	6	20,0	–	–	–	140,0	–	124,0	10,0	35400	0,4	RD..0501
R335.29-2550.0-05.8N-R25A	02628071	Cylindrical	50,0	5,0	12,9	8	25,0	–	–	–	150,0	–	134,0	10,0	31700	0,6	RD..0501
R335.29-1225.0-06.4N-R3A	02628045	Cylindrical	25,0	6,0	6,9	4	12,0	–	–	–	110,0	–	93,0	10,0	20600	0,1	RD..06T1
R335.29-1632.0-06.5N-R3A	02628061	Cylindrical	32,0	6,0	8,4	5	16,0	–	–	–	130,0	–	113,0	10,0	18700	0,2	RD..06T1
R335.29-2040.0-06.6N-R3A	02628066	Cylindrical	40,0	6,0	10,4	6	20,0	–	–	–	140,0	–	123,0	10,0	16300	0,4	RD..06T1
R335.29-1240.RE-06.6N-R3A	02661227	Combimaster	40,0	6,0	10,0	6	–	M12	–	23,0	–	28,0	–	10,0	17600	0,2	RD..06T1
R335.29-2550.0-06.8N-R3A	02628069	Cylindrical	50,0	6,0	12,9	8	25,0	–	–	–	150,0	–	133,0	10,0	17300	0,6	RD..06T1
R335.29-1650.RE-06.8N-R3A	02661228	Combimaster	50,0	6,0	12,5	8	–	M16	–	30,0	–	28,0	–	9,0	17300	0,2	RD..06T1
R335.29-063.06.22-10N-R3A	02627922	Arbor	63,0	6,0	15,0	10	–	–	22,0	40,0	–	50,0	–	30,6	13900	0,4	RD..06T1
R335.29-1632.0-07.5N-R35A	02628060	Cylindrical	32,0	7,0	8,4	5	16,0	–	–	–	130,0	–	112,0	10,0	31600	0,2	RD..0702
R335.29-1240.RE-07.6N-R35A	02627979	Combimaster	40,0	7,0	10,0	6	–	M12	–	23,0	–	28,0	–	9,0	28200	0,2	RD..0702
R335.29-1650.RE-07.7N-R35A	02627984	Combimaster	50,0	7,0	12,5	7	–	M16	–	30,0	–	28,0	–	8,0	25300	0,2	RD..0702
R335.29-063.07.22-10N-R35A	02627950	Arbor	63,0	7,0	15,0	10	–	–	22,0	40,0	–	50,0	–	29,6	22500	0,4	RD..0702
R335.29-1632.0-08.4N-R4A	02628058	Cylindrical	32,0	8,0	8,4	4	16,0	–	–	–	130,0	–	111,0	10,0	23300	0,2	RD..08..
R335.29-2040.0-08.5N-R4A	02628064	Cylindrical	40,0	8,0	10,4	5	20,0	–	–	–	140,0	–	121,0	10,0	18800	0,4	RD..08..
R335.29-1240.RE-08.5N-R4A	02627978	Combimaster	40,0	8,0	10,0	5	–	M12	–	23,0	–	28,0	–	8,0	18800	0,2	RD..08..
R335.29-2550.0-08.6N-R4A	02628068	Cylindrical	50,0	8,0	12,9	6	25,0	–	–	–	150,0	–	131,0	10,0	17300	0,6	RD..08..
R335.29-1650.RE-08.6N-R4A	02661229	Combimaster	50,0	8,0	12,5	6	–	M16	–	30,0	–	28,0	–	7,0	17300	0,2	RD..08..
R335.29-063.08.22-8N-R4A	02661224	Arbor	63,0	8,0	15,0	8	–	–	22,0	40,0	–	50,0	–	28,6	15600	0,4	RD..08..
R335.29-080.08.27-10N-R4A	02627974	Arbor	80,0	8,0	20,0	10	–	–	27,0	48,0	–	50,0	–	26,8	13700	0,5	RD..08..
R335.29I-1650.RE-10.6N-R5A	03278721	Combimaster	50,0	10,0	12,34	3	–	M16	–	30,0	–	28,0	–	4,3	15800	0,2	RD..10T3
R335.29I-063.10.22-6N-R5A	03278719	Arbor	63,0	10,0	14,67	6	–	–	22,0	38,0	–	50,0	–	26,61	13500	0,4	RD..10T3
R335.29I-080.10.27-8N-R5A	03278720	Arbor	80,0	10,0	19,67	8	–	–	27,0	46,0	–	50,0	–	24,74	12000	0,5	RD..10T3
R335.29I-1650.RE-12.4N-R6A	02988077	Combimaster	50,0	12,0	12,5	2	–	M16	–	30,0	–	28,0	–	4,3	11200	0,2	RP..1204
R335.29I-063.12.22-6N-R6A	02988078	Arbor	63,0	12,0	15,0	6	–	–	22,0	40,0	–	50,0	–	24,6	10200	0,4	RP..1204
R335.29I-080.12.27-8N-R6A	02988079	Arbor	80,0	12,0	20,0	4	–	–	27,0	48,0	–	50,0	–	22,7	10000	0,5	RP..1204

R335.29I Disc Milling cutters offer indexing possibility - Indexing screw SX2035-T05P included in the delivery

Note: All cutters are equipped with central coolant channels, Arbor type are delivered with a lid kit to get central coolant capability

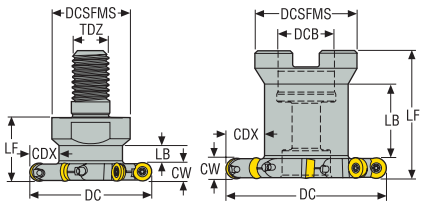
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R335.29 -R25A	–	C02035-T06P	T00-06P05	0.5NM
R335.29-06. RE / R335.29-06 .0-R3A	–	C02205-T07P	T00-07P09	0.9NM
R335.29 R3A DCB=22	MC6S10X40	C02205-T07P	T00-07P09	0.9NM
R335.29-07 .RE / R335.29-07 .0-R35A	–	C02545-T07P	T00-07P09	0.9NM
R335.29 R35A DCB=22	MC6S10X40	C02545-T07P	T00-07P09	0.9NM
R335.29-08 .RE / R335.29-08 .0-R4A	–	C02506-T08P	T00-08P12	1.2NM
R335.29 R4A DCB=22	MC6S10X40	C02506-T08P	T00-08P12	1.2NM
R335.29 R4A DCB=27	MC6S12X35	C02506-T08P	T00-08P12	1.2NM
R335.29-08 .RE / R335.29-08 .0-R5A	–	C03007-T09P	T00-09P20	2.0NM
R335.29 R5A DCB=22	MC6S10X40	C03007-T09P	T00-09P20	2.0NM
R335.29 R5A DCB=27	MC6S12X35	C03007-T09P	T00-09P20	2.0NM
R335.29-08 .RE / R335.29-08 .0-R5A	–	C03509-T15P	T00-15P30	3.0NM
R335.29 R6A DCB=22	MC6S10X40	C03509-T15P	T00-15P30	3.0NM
R335.29 R6A DCB=27	MC6S12X35	C03509-T15P	T00-15P30	3.0NM

Width 0.236/0.315/0.394" - full side - radius profile - Fixed pocket

Cutter 335.29 - Round insert – Inch



- For insert selection and cutting data recommendations, see page(s) 435-436, 439-440, 442-444
- For complete insert programme, see page(s) 746
- For spare parts and technical information, see page 420-418

Designation	Item number	Type of mounting	DC	CW	CDX	ZEFP	TDZ	DCB	DCSFMS	LF	LB	RPMX	Weight	Insert
			Inch	Inch	Inch			Inch	Inch	Inch	Inch		lbs	
R335.29-1.50-12RE-6N-R3	02477694	Combimaster	1.500	0.236	0.297	6	M12	–	0.906	1.102	–	33700	0.220	RD..06T1
R335.29-2.00-16RE-8N-R3	02477702	Combimaster	2.000	0.236	0.409	8	M16	–	1.181	1.102	–	30200	0.660	RD..06T1
R335.29-2.00-16RE-6N-R4	02477709	Combimaster	2.000	0.315	0.409	6	M16	–	1.181	1.102	–	20200	0.660	RD..08
R335.29I-02.50-6N-R5A	03278722	Arbor	2.500	0.394	0.587	6	–	0.750	1.501	1.998	1.075	13500	0.880	RD..10T3
R335.29I-03.00-8N-R5A	03278723	Arbor	3.000	0.394	0.700	8	–	1.000	1.803	2.000	1.052	12000	1.100	RD..10T3

R335.29I Disc Milling cutters offer indexing possibility - Indexing screw SX2035-T05P included in the delivery

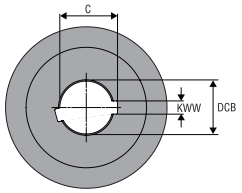
Note: All cutters are equipped with central coolant channels, Arbor type are delivered with a lid kit to get central coolant capability

Spare Parts

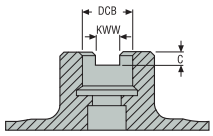
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R335.29 RE- R3	–	C02205-T07P	T00-07P09	0.9NM
R335.29 RE- R4	–	C02506-T08P	T00-08P12	1.2NM
R335.29I -R5A DCB=0.750	UC6S3/8UNFX11/2	C03007-T09P	T00-09P20	2.0NM
R335.29I -R5A DCB=1.000	UC6S1/2UNFX1-1/2	C03007-T09P	T00-09P20	2.0NM

335.18 and 335.25 – Keyway for Arbor hole type and Arbor cutter



Dimensions in mm			Dimensions in inch		
DCB	KWW	C	DCB	KWW	C
22	6	24,15	*1.00*	*0.250*	*1.110*
27	7	29,9	*1.25*	*0.312*	*1.393*
40	10	43,6	*1.50*	*0.375*	*1.673*
50	12	53,6	*2.00*	*0.500*	*2.198*
60	14	64,3			



Dimensions in mm			Dimensions in inch		
DCB	KWW	C	DCB	KWW	C
16	8,4	5,6	*0.75*	*0.32*	*0.19*
22	10,4	6,3	*1.00*	*0.38*	*0.22*
27	12,4	7	*1.25*	*0.51*	*0.28*
32	14,4	8	*1.50*	*0.63*	*0.38*
40	16,4	9			

Retaining screw Arbor type cutter: R335.18 / R335.25 (supplied with the cutter in the delivery) - Metric/Inch

For cutter dia – metric	Cutter 335.18 adj. "0810", "1012", "1215" series – metric	Cutter 335.25 - adjustable – metric	For cutter dia – Inch	Cutter 335.25 - adjustable – Inch
63	MC6S 10x40	-	*2.50*	-
80	MC6S 12x40	-	*3.00*	*MLC6S10X45*
100	MC6S 12x40	MC6S12X40	*4.00*	*UC6S1/2UNFX1-1/2*
125	-	MC6S16X40	*5.00*	*ULC6S5/8UNFX11/2*
160	-	MLC6S20X40	*6.00*	*ULC6S3/4UNFX1-1/2*

To order a standard adjustable disc milling cutter set at a specific width:

Note: For disc cutter not mentioned in the tables, please use cross head retaining screw, supplied with the Seco Tooling System shell mill holder

To obtain an adjustable disc mill set to your required dimension add "/ADJ" at the end of the reference and specify your required width which will be set with a tolerance of +/- 0,03 mm (+/- .001"). Without specifi ation the standard disc mill is set to the minimum cutting width.

Ordering example: R335.25-200.1317.40-7N/ADJ and specify on your order your width to any value within its range, for example specify a cutting width of 15.50mm in your order. The disc mill will be set to 15.50 +/- 0,03 mm (0.610" +/- .001").

The delivery time is approx. 3 days for a set adjustable disc mill.

(R)335.18 – LNK inserts

LNK.05
For width 8-10, .312"-.375"

LNK.06
For width 10-12, .625"

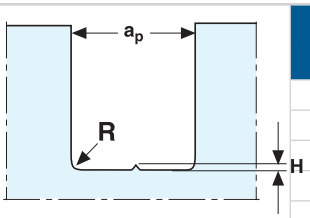
LNK.08
For width 12-15, 500"-.750"

LNK.06 and LNK.08 have the same size, but LNK.06 have a reduced cutting length (6mm, .250") to decrease cutting forces for width= 10-12 mm, .394"-.472".
LNK.08 have a cutting length = 7,5 mm, .295" for width 12-15 mm, .500"-.750".

Radius possibilities/Number of cutting edges

	Insert	R	Fixed pocket version: CW =						Adjustable version: CW =				R	Fixed pocket version: CW inch =				Adjustable version: CW inch =			
			8	10	12	14	17	20	8	10	12	15		0.312/ 0.375	0.500	0.625	0.750	0.313	0.394	0.472	0.591
4 cutting edges																					
	LNK.050404	0,4	x	x					x	x			.016	x				x	x		
	LNK.050408	0,8	x	x					x	x			.031	x				x	x		
	LNK.050416	1,6	x	x					x	x			.063	x				x	x		
	LNK.050420	2,0	x	x					x	x			.079	x				x	x		
	LNK.060504	0,4		x	x		x			x	x		.016			x			x	x	
	LNK.060508	0,8		x	x		x			x	x		.031			x			x	x	
	LNK.060516	1,6		x	x		x			x	x		.063			x			x	x	
	LNK.080504	0,4		o	o	x	o	x		o	o	x	.016		x	o	x		o	o	x
	LNK.080508	0,8		o	o	x	o	x		o	o	x	.031		x	o	x		o	o	x
	LNK.080516	1,6		o	o	x	o	x		o	o	x	.063		x	o	x		o	o	x
	LNK.080520	2,0		x	x	x	x	x		x	x	x	.079		x	x	x		x	x	x
	LNK.080524	2,4		x	x	x	x	x		x	x	x	.094		x	x	x		x	x	x
2 cutting edges																					
	LNK.050424	2,4	x	x					x	x			.094	x				x	x		
	LNK.060531	3,1		x	x		x			x	x		.122			x			x	x	
	LNK.080531	3,1			o	x	o	x			o	x	.122		x	o	x			o	x
1 cutting edge (L and R insert)																					
	LNK.050431...C	3,1	x						x				.122	x				x	x		
	LNK.050431	3,1		x						x			.157			x			x	x	
	LNK.060540	4,0		x	x		x			x	x		.157		x	o	x			o	x
	LNK.080540	4,0			o	x	o	x			o	x									
x = First choice o = Alternative choice																					

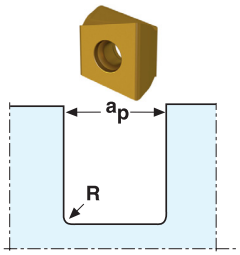
Width and profile generated with LNK.06/08 radii R1,6/R2,0 and R2,4



a_p (mm)	H (mm)		a_p (in)	H (in)	
	Radius 1,6	Radii 2 and 2,4		Radius .063	Radii .079 and .095
13,4	–	0	.518	–	0
14	–	0,03	.551	–	.001
14,2	0	0,07	.559	0	.003
14,5	0,01	0,13	.570	.0004	.005
15	0,1	0,3	.591	.004	.012

(R)335.25 – LNHQ/XNHQ inserts

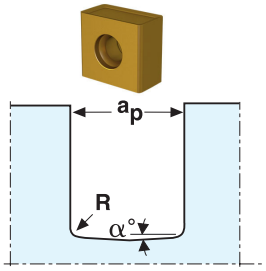
Width and profile generated by XNHQ insert with fixed pocket cutter for a_p = 15/20/25mm, a_p = 0.75”, 1.00”



Insert corner radius	a_p = 15mm	a_p = 20mm	a_p = 25mm
0,4	15	20	25
0,8	15	20	25
1,2	15	20	25
1,6	15	20	25
2	15	20	25
2,4	15	20	25
3,1	14,86	20	25
4	14,6	19,78	25
5	–	19,46	24,73
6	–	–	24,46

Insert corner radius	a_p = 0.75”	a_p = 1.00”
0.016	0.75	1.00
0.032	0.75	1.00
0.047	0.75	1.00
0.063	0.75	1.00
0.079	0.75	1.00
0.094	0.75	1.00
0.122	0.75	1.00
0.157	0.741	1.00
0.197	0.729	0.989
0.236	–	0.979

Width and profile generated by LNHQ* insert with fixed pocket cutter for a_p = 25mm, a_p = 1.00”

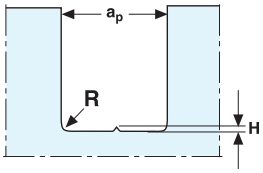


Insert corner radius mm	a_p mm generated	angle α°
0,8	25,17	2
3,1	25,02	2
4	24,92	2
5	24,78	2
6	24,64	2

Insert corner radius inch	a_p inch generated	angle α°
0.0315	1.007	2
0.122	1.001	2
0.157	0.997	2
0.197	0.992	2
0.236	0.986	2

*LNHQ is an insert intended for roughing in difficult conditions (this will not generate a flat bottom).

Width and profile generated with XNHQ 14 and 17 insert, radii 5 and 6 mm, radii 0.197” and 0.236” with adjustable cutter

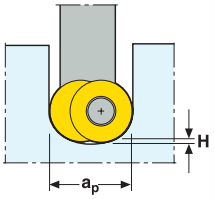


Width cutter	a_p mm	H (mm)	
		Radius 5	Radius 6
21-26	25,5	0	0
21-26	25,8	0	0,01
21-26	26,0	0,01	0,03
26-32	31,7	0	0
26-32	32,0	0	0,01

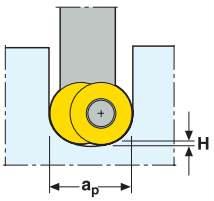
Width cutter	a_p inch	H (inch)	
		Radius 0.197”	Radius 0.236”
0.83-1.02	1.004	0	0
0.83-1.02	1.016	0	.0004
0.83-1.02	1.024	.0004	.0011
1.02-1.26	1.248	0	0
1.02-1.26	1.260	0	.0004

Profile machined with adjustable 335.18/335.25 cutter

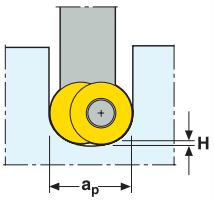
335.18/335.25 cutter equipped with round inserts mm/inch



	Round 8		Round 8		Round 10		Round 10	
	a_p mm	Profile height H mm	a_p inch	Profile height H inch	a_p mm	Profile height H mm	a_p inch	Profile height H inch
a_p min a_p max								
	8,03	0	.316	0	10,03	0	.406	0
	8,50	0	.335	0	10,50	0	.413	0
	9,00	0,03	.354	.001	11,00	0,025	.433	.001
	9,50	0,07	.374	.003	11,50	0,060	.453	.002
	10,00	0,13	.394	.005	12,00	0,100	.472	.004
	Recom. min setting width is 8,03 mm		Recom. min setting width is .316 inch		Recom. min setting width is 10,03 mm		Recom. min setting width is .406 inch	



	Round 12		Round 12		Round 16		Round 16	
	a_p mm	Profile height H mm	a_p mm	Profile height H mm	a_p mm	Profile height H mm	a_p inch	Profile height H inch
a_p min a_p max								
	12,03	0	.474	0	16,03	0	.631	0
	12,50	0,01	.492	.0004	16,50	0	.650	0
	13,00	0,02	.512	.001	17,00	0,02	.669	.001
	14,00	0,08	.551	.002			.709	.002
	15,00	0,19	.591	.007			.728	.004
	Recom. min setting width is 12,03 mm		Recom. min setting width is .474 inch		Recom. min setting width is 16,03 mm		Recom. min setting width is .631 inch	



	Round 20		Round 20	
	a_p mm	Profile height H mm	a_p mm	Profile height H mm
a_p min a_p max				
	20,03	0	0,789	0,0000
	20,5	0,01	0,807	0,0004
	21	0,02	0,827	0,0008
	Recom. min setting width is 20,03 mm		Recom. min setting width is 0,789 inch	

Spare parts

(R)335.18 -LNK and round insert - Adjustable design - Metric

(R)335.18-xxx-	Insert type	Insert screw/Nm	Insert key	Wedge	Wedge screw	Key for wedge screw	Adjusting screw	Key for adjusting screw	Cassettes R335.18-...	Cassettes L335.18-...
0810	LN.K05...	C02508-T08P/1,2Nm	H4B-T08P	335.18-607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	...0810-05	...0810-05
0810XL	LN.K05...	C02508-T08P/1,2Nm	H4B-T08P	335.18-XL607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	...0810XL-05	...0810XL-05
0810	RD..08..	C02506-T08P/1,2Nm	H4B-T08P	335.18-607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	N335.18-08-R4	N335.18-08-R4
0810XL	RD..08..	C02506-T08P/1,2Nm	H4B-T08P	335.18-XL607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	N335.18-08XL-R4	N335.18-08XL-R4
1012	LNK.06..	C73007-T09P/2,0Nm	H4B-T09P	335.18-609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1012-06	...1012-06
1012XL	LNK.06..	C73007-T09P/2,0Nm	H4B-T09P	335.18-XL609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1012XL-06	...1012XL-06
1012	RD..10T3	C03007-T09P/2,0Nm	H4B-T09P	335.18-609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...10-R5I	...10-R5I
1012XL	RD..10T3	C03007-T09P/2,0Nm	H4B-T09P	335.18-XL609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...10XL-R5I	...10XL-R5I
1215	LNK08..	C73007-T09P/2,0Nm	H4B-T09P	335.18-611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1215-08	...1215-08
1215XL	LNK08..	C73007-T09P/2,0Nm	H4B-T09P	335.18-XL611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1215XL-08	...1215XL-08
1215	RP..12..	C03508-T15P/3,0 Nm	H6B-T15PL	335.18-611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...12-R6	...12-R6
1215XL	RP..12..	C03508-T15P/3,0 Nm	H6B-T15PL	335.18-XL611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...12XL-R6	...12XL-R6

Torque and fixed keys, see page 829

(R)335.18 -LNK and round insert - Adjustable design - Inch

(R)335.18-xxx-	Insert type	Insert screw/ Nm	Insert key	Wedge	Wedge screw	Key for wedge screw	Adjusting screw	Key for adjusting screw	Cassettes R335.18-...	Cassettes L335.18-...
0506	LN.K05...	C02508-T08P 10.6 in.lbs	H4B-T08P	335.18-607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	...0810-05	...0810-05
XL0506	LN.K05...	C02508-T08P 10.6 in.lbs	H4B-T08P	335.18-XL607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	...0810XL-05	...0810XL-05
0506	RD..08..	C02508-T08P 10.6 in.lbs	H4B-T08P	335.18-607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	N335.18-08-R4	N335.18-08-R4
XL0506	RD..08..	C02508-T08P 10.6 in.lbs	H4B-T08P	335.18-XL607	LD5018F-T15P	H6B-T15PL	SH6004-T08P	H4B-T08P	N335.18-08XL-R4	N335.18-08XL-R4
0708	LNK.06..	C73007-T09P 17.7 in.lbs	H4B-T08P	335.18-609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1012-06	...1012-06
XL0708	LNK.06..	C73007-T09P 17.7 in.lbs	H4B-T09P	335.18-XL609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1012XL-06	...1012XL-06
0708	RD..10T3	C73007-T09P 17.7 in.lbs	H4B-T09P	335.18-609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...10-R5	...10-R5
XL0708	RD..10T3	C73007-T09P 17.7 in.lbs	H4B-T09P	335.18-XL609	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...10XL-R5	...10XL-R5
0809	LNK08..	C73007-T09P 17.7 in.lbs	H4B-T09P	335.18-611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1215-08	...1215-08
XL0809	LNK08..	C73007-T09P 17.7 in.lbs	H4B-T09P	335.18-XL611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...1215XL-08	...1215XL-08
0809	RP..12..	C03508-T15P 26.6 in.lbs	H4B-T09P	335.18-611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...12-R6	...12-R6
XL0809	RP..12..	C03508-T15P 26.6 in.lbs	H6B-T15PL	335.18-XL611	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...12XL-R6	...12XL-R6

Torque and fixed keys, see page 829

Spare parts

For adjustable cutter (R)335.25 equipped with XHNQ/LNHQ inserts - Metric

(R)335.25-xxx-	Insert type	Insert screw/Nm	Insert key	Wedge	Wedge screw	Key for wedge screw	Adjusting screw	Key for adjusting screw	Cassettes R335.25-...	Cassettes L335.25-...
1317	XNHQ09	C03509-T10P/3Nm	H4B-T10P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1317-09*	1317-09*
1317XL	XNHQ09	C03509-T10P/3Nm	H4B-T10P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1317XL-09	1317XL-09
1721	XNHQ12	C03511-T10P/3Nm	H4B-T10P	335.25-616	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1721-12**	1721-12**
1721XL	XNHQ12	C03511-T10P/3Nm	H4B-T10P	335.25-616	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1721XL-12	1721XL-12
2126	XNHQ14 / LNHQ14	C04013-T15P/5 Nm	H4B-T15P	335.25-620	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2126-14***	2126-14***
2126XL	XNHQ14 / LNHQ14	C04013-T15P/5 Nm	H4B-T15P	335.25-620	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2126XL-14	2126XL-14
2632	XNHQ17 / LNHQ17	C05013-T20P/5 Nm	H6B-T20P	335.25-625	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2632-17****	2632-17****
2632XL	XNHQ17 / LNHQ17	C05013-T20P/5 Nm	H6B-T20P	335.25-625	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2632XL-17	2632XL-17

*Cassette compatible with adjustable disc milling cutter x335.18-xxx-1418 series to generate width of cut from 14 to 17 mm, generating nominal “DC” diameter
**Cassette compatible with adjustable disc milling cutter x335.18-xxx-1924 series to generate width of cut from 18.5 to 21 mm, generating nominal “DC” diameter
***Cassette compatible with adjustable disc milling cutter x335.18-xxx-2530 series to generate width of cut from 24,3 to 26 mm, generating nominal “DC” diameter
**** Cassette compatible with adjustable disc milling cutter x335.18-xxx-2530 series to generate width of cut from 26 to 30,5 mm, generating nominal “DC” diameter

For adjustable cutter (R)335.25 equipped with round insert dia 16 and 20mm - Metric

(R)335.25-xxx-	Insert type	Insert screw/Nm	Insert key	Wedge	Wedge screw	Key for wedge screw	Adjusting screw	Key for adjusting screw	Cassettes R335.25-...	Cassettes L335.25-...
1317	RP..1605	C05010-T20P / 5N.m	H6B-T20P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...16-R8I-D5*	...16-R8I-D5*
1317XL	RP..1605	C05010-T20P / 5N.m	H6B-T20P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...16XL-R8I-D5	...16XL-R8I-D5
1721XL	RP..2006	C05013-T20P / 5N.m	H6B-T20P	335.25-616	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...20XL-R10-D5	...20XL-R10-D5

*Cassette compatible with adjustable disc milling cutter x335.18-xxx-1418 series to generate width of cut from 16 to 18,5 mm, generating nominal “DC” diameter +5mm

Spare parts

Spare parts for adjustable cutter (R)335.25 equipped with XHNQ/LNHQ inserts - Inch

(R)335.25-xxx-	Insert type	Insert screw/Nm	Insert key	Wedge	Wedge screw	Key for wedge screw	Adjusting screw	Key for adjusting screw	Cassettes R335.25-...	Cassettes L335.25-...
0911	XNHQ09	C03509-T10P/26.5	H4B-T10P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1317-09*	1317-09*
XL0911	XNHQ09	C03509-T10P/26.5	H4B-T10P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1317XL-09	1317XL-09
1113	XNHQ12	C03511-T10P/26.5	H4B-T10P	335.25-616	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1721-12**	1721-12**
XL1113	XNHQ12	C03511-T10P/26.5	H4B-T10P	335.25-616	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	1721XL-12	1721XL-12
1316	XNHQ14 / LNHQ14	C04013-T15P/44	H4B-T15P	335.25-620	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2126-14***	2126-14***
XL1316	XNHQ14 / LNHQ14	C04013-T15P/44	H4B-T15P	335.25-620	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2126XL-14	2126XL-14
1620	XNHQ17 / LNHQ17	C05013-T20P/44	H6B-T20P	335.25-625	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2632-17****	2632-17****
XL1620	XNHQ17 / LNHQ17	C05013-T20P/44	H6B-T20P	335.25-625	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	2632XL-17	2632XL-17

*Cassette compatible with adjustable disc milling cutter x335.18-xxx-1418 series to generate width of cut from 14 to 17 mm, generating nominal “DC” diameter
**Cassette compatible with adjustable disc milling cutter x335.18-xxx-1924 series to generate width of cut from 18.5 to 21 mm, generating nominal “DC” diameter
***Cassette compatible with adjustable disc milling cutter x335.18-xxx-2530 series to generate width of cut from 24,3 to 26 mm, generating nominal “DC” diameter
**** Cassette compatible with adjustable disc milling cutter x335.18-xxx-2530 series to generate width of cut from 26 to 30,5 mm, generating nominal “DC” diameter

Spare parts for adjustable cutter (R)335.25 equipped with round insert dia 16 and 20mm - Inch

(R)335.25-xxx-	Insert type	Insert screw/Nm	Insert key	Wedge	Wedge screw	Key for wedge screw	Adjusting screw	Key for adjusting screw	Cassettes R335.25-...	Cassettes L335.25-...
0911	RP..1605	C05010-T20P /	H6B-T20P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...16-R8I-D5*	...16-R8I-D5*
XL0911	RP..1605	C05010-T20P /	H6B-T20P	335.25-612	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...16XL-R8I-D5	...16XL-R8I-D5
XL1113	RP..2006	C05013-T20P /	H6B-T20P	335.25-616	LD6018F-T20P	H6B-T20PL	SH6005-T09P	H4B-T09P	...20XL-R10-D5	...20XL-R10-D5

*Cassette compatible with adjustable disc milling cutter x335.18-xxx-1418 series to generate width of cut from 16 to 18,5 mm, generating nominal “DC” diameter +5mm

335.18-LNK – Insert selection – mm/*Inch*

SMG				f_z		
				30%	20%	10%
P1	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P2	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
P3	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
P4	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
P5	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P6	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P7	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P8	LNKT05...-M06 MP3000	LNKT06...-M06 MP3000	*LNKT08...-M06 MP3000*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
P11	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
P12	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
M1	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
M2	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M3	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
M4	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
M5	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
K1	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
K2	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K3	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K4	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K5	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
K6	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K7	LNKT05...-M06 MP3000	LNKT06...-M06 MK2050	*LNKT08...-M06 MK2050*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
N1	LNKT05...-E05 H25	LNKT06...-E05 H25	*LNKT08...-E05 H25*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N2	LNKT05...-E05 H25	LNKT06...-E05 H25	*LNKT08...-E05 H25*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N3	LNKT05...-E05 H25	LNKT06...-E05 H25	*LNKT08...-E05 H25*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N11	LNKT05...-E05 H25	LNKT06...-E05 H25	*LNKT08...-E05 H25*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
S1	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S2	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S3	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
S11	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S12	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S13	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
H5	LNKT05...-M06 MP3000	LNKT06...-M06 MP3000	*LNKT08...-M06 MP3000*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
H8	LNKT05...-M06 MP3000	LNKT06...-M06 MP3000	*LNKT08...-M06 MP3000*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
H11	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
H12	LNKT05...-M06 F40M	LNKT06...-M06 F40M	*LNKT08...-M06 F40M*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*
H21	LNKT05...-M06 MP3000	LNKT06...-M06 MP3000	*LNKT08...-M06 MP3000*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.18-LNK – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			MP3000			T350M			F40M			MK1500			MK2050			H25		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	260	275	305	245	260	290	225	240	265	195	210	230	—	—	—	255	275	300	—	—	—
	850	*900*	*1000*	*800*	*850*	*950*	*740*	*790*	*870*	*640*	*690*	*750*	—	—	—	*840*	*900*	*980*	—	—	—
P2	250	270	295	235	255	280	215	235	260	190	205	225	—	—	—	245	265	295	—	—	—
	820	*890*	*970*	*770*	*840*	*920*	*710*	*770*	*850*	*620*	*670*	*740*	—	—	—	*800*	*870*	*970*	—	—	—
P3	220	230	260	205	220	245	190	200	225	165	175	195	—	—	—	215	230	255	—	—	—
	720	*750*	*850*	*670*	*720*	*800*	*620*	*660*	*740*	*540*	*570*	*640*	—	—	—	*710*	*750*	*840*	—	—	—
P4	190	210	230	180	195	215	165	180	200	145	160	175	—	—	—	190	205	225	—	—	—
	620	*690*	*750*	*590*	*640*	*710*	*540*	*590*	*660*	*475*	*520*	*570*	—	—	—	*620*	*670*	*740*	—	—	—
P5	185	200	220	175	190	210	165	175	195	140	150	165	—	—	—	185	195	220	—	—	—
	610	*660*	*720*	*570*	*620*	*690*	*540*	*570*	*640*	*460*	*490*	*540*	—	—	—	*610*	*640*	*720*	—	—	—
P6	210	225	250	200	210	235	185	195	215	160	170	190	—	—	—	205	220	245	—	—	—
	690	*740*	*820*	*660*	*690*	*770*	*610*	*640*	*710*	*520*	*560*	*620*	—	—	—	*670*	*720*	*800*	—	—	—
P7	200	210	235	190	200	220	175	185	205	150	160	175	—	—	—	195	205	230	—	—	—
	660	*690*	*770*	*620*	*660*	*720*	*570*	*610*	*670*	*490*	*520*	*570*	—	—	—	*640*	*670*	*750*	—	—	—
P8	185	195	220	175	185	205	160	170	190	140	150	165	—	—	—	180	190	215	—	—	—
	610	*640*	*720*	*570*	*610*	*670*	*520*	*560*	*620*	*460*	*490*	*540*	—	—	—	*590*	*620*	*710*	—	—	—
P11	195	205	230	185	195	215	170	180	200	145	155	170	—	—	—	190	200	225	—	—	—
	640	*670*	*750*	*610*	*640*	*710*	*560*	*590*	*660*	*475*	*510*	*560*	—	—	—	*620*	*660*	*740*	—	—	—
P12	125	130	145	120	125	140	110	115	125	95	100	110	—	—	—	125	130	145	—	—	—
	410	*425*	*475*	*395*	*410*	*460*	*360*	*375*	*410*	*310*	*330*	*360*	—	—	—	*410*	*425*	*475*	—	—	—
M1	180	195	215	175	190	210	165	180	200	150	165	180	—	—	—	—	—	—	—	—	—
	590	*640*	*710*	*570*	*620*	*690*	*540*	*590*	*660*	*490*	*540*	*590*	—	—	—	—	—	—	—	—	—
M2	150	160	180	150	155	175	140	150	165	130	135	150	—	—	—	—	—	—	—	—	—
	490	*520*	*590*	*490*	*510*	*570*	*460*	*490*	*540*	*425*	*445*	*490*	—	—	—	—	—	—	—	—	—
M3	120	130	140	120	130	140	110	120	130	100	110	120	—	—	—	—	—	—	—	—	—
	395	*425*	*460*	*395*	*425*	*460*	*360*	*395*	*425*	*330*	*360*	*395*	—	—	—	—	—	—	—	—	—
M4	95	100	110	90	100	110	85	95	105	80	85	95	—	—	—	—	—	—	—	—	—
	310	*330*	*360*	*295*	*330*	*360*	*280*	*310*	*345*	*260*	*280*	*310*	—	—	—	—	—	—	—	—	—
M5	75	85	90	75	80	90	70	75	85	65	70	80	—	—	—	—	—	—	—	—	—
	245	*280*	*295*	*245*	*260*	*295*	*230*	*245*	*280*	*215*	*230*	*260*	—	—	—	—	—	—	—	—	—
K1	195	215	235	155	170	185	170	185	205	150	160	180	280	305	335	265	285	315	—	—	—
	640	*710*	*770*	*510*	*560*	*610*	*560*	*610*	*670*	*490*	*520*	*590*	*920*	*1000*	*1100*	*870*	*940*	*1025*	—	—	—
K2	180	190	210	140	150	165	155	165	185	135	145	160	250	265	295	240	255	280	—	—	—
	590	*620*	*690*	*460*	*490*	*540*	*510*	*540*	*610*	*445*	*475*	*520*	*820*	*870*	*970*	*790*	*840*	*920*	—	—	—
K3	150	160	180	120	125	140	130	140	155	115	120	135	215	225	250	200	215	240	—	—	—
	490	*520*	*590*	*395*	*410*	*460*	*425*	*460*	*510*	*375*	*395*	*445*	*710*	*740*	*820*	*660*	*710*	*790*	—	—	—
K4	145	150	170	115	120	135	125	135	150	110	115	130	205	215	240	195	205	225	—	—	—
	475	*490*	*560*	*375*	*395*	*445*	*410*	*445*	*490*	*360*	*375*	*425*	*670*	*710*	*790*	*640*	*670*	*740*	—	—	—
K5	90	95	100	70	75	80	75	80	90	65	70	80	125	130	145	115	125	135	—	—	—
	295	*310*	*330*	*230*	*245*	*260*	*245*	*260*	*295*	*215*	*230*	*260*	*410*	*425*	*475*	*375*	*410*	*445*	—	—	—
K6	125	135	150	100	105	120	110	115	130	95	100	115	180	190	210	170	180	200	—	—	—
	410	*445*	*490*	*330*	*345*	*395*	*360*	*375*	*425*	*310*	*330*	*375*	*590*	*620*	*690*	*560*	*590*	*660*	—	—	—
K7	110	120	130	90	95	105	100	105	115	85	90	100	160	170	185	150	160	175	—	—	—
	360	*395*	*425*	*295*	*310*	*345*	*330*	*345*	*375*	*280*	*295*	*330*	*520*	*560*	*610*	*490*	*520*	*570*	—	—	—
N1	—	—	—	1400	1500	1650	—	—	—	1100	1200	1325	—	—	—	—	—	—	1150	1225	1350
	—	—	—	*4600*	*4925*	*5425*	—	—	—	*3600*	*3925*	*4350*	—	—	—	—	—	—	*3775*	*4025*	*4425*
N2	—	—	—	560	600	670	—	—	—	450	485	540	—	—	—	—	—	—	465	495	550
	—	—	—	*1825*	*1975*	*2200*	—	—	—	*1475*	*1600*	*1775*	—	—	—	—	—	—	*1525*	*1625*	*1800*
N3	—	—	—	375	405	445	—	—	—	300	320	355	—	—	—	—	—	—	310	330	365
	—	—	—	*1225*	*1325*	*1450*	—	—	—	*980*	*1050*	*1175*	—	—	—	—	—	—	*1025*	*1075*	*1200*
N11	—	—	—	430	460	510	—	—	—	340	370	410	—	—	—	—	—	—	355	380	415
	—	—	—	*1400*	*1500*	*1675*	—	—	—	*1125*	*1225*	*1350*	—	—	—	—	—	—	*1175*	*1250*	*1350*
S1	45	48	55	43	46	50	40	43	48	37	39	44	—	—	—	—	—	—	—	—	—
	150	*155*	*180*	*140*	*150*	*165*	*130*	*140*	*155*	*120*	*130*	*145*	—	—	—	—	—	—	—	—	—
S2	36	39	43	34	37	41	33	35	39	30	32	35	—	—	—	—	—	—	—	—	—
	120	*130*	*140*	*110*	*120*	*135*	*110*	*115*	*130*	*100*	*105*	*115*	—	—	—	—	—	—	—	—	—
S3	32	34	38	30	32	36	28	30	34	26	28	31	—	—	—	—	—	—	—	—	—
	105	*110*	*125*	*100*	*105*	*120*	*90*	*100*	*110*	*85*	*90*	*100*	—	—	—	—	—	—	—	—	—
S11	65	70	75	60	65	70	55	60	65	50	55	60	—	—	—	—	—	—	—	—	—
	215	*230*	*245*	*195*	*215*	*230*	*180*	*195*	*215*	*165*	*180*	*195*	—	—	—	—	—	—	—	—	—
S12	55	55	65	50	55	60	48	50	55	43	47	50	—	—	—	—	—	—	—	—	—
	180	*180*	*215*	*165*	*180*	*195*	*155*	*165*	*180*	*140*	*155*	*165*	—	—	—	—	—	—	—	—	—
S13	31	33	37	29	31	35	28	30	33	25	27	30	—	—	—	—	—	—	—	—	—
	100	*110*	*120*	*95*	*100*	*115*	*90*	*100*	*110*	*80*	*90*	*100*	—	—	—	—	—	—	—	—	—
H5	38	40	44	33	35	38	36	38	42	31	33	37	—	—	—	—	—	—	—	—	—
	125	*130*	*145*	*110*	*115*	*125*	*120*	*125*	*140*	*100*	*110*	*120*	—	—	—	—	—	—	—	—	—
H8	39	42	47	34	37	41	38	40	45	33	35	39	—	—	—	—	—	—	—	—	—
	130	*140*	*155*	*110*	*120*	*135*	*125*	*130*	*150*	*110*	*115*	*130*	—	—	—	—	—	—	—	—	—
H11	48	50	55	42	44	49	46	48	55	40	42	47	—	—	—	—	—	—	—	—	—
	155	*165*	*180*	*140*	*145*	*160*	*150*	*155*	*180*	*130*	*140*	*155*	—	—	—	—	—	—	—	—	—
H12	46	49	55	40	43	47	44	47	50	38	41	45	—	—	—	—	—	—	—	—	—
	150	*160*	*180*	*130*	*140*	*155*	*145*	*155*	*165*	*125*	*135*	*150*	—	—	—	—	—	—	—	—	—
H21	39	42	47	34	37	41	38	40	45	33	35	39	—	—	—	—	—	—	—	—	—
	130	*140*	*155*	*110*	*120*	*135*	*125*	*130*	*150*	*110*	*115*	*130*	—	—	—	—	—	—	—	—	—

335.25-XN09 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	XNHQ090508TN4-M08 F40M	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P2	XNHQ090508TN4-M08 F40M	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P3	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
P4	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
P5	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
P6	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*
P7	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*
P8	XNHQ090508TN4-M08 MP2501	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
P11	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*
P12	XNHQ090508TN4-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
M1	XNHQ090508TN4-M08 F40M	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
M2	XNHQ090508TN4-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M3	XNHQ090508TN4-M08 F40M	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
M4	XNHQ090508TN4-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
M5	XNHQ090508TN4-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
K1	XNHQ090508TN4-M08 MK2050	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
K2	XNHQ090508TN4-M08 MK2050	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K3	XNHQ090508TN4-M08 MK2050	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K4	XNHQ090508TN4-M08 MK2050	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K5	XNHQ090508TN4-M08 MK2050	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
K6	XNHQ090508TN4-M08 MK2050	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K7	XNHQ090508TN4-M08 MK2050	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
N1	XNHQ090508EN4-E07 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
N2	XNHQ090508EN4-E07 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
N3	XNHQ090508EN4-E07 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
N11	XNHQ090508EN4-E07 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
S1	XNHQ090508TN4-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S2	XNHQ090508TN4-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
S3	XNHQ090508TN4-M08 F40M	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
S11	XNHQ090508TN4-M08 F40M	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
S12	XNHQ090508TN4-M08 F40M	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
S13	XNHQ090508TN4-M08 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
H5	XNHQ090508TN4-M08 MP2501	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
H8	XNHQ090508TN4-M08 MP2501	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
H11	XNHQ090508TN4-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
H12	XNHQ090508TN4-M08 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
H21	XNHQ090508TN4-M08 MP2501	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.25-XN09 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP2501			MK2050		
	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	185 *610*	195 *640*	215 *710*	240 *790*	260 *850*	285 *940*	240 *790*	255 *840*	280 *920*
P2	180 *590*	190 *620*	210 *690*	235 *770*	255 *840*	280 *920*	230 *750*	250 *820*	275 *900*
P3	155 *510*	170 *560*	185 *610*	205 *670*	220 *720*	245 *800*	205 *670*	220 *720*	240 *790*
P4	140 *460*	150 *490*	165 *540*	180 *590*	195 *640*	215 *710*	180 *590*	190 *620*	210 *690*
P5	130 *425*	140 *460*	155 *510*	175 *570*	185 *610*	205 *670*	170 *560*	185 *610*	205 *670*
P6	150 *490*	160 *520*	180 *590*	195 *640*	210 *690*	235 *770*	195 *640*	205 *670*	230 *750*
P7	140 *460*	150 *490*	170 *560*	185 *610*	195 *640*	220 *720*	180 *590*	195 *640*	220 *720*
P8	130 *425*	140 *460*	155 *510*	175 *570*	185 *610*	205 *670*	170 *560*	185 *610*	205 *670*
P11	135 *445*	145 *475*	165 *540*	180 *590*	190 *620*	215 *710*	175 *570*	190 *620*	210 *690*
P12	90 *295*	95 *310*	105 *345*	120 *395*	125 *410*	140 *460*	115 *375*	125 *410*	135 *445*
M1	145 *475*	155 *510*	170 *560*	170 *560*	180 *590*	200 *660*	— —	— —	— —
M2	120 *395*	125 *410*	140 *460*	140 *460*	150 *490*	165 *540*	— —	— —	— —
M3	95 *310*	100 *330*	115 *375*	115 *375*	120 *395*	135 *445*	— —	— —	— —
M4	75 *245*	80 *260*	90 *295*	90 *295*	95 *310*	105 *345*	— —	— —	— —
M5	60 *195*	65 *215*	75 *245*	75 *245*	80 *260*	85 *280*	— —	— —	— —
K1	140 *460*	150 *490*	165 *540*	185 *610*	200 *660*	220 *720*	250 *820*	270 *890*	295 *970*
K2	125 *410*	135 *445*	150 *490*	165 *540*	175 *570*	195 *640*	220 *720*	235 *770*	260 *850*
K3	105 *345*	115 *375*	125 *410*	140 *460*	150 *490*	165 *540*	190 *620*	200 *660*	220 *720*
K4	100 *330*	110 *360*	120 *395*	135 *445*	145 *475*	160 *520*	180 *590*	190 *620*	210 *690*
K5	60 *195*	65 *215*	75 *245*	80 *260*	90 *295*	95 *310*	110 *360*	120 *395*	130 *425*
K6	90 *295*	95 *310*	105 *345*	120 *395*	125 *410*	140 *460*	160 *520*	170 *560*	185 *610*
K7	80 *260*	85 *280*	95 *310*	105 *345*	115 *375*	125 *410*	140 *460*	150 *490*	165 *540*
N1	1050 *3450*	1125 *3700*	1225 *4025*	— —	— —	— —	— —	— —	— —
N2	420 *1375*	455 *1500*	500 *1650*	— —	— —	— —	— —	— —	— —
N3	280 *920*	305 *1000*	330 *1075*	— —	— —	— —	— —	— —	— —
N11	320 *1050*	345 *1125*	380 *1250*	— —	— —	— —	— —	— —	— —
S1	35 *115*	37 *120*	41 *135*	43 *140*	46 *150*	50 *165*	— —	— —	— —
S2	28 *90*	30 *100*	33 *110*	34 *110*	37 *120*	41 *135*	— —	— —	— —
S3	24 *80*	26 *85*	29 *95*	30 *100*	32 *105*	36 *120*	— —	— —	— —
S11	49 *160*	50 *165*	55 *180*	60 *195*	65 *215*	70 *230*	— —	— —	— —
S12	41 *135*	43 *140*	48 *155*	50 *165*	55 *180*	60 *195*	— —	— —	— —
S13	24 *80*	26 *85*	28 *90*	29 *95*	31 *100*	34 *110*	— —	— —	— —
H5	30 *100*	31 *100*	35 *115*	35 *115*	38 *125*	42 *140*	— —	— —	— —
H8	31 *100*	33 *110*	37 *120*	38 *125*	40 *130*	44 *145*	— —	— —	— —
H11	38 *125*	40 *130*	44 *145*	45 *150*	48 *155*	55 *180*	— —	— —	— —
H12	36 *120*	39 *130*	43 *140*	44 *145*	47 *155*	50 *165*	— —	— —	— —
H21	31 *100*	33 *110*	37 *120*	38 *125*	40 *130*	44 *145*	— —	— —	— —

335.25-XN12 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	XNHQ120608TN4-M10 F40M	0,17 *0.0065*	0,19 *0.0075*	0,26 *0.010*
P2	XNHQ120608TN4-M10 F40M	0,17 *0.0065*	0,20 *0.0080*	0,26 *0.010*
P3	XNHQ120608TN4-M10 F40M	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*
P4	XNHQ120608TN4-M10 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
P5	XNHQ120608TN4-M10 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
P6	XNHQ120608TN4-M10 F40M	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
P7	XNHQ120608TN4-M10 F40M	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
P8	XNHQ120608TN4-M10 MP2501	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*
P11	XNHQ120608TN4-M10 F40M	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
P12	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
M1	XNHQ120608TN4-M10 F40M	0,17 *0.0065*	0,20 *0.0080*	0,26 *0.010*
M2	XNHQ120608TN4-M10 F40M	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
M3	XNHQ120608TN4-M10 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
M4	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M5	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
K1	XNHQ120608TN4-M10 MK2050	0,17 *0.0065*	0,20 *0.0080*	0,26 *0.010*
K2	XNHQ120608TN4-M10 MK2050	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K3	XNHQ120608TN4-M10 MK2050	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K4	XNHQ120608TN4-M10 MK2050	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K5	XNHQ120608TN4-M10 MK2050	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
K6	XNHQ120608TN4-M10 MK2050	0,16 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K7	XNHQ120608TN4-M10 MK2050	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N1	XNHQ120608EN4-E09 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
N2	XNHQ120608EN4-E09 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
N3	XNHQ120608EN4-E09 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
N11	XNHQ120608EN4-E09 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
S1	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
S2	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
S3	XNHQ120608TN4-M10 F40M	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
S11	XNHQ120608TN4-M10 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
S12	XNHQ120608TN4-M10 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
S13	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
H5	XNHQ120608TN4-M10 MP2501	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
H8	XNHQ120608TN4-M10 MP2501	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
H11	XNHQ120608TN4-M10 F40M	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
H12	XNHQ120608TN4-M10 F40M	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*
H21	XNHQ120608TN4-M10 MP2501	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.25-XN12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MP2501			MK2050		
	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	175 *570*	190 *620*	210 *690*	235 *770*	250 *820*	275 *900*	230 *750*	250 *820*	275 *900*
P2	170 *560*	185 *610*	205 *670*	225 *740*	240 *790*	270 *890*	225 *740*	240 *790*	265 *870*
P3	150 *490*	160 *520*	180 *590*	200 *660*	210 *690*	235 *770*	195 *640*	210 *690*	230 *750*
P4	135 *445*	145 *475*	160 *520*	175 *570*	190 *620*	210 *690*	175 *570*	185 *610*	205 *670*
P5	125 *410*	135 *445*	150 *490*	165 *540*	180 *590*	200 *660*	165 *540*	175 *570*	195 *640*
P6	145 *475*	155 *510*	170 *560*	190 *620*	200 *660*	225 *740*	190 *620*	200 *660*	220 *720*
P7	135 *445*	145 *475*	160 *520*	180 *590*	190 *620*	210 *690*	180 *590*	190 *620*	210 *690*
P8	125 *410*	135 *445*	150 *490*	165 *540*	175 *570*	195 *640*	165 *540*	175 *570*	195 *640*
P11	135 *445*	140 *460*	155 *510*	175 *570*	185 *610*	205 *670*	175 *570*	185 *610*	200 *660*
P12	85 *280*	90 *295*	100 *330*	110 *360*	120 *395*	135 *445*	110 *360*	120 *395*	135 *445*
M1	140 *460*	150 *490*	165 *540*	165 *540*	175 *570*	195 *640*	— —	— —	— —
M2	115 *375*	125 *410*	135 *445*	135 *445*	145 *475*	160 *520*	— —	— —	— —
M3	95 *310*	100 *330*	110 *360*	110 *360*	120 *395*	130 *425*	— —	— —	— —
M4	70 *230*	75 *245*	85 *280*	85 *280*	90 *295*	100 *330*	— —	— —	— —
M5	60 *195*	65 *215*	70 *230*	70 *230*	75 *245*	85 *280*	— —	— —	— —
K1	135 *445*	145 *475*	160 *520*	180 *590*	190 *620*	215 *710*	240 *790*	255 *840*	285 *940*
K2	120 *395*	130 *425*	145 *475*	160 *520*	170 *560*	190 *620*	215 *710*	230 *750*	255 *840*
K3	100 *330*	110 *360*	120 *395*	135 *445*	145 *475*	160 *520*	180 *590*	195 *640*	215 *710*
K4	95 *310*	105 *345*	115 *375*	130 *425*	140 *460*	155 *510*	170 *560*	185 *610*	205 *670*
K5	60 *195*	65 *215*	70 *230*	80 *260*	85 *280*	95 *310*	105 *345*	115 *375*	125 *410*
K6	85 *280*	90 *295*	100 *330*	115 *375*	120 *395*	135 *445*	150 *490*	165 *540*	180 *590*
K7	75 *245*	80 *260*	90 *295*	100 *330*	110 *360*	120 *395*	135 *445*	145 *475*	160 *520*
N1	1000 *3275*	1075 *3525*	1175 *3850*	— —	— —	— —	— —	— —	— —
N2	405 *1325*	435 *1425*	480 *1575*	— —	— —	— —	— —	— —	— —
N3	270 *890*	290 *950*	320 *1050*	— —	— —	— —	— —	— —	— —
N11	305 *1000*	330 *1075*	365 *1200*	— —	— —	— —	— —	— —	— —
S1	34 *110*	36 *120*	40 *130*	41 *135*	44 *145*	49 *160*	— —	— —	— —
S2	27 *90*	29 *95*	32 *105*	33 *110*	35 *115*	39 *130*	— —	— —	— —
S3	24 *80*	25 *80*	28 *90*	29 *95*	31 *100*	34 *110*	— —	— —	— —
S11	48 *155*	50 *165*	55 *180*	60 *195*	60 *195*	70 *230*	— —	— —	— —
S12	40 *130*	43 *140*	47 *155*	49 *160*	50 *165*	60 *195*	— —	— —	— —
S13	23 *75*	24 *80*	27 *90*	28 *90*	30 *100*	33 *110*	— —	— —	— —
H5	28 *90*	31 *100*	34 *110*	34 *110*	37 *120*	41 *135*	— —	— —	— —
H8	31 *100*	32 *105*	36 *120*	37 *120*	39 *130*	43 *140*	— —	— —	— —
H11	36 *120*	39 *130*	43 *140*	43 *140*	47 *155*	50 *165*	— —	— —	— —
H12	36 *120*	38 *125*	42 *140*	43 *140*	45 *150*	50 *165*	— —	— —	— —
H21	31 *100*	32 *105*	36 *120*	37 *120*	39 *130*	43 *140*	— —	— —	— —

335.25-XN14/XN17 – Insert selection – mm/*Inch*

SMG			f_z		
			30%	20%	10%
P1	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
P2	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
P3	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P4	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P5	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
P6	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P7	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P8	XNHQ140708TN4-M11 MP2501	XNHQ170708TN4-M13 MP2501	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P11	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P12	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
M1	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
M2	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
M3	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*
M4	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M5	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K1	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
K2	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K3	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K4	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K5	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,17 *0.0065*	0,19 *0.0075*	0,25 *0.010*
K6	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K7	XNHQ140708TN4-M11 MK2050	XNHQ170708TN4-M13 MK2050	0,17 *0.0065*	0,19 *0.0075*	0,25 *0.010*
N1	XNHQ140708EN4-E10 H25	XNHQ170708EN4-E12 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
N2	XNHQ140708EN4-E10 H25	XNHQ170708EN4-E12 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
N3	XNHQ140708EN4-E10 H25	XNHQ170708EN4-E12 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
N11	XNHQ140708EN4-E10 H25	XNHQ170708EN4-E12 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
S1	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S2	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S3	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
S11	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*
S12	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*
S13	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
H5	XNHQ140708TN4-M11 MP2501	XNHQ170708TN4-M13 MP2501	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
H8	XNHQ140708TN4-M11 MP2501	XNHQ170708TN4-M13 MP2501	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
H11	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
H12	XNHQ140708TN4-M11 F40M	XNHQ170708TN4-M13 F40M	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
H21	XNHQ140708TN4-M11 MP2501	XNHQ170708TN4-M13 MP2501	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.25-XN14/XN17 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			F40M			MK2050			H25		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	225 *740*	245 *800*	270 *890*	170 *560*	185 *610*	205 *670*	225 *740*	240 *790*	265 *870*	— —	— —	— —
P2	220 *720*	235 *770*	260 *850*	165 *540*	175 *570*	195 *640*	215 *710*	230 *750*	255 *840*	— —	— —	— —
P3	195 *640*	205 *670*	225 *740*	145 *475*	155 *510*	170 *560*	190 *620*	205 *670*	225 *740*	— —	— —	— —
P4	170 *560*	180 *590*	205 *670*	130 *425*	135 *445*	155 *510*	165 *540*	180 *590*	200 *660*	— —	— —	— —
P5	165 *540*	175 *570*	195 *640*	125 *410*	130 *425*	145 *475*	160 *520*	170 *560*	190 *620*	— —	— —	— —
P6	185 *610*	200 *660*	220 *720*	140 *460*	150 *490*	165 *540*	180 *590*	195 *640*	215 *710*	— —	— —	— —
P7	175 *570*	190 *620*	205 *670*	130 *425*	145 *475*	155 *510*	170 *560*	185 *610*	205 *670*	— —	— —	— —
P8	160 *520*	175 *570*	190 *620*	125 *410*	130 *425*	145 *475*	160 *520*	170 *560*	190 *620*	— —	— —	— —
P11	170 *560*	185 *610*	200 *660*	130 *425*	140 *460*	150 *490*	165 *540*	180 *590*	195 *640*	— —	— —	— —
P12	110 *360*	120 *395*	130 *425*	85 *280*	90 *295*	100 *330*	110 *360*	120 *395*	130 *425*	— —	— —	— —
M1	160 *520*	170 *560*	185 *610*	135 *445*	140 *460*	160 *520*	— —	— —	— —	— —	— —	— —
M2	130 *425*	140 *460*	155 *510*	110 *360*	120 *395*	135 *445*	— —	— —	— —	— —	— —	— —
M3	105 *345*	115 *375*	130 *425*	90 *295*	95 *310*	110 *360*	— —	— —	— —	— —	— —	— —
M4	85 *280*	90 *295*	100 *330*	70 *230*	75 *245*	85 *280*	— —	— —	— —	— —	— —	— —
M5	70 *230*	75 *245*	80 *260*	60 *195*	65 *215*	70 *230*	— —	— —	— —	— —	— —	— —
K1	175 *570*	185 *610*	205 *670*	130 *425*	140 *460*	155 *510*	235 *770*	250 *820*	275 *900*	— —	— —	— —
K2	155 *510*	165 *540*	185 *610*	120 *395*	125 *410*	140 *460*	210 *690*	220 *720*	250 *820*	— —	— —	— —
K3	130 *425*	140 *460*	155 *510*	100 *330*	105 *345*	120 *395*	175 *570*	185 *610*	210 *690*	— —	— —	— —
K4	125 *410*	135 *445*	150 *490*	95 *310*	100 *330*	115 *375*	170 *560*	180 *590*	200 *660*	— —	— —	— —
K5	75 *245*	80 *260*	90 *295*	60 *195*	60 *195*	70 *230*	100 *330*	110 *360*	125 *410*	— —	— —	— —
K6	110 *360*	115 *375*	130 *425*	85 *280*	90 *295*	100 *330*	150 *490*	155 *510*	175 *570*	— —	— —	— —
K7	100 *330*	105 *345*	115 *375*	75 *245*	80 *260*	90 *295*	130 *425*	140 *460*	160 *520*	— —	— —	— —
N1	— —	— —	— —	960 *3150*	1025 *3375*	1150 *3775*	— —	— —	— —	970 *3175*	1050 *3450*	1175 *3850*
N2	— —	— —	— —	390 *1275*	415 *1350*	460 *1500*	— —	— —	— —	395 *1300*	420 *1375*	470 *1550*
N3	— —	— —	— —	260 *850*	280 *920*	310 *1025*	— —	— —	— —	260 *850*	280 *920*	315 *1025*
N11	— —	— —	— —	295 *970*	315 *1025*	350 *1150*	— —	— —	— —	300 *980*	320 *1050*	360 *1175*
S1	40 *130*	43 *140*	48 *155*	33 *110*	35 *115*	39 *130*	— —	— —	— —	— —	— —	— —
S2	33 *110*	35 *115*	39 *130*	26 *85*	28 *90*	31 *100*	— —	— —	— —	— —	— —	— —
S3	29 *95*	31 *100*	34 *110*	23 *75*	25 *80*	28 *90*	— —	— —	— —	— —	— —	— —
S11	55 *180*	60 *195*	65 *215*	46 *150*	49 *160*	55 *180*	— —	— —	— —	— —	— —	— —
S12	47 *155*	50 *165*	55 *180*	38 *125*	41 *135*	46 *150*	— —	— —	— —	— —	— —	— —
S13	28 *90*	29 *95*	33 *110*	22 *70*	24 *80*	27 *90*	— —	— —	— —	— —	— —	— —
H5	33 *110*	36 *120*	40 *130*	28 *90*	30 *100*	33 *110*	— —	— —	— —	— —	— —	— —
H8	36 *120*	38 *125*	42 *140*	30 *100*	32 *105*	35 *115*	— —	— —	— —	— —	— —	— —
H11	42 *140*	46 *150*	50 *165*	35 *115*	38 *125*	42 *140*	— —	— —	— —	— —	— —	— —
H12	42 *140*	45 *150*	49 *160*	35 *115*	37 *120*	41 *135*	— —	— —	— —	— —	— —	— —
H21	36 *120*	38 *125*	42 *140*	30 *100*	32 *105*	35 *115*	— —	— —	— —	— —	— —	— —

335.25-LN14/LN17 – Insert selection – mm/*Inch*

SMG			f_z		
			30%	20%	10%
P1	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
P2	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
P3	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P4	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P5	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
P6	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P7	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P8	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P11	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P12	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
M1	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
M2	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
M3	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*
M4	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M5	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K1	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
K2	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K3	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K4	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K5	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,17 *0.0065*	0,19 *0.0075*	0,25 *0.010*
K6	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*
K7	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,17 *0.0065*	0,19 *0.0075*	0,25 *0.010*
S1	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S2	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S3	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*
S11	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*
S12	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*
S13	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
H5	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
H8	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
H11	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,13 *0.0050*	0,14 *0.0055*	0,19 *0.0075*
H12	LNHQ140708TN4-M11 F40M	LNHQ170708TN4-M13 F40M	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
H21	LNHQ140708TN4-M11 MP2501	LNHQ170708TN4-M13 F40M	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.25-LN14/LN17 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			F40M		
	30%	20%	10%	30%	20%	10%
P1	225 *740*	245 *800*	270 *890*	170 *560*	185 *610*	205 *670*
P2	220 *720*	235 *770*	260 *850*	165 *540*	175 *570*	195 *640*
P3	195 *640*	205 *670*	225 *740*	145 *475*	155 *510*	170 *560*
P4	170 *560*	180 *590*	205 *670*	130 *425*	135 *445*	155 *510*
P5	165 *540*	175 *570*	195 *640*	125 *410*	130 *425*	145 *475*
P6	185 *610*	200 *660*	220 *720*	140 *460*	150 *490*	165 *540*
P7	175 *570*	190 *620*	205 *670*	130 *425*	145 *475*	155 *510*
P8	160 *520*	175 *570*	190 *620*	125 *410*	130 *425*	145 *475*
P11	170 *560*	185 *610*	200 *660*	130 *425*	140 *460*	150 *490*
P12	110 *360*	120 *395*	130 *425*	85 *280*	90 *295*	100 *330*
M1	160 *520*	170 *560*	185 *610*	135 *445*	140 *460*	160 *520*
M2	130 *425*	140 *460*	155 *510*	110 *360*	120 *395*	135 *445*
M3	105 *345*	115 *375*	130 *425*	90 *295*	95 *310*	110 *360*
M4	85 *280*	90 *295*	100 *330*	70 *230*	75 *245*	85 *280*
M5	70 *230*	75 *245*	80 *260*	60 *195*	65 *215*	70 *230*
K1	175 *570*	185 *610*	205 *670*	130 *425*	140 *460*	155 *510*
K2	155 *510*	165 *540*	185 *610*	120 *395*	125 *410*	140 *460*
K3	130 *425*	140 *460*	155 *510*	100 *330*	105 *345*	120 *395*
K4	125 *410*	135 *445*	150 *490*	95 *310*	100 *330*	115 *375*
K5	75 *245*	80 *260*	90 *295*	60 *195*	60 *195*	70 *230*
K6	110 *360*	115 *375*	130 *425*	85 *280*	90 *295*	100 *330*
K7	100 *330*	105 *345*	115 *375*	75 *245*	80 *260*	90 *295*
N1	— —	— —	— —	960 *3150*	1025 *3375*	1150 *3775*
N2	— —	— —	— —	390 *1275*	415 *1350*	460 *1500*
N3	— —	— —	— —	260 *850*	280 *920*	310 *1025*
N11	— —	— —	— —	295 *970*	315 *1025*	350 *1150*
S1	40 *130*	43 *140*	48 *155*	33 *110*	35 *115*	39 *130*
S2	33 *110*	35 *115*	39 *130*	26 *85*	28 *90*	31 *100*
S3	29 *95*	31 *100*	34 *110*	23 *75*	25 *80*	28 *90*
S11	55 *180*	60 *195*	65 *215*	46 *150*	49 *160*	55 *180*
S12	47 *155*	50 *165*	55 *180*	38 *125*	41 *135*	46 *150*
S13	28 *90*	29 *95*	33 *110*	22 *70*	24 *80*	27 *90*
H5	33 *110*	36 *120*	40 *130*	28 *90*	30 *100*	33 *110*
H8	36 *120*	38 *125*	42 *140*	30 *100*	32 *105*	35 *115*
H11	42 *140*	46 *150*	50 *165*	35 *115*	38 *125*	42 *140*
H12	42 *140*	45 *150*	49 *160*	35 *115*	37 *120*	41 *135*
H21	36 *120*	38 *125*	42 *140*	30 *100*	32 *105*	35 *115*

335.29 Round 5 – Insert selection – mm/*Inch*

SMG		f_z		
		25%	10%	5%
P1	RDHW0501M0-MD01 F40M	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*
P2	RDHW0501M0-MD01 F40M	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*
P3	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
P4	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
P5	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
P6	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,070 *0.0028*	0,10 *0.0040*
P7	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,070 *0.0028*	0,10 *0.0040*
P8	RDHW0501M0-MD01 MP3000	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
P11	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,070 *0.0028*	0,10 *0.0040*
P12	RDHW0501M0-MD01 F40M	0,034 *0.0013*	0,050 *0.0020*	0,070 *0.0028*
M1	RDHW0501M0-MD01 F40M	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*
M2	RDHW0501M0-MD01 F40M	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
M3	RDHW0501M0-MD01 F40M	0,040 *0.0016*	0,060 *0.0024*	0,080 *0.0032*
M4	RDHW0501M0-MD01 F40M	0,036 *0.0014*	0,050 *0.0020*	0,070 *0.0028*
M5	RDHW0501M0-MD01 F40M	0,036 *0.0014*	0,050 *0.0020*	0,070 *0.0028*
K1	RDHW0501M0-MD01 MP3000	0,055 *0.0022*	0,080 *0.0032*	0,11 *0.0044*
K2	RDHW0501M0-MD01 MP3000	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
K3	RDHW0501M0-MD01 MP3000	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
K4	RDHW0501M0-MD01 MP3000	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
K5	RDHW0501M0-MD01 MP3000	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*
K6	RDHW0501M0-MD01 MP3000	0,050 *0.0020*	0,075 *0.0030*	0,10 *0.0040*
K7	RDHW0501M0-MD01 MP3000	0,046 *0.0018*	0,065 *0.0026*	0,090 *0.0036*
N1	RDHW0501M0-MD01 MP3000	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*
N2	RDHW0501M0-MD01 MP3000	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*
N3	RDHW0501M0-MD01 MP3000	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*
N11	RDHW0501M0-MD01 MP3000	0,070 *0.0028*	0,10 *0.0040*	0,14 *0.0055*
S1	RDHW0501M0-MD01 F40M	0,036 *0.0014*	0,050 *0.0020*	0,070 *0.0028*
S2	RDHW0501M0-MD01 F40M	0,036 *0.0014*	0,050 *0.0020*	0,070 *0.0028*
S3	RDHW0501M0-MD01 F40M	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*
S11	RDHW0501M0-MD01 F40M	0,040 *0.0016*	0,060 *0.0024*	0,080 *0.0032*
S12	RDHW0501M0-MD01 F40M	0,040 *0.0016*	0,060 *0.0024*	0,080 *0.0032*
S13	RDHW0501M0-MD01 F40M	0,036 *0.0014*	0,050 *0.0020*	0,070 *0.0028*
H5	RDHW0501M0-MD01 MP3000	0,034 *0.0013*	0,050 *0.0020*	0,070 *0.0028*
H8	RDHW0501M0-MD01 MP3000	0,026 *0.0010*	0,038 *0.0015*	0,050 *0.0020*
H11	RDHW0501M0-MD01 MP3000	0,034 *0.0013*	0,050 *0.0020*	0,070 *0.0028*
H12	RDHW0501M0-MD01 MP3000	0,026 *0.0010*	0,038 *0.0015*	0,050 *0.0020*
H21	RDHW0501M0-MD01 MP3000	0,026 *0.0010*	0,038 *0.0015*	0,050 *0.0020*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.29 Round 5 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			F40M		
	25%	10%	5%	25%	10%	5%
P1	325 *1075*	365 *1200*	400 *1300*	260 *850*	295 *970*	320 *1050*
P2	315 *1025*	360 *1175*	390 *1275*	250 *820*	285 *940*	310 *1025*
P3	275 *900*	310 *1025*	340 *1125*	220 *720*	250 *820*	270 *890*
P4	240 *790*	275 *900*	300 *980*	195 *640*	220 *720*	240 *790*
P5	230 *750*	260 *850*	285 *940*	185 *610*	210 *690*	225 *740*
P6	260 *850*	295 *970*	320 *1050*	205 *670*	235 *770*	255 *840*
P7	245 *800*	280 *920*	300 *980*	195 *640*	225 *740*	240 *790*
P8	230 *750*	260 *850*	285 *940*	185 *610*	210 *690*	225 *740*
P11	235 *770*	270 *890*	295 *970*	190 *620*	215 *710*	235 *770*
P12	145 *475*	165 *540*	180 *590*	120 *395*	135 *445*	145 *475*
M1	235 *770*	270 *890*	290 *950*	200 *660*	230 *750*	250 *820*
M2	195 *640*	220 *720*	240 *790*	165 *540*	190 *620*	205 *670*
M3	150 *490*	170 *560*	185 *610*	130 *425*	150 *490*	160 *520*
M4	115 *375*	130 *425*	140 *460*	100 *330*	115 *375*	120 *395*
M5	95 *310*	110 *360*	120 *395*	80 *260*	95 *310*	100 *330*
K1	210 *690*	240 *790*	260 *850*	200 *660*	225 *740*	245 *800*
K2	185 *610*	210 *690*	225 *740*	175 *570*	200 *660*	215 *710*
K3	155 *510*	175 *570*	190 *620*	150 *490*	170 *560*	185 *610*
K4	150 *490*	170 *560*	185 *610*	140 *460*	160 *520*	175 *570*
K5	90 *295*	100 *330*	110 *360*	85 *280*	95 *310*	105 *345*
K6	130 *425*	150 *490*	160 *520*	125 *410*	140 *460*	155 *510*
K7	115 *375*	130 *425*	140 *460*	110 *360*	125 *410*	135 *445*
N1	1900 *6225*	2175 *7125*	2350 *7700*	1525 *5000*	1725 *5650*	1875 *6150*
N2	760 *2500*	870 *2850*	950 *3125*	610 *2000*	700 *2300*	760 *2500*
N3	510 *1675*	580 *1900*	630 *2075*	410 *1350*	465 *1525*	500 *1650*
N11	580 *1900*	670 *2200*	720 *2350*	465 *1525*	530 *1750*	580 *1900*
S1	55 *180*	60 *195*	65 *215*	46 *150*	55 *180*	55 *180*
S2	43 *140*	49 *160*	55 *180*	37 *120*	42 *140*	46 *150*
S3	38 *125*	43 *140*	46 *150*	32 *105*	37 *120*	40 *130*
S11	75 *245*	85 *280*	95 *310*	65 *215*	75 *245*	80 *260*
S12	65 *215*	75 *245*	80 *260*	55 *180*	65 *215*	70 *230*
S13	37 *120*	42 *140*	45 *150*	32 *105*	36 *120*	39 *130*
H5	41 *135*	47 *155*	50 *165*	39 *130*	44 *145*	48 *155*
H8	42 *140*	48 *155*	50 *165*	40 *130*	45 *150*	49 *160*
H11	50 *165*	60 *195*	65 *215*	50 *165*	55 *180*	60 *195*
H12	49 *160*	55 *180*	60 *195*	47 *155*	55 *180*	55 *180*
H21	42 *140*	48 *155*	50 *165*	40 *130*	45 *150*	49 *160*

335.29 Round 6 – Insert selection – mm/*Inch*

SMG		f_z		
		20%	10%	5%
P1	RDHW06T1M0-MD02 F40M	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
P2	RDHW06T1M0-MD02 F40M	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
P3	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
P4	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
P5	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
P6	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,070 *0.0028*	0,10 *0.0040*
P7	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,070 *0.0028*	0,10 *0.0040*
P8	RDHW06T1M0-MD02 MP3000	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
P11	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,070 *0.0028*	0,10 *0.0040*
P12	RDHW06T1M0-MD02 F40M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
M1	RDHW06T1M0-MD02 F40M	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
M2	RDHW06T1M0-MD02 F40M	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
M3	RDHW06T1M0-MD02 F40M	0,044 *0.0017*	0,060 *0.0024*	0,080 *0.0032*
M4	RDHW06T1M0-MD02 F40M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
M5	RDHW06T1M0-MD02 F40M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
K1	RDHW06T1M0-MD02 MK2050	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
K2	RDHW06T1M0-MD02 MK2050	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
K3	RDHW06T1M0-MD02 MK2050	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
K4	RDHW06T1M0-MD02 MK2050	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
K5	RDHW06T1M0-MD02 MK2050	0,050 *0.0020*	0,065 *0.0026*	0,090 *0.0036*
K6	RDHW06T1M0-MD02 MK2050	0,055 *0.0022*	0,075 *0.0030*	0,10 *0.0040*
K7	RDHW06T1M0-MD02 MK2050	0,050 *0.0020*	0,065 *0.0026*	0,090 *0.0036*
N1	RDHT06T1M0-E02 H25	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
N2	RDHT06T1M0-E02 H25	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
N3	RDHT06T1M0-E02 H25	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
N11	RDHT06T1M0-E02 H25	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
S1	RDHW06T1M0-MD02 F40M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
S2	RDHW06T1M0-MD02 F40M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
S3	RDHW06T1M0-MD02 F40M	0,036 *0.0014*	0,048 *0.0019*	0,065 *0.0026*
S11	RDHW06T1M0-MD02 F40M	0,044 *0.0017*	0,060 *0.0024*	0,080 *0.0032*
S12	RDHW06T1M0-MD02 F40M	0,044 *0.0017*	0,060 *0.0024*	0,080 *0.0032*
S13	RDHW06T1M0-MD02 F40M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
H5	RDHW06T1M0-MD02 F15M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
H8	RDHW06T1M0-MD02 F15M	0,028 *0.0011*	0,038 *0.0015*	0,050 *0.0020*
H11	RDHW06T1M0-MD02 F15M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
H12	RDHW06T1M0-MD02 F15M	0,028 *0.0011*	0,038 *0.0015*	0,050 *0.0020*
H21	RDHW06T1M0-MD02 F15M	0,028 *0.0011*	0,038 *0.0015*	0,050 *0.0020*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.29 Round 6 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			F15M			F30M			F40M			MK2050			H25		
	20%	10%	5%	20%	10%	5%	20%	10%	5%	20%	10%	5%	20%	10%	5%	20%	10%	5%
P1	320	350	380	—	—	—	270	295	320	255	280	305	330	365	395	—	—	—
	1050	*1150*	*1250*	—	—	—	*890*	*970*	*1050*	*840*	*920*	*1000*	*1075*	*1200*	*1300*	—	—	—
P2	310	345	370	—	—	—	260	290	310	250	275	295	325	355	385	—	—	—
	1025	*1125*	*1225*	—	—	—	*850*	*950*	*1025*	*820*	*900*	*970*	*1075*	*1175*	*1275*	—	—	—
P3	270	300	325	—	—	—	230	250	270	215	240	260	280	310	335	—	—	—
	890	*980*	*1075*	—	—	—	*750*	*820*	*890*	*710*	*790*	*850*	*920*	*1025*	*1100*	—	—	—
P4	240	260	285	—	—	—	200	220	240	190	210	230	250	275	295	—	—	—
	790	*850*	*940*	—	—	—	*660*	*720*	*790*	*620*	*690*	*750*	*820*	*900*	*970*	—	—	—
P5	230	250	275	—	—	—	190	210	230	180	200	220	235	260	285	—	—	—
	750	*820*	*900*	—	—	—	*620*	*690*	*750*	*590*	*660*	*720*	*770*	*850*	*940*	—	—	—
P6	255	285	305	—	—	—	215	240	255	205	225	245	265	295	320	—	—	—
	840	*940*	*1000*	—	—	—	*710*	*790*	*840*	*670*	*740*	*800*	*870*	*970*	*1050*	—	—	—
P7	240	270	290	—	—	—	205	225	245	195	215	230	250	280	300	—	—	—
	790	*890*	*950*	—	—	—	*670*	*740*	*800*	*640*	*710*	*750*	*820*	*920*	*980*	—	—	—
P8	230	250	275	—	—	—	190	210	230	180	200	220	235	260	285	—	—	—
	750	*820*	*900*	—	—	—	*620*	*690*	*750*	*590*	*660*	*720*	*770*	*850*	*940*	—	—	—
P11	235	260	280	—	—	—	195	220	235	190	210	225	245	270	290	—	—	—
	770	*850*	*920*	—	—	—	*640*	*720*	*770*	*620*	*690*	*740*	*800*	*890*	*950*	—	—	—
M1	235	255	280	—	—	—	210	230	250	200	220	240	—	—	—	—	—	—
	770	*840*	*920*	—	—	—	*690*	*750*	*820*	*660*	*720*	*790*	—	—	—	—	—	—
M2	190	210	230	—	—	—	170	190	205	165	180	195	—	—	—	—	—	—
	620	*690*	*750*	—	—	—	*560*	*620*	*670*	*540*	*590*	*640*	—	—	—	—	—	—
M3	150	165	180	—	—	—	135	150	160	130	140	155	—	—	—	—	—	—
	490	*540*	*590*	—	—	—	*445*	*490*	*520*	*425*	*460*	*510*	—	—	—	—	—	—
M4	115	125	135	—	—	—	105	115	125	100	110	115	—	—	—	—	—	—
	375	*410*	*445*	—	—	—	*345*	*375*	*410*	*330*	*360*	*375*	—	—	—	—	—	—
M5	95	105	115	—	—	—	85	95	105	80	90	100	—	—	—	—	—	—
	310	*345*	*375*	—	—	—	*280*	*310*	*345*	*260*	*295*	*330*	—	—	—	—	—	—
K1	205	230	245	235	260	285	205	230	245	195	215	235	350	385	415	—	—	—
	670	*750*	*800*	*770*	*850*	*940*	*670*	*750*	*800*	*640*	*710*	*770*	*1150*	*1275*	*1350*	—	—	—
K2	180	200	215	210	230	250	180	200	215	175	190	205	305	335	365	—	—	—
	590	*660*	*710*	*690*	*750*	*820*	*590*	*660*	*710*	*570*	*620*	*670*	*1000*	*1100*	*1200*	—	—	—
K3	155	170	185	175	195	210	155	170	185	145	160	175	260	285	310	—	—	—
	510	*560*	*610*	*570*	*640*	*690*	*510*	*560*	*610*	*475*	*520*	*570*	*850*	*940*	*1025*	—	—	—
K4	145	160	175	170	185	200	145	160	175	140	155	165	250	270	295	—	—	—
	475	*520*	*570*	*560*	*610*	*660*	*475*	*520*	*570*	*460*	*510*	*540*	*820*	*890*	*970*	—	—	—
K5	90	100	105	100	110	120	90	100	105	85	95	100	150	165	180	—	—	—
	295	*330*	*345*	*330*	*360*	*395*	*295*	*330*	*345*	*280*	*310*	*330*	*490*	*540*	*590*	—	—	—
K6	130	140	155	150	160	175	130	140	155	125	135	145	220	240	260	—	—	—
	425	*460*	*510*	*490*	*520*	*570*	*425*	*460*	*510*	*410*	*445*	*475*	*720*	*790*	*850*	—	—	—
K7	115	125	135	130	145	155	115	125	135	110	120	130	190	210	230	—	—	—
	375	*410*	*445*	*425*	*475*	*510*	*375*	*410*	*445*	*360*	*395*	*425*	*620*	*690*	*750*	—	—	—
N1	1875	2075	2250	—	—	—	1575	1750	1875	1500	1650	1800	—	—	—	1725	1900	2050
	6150	*6800*	*7375*	—	—	—	*5175*	*5750*	*6150*	*4925*	*5425*	*5900*	—	—	—	*5650*	*6225*	*6725*
N2	760	840	910	—	—	—	640	700	760	610	670	730	—	—	—	700	770	830
	2500	*2750*	*2975*	—	—	—	*2100*	*2300*	*2500*	*2000*	*2200*	*2400*	—	—	—	*2300*	*2525*	*2725*
N3	510	560	600	—	—	—	425	470	510	405	445	485	—	—	—	465	510	560
	1675	*1825*	*1975*	—	—	—	*1400*	*1550*	*1675*	*1325*	*1450*	*1600*	—	—	—	*1525*	*1675*	*1825*
N11	580	640	690	—	—	—	485	540	580	465	510	550	—	—	—	530	580	630
	1900	*2100*	*2275*	—	—	—	*1600*	*1775*	*1900*	*1525*	*1675*	*1800*	—	—	—	*1750*	*1900*	*2075*
S1	55	60	65	—	—	—	48	55	55	46	50	55	—	—	—	—	—	—
	180	*195*	*215*	—	—	—	*155*	*180*	*180*	*150*	*165*	*180*	—	—	—	—	—	—
S2	43	47	50	—	—	—	39	43	46	37	41	44	—	—	—	—	—	—
	140	*155*	*165*	—	—	—	*130*	*140*	*150*	*120*	*135*	*145*	—	—	—	—	—	—
S3	37	41	44	—	—	—	34	37	40	32	35	38	—	—	—	—	—	—
	120	*135*	*145*	—	—	—	*110*	*120*	*130*	*105*	*115*	*125*	—	—	—	—	—	—
S11	75	85	90	—	—	—	70	75	80	65	70	80	—	—	—	—	—	—
	245	*280*	*295*	—	—	—	*230*	*245*	*260*	*215*	*230*	*260*	—	—	—	—	—	—
S12	65	70	75	—	—	—	48	55	55	55	60	65	—	—	—	—	—	—
	215	*230*	*245*	—	—	—	*155*	*180*	*180*	*180*	*195*	*215*	—	—	—	—	—	—
S13	36	40	43	—	—	—	27	30	33	31	35	37	—	—	—	—	—	—
	120	*130*	*140*	—	—	—	*90*	*100*	*110*	*100*	*115*	*120*	—	—	—	—	—	—
H5	40	45	48	46	50	55	40	45	48	39	43	46	—	—	—	—	—	—
	130	*150*	*155*	*150*	*165*	*180*	*130*	*150*	*155*	*130*	*140*	*150*	—	—	—	—	—	—
H8	42	46	50	48	50	55	42	46	50	40	44	47	—	—	—	—	—	—
	140	*150*	*165*	*155*	*165*	*180*	*140*	*150*	*165*	*130*	*145*	*155*	—	—	—	—	—	—
H11	50	55	60	60	65	70	50	55	60	49	55	60	—	—	—	—	—	—
	165	*180*	*195*	*195*	*215*	*230*	*165*	*180*	*195*	*160*	*180*	*195*	—	—	—	—	—	—
H12	49	55	60	55	60	65	49	55	60	46	50	55	—	—	—	—	—	—
	160	*180*	*195*	*180*	*195*	*215*	*160*	*180*	*195*	*150*	*165*	*180*	—	—	—	—	—	—
H21	42	46	50	48	50	55	42	46	50	40	44	47	—	—	—	—	—	—
	140	*150*	*165*	*155*	*165*	*180*	*140*	*150*	*165*	*130*	*145*	*155*	—	—	—	—	—	—

335.29 Round 7 – Insert selection – mm/*Inch*

SMG		f_z		
		20%	10%	5%
P1	RDHW0702M0-MD03 F40M	0,080 *0.0032*	0,10 *0.0040*	0,14 *0.0055*
P2	RDHW0702M0-MD03 F40M	0,080 *0.0032*	0,11 *0.0044*	0,15 *0.0060*
P3	RDHW0702M0-MD03 F40M	0,075 *0.0030*	0,10 *0.0040*	0,14 *0.0055*
P4	RDHW0702M0-MD03 F40M	0,075 *0.0030*	0,10 *0.0040*	0,14 *0.0055*
P5	RDHW0702M0-MD03 F40M	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
P6	RDHW0702M0-MD03 F40M	0,070 *0.0028*	0,095 *0.0038*	0,13 *0.0050*
P7	RDHW0702M0-MD03 F40M	0,070 *0.0028*	0,095 *0.0038*	0,13 *0.0050*
P8	RDHW0702M0-MD03 MP3000	0,075 *0.0030*	0,10 *0.0040*	0,14 *0.0055*
P11	RDHW0702M0-MD03 F40M	0,070 *0.0028*	0,095 *0.0038*	0,13 *0.0050*
P12	RDHW0702M0-MD03 F40M	0,050 *0.0020*	0,065 *0.0026*	0,090 *0.0036*
M1	RDHW0702M0-MD03 F40M	0,080 *0.0032*	0,11 *0.0044*	0,15 *0.0060*
M2	RDHW0702M0-MD03 F40M	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
M3	RDHW0702M0-MD03 F40M	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
M4	RDHW0702M0-MD03 F40M	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
M5	RDHW0702M0-MD03 F40M	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
K1	RDHW0702M0-MD03 MP3000	0,080 *0.0032*	0,11 *0.0044*	0,15 *0.0060*
K2	RDHW0702M0-MD03 MP3000	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
K3	RDHW0702M0-MD03 MP3000	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
K4	RDHW0702M0-MD03 MP3000	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
K5	RDHW0702M0-MD03 MP3000	0,065 *0.0026*	0,085 *0.0034*	0,12 *0.0048*
K6	RDHW0702M0-MD03 MP3000	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
K7	RDHW0702M0-MD03 MP3000	0,065 *0.0026*	0,085 *0.0034*	0,12 *0.0048*
N1	RDHW0702M0-MD03 MP3000	0,10 *0.0040*	0,14 *0.0055*	0,19 *0.0075*
N2	RDHW0702M0-MD03 MP3000	0,10 *0.0040*	0,14 *0.0055*	0,19 *0.0075*
N3	RDHW0702M0-MD03 MP3000	0,10 *0.0040*	0,14 *0.0055*	0,19 *0.0075*
N11	RDHW0702M0-MD03 MP3000	0,10 *0.0040*	0,14 *0.0055*	0,19 *0.0075*
S1	RDHW0702M0-MD03 F40M	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
S2	RDHW0702M0-MD03 F40M	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
S3	RDHW0702M0-MD03 F40M	0,048 *0.0019*	0,065 *0.0026*	0,085 *0.0034*
S11	RDHW0702M0-MD03 F40M	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
S12	RDHW0702M0-MD03 F40M	0,060 *0.0024*	0,080 *0.0032*	0,11 *0.0044*
S13	RDHW0702M0-MD03 F40M	0,050 *0.0020*	0,070 *0.0028*	0,095 *0.0038*
H5	RDHW0702M0T-MD04 F15M	0,050 *0.0020*	0,065 *0.0026*	0,090 *0.0036*
H8	RDHW0702M0T-MD04 F15M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
H11	RDHW0702M0T-MD04 F15M	0,050 *0.0020*	0,065 *0.0026*	0,090 *0.0036*
H12	RDHW0702M0T-MD04 F15M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*
H21	RDHW0702M0T-MD04 F15M	0,038 *0.0015*	0,050 *0.0020*	0,070 *0.0028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.29 Round 7 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000			F15M			F40M		
	20%	10%	5%	20%	10%	5%	20%	10%	5%
P1	305 *1000*	340 *1125*	370 *1225*	— —	— —	— —	245 *800*	270 *890*	295 *970*
P2	295 *970*	325 *1075*	355 *1175*	— —	— —	— —	235 *770*	260 *850*	285 *940*
P3	260 *850*	285 *940*	310 *1025*	— —	— —	— —	205 *670*	230 *750*	245 *800*
P4	225 *740*	250 *820*	270 *890*	— —	— —	— —	180 *590*	200 *660*	215 *710*
P5	215 *710*	240 *790*	260 *850*	— —	— —	— —	175 *570*	195 *640*	210 *690*
P6	245 *800*	270 *890*	295 *970*	— —	— —	— —	195 *640*	215 *710*	235 *770*
P7	235 *770*	255 *840*	280 *920*	— —	— —	— —	185 *610*	205 *670*	220 *720*
P8	215 *710*	240 *790*	260 *850*	— —	— —	— —	175 *570*	190 *620*	205 *670*
P11	225 *740*	250 *820*	270 *890*	— —	— —	— —	180 *590*	200 *660*	215 *710*
P12	140 *460*	155 *510*	170 *560*	— —	— —	— —	110 *360*	125 *410*	135 *445*
M1	220 *720*	245 *800*	265 *870*	— —	— —	— —	190 *620*	210 *690*	230 *750*
M2	180 *590*	200 *660*	220 *720*	— —	— —	— —	155 *510*	175 *570*	190 *620*
M3	145 *475*	160 *520*	170 *560*	— —	— —	— —	125 *410*	135 *445*	150 *490*
M4	110 *360*	120 *395*	130 *425*	— —	— —	— —	95 *310*	105 *345*	115 *375*
M5	90 *295*	100 *330*	110 *360*	— —	— —	— —	80 *260*	85 *280*	95 *310*
K1	200 *660*	215 *710*	235 *770*	225 *740*	250 *820*	270 *890*	190 *620*	205 *670*	225 *740*
K2	175 *570*	195 *640*	210 *690*	200 *660*	220 *720*	240 *790*	165 *540*	185 *610*	200 *660*
K3	145 *475*	165 *540*	175 *570*	165 *540*	185 *610*	200 *660*	140 *460*	155 *510*	170 *560*
K4	140 *460*	155 *510*	170 *560*	160 *520*	180 *590*	195 *640*	135 *445*	150 *490*	160 *520*
K5	85 *280*	95 *310*	100 *330*	95 *310*	110 *360*	115 *375*	80 *260*	90 *295*	95 *310*
K6	125 *410*	135 *445*	150 *490*	140 *460*	155 *510*	170 *560*	115 *375*	130 *425*	140 *460*
K7	110 *360*	120 *395*	130 *425*	125 *410*	140 *460*	150 *490*	105 *345*	115 *375*	125 *410*
N1	1775 *5825*	1950 *6400*	2125 *6975*	— —	— —	— —	1425 *4675*	1550 *5075*	1700 *5575*
N2	720 *2350*	790 *2600*	860 *2825*	— —	— —	— —	580 *1900*	630 *2075*	690 *2275*
N3	480 *1575*	530 *1750*	570 *1875*	— —	— —	— —	385 *1275*	420 *1375*	460 *1500*
N11	550 *1800*	600 *1975*	650 *2125*	— —	— —	— —	440 *1450*	480 *1575*	520 *1700*
S1	50 *165*	55 *180*	60 *195*	— —	— —	— —	44 *145*	49 *160*	55 *180*
S2	41 *135*	45 *150*	49 *160*	— —	— —	— —	36 *120*	39 *130*	42 *140*
S3	36 *120*	39 *130*	43 *140*	— —	— —	— —	31 *100*	34 *110*	37 *120*
S11	70 *230*	80 *260*	85 *280*	— —	— —	— —	60 *195*	70 *230*	75 *245*
S12	60 *195*	65 *215*	75 *245*	— —	— —	— —	50 *165*	60 *195*	65 *215*
S13	35 *115*	38 *125*	42 *140*	— —	— —	— —	30 *100*	33 *110*	36 *120*
H5	39 *130*	43 *140*	47 *155*	45 *150*	49 *160*	55 *180*	37 *120*	41 *135*	45 *150*
H8	40 *130*	45 *150*	48 *155*	46 *150*	50 *165*	55 *180*	39 *130*	43 *140*	46 *150*
H11	50 *165*	55 *180*	60 *195*	55 *180*	65 *215*	70 *230*	47 *155*	50 *165*	55 *180*
H12	47 *155*	50 *165*	55 *180*	55 *180*	60 *195*	65 *215*	45 *150*	49 *160*	55 *180*
H21	40 *130*	45 *150*	48 *155*	46 *150*	50 *165*	55 *180*	39 *130*	43 *140*	46 *150*

335.18/29 Round 8 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	RDHW0803M0-MD03 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
P2	RDHW0803M0-MD03 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
P3	RDHW0803M0-MD03 F40M	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*
P4	RDKW0803M0T-MD05 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P5	RDKW0803M0T-MD05 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
P6	RDKW0803M0T-MD05 F40M	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
P7	RDKW0803M0T-MD05 F40M	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
P8	RDKW0803M0T-MD05 MP2501	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P11	RDKW0803M0T-MD05 F40M	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
P12	RDKW0803M0T-MD05 F40M	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
M1	RDHW0803M0-MD03 F40M	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
M2	RDHW0803M0-MD03 F40M	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
M3	RDHW0803M0-MD03 F40M	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
M4	RDHW0803M0-MD03 F40M	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
M5	RDHW0803M0-MD03 F40M	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
K1	RDKW0803M0T-MD05 MK2050	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
K2	RDKW0803M0T-MD05 MK2050	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K3	RDKW0803M0T-MD05 MK2050	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K4	RDKW0803M0T-MD05 MK2050	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K5	RDKW0803M0T-MD05 MK2050	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
K6	RDKW0803M0T-MD05 MK2050	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K7	RDKW0803M0T-MD05 MK2050	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
N1	RDHT0803M0-E03 H25	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
N2	RDHT0803M0-E03 H25	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
N3	RDHT0803M0-E03 H25	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
N11	RDHT0803M0-E03 H25	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
S1	RDHW0803M0-MD03 F40M	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
S2	RDHW0803M0-MD03 F40M	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
S3	RDHW0803M0-MD03 F40M	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
S11	RDHW0803M0-MD03 F40M	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
S12	RDHW0803M0-MD03 F40M	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
S13	RDHW0803M0-MD03 F40M	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*
H5	RDKW0803M0T-MD05 F15M	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
H8	RDKW0803M0T-MD05 F15M	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H11	RDKW0803M0T-MD05 F15M	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
H12	RDKW0803M0T-MD05 F15M	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*
H21	RDKW0803M0T-MD05 F15M	0,040 *0.0016*	0,046 *0.0018*	0,060 *0.0024*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.18/29 Round 8 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			MP3000			T350M			F15M			F25M			F30M		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	285	305	335	285	305	335	315	340	370	—	—	—	240	255	280	240	255	280
	940	*1000*	*1100*	*940*	*1000*	*1100*	*1025*	*1125*	*1225*	—	—	—	*790*	*840*	*920*	*790*	*840*	*920*
P2	280	300	330	280	295	325	305	325	360	—	—	—	230	250	275	235	250	275
	920	*980*	*1075*	*920*	*970*	*1075*	*1000*	*1075*	*1175*	—	—	—	*750*	*820*	*900*	*770*	*820*	*900*
P3	245	260	285	240	255	285	265	285	310	—	—	—	200	215	240	200	215	240
	800	*850*	*940*	*790*	*840*	*940*	*870*	*940*	*1025*	—	—	—	*660*	*710*	*790*	*660*	*710*	*790*
P4	215	230	255	215	225	250	235	250	275	—	—	—	180	190	210	180	190	210
	710	*750*	*840*	*710*	*740*	*820*	*770*	*820*	*900*	—	—	—	*590*	*620*	*690*	*590*	*620*	*690*
P5	205	220	240	205	215	240	225	240	265	—	—	—	170	180	200	170	180	200
	670	*720*	*790*	*670*	*710*	*790*	*740*	*790*	*870*	—	—	—	*560*	*590*	*660*	*560*	*590*	*660*
P6	230	250	270	230	245	270	250	270	295	—	—	—	195	205	225	190	205	225
	750	*820*	*890*	*750*	*800*	*890*	*820*	*890*	*970*	—	—	—	*640*	*670*	*740*	*620*	*670*	*740*
P7	220	235	255	215	230	255	240	255	280	—	—	—	180	195	215	180	195	215
	720	*770*	*840*	*710*	*750*	*840*	*790*	*840*	*920*	—	—	—	*590*	*640*	*710*	*590*	*640*	*710*
P8	205	220	240	200	215	240	225	240	260	—	—	—	170	180	200	170	180	200
	670	*720*	*790*	*660*	*710*	*790*	*740*	*790*	*850*	—	—	—	*560*	*590*	*660*	*560*	*590*	*660*
P11	215	225	250	210	225	245	230	250	270	—	—	—	175	190	205	175	185	205
	710	*740*	*820*	*690*	*740*	*800*	*750*	*820*	*890*	—	—	—	*570*	*620*	*670*	*570*	*610*	*670*
P12	135	140	155	130	140	155	145	150	170	—	—	—	110	120	130	110	115	130
	445	*460*	*510*	*425*	*460*	*510*	*475*	*490*	*560*	—	—	—	*360*	*395*	*425*	*360*	*375*	*425*
M1	200	215	235	210	220	245	235	250	280	—	—	—	—	—	—	190	200	220
	660	*710*	*770*	*690*	*720*	*800*	*770*	*820*	*920*	—	—	—	—	—	—	*620*	*660*	*720*
M2	165	175	195	170	180	200	195	205	225	—	—	—	—	—	—	155	165	180
	540	*570*	*640*	*560*	*590*	*660*	*640*	*670*	*740*	—	—	—	—	—	—	*510*	*540*	*590*
M3	130	140	155	135	145	155	150	160	180	—	—	—	—	—	—	120	130	140
	425	*460*	*510*	*445*	*475*	*510*	*490*	*520*	*590*	—	—	—	—	—	—	*395*	*425*	*460*
M4	100	110	120	105	110	120	115	125	135	—	—	—	—	—	—	95	100	110
	330	*360*	*395*	*345*	*360*	*395*	*375*	*410*	*445*	—	—	—	—	—	—	*310*	*330*	*360*
M5	85	90	100	85	90	100	95	105	115	—	—	—	—	—	—	75	80	90
	280	*295*	*330*	*280*	*295*	*330*	*310*	*345*	*375*	—	—	—	—	—	—	*245*	*260*	*295*
K1	220	235	260	185	195	215	—	—	—	200	215	235	185	195	215	185	195	215
	720	*770*	*850*	*610*	*640*	*710*	—	—	—	*660*	*710*	*770*	*610*	*640*	*710*	*610*	*640*	*710*
K2	195	205	230	160	170	190	—	—	—	180	190	210	165	175	190	160	170	190
	640	*670*	*750*	*520*	*560*	*620*	—	—	—	*590*	*620*	*690*	*540*	*570*	*620*	*520*	*560*	*620*
K3	165	175	195	135	145	160	—	—	—	150	160	175	140	145	160	135	145	160
	540	*570*	*640*	*445*	*475*	*520*	—	—	—	*490*	*520*	*570*	*460*	*475*	*520*	*445*	*475*	*520*
K4	160	170	185	130	140	155	—	—	—	145	150	170	130	140	155	130	140	155
	520	*560*	*610*	*425*	*460*	*510*	—	—	—	*475*	*490*	*560*	*425*	*460*	*510*	*425*	*460*	*510*
K5	95	100	110	80	85	95	—	—	—	85	95	100	80	85	95	80	85	95
	310	*330*	*360*	*260*	*280*	*310*	—	—	—	*280*	*310*	*330*	*260*	*280*	*310*	*260*	*280*	*310*
K6	140	150	165	115	125	135	—	—	—	125	135	150	115	125	135	115	125	135
	460	*490*	*540*	*375*	*410*	*445*	—	—	—	*410*	*445*	*490*	*375*	*410*	*445*	*375*	*410*	*445*
K7	120	130	145	100	105	120	—	—	—	110	120	130	100	110	120	100	105	120
	395	*425*	*475*	*330*	*345*	*395*	—	—	—	*360*	*395*	*425*	*330*	*360*	*395*	*330*	*345*	*395*
N1	—	—	—	1650	1750	1950	—	—	—	—	—	—	—	—	—	1400	1475	1650
	—	—	—	*5425*	*5750*	*6400*	—	—	—	—	—	—	—	—	—	*4600*	*4850*	*5425*
N2	—	—	—	670	710	790	—	—	—	—	—	—	—	—	—	560	600	660
	—	—	—	*2200*	*2325*	*2600*	—	—	—	—	—	—	—	—	—	*1825*	*1975*	*2175*
N3	—	—	—	445	475	530	—	—	—	—	—	—	—	—	—	375	400	440
	—	—	—	*1450*	*1550*	*1750*	—	—	—	—	—	—	—	—	—	*1225*	*1300*	*1450*
N11	—	—	—	510	540	600	—	—	—	—	—	—	—	—	—	430	455	500
	—	—	—	*1675*	*1775*	*1975*	—	—	—	—	—	—	—	—	—	*1400*	*1500*	*1650*
S1	—	—	—	48	50	55	55	60	65	—	—	—	—	—	—	43	46	50
	—	—	—	*155*	*165*	*180*	*180*	*195*	*215*	—	—	—	—	—	—	*140*	*150*	*165*
S2	—	—	—	39	41	45	44	46	50	—	—	—	—	—	—	35	37	41
	—	—	—	*130*	*135*	*150*	*145*	*150*	*165*	—	—	—	—	—	—	*115*	*120*	*135*
S3	—	—	—	33	36	39	38	40	44	—	—	—	—	—	—	30	32	36
	—	—	—	*110*	*120*	*130*	*125*	*130*	*145*	—	—	—	—	—	—	*100*	*105*	*120*
S11	—	—	—	70	70	80	75	80	90	—	—	—	—	—	—	60	65	70
	—	—	—	*230*	*230*	*260*	*245*	*260*	*295*	—	—	—	—	—	—	*195*	*215*	*230*
S12	—	—	—	55	60	65	65	70	75	—	—	—	—	—	—	43	46	50
	—	—	—	*180*	*195*	*215*	*215*	*230*	*245*	—	—	—	—	—	—	*140*	*150*	*165*
S13	—	—	—	33	35	38	37	39	43	—	—	—	—	—	—	25	26	29
	—	—	—	*110*	*115*	*125*	*120*	*130*	*140*	—	—	—	—	—	—	*80*	*85*	*95*
H5	—	—	—	36	39	43	48	50	55	41	43	47	—	—	—	36	39	43
	—	—	—	*120*	*130*	*140*	*155*	*165*	*180*	*135*	*140*	*155*	—	—	—	*120*	*130*	*140*
H8	—	—	—	38	40	44	49	50	55	42	45	49	—	—	—	38	40	44
	—	—	—	*125*	*130*	*145*	*160*	*165*	*180*	*140*	*150*	*160*	—	—	—	*125*	*130*	*145*
H11	—	—	—	46	49	55	60	65	70	50	55	60	—	—	—	46	49	55
	—	—	—	*150*	*160*	*180*	*195*	*215*	*230*	*165*	*180*	*195*	—	—	—	*150*	*160*	*180*
H12	—	—	—	44	47	50	55	60	65	49	50	55	—	—	—	44	47	50
	—	—	—	*145*	*155*	*165*	*180*	*195*	*215*	*160*	*165*	*180*	—	—	—	*145*	*155*	*165*
H21	—	—	—	38	40	44	49	50	55	42	45	49	—	—	—	38	40	44
	—	—	—	*125*	*130*	*145*	*160*	*165*	*180*	*140*	*150*	*160*	—	—	—	*125*	*130*	*145*

335.18/29 Round 8 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MK2050			MS2050			MS2500			H25		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	230 *750*	245 *800*	270 *890*	280 *920*	305 *1000*	330 *1075*	— —	— —	— —	315 *1025*	335 *1100*	370 *1225*	— —	— —	— —
P2	220 *720*	235 *770*	260 *850*	275 *900*	295 *970*	325 *1075*	— —	— —	— —	305 *1000*	325 *1075*	360 *1175*	— —	— —	— —
P3	190 *620*	205 *670*	225 *740*	240 *790*	255 *840*	285 *940*	— —	— —	— —	265 *870*	285 *940*	315 *1025*	— —	— —	— —
P4	170 *560*	180 *590*	200 *660*	210 *690*	225 *740*	250 *820*	— —	— —	— —	235 *770*	250 *820*	275 *900*	— —	— —	— —
P5	165 *540*	175 *570*	190 *620*	205 *670*	215 *710*	240 *790*	— —	— —	— —	225 *740*	240 *790*	265 *870*	— —	— —	— —
P6	185 *610*	195 *640*	215 *710*	230 *750*	245 *800*	265 *870*	— —	— —	— —	255 *840*	270 *890*	295 *970*	— —	— —	— —
P7	175 *570*	185 *610*	205 *670*	215 *710*	230 *750*	250 *820*	— —	— —	— —	240 *790*	255 *840*	280 *920*	— —	— —	— —
P8	160 *520*	170 *560*	190 *620*	200 *660*	215 *710*	240 *790*	— —	— —	— —	225 *740*	240 *790*	265 *870*	— —	— —	— —
P11	170 *560*	180 *590*	200 *660*	210 *690*	225 *740*	245 *800*	— —	— —	— —	230 *750*	250 *820*	270 *890*	— —	— —	— —
P12	105 *345*	110 *360*	120 *395*	130 *425*	140 *460*	155 *510*	— —	— —	— —	145 *475*	155 *510*	170 *560*	— —	— —	— —
M1	180 *590*	190 *620*	210 *690*	— —	— —	— —	— —	— —	— —	220 *720*	235 *770*	255 *840*	— —	— —	— —
M2	145 *475*	155 *510*	170 *560*	— —	— —	— —	— —	— —	— —	180 *590*	190 *620*	210 *690*	— —	— —	— —
M3	115 *375*	125 *410*	135 *445*	— —	— —	— —	— —	— —	— —	145 *475*	150 *490*	165 *540*	— —	— —	— —
M4	90 *295*	95 *310*	105 *345*	— —	— —	— —	— —	— —	— —	110 *360*	115 *375*	130 *425*	— —	— —	— —
M5	75 *245*	80 *260*	85 *280*	— —	— —	— —	— —	— —	— —	90 *295*	95 *310*	105 *345*	— —	— —	— —
K1	175 *570*	185 *610*	205 *670*	295 *970*	320 *1050*	350 *1150*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	155 *510*	165 *540*	180 *590*	265 *870*	280 *920*	305 *1000*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	130 *425*	140 *460*	155 *510*	225 *740*	235 *770*	260 *850*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	125 *410*	135 *445*	145 *475*	215 *710*	225 *740*	250 *820*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	75 *245*	80 *260*	90 *295*	130 *425*	135 *445*	150 *490*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	110 *360*	115 *375*	130 *425*	185 *610*	200 *660*	220 *720*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	95 *310*	100 *330*	115 *375*	165 *540*	175 *570*	190 *620*	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	1325 *4350*	1400 *4600*	1550 *5075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	1525 *5000*	1625 *5325*	1800 *5900*
N2	530 *1750*	570 *1875*	630 *2075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	620 *2025*	660 *2175*	720 *2350*
N3	355 *1175*	380 *1250*	420 *1375*	— —	— —	— —	— —	— —	— —	— —	— —	— —	410 *1350*	435 *1425*	480 *1575*
N11	410 *1350*	435 *1425*	480 *1575*	— —	— —	— —	— —	— —	— —	— —	— —	— —	470 *1550*	500 *1650*	550 *1800*
S1	41 *135*	44 *145*	48 *155*	— —	— —	— —	45 *150*	48 *155*	55 *180*	55 *180*	55 *180*	65 *215*	— —	— —	— —
S2	33 *110*	35 *115*	39 *130*	— —	— —	— —	37 *120*	39 *130*	43 *140*	43 *140*	46 *150*	50 *165*	— —	— —	— —
S3	29 *95*	31 *100*	34 *110*	— —	— —	— —	32 *105*	34 *110*	37 *120*	37 *120*	40 *130*	44 *145*	— —	— —	— —
S11	60 *195*	60 *195*	70 *230*	— —	— —	— —	65 *215*	70 *230*	75 *245*	75 *245*	80 *260*	90 *295*	— —	— —	— —
S12	49 *160*	50 *165*	60 *195*	— —	— —	— —	55 *180*	60 *195*	65 *215*	65 *215*	70 *230*	75 *245*	— —	— —	— —
S13	28 *90*	30 *100*	33 *110*	— —	— —	— —	31 *100*	33 *110*	36 *120*	36 *120*	39 *130*	43 *140*	— —	— —	— —
H5	35 *115*	37 *120*	41 *135*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	36 *120*	38 *125*	42 *140*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	44 *145*	47 *155*	50 *165*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	42 *140*	44 *145*	49 *160*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	36 *120*	38 *125*	42 *140*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

335.18/29 Round 10 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	RDKT10T3M0T-8-M05 F40M	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
P2	RDKT10T3M0T-8-M05 F40M	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
P3	RDKT10T3M0T-8-M05 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P4	RDKT10T3M0T-8-M05 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
P5	RDKT10T3M0T-8-M05 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
P6	RDKT10T3M0T-8-M05 F40M	0,075 *0.0030*	0,085 *0.0034*	0,12 *0.0048*
P7	RDKW10T3M0T-8-MD06 F40M	0,090 *0.0036*	0,10 *0.0040*	0,14 *0.0055*
P8	RDKW10T3M0T-8-MD06 MP2501	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
P11	RDKT10T3M0T-8-M07 F40M	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
P12	RDKT10T3M0T-8-M07 F40M	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*
M1	RDKT10T3M0T-8-M05 F40M	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
M2	RDKT10T3M0T-8-M05 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
M3	RDKT10T3M0T-8-M05 F40M	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
M4	RDKT10T3M0T-8-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
M5	RDKT10T3M0T-8-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
K1	RDKW10T3M0T-8-MD06 MK2050	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
K2	RDKW10T3M0T-8-MD06 MK2050	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K3	RDKW10T3M0T-8-MD06 MK2050	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K4	RDKW10T3M0T-8-MD06 MK2050	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K5	RDKW10T3M0T-8-MD06 MK2050	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
K6	RDKW10T3M0T-8-MD06 MK2050	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*
K7	RDKW10T3M0T-8-MD06 MK2050	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
N1	RDHT10T3M0-8-E04 H25	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
N2	RDHT10T3M0-8-E04 H25	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
N3	RDHT10T3M0-8-E04 H25	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
N11	RDHT10T3M0-8-E04 H25	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
S1	RDKT10T3M0T-8-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
S2	RDKT10T3M0T-8-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
S3	RDKT10T3M0T-8-M05 F40M	0,050 *0.0020*	0,055 *0.0022*	0,075 *0.0030*
S11	RDKT10T3M0T-8-M05 F40M	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S12	RDKT10T3M0T-8-M05 F40M	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
S13	RDKT10T3M0T-8-M05 F40M	0,055 *0.0022*	0,060 *0.0024*	0,080 *0.0032*
H5	RDKW10T3M0T-8-MD06 F15M	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
H8	RDKW10T3M0T-8-MD06 F15M	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
H11	RDKW10T3M0T-8-MD06 F15M	0,065 *0.0026*	0,070 *0.0028*	0,095 *0.0038*
H12	RDKW10T3M0T-8-MD06 F15M	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*
H21	RDKW10T3M0T-8-MD06 F15M	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.18/29 Round 10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			T350M			F15M			F40M		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	315 *1025*	340 *1125*	370 *1225*	290 *950*	315 *1025*	345 *1125*	280 *920*	300 *980*	330 *1075*	— —	— —	— —	245 *800*	260 *850*	290 *950*
P2	305 *1000*	325 *1075*	360 *1175*	280 *920*	300 *980*	335 *1100*	275 *900*	295 *970*	325 *1075*	— —	— —	— —	240 *790*	255 *840*	280 *920*
P3	265 *870*	285 *940*	310 *1025*	250 *820*	265 *870*	290 *950*	240 *790*	255 *840*	280 *920*	— —	— —	— —	205 *670*	220 *720*	245 *800*
P4	235 *770*	250 *820*	280 *920*	220 *720*	230 *750*	255 *840*	210 *690*	225 *740*	250 *820*	— —	— —	— —	185 *610*	195 *640*	215 *710*
P5	225 *740*	240 *790*	265 *870*	210 *690*	225 *740*	250 *820*	205 *670*	215 *710*	235 *770*	— —	— —	— —	175 *570*	185 *610*	205 *670*
P6	255 *840*	275 *900*	300 *980*	235 *770*	250 *820*	280 *920*	230 *750*	245 *800*	265 *870*	— —	— —	— —	200 *660*	210 *690*	230 *750*
P7	240 *790*	260 *850*	280 *920*	220 *720*	240 *790*	265 *870*	215 *710*	230 *750*	250 *820*	— —	— —	— —	185 *610*	200 *660*	220 *720*
P8	225 *740*	240 *790*	260 *850*	210 *690*	220 *720*	245 *800*	200 *660*	215 *710*	235 *770*	— —	— —	— —	175 *570*	185 *610*	205 *670*
P11	235 *770*	250 *820*	275 *900*	215 *710*	230 *750*	255 *840*	210 *690*	225 *740*	245 *800*	— —	— —	— —	180 *590*	195 *640*	210 *690*
P12	145 *475*	155 *510*	175 *570*	135 *445*	145 *475*	160 *520*	130 *425*	140 *460*	155 *510*	— —	— —	— —	115 *375*	120 *395*	135 *445*
M1	— —	— —	— —	205 *670*	215 *710*	240 *790*	210 *690*	225 *740*	250 *820*	— —	— —	— —	190 *620*	205 *670*	225 *740*
M2	— —	— —	— —	170 *560*	180 *590*	200 *660*	175 *570*	185 *610*	205 *670*	— —	— —	— —	160 *520*	170 *560*	185 *610*
M3	— —	— —	— —	135 *445*	145 *475*	160 *520*	140 *460*	145 *475*	160 *520*	— —	— —	— —	125 *410*	135 *445*	145 *475*
M4	— —	— —	— —	105 *345*	110 *360*	120 *395*	105 *345*	115 *375*	125 *410*	— —	— —	— —	95 *310*	105 *345*	115 *375*
M5	— —	— —	— —	85 *280*	90 *295*	100 *330*	90 *295*	95 *310*	105 *345*	— —	— —	— —	80 *260*	85 *280*	95 *310*
K1	245 *800*	255 *840*	285 *940*	225 *740*	240 *790*	265 *870*	215 *710*	235 *770*	255 *840*	195 *640*	205 *670*	230 *750*	190 *620*	200 *660*	220 *720*
K2	215 *710*	225 *740*	250 *820*	200 *660*	215 *710*	235 *770*	195 *640*	205 *670*	225 *740*	175 *570*	180 *590*	205 *670*	170 *560*	175 *570*	195 *640*
K3	180 *590*	190 *620*	215 *710*	165 *540*	180 *590*	200 *660*	165 *540*	170 *560*	190 *620*	145 *475*	155 *510*	170 *560*	140 *460*	150 *490*	165 *540*
K4	175 *570*	185 *610*	205 *670*	160 *520*	170 *560*	190 *620*	155 *510*	165 *540*	180 *590*	140 *460*	145 *475*	165 *540*	135 *445*	145 *475*	160 *520*
K5	105 *345*	110 *360*	125 *410*	100 *330*	105 *345*	115 *375*	95 *310*	100 *330*	110 *360*	85 *280*	90 *295*	100 *330*	80 *260*	85 *280*	95 *310*
K6	155 *510*	160 *520*	180 *590*	140 *460*	150 *490*	170 *560*	135 *445*	145 *475*	160 *520*	125 *410*	130 *425*	145 *475*	120 *395*	125 *410*	140 *460*
K7	135 *445*	145 *475*	160 *520*	125 *410*	135 *445*	145 *475*	120 *395*	130 *425*	140 *460*	110 *360*	115 *375*	125 *410*	105 *345*	110 *360*	120 *395*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1425 *4675*	1525 *5000*	1675 *5500*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	570 *1875*	620 *2025*	680 *2225*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	380 *1250*	410 *1350*	455 *1500*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	435 *1425*	470 *1550*	520 *1700*
S1	— —	— —	— —	50 *165*	55 *180*	60 *195*	49 *160*	55 *180*	60 *195*	— —	— —	— —	45 *150*	48 *155*	55 *180*
S2	— —	— —	— —	41 *135*	43 *140*	47 *155*	40 *130*	43 *140*	47 *155*	— —	— —	— —	36 *120*	39 *130*	43 *140*
S3	— —	— —	— —	35 *115*	38 *125*	41 *135*	35 *115*	37 *120*	41 *135*	— —	— —	— —	32 *105*	34 *110*	37 *120*
S11	— —	— —	— —	70 *230*	75 *245*	85 *280*	70 *230*	75 *245*	80 *260*	— —	— —	— —	65 *215*	70 *230*	75 *245*
S12	— —	— —	— —	60 *195*	65 *215*	70 *230*	60 *195*	65 *215*	70 *230*	— —	— —	— —	55 *180*	55 *180*	65 *215*
S13	— —	— —	— —	34 *110*	37 *120*	40 *130*	34 *110*	36 *120*	40 *130*	— —	— —	— —	31 *100*	33 *110*	36 *120*
H5	49 *160*	50 *165*	55 *180*	41 *135*	44 *145*	49 *160*	44 *145*	46 *150*	50 *165*	39 *130*	42 *140*	46 *150*	38 *125*	40 *130*	44 *145*
H8	50 *165*	55 *180*	60 *195*	44 *145*	46 *150*	50 *165*	45 *150*	48 *155*	55 *180*	41 *135*	44 *145*	48 *155*	39 *130*	42 *140*	46 *150*
H11	60 *195*	65 *215*	75 *245*	55 *180*	55 *180*	60 *195*	55 *180*	60 *195*	65 *215*	50 *165*	55 *180*	60 *195*	49 *160*	50 *165*	55 *180*
H12	60 *195*	65 *215*	70 *230*	50 *165*	55 *180*	60 *195*	55 *180*	55 *180*	60 *195*	48 *155*	50 *165*	55 *180*	46 *150*	49 *160*	55 *180*
H21	50 *165*	55 *180*	60 *195*	44 *145*	46 *150*	50 *165*	45 *150*	48 *155*	55 *180*	41 *135*	44 *145*	48 *155*	39 *130*	42 *140*	46 *150*

335.18/29 Round 10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MM4500			MS2050			MS2500			MH1000			H25		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	275	295	325	200	215	235	270	290	315	350	380	415	—	—	—	—	—	—
	900	*970*	*1075*	*660*	*710*	*770*	*890*	*950*	*1025*	*1150*	*1250*	*1350*	—	—	—	—	—	—
P2	265	285	310	195	205	225	260	280	310	345	370	405	—	—	—	—	—	—
	870	*940*	*1025*	*640*	*670*	*740*	*850*	*920*	*1025*	*1125*	*1225*	*1325*	—	—	—	—	—	—
P3	230	250	270	170	180	200	230	245	270	300	320	355	—	—	—	—	—	—
	750	*820*	*890*	*560*	*590*	*660*	*750*	*800*	*890*	*980*	*1050*	*1175*	—	—	—	—	—	—
P4	205	220	245	150	160	175	200	215	235	265	280	310	—	—	—	—	—	—
	670	*720*	*800*	*490*	*520*	*570*	*660*	*710*	*770*	*870*	*920*	*1025*	—	—	—	—	—	—
P5	200	210	230	145	150	165	195	205	225	255	270	295	—	—	—	—	—	—
	660	*690*	*750*	*475*	*490*	*540*	*640*	*670*	*740*	*840*	*890*	*970*	—	—	—	—	—	—
P6	220	240	260	160	170	185	220	235	255	285	305	335	—	—	—	—	—	—
	720	*790*	*850*	*520*	*560*	*610*	*720*	*770*	*840*	*940*	*1000*	*1100*	—	—	—	—	—	—
P7	210	225	245	150	160	175	205	220	240	270	290	315	—	—	—	—	—	—
	690	*740*	*800*	*490*	*520*	*570*	*670*	*720*	*790*	*890*	*950*	*1025*	—	—	—	—	—	—
P8	195	210	230	140	150	165	190	205	225	250	270	295	—	—	—	—	—	—
	640	*690*	*750*	*460*	*490*	*540*	*620*	*670*	*740*	*820*	*890*	*970*	—	—	—	—	—	—
P11	205	220	240	145	155	170	200	215	235	260	280	305	—	—	—	—	—	—
	670	*720*	*790*	*475*	*510*	*560*	*660*	*710*	*770*	*850*	*920*	*1000*	—	—	—	—	—	—
P12	130	135	150	95	100	110	125	135	145	165	175	195	—	—	—	—	—	—
	425	*445*	*490*	*310*	*330*	*360*	*410*	*445*	*475*	*540*	*570*	*640*	—	—	—	—	—	—
M1	—	—	—	165	180	195	210	225	250	245	265	290	—	—	—	—	—	—
	—	—	—	*540*	*590*	*640*	*690*	*740*	*820*	*800*	*870*	*950*	—	—	—	—	—	—
M2	—	—	—	135	145	160	175	185	205	205	215	235	—	—	—	—	—	—
	—	—	—	*445*	*475*	*520*	*570*	*610*	*670*	*670*	*710*	*770*	—	—	—	—	—	—
M3	—	—	—	110	115	125	140	145	160	160	170	190	—	—	—	—	—	—
	—	—	—	*360*	*375*	*410*	*460*	*475*	*520*	*520*	*560*	*620*	—	—	—	—	—	—
M4	—	—	—	85	90	100	105	115	125	125	130	145	—	—	—	—	—	—
	—	—	—	*280*	*295*	*330*	*345*	*375*	*410*	*410*	*425*	*475*	—	—	—	—	—	—
M5	—	—	—	70	75	80	90	95	105	100	110	120	—	—	—	—	—	—
	—	—	—	*230*	*245*	*260*	*295*	*310*	*345*	*330*	*360*	*395*	—	—	—	—	—	—
K1	290	305	335	—	—	—	—	—	—	—	—	—	235	250	275	—	—	—
	950	*1000*	*1100*	—	—	—	—	—	—	—	—	—	*770*	*820*	*900*	—	—	—
K2	255	270	300	—	—	—	—	—	—	—	—	—	210	220	245	—	—	—
	840	*890*	*980*	—	—	—	—	—	—	—	—	—	*690*	*720*	*800*	—	—	—
K3	215	230	255	—	—	—	—	—	—	—	—	—	175	185	210	—	—	—
	710	*750*	*840*	—	—	—	—	—	—	—	—	—	*570*	*610*	*690*	—	—	—
K4	205	215	240	—	—	—	—	—	—	—	—	—	170	180	200	—	—	—
	670	*710*	*790*	—	—	—	—	—	—	—	—	—	*560*	*590*	*660*	—	—	—
K5	125	135	145	—	—	—	—	—	—	—	—	—	100	110	120	—	—	—
	410	*445*	*475*	—	—	—	—	—	—	—	—	—	*330*	*360*	*395*	—	—	—
K6	180	190	215	—	—	—	—	—	—	—	—	—	150	155	175	—	—	—
	590	*620*	*710*	—	—	—	—	—	—	—	—	—	*490*	*510*	*570*	—	—	—
K7	160	170	185	—	—	—	—	—	—	—	—	—	130	140	155	—	—	—
	520	*560*	*610*	—	—	—	—	—	—	—	—	—	*425*	*460*	*510*	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1450	1550	1725
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*4750*	*5075*	*5650*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	590	620	690
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1925*	*2025*	*2275*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	390	415	460
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1275*	*1350*	*1500*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	450	475	530
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1475*	*1550*	*1750*
S1	—	—	—	25	27	30	49	55	60	60	65	70	—	—	—	—	—	—
	—	—	—	*80*	*90*	*100*	*160*	*180*	*195*	*195*	*215*	*230*	—	—	—	—	—	—
S2	—	—	—	20	22	24	40	43	47	48	50	55	—	—	—	—	—	—
	—	—	—	*65*	*70*	*80*	*130*	*140*	*155*	*155*	*165*	*180*	—	—	—	—	—	—
S3	—	—	—	18	19	21	35	37	41	42	45	50	—	—	—	—	—	—
	—	—	—	*60*	*60*	*70*	*115*	*120*	*135*	*140*	*150*	*165*	—	—	—	—	—	—
S11	—	—	—	36	38	42	70	75	80	85	90	100	—	—	—	—	—	—
	—	—	—	*120*	*125*	*140*	*230*	*245*	*260*	*280*	*295*	*330*	—	—	—	—	—	—
S12	—	—	—	33	35	39	60	65	70	70	75	85	—	—	—	—	—	—
	—	—	—	*110*	*115*	*130*	*195*	*215*	*230*	*230*	*245*	*280*	—	—	—	—	—	—
S13	—	—	—	19	20	22	34	36	40	41	44	48	—	—	—	—	—	—
	—	—	—	*60*	*65*	*70*	*110*	*120*	*130*	*135*	*145*	*155*	—	—	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	47	50	55	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*155*	*165*	*180*	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	50	55	60	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*165*	*180*	*195*	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	60	65	70	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*195*	*215*	*230*	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	60	60	65	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*195*	*195*	*215*	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	50	55	60	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*165*	*180*	*195*	—	—	—

335.18/29 Round 12 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	RPHT1204M0T-6-ME07 F40M	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
P2	RPHT1204M0T-6-ME07 F40M	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
P3	RPHT1204M0T-6-M08 F40M	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*
P4	RPHT1204M0T-6-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P5	RPHT1204M0T-6-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P6	RPHT1204M0T-6-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P7	RPHT1204M0T-6-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P8	RPHT1204M0T-6-M08 MP2501	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*
P11	RPHT1204M0T-6-M08 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
P12	RPHT1204M0T-6-M08 F40M	0,085 *0.0034*	0,095 *0.0038*	0,13 *0.0050*
M1	RPHT1204M0T-6-ME07 F40M	0,12 *0.0048*	0,13 *0.0050*	0,18 *0.0070*
M2	RPHT1204M0T-6-ME07 F40M	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
M3	RPHT1204M0T-6-M08 F40M	0,10 *0.0040*	0,11 *0.0044*	0,15 *0.0060*
M4	RPHT1204M0T-6-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
M5	RPHT1204M0T-6-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
K1	RPKW1204M0T-6-MD10 MK2050	0,17 *0.0065*	0,19 *0.0075*	0,26 *0.010*
K2	RPKW1204M0T-6-MD10 MK2050	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
K3	RPKW1204M0T-6-MD10 MK2050	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
K4	RPKW1204M0T-6-MD10 MK2050	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
K5	RPKW1204M0T-6-MD10 MK2050	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
K6	RPKW1204M0T-6-MD10 MK2050	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
K7	RPKW1204M0T-6-MD10 MK2050	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
N1	RPHT1204M0-6-E05 H25	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
N2	RPHT1204M0-6-E05 H25	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
N3	RPHT1204M0-6-E05 H25	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
N11	RPHT1204M0-6-E05 H25	0,11 *0.0044*	0,12 *0.0048*	0,16 *0.0065*
S1	RPHT1204M0T-6-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
S2	RPHT1204M0T-6-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
S3	RPHT1204M0T-6-M08 F40M	0,080 *0.0032*	0,090 *0.0036*	0,12 *0.0048*
S11	RPHT1204M0T-6-ME07 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
S12	RPHT1204M0T-6-ME07 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
S13	RPHT1204M0T-6-M08 F40M	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*
H5	RPHW1204M0T-6-MD12 MH1000	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
H8	RPHW1204M0T-6-MD12 MH1000	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
H11	RPHT1204M0T-6-M13 F40M	0,14 *0.0055*	0,15 *0.0060*	0,20 *0.0080*
H12	RPHT1204M0T-6-M13 F40M	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
H21	RPHW1204M0T-6-MD12 MH1000	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.18/29 Round 12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			MP3000			T350M			F40M		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	290 *950*	310 *1025*	345 *1125*	270 *890*	290 *950*	320 *1050*	255 *840*	270 *890*	300 *980*	220 *720*	235 *770*	260 *850*
P2	285 *940*	305 *1000*	335 *1100*	265 *870*	280 *920*	310 *1025*	250 *820*	265 *870*	295 *970*	215 *710*	230 *750*	255 *840*
P3	245 *800*	260 *850*	290 *950*	230 *750*	245 *800*	270 *890*	215 *710*	230 *750*	255 *840*	185 *610*	200 *660*	220 *720*
P4	220 *720*	235 *770*	255 *840*	200 *660*	215 *710*	240 *790*	190 *620*	205 *670*	225 *740*	165 *540*	175 *570*	195 *640*
P5	210 *690*	225 *740*	245 *800*	195 *640*	205 *670*	225 *740*	185 *610*	195 *640*	215 *710*	160 *520*	170 *560*	185 *610*
P6	235 *770*	250 *820*	275 *900*	220 *720*	235 *770*	255 *840*	205 *670*	220 *720*	240 *790*	180 *590*	190 *620*	210 *690*
P7	220 *720*	235 *770*	260 *850*	205 *670*	220 *720*	240 *790*	195 *640*	205 *670*	225 *740*	170 *560*	180 *590*	195 *640*
P8	205 *670*	220 *720*	245 *800*	190 *620*	205 *670*	225 *740*	180 *590*	190 *620*	215 *710*	155 *510*	165 *540*	185 *610*
P11	215 *710*	230 *750*	255 *840*	200 *660*	215 *710*	235 *770*	190 *620*	200 *660*	220 *720*	165 *540*	175 *570*	190 *620*
P12	135 *445*	145 *475*	160 *520*	125 *410*	135 *445*	150 *490*	120 *395*	130 *425*	140 *460*	105 *345*	110 *360*	120 *395*
M1	205 *670*	220 *720*	240 *790*	195 *640*	210 *690*	230 *750*	190 *620*	205 *670*	225 *740*	175 *570*	185 *610*	205 *670*
M2	170 *560*	180 *590*	200 *660*	165 *540*	170 *560*	190 *620*	155 *510*	165 *540*	185 *610*	145 *475*	150 *490*	170 *560*
M3	135 *445*	145 *475*	160 *520*	130 *425*	135 *445*	150 *490*	125 *410*	135 *445*	150 *490*	115 *375*	120 *395*	135 *445*
M4	105 *345*	110 *360*	120 *395*	100 *330*	105 *345*	115 *375*	95 *310*	105 *345*	115 *375*	90 *295*	95 *310*	105 *345*
M5	85 *280*	90 *295*	100 *330*	80 *260*	90 *295*	95 *310*	80 *260*	85 *280*	95 *310*	75 *245*	80 *260*	85 *280*
K1	225 *740*	240 *790*	265 *870*	175 *570*	185 *610*	205 *670*	195 *640*	210 *690*	230 *750*	170 *560*	180 *590*	200 *660*
K2	200 *660*	210 *690*	235 *770*	155 *510*	165 *540*	180 *590*	175 *570*	185 *610*	205 *670*	150 *490*	160 *520*	175 *570*
K3	170 *560*	180 *590*	195 *640*	130 *425*	140 *460*	155 *510*	145 *475*	155 *510*	170 *560*	130 *425*	135 *445*	150 *490*
K4	160 *520*	170 *560*	190 *620*	125 *410*	135 *445*	145 *475*	140 *460*	150 *490*	165 *540*	120 *395*	130 *425*	145 *475*
K5	100 *330*	105 *345*	115 *375*	75 *245*	80 *260*	90 *295*	85 *280*	90 *295*	100 *330*	75 *245*	80 *260*	85 *280*
K6	140 *460*	150 *490*	165 *540*	110 *360*	115 *375*	130 *425*	125 *410*	130 *425*	145 *475*	105 *345*	115 *375*	125 *410*
K7	125 *410*	135 *445*	145 *475*	95 *310*	105 *345*	115 *375*	110 *360*	115 *375*	130 *425*	95 *310*	100 *330*	110 *360*
N1	— —	— —	— —	1550 *5075*	1675 *5500*	1850 *6075*	— —	— —	— —	1275 *4175*	1350 *4425*	1500 *4925*
N2	— —	— —	— —	630 *2075*	680 *2225*	750 *2450*	— —	— —	— —	510 *1675*	540 *1775*	600 *1975*
N3	— —	— —	— —	420 *1375*	455 *1500*	500 *1650*	— —	— —	— —	340 *1125*	360 *1175*	405 *1325*
N11	— —	— —	— —	480 *1575*	520 *1700*	570 *1875*	— —	— —	— —	390 *1275*	415 *1350*	460 *1500*
S1	50 *165*	55 *180*	60 *195*	46 *150*	49 *160*	55 *180*	45 *150*	48 *155*	55 *180*	41 *135*	44 *145*	48 *155*
S2	41 *135*	43 *140*	48 *155*	37 *120*	40 *130*	44 *145*	36 *120*	39 *130*	43 *140*	33 *110*	35 *115*	39 *130*
S3	35 *115*	38 *125*	42 *140*	32 *105*	35 *115*	38 *125*	32 *105*	34 *110*	37 *120*	29 *95*	31 *100*	34 *110*
S11	70 *230*	75 *245*	85 *280*	65 *215*	70 *230*	75 *245*	65 *215*	70 *230*	75 *245*	55 *180*	60 *195*	70 *230*
S12	60 *195*	65 *215*	70 *230*	55 *180*	60 *195*	65 *215*	55 *180*	55 *180*	65 *215*	48 *155*	50 *165*	55 *180*
S13	34 *110*	37 *120*	41 *135*	31 *100*	34 *110*	37 *120*	31 *100*	33 *110*	36 *120*	28 *90*	30 *100*	33 *110*
H5	41 *135*	44 *145*	49 *160*	35 *115*	37 *120*	41 *135*	40 *130*	43 *140*	47 *155*	34 *110*	37 *120*	41 *135*
H8	43 *140*	46 *150*	50 *165*	36 *120*	39 *130*	43 *140*	42 *140*	44 *145*	49 *160*	36 *120*	39 *130*	43 *140*
H11	55 *180*	55 *180*	60 *195*	45 *150*	48 *155*	50 *165*	50 *165*	55 *180*	60 *195*	44 *145*	47 *155*	50 *165*
H12	50 *165*	55 *180*	60 *195*	42 *140*	45 *150*	50 *165*	48 *155*	50 *165*	55 *180*	42 *140*	45 *150*	50 *165*
H21	43 *140*	46 *150*	50 *165*	36 *120*	39 *130*	43 *140*	42 *140*	44 *145*	49 *160*	36 *120*	39 *130*	43 *140*

335.18/29 Round 12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MM4500			MS2050			H25		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	240 *790*	260 *850*	290 *950*	180 *590*	190 *620*	210 *690*	245 *800*	260 *850*	290 *950*	— —	— —	— —
P2	235 *770*	250 *820*	275 *900*	175 *570*	185 *610*	205 *670*	235 *770*	255 *840*	280 *920*	— —	— —	— —
P3	205 *670*	220 *720*	245 *800*	150 *490*	160 *520*	180 *590*	205 *670*	220 *720*	245 *800*	— —	— —	— —
P4	180 *590*	195 *640*	215 *710*	135 *445*	145 *475*	160 *520*	185 *610*	195 *640*	215 *710*	— —	— —	— —
P5	175 *570*	185 *610*	205 *670*	130 *425*	135 *445*	150 *490*	175 *570*	185 *610*	205 *670*	— —	— —	— —
P6	195 *640*	210 *690*	230 *750*	145 *475*	155 *510*	170 *560*	195 *640*	210 *690*	230 *750*	— —	— —	— —
P7	185 *610*	200 *660*	215 *710*	135 *445*	145 *475*	160 *520*	185 *610*	195 *640*	215 *710*	— —	— —	— —
P8	170 *560*	185 *610*	205 *670*	125 *410*	135 *445*	150 *490*	170 *560*	185 *610*	205 *670*	— —	— —	— —
P11	180 *590*	195 *640*	210 *690*	135 *445*	140 *460*	155 *510*	180 *590*	190 *620*	210 *690*	— —	— —	— —
P12	115 *375*	125 *410*	135 *445*	85 *280*	90 *295*	100 *330*	115 *375*	125 *410*	135 *445*	— —	— —	— —
M1	— —	— —	— —	150 *490*	160 *520*	175 *570*	190 *620*	205 *670*	225 *740*	— —	— —	— —
M2	— —	— —	— —	125 *410*	130 *425*	145 *475*	155 *510*	170 *560*	185 *610*	— —	— —	— —
M3	— —	— —	— —	100 *330*	105 *345*	115 *375*	125 *410*	135 *445*	150 *490*	— —	— —	— —
M4	— —	— —	— —	75 *245*	80 *260*	90 *295*	95 *310*	105 *345*	115 *375*	— —	— —	— —
M5	— —	— —	— —	65 *215*	65 *215*	75 *245*	80 *260*	85 *280*	95 *310*	— —	— —	— —
K1	255 *840*	270 *890*	300 *980*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	225 *740*	240 *790*	265 *870*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	190 *620*	200 *660*	225 *740*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	185 *610*	195 *640*	215 *710*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	110 *360*	120 *395*	130 *425*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	160 *520*	170 *560*	190 *620*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	140 *460*	150 *490*	165 *540*	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	1375 *4500*	1475 *4850*	1625 *5325*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	550 *1800*	600 *1975*	660 *2175*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	370 *1225*	400 *1300*	440 *1450*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	420 *1375*	455 *1500*	500 *1650*
S1	— —	— —	— —	23 *75*	25 *80*	27 *90*	45 *150*	48 *155*	55 *180*	— —	— —	— —
S2	— —	— —	— —	19 *60*	20 *65*	22 *70*	36 *120*	39 *130*	43 *140*	— —	— —	— —
S3	— —	— —	— —	16 *50*	17 *55*	19 *60*	32 *105*	34 *110*	38 *125*	— —	— —	— —
S11	— —	— —	— —	32 *105*	35 *115*	38 *125*	65 *215*	70 *230*	75 *245*	— —	— —	— —
S12	— —	— —	— —	30 *100*	32 *105*	35 *115*	55 *180*	55 *180*	65 *215*	— —	— —	— —
S13	— —	— —	— —	17 *55*	18 *60*	21 *70*	31 *100*	33 *110*	36 *120*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

335.25 Round 16 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	RPHT1605M0T-8-ME11 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P2	RPHT1605M0T-8-ME11 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P3	RPHT1605M0T-8-ME11 F40M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
P4	RPHT1605M0T-8-M12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P5	RPHT1605M0T-8-M12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P6	RPHT1605M0T-8-M12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P7	RPHT1605M0T-8-M12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P8	RPKT1605M0T-8-M12 MP2501	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
P11	RPHT1605M0T-8-M12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P12	RPHT1605M0T-8-M12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M1	RPHT1605M0T-8-ME11 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
M2	RPHT1605M0T-8-ME11 F40M	0,17 *0.0065*	0,20 *0.0080*	0,26 *0.010*
M3	RPHT1605M0T-8-M12 F40M	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
M4	RPHT1605M0T-8-M12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M5	RPHT1605M0T-8-M12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K1	RPKT1605M0T-8-M18 MK2050	0,32 *0.013*	0,36 *0.014*	0,48 *0.019*
K2	RPKT1605M0T-8-M18 MK2050	0,28 *0.011*	0,32 *0.013*	0,44 *0.017*
K3	RPKT1605M0T-8-M18 MK2050	0,28 *0.011*	0,32 *0.013*	0,44 *0.017*
K4	RPKT1605M0T-8-M18 MK2050	0,28 *0.011*	0,32 *0.013*	0,44 *0.017*
K5	RPKT1605M0T-8-M18 MK2050	0,25 *0.010*	0,30 *0.012*	0,38 *0.015*
K6	RPKT1605M0T-8-M18 MK2050	0,28 *0.011*	0,32 *0.013*	0,44 *0.017*
K7	RPKT1605M0T-8-M18 MK2050	0,25 *0.010*	0,30 *0.012*	0,38 *0.015*
N1	RPHT1605M0T-8-ME11 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
N2	RPHT1605M0T-8-ME11 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
N3	RPHT1605M0T-8-ME11 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
N11	RPHT1605M0T-8-ME11 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
S1	RPHT1605M0T-8-M12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S2	RPHT1605M0T-8-M12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S3	RPHT1605M0T-8-M12 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
S11	RPHT1605M0T-8-ME11 F40M	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
S12	RPHT1605M0T-8-ME11 F40M	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
H5	RPKW1605M0T-8-MD20 F15M	0,22 *0.0085*	0,24 *0.0095*	0,32 *0.013*
H8	RPKW1605M0T-8-MD20 F15M	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*
H11	RPKW1605M0T-8-MD20 F15M	0,22 *0.0085*	0,24 *0.0095*	0,32 *0.013*
H12	RPKW1605M0T-8-MD20 F15M	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*
H21	RPKW1605M0T-8-MD20 F15M	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.25 Round 16 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			T350M			F15M			F40M		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	245 *800*	265 *870*	295 *970*	245 *800*	260 *850*	290 *950*	215 *710*	225 *740*	250 *820*	— —	— —	— —	185 *610*	195 *640*	220 *720*
P2	235 *770*	255 *840*	280 *920*	240 *790*	255 *840*	280 *920*	210 *690*	220 *720*	245 *800*	— —	— —	— —	180 *590*	190 *620*	210 *690*
P3	205 *670*	220 *720*	250 *820*	205 *670*	225 *740*	245 *800*	180 *590*	195 *640*	215 *710*	— —	— —	— —	155 *510*	170 *560*	185 *610*
P4	185 *610*	200 *660*	220 *720*	185 *610*	195 *640*	215 *710*	160 *520*	170 *560*	190 *620*	— —	— —	— —	140 *460*	150 *490*	165 *540*
P5	175 *570*	190 *620*	210 *690*	175 *570*	185 *610*	210 *690*	155 *510*	165 *540*	185 *610*	— —	— —	— —	135 *445*	140 *460*	160 *520*
P6	200 *660*	215 *710*	240 *790*	195 *640*	210 *690*	235 *770*	170 *560*	185 *610*	205 *670*	— —	— —	— —	150 *490*	160 *520*	180 *590*
P7	190 *620*	200 *660*	225 *740*	185 *610*	200 *660*	220 *720*	160 *520*	175 *570*	195 *640*	— —	— —	— —	140 *460*	150 *490*	170 *560*
P8	175 *570*	185 *610*	210 *690*	175 *570*	185 *610*	205 *670*	150 *490*	165 *540*	180 *590*	— —	— —	— —	130 *425*	140 *460*	155 *510*
P11	180 *590*	195 *640*	220 *720*	180 *590*	195 *640*	215 *710*	155 *510*	170 *560*	190 *620*	— —	— —	— —	135 *445*	145 *475*	165 *540*
P12	120 *395*	130 *425*	140 *460*	115 *375*	125 *410*	140 *460*	100 *330*	110 *360*	120 *395*	— —	— —	— —	90 *295*	95 *310*	105 *345*
M1	— —	— —	— —	170 *560*	180 *590*	200 *660*	160 *520*	170 *560*	190 *620*	— —	— —	— —	145 *475*	155 *510*	170 *560*
M2	— —	— —	— —	140 *460*	150 *490*	170 *560*	130 *425*	140 *460*	155 *510*	— —	— —	— —	120 *395*	130 *425*	145 *475*
M3	— —	— —	— —	115 *375*	120 *395*	135 *445*	105 *345*	115 *375*	125 *410*	— —	— —	— —	95 *310*	105 *345*	115 *375*
M4	— —	— —	— —	90 *295*	95 *310*	105 *345*	85 *280*	90 *295*	100 *330*	— —	— —	— —	75 *245*	80 *260*	90 *295*
M5	— —	— —	— —	75 *245*	80 *260*	85 *280*	70 *230*	75 *245*	80 *260*	— —	— —	— —	65 *215*	65 *215*	75 *245*
K1	185 *610*	200 *660*	225 *740*	190 *620*	200 *660*	220 *720*	165 *540*	175 *570*	195 *640*	130 *425*	140 *460*	155 *510*	145 *475*	150 *490*	170 *560*
K2	170 *560*	180 *590*	200 *660*	165 *540*	180 *590*	200 *660*	145 *475*	155 *510*	175 *570*	115 *375*	125 *410*	140 *460*	125 *410*	135 *445*	150 *490*
K3	140 *460*	155 *510*	170 *560*	140 *460*	150 *490*	170 *560*	125 *410*	130 *425*	145 *475*	100 *330*	105 *345*	120 *395*	105 *345*	115 *375*	130 *425*
K4	135 *445*	145 *475*	160 *520*	135 *445*	145 *475*	160 *520*	115 *375*	125 *410*	140 *460*	95 *310*	100 *330*	110 *360*	100 *330*	110 *360*	120 *395*
K5	85 *280*	90 *295*	100 *330*	80 *260*	90 *295*	100 *330*	70 *230*	75 *245*	85 *280*	60 *195*	60 *195*	70 *230*	60 *195*	65 *215*	75 *245*
K6	120 *395*	130 *425*	140 *460*	120 *395*	125 *410*	140 *460*	105 *345*	110 *360*	125 *410*	85 *280*	90 *295*	100 *330*	90 *295*	95 *310*	105 *345*
K7	105 *345*	115 *375*	125 *410*	105 *345*	115 *375*	125 *410*	90 *295*	100 *330*	110 *360*	75 *245*	80 *260*	90 *295*	80 *260*	85 *280*	95 *310*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1050 *3450*	1125 *3700*	1250 *4100*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	425 *1400*	455 *1500*	500 *1650*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	285 *940*	305 *1000*	335 *1100*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	325 *1075*	345 *1125*	385 *1275*
S1	— —	— —	— —	43 *140*	46 *150*	50 *165*	39 *130*	41 *135*	46 *150*	— —	— —	— —	35 *115*	37 *120*	41 *135*
S2	— —	— —	— —	35 *115*	37 *120*	41 *135*	31 *100*	33 *110*	37 *120*	— —	— —	— —	28 *90*	30 *100*	33 *110*
S3	— —	— —	— —	31 *100*	32 *105*	36 *120*	27 *90*	29 *95*	32 *105*	— —	— —	— —	25 *80*	26 *85*	29 *95*
S11	— —	— —	— —	60 *195*	65 *215*	70 *230*	55 *180*	60 *195*	65 *215*	— —	— —	— —	49 *160*	50 *165*	55 *180*
S12	— —	— —	— —	50 *165*	55 *180*	60 *195*	45 *150*	49 *160*	55 *180*	— —	— —	— —	41 *135*	44 *145*	48 *155*
S13	— —	— —	— —	29 *95*	31 *100*	35 *115*	26 *85*	28 *90*	31 *100*	— —	— —	— —	24 *80*	26 *85*	28 *90*
H5	40 *130*	43 *140*	47 *155*	35 *115*	38 *125*	42 *140*	34 *110*	36 *120*	40 *130*	28 *90*	30 *100*	33 *110*	29 *95*	31 *100*	35 *115*
H8	42 *140*	45 *150*	50 *165*	37 *120*	40 *130*	44 *145*	36 *120*	39 *130*	43 *140*	30 *100*	32 *105*	35 *115*	31 *100*	34 *110*	37 *120*
H11	50 *165*	55 *180*	60 *195*	45 *150*	48 *155*	55 *180*	43 *140*	46 *150*	50 *165*	35 *115*	38 *125*	42 *140*	38 *125*	40 *130*	44 *145*
H12	49 *160*	55 *180*	60 *195*	44 *145*	47 *155*	50 *165*	42 *140*	45 *150*	49 *160*	35 *115*	37 *120*	41 *135*	36 *120*	39 *130*	43 *140*
H21	42 *140*	45 *150*	50 *165*	37 *120*	40 *130*	44 *145*	36 *120*	39 *130*	43 *140*	30 *100*	32 *105*	35 *115*	31 *100*	34 *110*	37 *120*

335.25 Round 16 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050			MM4500			MS2050			MS2500		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	215 *710*	230 *750*	255 *840*	150 *490*	160 *520*	175 *570*	215 *710*	230 *750*	260 *850*	270 *890*	285 *940*	315 *1025*
P2	205 *670*	220 *720*	245 *800*	145 *475*	155 *510*	170 *560*	210 *690*	225 *740*	245 *800*	260 *850*	275 *900*	305 *1000*
P3	180 *590*	195 *640*	215 *710*	125 *410*	135 *445*	150 *490*	185 *610*	200 *660*	215 *710*	225 *740*	245 *800*	265 *870*
P4	160 *520*	175 *570*	190 *620*	115 *375*	120 *395*	130 *425*	160 *520*	175 *570*	195 *640*	200 *660*	215 *710*	235 *770*
P5	155 *510*	165 *540*	180 *590*	110 *360*	115 *375*	130 *425*	155 *510*	165 *540*	185 *610*	190 *620*	205 *670*	230 *750*
P6	175 *570*	185 *610*	210 *690*	120 *395*	130 *425*	145 *475*	175 *570*	185 *610*	210 *690*	215 *710*	230 *750*	255 *840*
P7	165 *540*	175 *570*	195 *640*	115 *375*	120 *395*	135 *445*	165 *540*	175 *570*	195 *640*	205 *670*	215 *710*	240 *790*
P8	150 *490*	165 *540*	180 *590*	105 *345*	115 *375*	125 *410*	155 *510*	165 *540*	180 *590*	190 *620*	205 *670*	225 *740*
P11	160 *520*	170 *560*	190 *620*	110 *360*	120 *395*	135 *445*	160 *520*	170 *560*	190 *620*	195 *640*	210 *690*	235 *770*
P12	105 *345*	110 *360*	125 *410*	70 *230*	75 *245*	85 *280*	105 *345*	110 *360*	125 *410*	130 *425*	135 *445*	150 *490*
M1	— —	— —	— —	125 *410*	135 *445*	145 *475*	170 *560*	180 *590*	200 *660*	185 *610*	200 *660*	220 *720*
M2	— —	— —	— —	105 *345*	110 *360*	125 *410*	140 *460*	150 *490*	165 *540*	155 *510*	165 *540*	185 *610*
M3	— —	— —	— —	85 *280*	90 *295*	100 *330*	115 *375*	120 *395*	135 *445*	125 *410*	135 *445*	145 *475*
M4	— —	— —	— —	65 *215*	70 *230*	75 *245*	90 *295*	95 *310*	105 *345*	95 *310*	105 *345*	115 *375*
M5	— —	— —	— —	55 *180*	60 *195*	65 *215*	75 *245*	80 *260*	85 *280*	80 *260*	85 *280*	95 *310*
K1	220 *720*	240 *790*	265 *870*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	200 *660*	215 *710*	235 *770*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	170 *560*	180 *590*	200 *660*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	160 *520*	175 *570*	190 *620*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	100 *330*	105 *345*	120 *395*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	140 *460*	155 *510*	170 *560*	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	125 *410*	135 *445*	150 *490*	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	20 *65*	21 *70*	23 *75*	41 *135*	44 *145*	49 *160*	47 *155*	50 *165*	55 *180*
S2	— —	— —	— —	16 *50*	17 *55*	19 *60*	33 *110*	35 *115*	39 *130*	38 *125*	40 *130*	45 *150*
S3	— —	— —	— —	14 *46*	15 *49*	16 *50*	29 *95*	31 *100*	34 *110*	33 *110*	35 *115*	39 *130*
S11	— —	— —	— —	28 *90*	30 *100*	32 *105*	55 *180*	60 *195*	65 *215*	65 *215*	70 *230*	75 *245*
S12	— —	— —	— —	26 *85*	27 *90*	30 *100*	48 *155*	50 *165*	55 *180*	55 *180*	60 *195*	65 *215*
S13	— —	— —	— —	15 *49*	16 *50*	18 *60*	28 *90*	30 *100*	33 *110*	32 *105*	34 *110*	38 *125*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

335.25 Round 20 – Insert selection – mm/*Inch*

SMG		f_z		
		30%	20%	10%
P1	RPHT2006M0T-ME12 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
P2	RPHT2006M0T-ME12 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
P3	RPHT2006M0T-ME12 F40M	0,20 *0.0080*	0,22 *0.0085*	0,30 *0.012*
P4	RPHT2006M0T-ME12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P5	RPKT2006M0T-M15 F40M	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
P6	RPKT2006M0T-M15 F40M	0,24 *0.0095*	0,26 *0.010*	0,36 *0.014*
P7	RPKT2006M0T-M15 F40M	0,24 *0.0095*	0,26 *0.010*	0,36 *0.014*
P8	RPKT2006M0T-M15 MP2501	0,25 *0.010*	0,28 *0.011*	0,38 *0.015*
P11	RPHT2006M0T-ME12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
P12	RPHT2006M0T-ME12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M1	RPHT2006M0T-ME12 F40M	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
M2	RPHT2006M0T-ME12 F40M	0,19 *0.0075*	0,22 *0.0085*	0,28 *0.011*
M3	RPHT2006M0T-ME12 F40M	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
M4	RPHT2006M0T-ME12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
M5	RPHT2006M0T-ME12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
K1	RPKT2006M0T-M20 MK2050	0,26 *0.010*	0,30 *0.012*	0,40 *0.016*
K2	RPKT2006M0T-M20 MK2050	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
K3	RPKT2006M0T-M20 MK2050	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
K4	RPKT2006M0T-M20 MK2050	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
K5	RPKT2006M0T-M20 MK2050	0,22 *0.0085*	0,24 *0.0095*	0,32 *0.013*
K6	RPKT2006M0T-M20 MK2050	0,24 *0.0095*	0,28 *0.011*	0,36 *0.014*
K7	RPKT2006M0T-M20 MK2050	0,22 *0.0085*	0,24 *0.0095*	0,32 *0.013*
N1	RPHT2006M0T-ME12 F40M	0,26 *0.010*	0,30 *0.012*	0,40 *0.016*
N2	RPHT2006M0T-ME12 F40M	0,26 *0.010*	0,30 *0.012*	0,40 *0.016*
N3	RPHT2006M0T-ME12 F40M	0,26 *0.010*	0,30 *0.012*	0,40 *0.016*
N11	RPHT2006M0T-ME12 F40M	0,26 *0.010*	0,30 *0.012*	0,40 *0.016*
S1	RPHT2006M0T-ME12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S2	RPHT2006M0T-ME12 F40M	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
S3	RPHT2006M0T-ME12 F40M	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
S11	RPHT2006M0T-ME12 F40M	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
S12	RPHT2006M0T-ME12 F40M	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
H5	RPKW2006M0T-MD22 F15M	0,24 *0.0095*	0,26 *0.010*	0,36 *0.014*
H8	RPKW2006M0T-MD22 F15M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
H11	RPKW2006M0T-MD22 F15M	0,24 *0.0095*	0,26 *0.010*	0,36 *0.014*
H12	RPKW2006M0T-MD22 F15M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*
H21	RPKW2006M0T-MD22 F15M	0,18 *0.0070*	0,20 *0.0080*	0,28 *0.011*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.25 Round 20 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			T350M			F15M			F25M			F30M		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	235 *770*	255 *840*	285 *940*	230 *750*	245 *800*	275 *900*	200 *660*	210 *690*	240 *790*	— —	— —	— —	190 *620*	205 *670*	230 *750*	180 *590*	195 *640*	215 *710*
P2	230 *750*	245 *800*	270 *890*	220 *720*	235 *770*	265 *870*	195 *640*	205 *670*	230 *750*	— —	— —	— —	185 *610*	200 *660*	220 *720*	175 *570*	190 *620*	210 *690*
P3	200 *660*	215 *710*	240 *790*	195 *640*	210 *690*	230 *750*	170 *560*	180 *590*	200 *660*	— —	— —	— —	160 *520*	175 *570*	190 *620*	155 *510*	165 *540*	185 *610*
P4	180 *590*	190 *620*	210 *690*	170 *560*	185 *610*	205 *670*	150 *490*	160 *520*	180 *590*	— —	— —	— —	145 *475*	155 *510*	170 *560*	135 *445*	145 *475*	160 *520*
P5	170 *560*	185 *610*	205 *670*	165 *540*	175 *570*	195 *640*	145 *475*	155 *510*	170 *560*	— —	— —	— —	135 *445*	145 *475*	165 *540*	130 *425*	140 *460*	155 *510*
P6	190 *620*	205 *670*	230 *750*	185 *610*	200 *660*	220 *720*	160 *520*	175 *570*	190 *620*	— —	— —	— —	155 *510*	165 *540*	185 *610*	145 *475*	155 *510*	175 *570*
P7	180 *590*	195 *640*	215 *710*	175 *570*	190 *620*	210 *690*	150 *490*	165 *540*	180 *590*	— —	— —	— —	145 *475*	160 *520*	175 *570*	140 *460*	150 *490*	165 *540*
P8	170 *560*	180 *590*	200 *660*	160 *520*	175 *570*	195 *640*	140 *460*	155 *510*	170 *560*	— —	— —	— —	135 *445*	145 *475*	160 *520*	130 *425*	140 *460*	155 *510*
P11	175 *570*	190 *620*	210 *690*	170 *560*	185 *610*	200 *660*	145 *475*	160 *520*	175 *570*	— —	— —	— —	140 *460*	155 *510*	170 *560*	135 *445*	145 *475*	160 *520*
P12	115 *375*	125 *410*	140 *460*	110 *360*	120 *395*	130 *425*	95 *310*	105 *345*	115 *375*	— —	— —	— —	95 *310*	100 *330*	110 *360*	85 *280*	95 *310*	105 *345*
M1	— —	— —	— —	160 *520*	170 *560*	190 *620*	150 *490*	160 *520*	175 *570*	— —	— —	— —	— —	— —	— —	145 *475*	150 *490*	170 *560*
M2	— —	— —	— —	130 *425*	140 *460*	160 *520*	125 *410*	130 *425*	145 *475*	— —	— —	— —	— —	— —	— —	115 *375*	125 *410*	140 *460*
M3	— —	— —	— —	105 *345*	115 *375*	130 *425*	100 *330*	105 *345*	120 *395*	— —	— —	— —	— —	— —	— —	95 *310*	100 *330*	110 *360*
M4	— —	— —	— —	85 *280*	90 *295*	100 *330*	80 *260*	85 *280*	90 *295*	— —	— —	— —	— —	— —	— —	75 *245*	80 *260*	85 *280*
M5	— —	— —	— —	70 *230*	75 *245*	85 *280*	65 *215*	70 *230*	75 *245*	— —	— —	— —	— —	— —	— —	60 *195*	65 *215*	70 *230*
K1	185 *610*	195 *640*	215 *710*	175 *570*	190 *620*	210 *690*	155 *510*	165 *540*	180 *590*	125 *410*	135 *445*	150 *490*	145 *475*	155 *510*	175 *570*	140 *460*	150 *490*	165 *540*
K2	160 *520*	175 *570*	195 *640*	155 *510*	165 *540*	185 *610*	135 *445*	145 *475*	160 *520*	115 *375*	120 *395*	135 *445*	130 *425*	140 *460*	155 *510*	125 *410*	135 *445*	145 *475*
K3	135 *445*	145 *475*	165 *540*	130 *425*	140 *460*	155 *510*	115 *375*	125 *410*	135 *445*	95 *310*	105 *345*	115 *375*	110 *360*	115 *375*	130 *425*	105 *345*	110 *360*	125 *410*
K4	130 *425*	140 *460*	155 *510*	125 *410*	135 *445*	150 *490*	110 *360*	115 *375*	130 *425*	90 *295*	100 *330*	110 *360*	105 *345*	110 *360*	125 *410*	100 *330*	105 *345*	120 *395*
K5	80 *260*	85 *280*	95 *310*	75 *245*	85 *280*	90 *295*	65 *215*	75 *245*	80 *260*	55 *180*	60 *195*	65 *215*	65 *215*	70 *230*	75 *245*	60 *195*	65 *215*	70 *230*
K6	115 *375*	125 *410*	140 *460*	110 *360*	120 *395*	130 *425*	95 *310*	105 *345*	115 *375*	80 *260*	85 *280*	95 *310*	90 *295*	100 *330*	110 *360*	90 *295*	95 *310*	105 *345*
K7	105 *345*	110 *360*	120 *395*	100 *330*	105 *345*	120 *395*	85 *280*	95 *310*	105 *345*	70 *230*	75 *245*	85 *280*	80 *260*	90 *295*	100 *330*	80 *260*	85 *280*	90 *295*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1050 *3450*	1125 *3700*	1225 *4025*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	420 *1375*	450 *1475*	495 *1625*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	280 *920*	300 *980*	330 *1075*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	320 *1050*	345 *1125*	380 *1250*
S1	— —	— —	— —	41 *135*	43 *140*	48 *155*	37 *120*	39 *130*	43 *140*	— —	— —	— —	37 *120*	39 *130*	43 *140*	34 *110*	36 *120*	40 *130*
S2	— —	— —	— —	33 *110*	35 *115*	39 *130*	30 *100*	31 *100*	35 *115*	— —	— —	— —	30 *100*	31 *100*	35 *115*	28 *90*	29 *95*	32 *105*
S3	— —	— —	— —	29 *95*	31 *100*	34 *110*	26 *85*	27 *90*	30 *100*	— —	— —	— —	26 *85*	27 *90*	30 *100*	24 *80*	26 *85*	28 *90*
S11	— —	— —	— —	55 *180*	60 *195*	70 *230*	50 *165*	55 *180*	60 *195*	— —	— —	— —	50 *165*	55 *180*	60 *195*	48 *155*	50 *165*	55 *180*
S12	— —	— —	— —	48 *155*	50 *165*	55 *180*	43 *140*	45 *150*	50 *165*	— —	— —	— —	43 *140*	45 *150*	50 *165*	33 *110*	36 *120*	40 *130*
S13	— —	— —	— —	28 *90*	30 *100*	33 *110*	25 *80*	27 *90*	29 *95*	— —	— —	— —	25 *80*	27 *90*	29 *95*	19 *60*	21 *70*	23 *75*
H5	38 *125*	42 *140*	46 *150*	34 *110*	36 *120*	40 *130*	32 *105*	35 *115*	38 *125*	27 *90*	29 *95*	32 *105*	31 *100*	33 *110*	36 *120*	29 *95*	31 *100*	34 *110*
H8	42 *140*	44 *145*	49 *160*	36 *120*	38 *125*	42 *140*	35 *115*	37 *120*	40 *130*	29 *95*	31 *100*	34 *110*	33 *110*	35 *115*	39 *130*	31 *100*	32 *105*	36 *120*
H11	49 *160*	55 *180*	60 *195*	43 *140*	46 *150*	50 *165*	41 *135*	44 *145*	48 *155*	34 *110*	37 *120*	41 *135*	39 *130*	42 *140*	46 *150*	37 *120*	39 *130*	44 *145*
H12	49 *160*	50 *165*	55 *180*	42 *140*	45 *150*	49 *160*	40 *130*	43 *140*	47 *155*	34 *110*	37 *120*	40 *130*	38 *125*	41 *135*	45 *150*	36 *120*	38 *125*	42 *140*
H21	42 *140*	44 *145*	49 *160*	36 *120*	38 *125*	42 *140*	35 *115*	37 *120*	40 *130*	29 *95*	31 *100*	34 *110*	33 *110*	35 *115*	39 *130*	31 *100*	32 *105*	36 *120*

335.25 Round 20 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MK2050			MM4500			MS2050			MS2500			T25M		
	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%	30%	20%	10%
P1	195 *640*	205 *670*	225 *740*	225 *740*	240 *790*	270 *890*	155 *510*	165 *540*	185 *610*	210 *690*	225 *740*	250 *820*	250 *820*	265 *870*	300 *980*	210 *690*	225 *740*	250 *820*
P2	190 *620*	200 *660*	220 *720*	220 *720*	235 *770*	260 *850*	150 *490*	160 *520*	180 *590*	205 *670*	220 *720*	240 *790*	240 *790*	260 *850*	285 *940*	205 *670*	220 *720*	240 *790*
P3	160 *520*	175 *570*	190 *620*	190 *620*	205 *670*	225 *740*	130 *425*	140 *460*	155 *510*	175 *570*	190 *620*	210 *690*	210 *690*	225 *740*	250 *820*	175 *570*	190 *620*	210 *690*
P4	145 *475*	155 *510*	170 *560*	170 *560*	180 *590*	200 *660*	115 *375*	125 *410*	135 *445*	160 *520*	170 *560*	185 *610*	190 *620*	200 *660*	225 *740*	160 *520*	170 *560*	185 *610*
P5	140 *460*	145 *475*	165 *540*	160 *520*	175 *570*	195 *640*	110 *360*	120 *395*	135 *445*	150 *490*	160 *520*	180 *590*	180 *590*	190 *620*	215 *710*	150 *490*	160 *520*	180 *590*
P6	155 *510*	165 *540*	185 *610*	180 *590*	200 *660*	215 *710*	125 *410*	135 *445*	150 *490*	170 *560*	180 *590*	205 *670*	200 *660*	220 *720*	240 *790*	170 *560*	180 *590*	205 *670*
P7	145 *475*	155 *510*	175 *570*	170 *560*	185 *610*	205 *670*	120 *395*	125 *410*	140 *460*	160 *520*	170 *560*	190 *620*	190 *620*	205 *670*	225 *740*	160 *520*	170 *560*	190 *620*
P8	135 *445*	145 *475*	160 *520*	160 *520*	175 *570*	190 *620*	110 *360*	120 *395*	130 *425*	150 *490*	160 *520*	180 *590*	175 *570*	190 *620*	210 *690*	150 *490*	160 *520*	180 *590*
P11	140 *460*	150 *490*	170 *560*	165 *540*	180 *590*	200 *660*	115 *375*	120 *395*	135 *445*	155 *510*	165 *540*	185 *610*	185 *610*	200 *660*	220 *720*	155 *510*	165 *540*	185 *610*
P12	90 *295*	100 *330*	110 *360*	110 *360*	120 *395*	130 *425*	75 *245*	80 *260*	90 *295*	100 *330*	110 *360*	120 *395*	120 *395*	130 *425*	145 *475*	100 *330*	110 *360*	120 *395*
M1	150 *490*	160 *520*	175 *570*	— —	— —	— —	130 *425*	140 *460*	155 *510*	165 *540*	175 *570*	195 *640*	175 *570*	185 *610*	205 *670*	165 *540*	175 *570*	195 *640*
M2	125 *410*	130 *425*	150 *490*	— —	— —	— —	105 *345*	115 *375*	130 *425*	135 *445*	145 *475*	165 *540*	145 *475*	155 *510*	170 *560*	135 *445*	145 *475*	165 *540*
M3	100 *330*	105 *345*	115 *375*	— —	— —	— —	85 *280*	95 *310*	100 *330*	110 *360*	120 *395*	130 *425*	115 *375*	125 *410*	140 *460*	110 *360*	120 *395*	130 *425*
M4	80 *260*	85 *280*	90 *295*	— —	— —	— —	65 *215*	70 *230*	80 *260*	85 *280*	90 *295*	100 *330*	90 *295*	95 *310*	110 *360*	85 *280*	90 *295*	100 *330*
M5	65 *215*	70 *230*	75 *245*	— —	— —	— —	55 *180*	60 *195*	65 *215*	70 *230*	75 *245*	85 *280*	75 *245*	80 *260*	90 *295*	70 *230*	75 *245*	85 *280*
K1	150 *490*	155 *510*	175 *570*	235 *770*	250 *820*	280 *920*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	130 *425*	140 *460*	155 *510*	210 *690*	225 *740*	250 *820*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	110 *360*	120 *395*	130 *425*	175 *570*	190 *620*	210 *690*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	105 *345*	115 *375*	125 *410*	170 *560*	180 *590*	200 *660*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	65 *215*	70 *230*	75 *245*	105 *345*	110 *360*	125 *410*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	95 *310*	100 *330*	110 *360*	150 *490*	160 *520*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	85 *280*	90 *295*	100 *330*	130 *425*	145 *475*	160 *520*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	1100 *3600*	1175 *3850*	1300 *4275*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	440 *1450*	470 *1550*	520 *1700*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	295 *970*	315 *1025*	350 *1150*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	335 *1100*	360 *1175*	400 *1300*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	36 *120*	39 *130*	43 *140*	— —	— —	— —	21 *70*	22 *70*	24 *80*	40 *130*	43 *140*	47 *155*	45 *150*	47 *155*	55 *180*	— —	— —	— —
S2	29 *95*	31 *100*	35 *115*	— —	— —	— —	17 *55*	18 *60*	20 *65*	32 *105*	34 *110*	38 *125*	36 *120*	38 *125*	42 *140*	— —	— —	— —
S3	26 *85*	27 *90*	30 *100*	— —	— —	— —	15 *49*	15 *49*	17 *55*	28 *90*	30 *100*	33 *110*	32 *105*	33 *110*	37 *120*	— —	— —	— —
S11	50 *165*	55 *180*	60 *195*	— —	— —	— —	29 *95*	31 *100*	34 *110*	55 *180*	60 *195*	65 *215*	60 *195*	65 *215*	75 *245*	— —	— —	— —
S12	43 *140*	46 *150*	50 *165*	— —	— —	— —	26 *85*	28 *90*	31 *100*	47 *155*	50 *165*	55 *180*	50 *165*	55 *180*	60 *195*	— —	— —	— —
S13	25 *80*	26 *85*	29 *95*	— —	— —	— —	15 *49*	16 *50*	18 *60*	27 *90*	29 *95*	32 *105*	31 *100*	32 *105*	36 *120*	— —	— —	— —
H5	31 *100*	33 *110*	36 *120*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	32 *105*	35 *115*	38 *125*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	39 *130*	41 *135*	46 *150*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	38 *125*	40 *130*	45 *150*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	32 *105*	35 *115*	38 *125*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

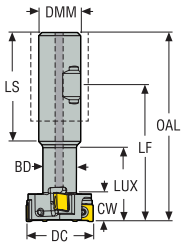
Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

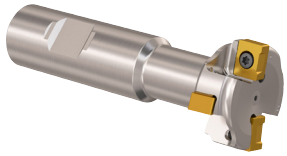
335.16

Free-cutting and reliable disc milling cutter system dedicated for T-shape slotting

- Width of cut 10.91 -21 mm (.387 - .823 inch)
- Cutter range diameter 25-50 mm (0.969 - 1.844 inch)
- Weldon connection, with through coolant capability for reliable chips evacuation
- Economical solution with 4 cutting edges per insert

R335.16 – Metric





- For insert selection and cutting data recommendations, see page(s) 457-462
- For complete insert programme, see page(s) 741, 770
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CW	ZNP	ZEFP	DMM	LS	LF	LUX	BD	OAL	RPMX	Weight	Insert
			mm	mm			mm	mm	mm	mm	mm	mm		kg	
R335.16-1625.3-11.2NA	02980627	Weldon	25,0	10,91	4	2	16,0	49,0	56,0	28.38	12,0	80,0	24500	0,2	SPMX07..
R335.16-2032.3-14.2NA	02980628	Weldon	32,0	13,91	4	2	20,0	52,0	65,0	35.38	16,0	90,0	17600	0,2	LNK.08..
R335.16-2540.3-18.2NA	02980629	Weldon	40,0	17,91	5	2	25,0	58,0	73,0	43.67	20,0	105,0	14600	0,4	LNK.08..
R335.16-3250.3-21.2NA	02980630	Weldon	50,0	21,0	6	2	32,0	61,0	84,0	55.17	26,0	120,0	9800	0,7	LNK.08..

ZEFP = Effective number of teeth

Spare Parts

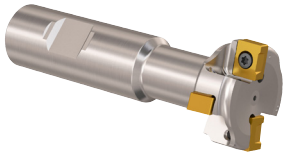
For cutter	Insert screw
ø 25	C02506-T07P
ø 32-50	C73007-T09P

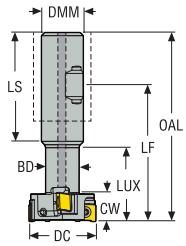
Accessories

Torque key	Torque value
T00-07P12	1.2NM
T00-09P20	2.0NM

For best result it is recommended to let a stock allowance when machining the T-slot shank passage H = min 20% of the CW at the bottom of the T-slot. H= 0.2 x CW
Torque and fixed keys, see page 829

R335.16 – Inch





- For insert selection and cutting data recommendations, see page(s) 457-462
- For complete insert programme, see page(s) 741, 770
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	CW	ZNP	ZEFP	DMM	LS	LF	LUX	BD	OAL	RPMX	Weight	Insert
			Inch	Inch			Inch	Inch	Inch	Inch	Inch	Inch		lbs	
R335.16-00.97-3-0.39-2NA	02980638	Weldon	0.969	0.387	4	2	0.750	2.307	2.528	1.063	0.453	3.543	24500	0.440	SPMX06..
R335.16-01.25-3-0.48-2NA	02980639	Weldon	1.249	0.477	4	2	1.000	2.539	2.796	1.256	0.656	3.937	17600	0.880	LNK.08..
R335.16-01.47-3-0.63-2NA	02980640	Weldon	1.469	0.626	5	2	1.000	2.539	3.190	1.633	0.748	4.331	14600	0.880	LNK.08..
R335.16-01.84-3-0.83-2NA	02980641	Weldon	1.844	0.823	6	2	1.250	2.697	3.978	2.264	1.000	5.118	9800	1.760	LNK.08..

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
ø 0.97	C02205-T07P	T00-07P09	8.0IN.LBS
ø 1.25-1.84	C73007-T09P	T00-09P20	17.7IN.LBS

For best result it is recommended to let a stock allowance when machining the T-slot shank passage H = min 20% of the CW at the bottom of the T-slot. H= 0.2 x CW
Torque and fixed keys, see page 829

335.16 - SP06 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	20%	10%
P1	SPMX060204-75 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
P2	SPMX060204-75 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
P3	SPMX060204-75 F40M	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
P4	SPMX060204-75 F40M	0,065 *0.0026*	0,085 *0.0034*	0,11 *0.0044*
P5	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
P6	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
P7	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
P8	SPMX060204-75 F40M	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
P11	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
P12	SPMX060204-75 F40M	0,044 *0.0017*	0,055 *0.0022*	0,075 *0.0030*
M1	SPMX060204-75 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
M2	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
M3	SPMX060204-75 F40M	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
M4	SPMX060204-75 F40M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
M5	SPMX060204-75 F40M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
K1	SPMX060204-75 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
K2	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K3	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K4	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K5	SPMX060204-75 F40M	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
K6	SPMX060204-75 F40M	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K7	SPMX060204-75 F40M	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
N1	SPMX060204-75 F40M	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
N2	SPMX060204-75 F40M	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
N3	SPMX060204-75 F40M	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
N11	SPMX060204-75 F40M	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
S1	SPMX060204-75 F40M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S2	SPMX060204-75 F40M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S3	SPMX060204-75 F40M	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*
S11	SPMX060204-75 F40M	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
S12	SPMX060204-75 F40M	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
S13	SPMX060204-75 F40M	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
H5	SPMX060204-75 F40M	0,044 *0.0017*	0,055 *0.0022*	0,075 *0.0030*
H8	SPMX060204-75 F40M	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*
H11	SPMX060204-75 F40M	0,044 *0.0017*	0,055 *0.0022*	0,075 *0.0030*
H12	SPMX060204-75 F40M	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*
H21	SPMX060204-75 F40M	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.16 - SP06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			T25M		
	100%	20%	10%	100%	20%	10%
P1	190 *620*	270 *890*	295 *970*	210 *690*	295 *970*	325 *1075*
P2	185 *610*	260 *850*	290 *950*	205 *670*	290 *950*	320 *1050*
P3	160 *520*	230 *750*	255 *840*	175 *570*	250 *820*	280 *920*
P4	145 *475*	200 *660*	225 *740*	160 *520*	220 *720*	245 *800*
P5	140 *460*	195 *640*	215 *710*	150 *490*	215 *710*	235 *770*
P6	155 *510*	220 *720*	240 *790*	170 *560*	240 *790*	265 *870*
P7	145 *475*	205 *670*	225 *740*	160 *520*	225 *740*	250 *820*
P8	135 *445*	190 *620*	215 *710*	150 *490*	210 *690*	235 *770*
P11	140 *460*	200 *660*	220 *720*	155 *510*	220 *720*	240 *790*
P12	90 *295*	125 *410*	140 *460*	100 *330*	140 *460*	155 *510*
M1	150 *490*	210 *690*	235 *770*	165 *540*	230 *750*	255 *840*
M2	125 *410*	175 *570*	190 *620*	135 *445*	190 *620*	210 *690*
M3	100 *330*	140 *460*	155 *510*	110 *360*	155 *510*	170 *560*
M4	75 *245*	105 *345*	120 *395*	85 *280*	120 *395*	130 *425*
M5	65 *215*	90 *295*	100 *330*	70 *230*	100 *330*	110 *360*
K1	150 *490*	205 *670*	230 *750*	165 *540*	230 *750*	250 *820*
K2	130 *425*	185 *610*	200 *660*	145 *475*	205 *670*	225 *740*
K3	110 *360*	155 *510*	170 *560*	120 *395*	170 *560*	190 *620*
K4	105 *345*	150 *490*	165 *540*	115 *375*	165 *540*	180 *590*
K5	65 *215*	90 *295*	100 *330*	70 *230*	100 *330*	110 *360*
K6	95 *310*	130 *425*	145 *475*	100 *330*	145 *475*	160 *520*
K7	80 *260*	115 *375*	125 *410*	90 *295*	125 *410*	140 *460*
N1	1100 *3600*	1575 *5175*	1725 *5650*	— —	— —	— —
N2	445 *1450*	630 *2075*	700 *2300*	— —	— —	— —
N3	295 *970*	420 *1375*	465 *1525*	— —	— —	— —
N11	340 *1125*	480 *1575*	530 *1750*	— —	— —	— —
S1	36 *120*	50 *165*	55 *180*	— —	— —	— —
S2	29 *95*	40 *130*	44 *145*	— —	— —	— —
S3	25 *80*	35 *115*	39 *130*	— —	— —	— —
S11	50 *165*	70 *230*	80 *260*	— —	— —	— —
S12	42 *140*	60 *195*	65 *215*	— —	— —	— —
S13	24 *80*	34 *110*	38 *125*	— —	— —	— —
H5	30 *100*	42 *140*	46 *150*	— —	— —	— —
H8	32 *105*	44 *145*	49 *160*	— —	— —	— —
H11	38 *125*	55 *180*	60 *195*	— —	— —	— —
H12	37 *120*	50 *165*	55 *180*	— —	— —	— —
H21	32 *105*	44 *145*	49 *160*	— —	— —	— —

335.16 - SP07 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	20%	10%
P1	SPMX070304-75 F40M	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
P2	SPMX070304-75 F40M	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
P3	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,14 *0.0055*
P4	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P5	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
P6	SPMX070304-75 F40M	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
P7	SPMX070304-75 F40M	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
P8	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,14 *0.0055*
P11	SPMX070304-75 F40M	0,075 *0.0030*	0,095 *0.0038*	0,13 *0.0050*
P12	SPMX070304-75 F40M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M1	SPMX070304-75 F40M	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
M2	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
M3	SPMX070304-75 F40M	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*
M4	SPMX070304-75 F40M	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
M5	SPMX070304-75 F40M	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
K1	SPMX070304-75 F40M	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*
K2	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K3	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K4	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K5	SPMX070304-75 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
K6	SPMX070304-75 F40M	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*
K7	SPMX070304-75 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
N1	SPMX070304-75 F40M	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N2	SPMX070304-75 F40M	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N3	SPMX070304-75 F40M	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
N11	SPMX070304-75 F40M	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
S1	SPMX070304-75 F40M	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S2	SPMX070304-75 F40M	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
S3	SPMX070304-75 F40M	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*
S11	SPMX070304-75 F40M	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*
S12	SPMX070304-75 F40M	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*
S13	SPMX070304-75 F40M	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
H5	SPMX070304-75 F40M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H8	SPMX070304-75 F40M	0,040 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
H11	SPMX070304-75 F40M	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
H12	SPMX070304-75 F40M	0,040 *0.0016*	0,050 *0.0020*	0,070 *0.0028*
H21	SPMX070304-75 F40M	0,040 *0.0016*	0,050 *0.0020*	0,070 *0.0028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

335.16 - SP07 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			T25M		
	100%	20%	10%	100%	20%	10%
P1	175 *570*	250 *820*	275 *900*	195 *640*	275 *900*	305 *1000*
P2	170 *560*	240 *790*	270 *890*	190 *620*	265 *870*	295 *970*
P3	150 *490*	210 *690*	230 *750*	165 *540*	235 *770*	255 *840*
P4	130 *425*	185 *610*	210 *690*	145 *475*	205 *670*	230 *750*
P5	125 *410*	180 *590*	200 *660*	140 *460*	195 *640*	220 *720*
P6	145 *475*	205 *670*	225 *740*	160 *520*	225 *740*	245 *800*
P7	135 *445*	190 *620*	210 *690*	150 *490*	210 *690*	230 *750*
P8	125 *410*	180 *590*	195 *640*	140 *460*	195 *640*	215 *710*
P11	130 *425*	185 *610*	205 *670*	145 *475*	205 *670*	225 *740*
P12	85 *280*	120 *395*	130 *425*	90 *295*	130 *425*	145 *475*
M1	140 *460*	195 *640*	215 *710*	155 *510*	215 *710*	240 *790*
M2	115 *375*	160 *520*	180 *590*	125 *410*	175 *570*	195 *640*
M3	95 *310*	130 *425*	145 *475*	100 *330*	140 *460*	160 *520*
M4	70 *230*	100 *330*	110 *360*	80 *260*	110 *360*	120 *395*
M5	60 *195*	85 *280*	90 *295*	65 *215*	90 *295*	100 *330*
K1	135 *445*	190 *620*	215 *710*	150 *490*	210 *690*	235 *770*
K2	120 *395*	170 *560*	190 *620*	130 *425*	185 *610*	205 *670*
K3	100 *330*	145 *475*	160 *520*	110 *360*	160 *520*	175 *570*
K4	95 *310*	135 *445*	150 *490*	105 *345*	150 *490*	165 *540*
K5	60 *195*	85 *280*	90 *295*	65 *215*	90 *295*	100 *330*
K6	85 *280*	120 *395*	135 *445*	95 *310*	135 *445*	145 *475*
K7	75 *245*	105 *345*	120 *395*	85 *280*	115 *375*	130 *425*
N1	1000 *3275*	1425 *4675*	1600 *5250*	— —	— —	— —
N2	405 *1325*	570 *1875*	640 *2100*	— —	— —	— —
N3	270 *890*	385 *1275*	430 *1400*	— —	— —	— —
N11	310 *1025*	440 *1450*	490 *1600*	— —	— —	— —
S1	33 *110*	46 *150*	50 *165*	— —	— —	— —
S2	27 *90*	37 *120*	41 *135*	— —	— —	— —
S3	23 *75*	33 *110*	36 *120*	— —	— —	— —
S11	47 *155*	65 *215*	75 *245*	— —	— —	— —
S12	39 *130*	55 *180*	60 *195*	— —	— —	— —
S13	23 *75*	32 *105*	35 *115*	— —	— —	— —
H5	28 *90*	39 *130*	43 *140*	— —	— —	— —
H8	30 *100*	41 *135*	45 *150*	— —	— —	— —
H11	35 *115*	50 *165*	55 *180*	— —	— —	— —
H12	34 *110*	48 *155*	55 *180*	— —	— —	— —
H21	30 *100*	41 *135*	45 *150*	— —	— —	— —

335.16 -LNK – Insert selection – mm/*Inch*

SMG		f_z		
		100%	20%	10%
P1	LNKT080508PPTN-M06 F40M	0,11 *0.0044*	0,14 *0.0055*	0,19 *0.0075*
P2	LNKT080508PPTN-M06 F40M	0,11 *0.0044*	0,14 *0.0055*	0,19 *0.0075*
P3	LNKT080508PPTN-M06 F40M	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
P4	LNKT080508PPTN-M06 F40M	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*
P5	LNKT080508PPTN-M06 F40M	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
P6	LNKT080508PPTN-M06 F40M	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
P7	LNKT080508PPTN-M06 F40M	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
P8	LNKT080508PPTN-M06 MP3000	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*
P11	LNKT080508PPTN-M06 F40M	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
P12	LNKT080508PPTN-M06 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
M1	LNKT080508PPTN-M06 F40M	0,11 *0.0044*	0,14 *0.0055*	0,19 *0.0075*
M2	LNKT080508PPTN-M06 F40M	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
M3	LNKT080508PPTN-M06 F40M	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
M4	LNKT080508PPTN-M06 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
M5	LNKT080508PPTN-M06 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
K1	LNKT080508PPTN-M06 MK2050	0,11 *0.0044*	0,14 *0.0055*	0,19 *0.0075*
K2	LNKT080508PPTN-M06 MK2050	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
K3	LNKT080508PPTN-M06 MK2050	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
K4	LNKT080508PPTN-M06 MK2050	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
K5	LNKT080508PPTN-M06 MK2050	0,095 *0.0038*	0,12 *0.0048*	0,16 *0.0065*
K6	LNKT080508PPTN-M06 MK2050	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*
K7	LNKT080508PPTN-M06 MK2050	0,095 *0.0038*	0,12 *0.0048*	0,16 *0.0065*
N1	LNKT080508PPN-E05 H25	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
N2	LNKT080508PPN-E05 H25	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
N3	LNKT080508PPN-E05 H25	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
N11	LNKT080508PPN-E05 H25	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
S1	LNKT080508PPTN-M06 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
S2	LNKT080508PPTN-M06 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
S3	LNKT080508PPTN-M06 F40M	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*
S11	LNKT080508PPTN-M06 F40M	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
S12	LNKT080508PPTN-M06 F40M	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
S13	LNKT080508PPTN-M06 F40M	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
H5	LNKT080508PPTN-M06 MP3000	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
H8	LNKT080508PPTN-M06 MP3000	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
H11	LNKT080508PPTN-M06 F40M	0,070 *0.0028*	0,090 *0.0036*	0,12 *0.0048*
H12	LNKT080508PPTN-M06 F40M	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*
H21	LNKT080508PPTN-M06 MP3000	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

SECO

335.16 -LNK – Cutting data v_c = (m/min)/*(sf/min)*

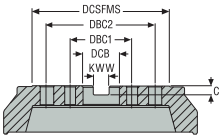
SMG	MP2501			MP3000			T350M			F40M			MK1500			MK2050			H25		
	100%	20%	10%	100%	20%	10%	100%	20%	10%	100%	20%	10%	100%	20%	10%	100%	20%	10%	100%	20%	10%
P1	200	285	315	190	270	300	175	250	275	155	215	240	—	—	—	200	280	310	—	—	—
	660	*940*	*1025*	*620*	*890*	*980*	*570*	*820*	*900*	*510*	*710*	*790*	—	—	—	*660*	*920*	*1025*	—	—	—
P2	195	275	305	185	265	290	170	240	265	150	210	230	—	—	—	195	275	300	—	—	—
	640	*900*	*1000*	*610*	*870*	*950*	*560*	*790*	*870*	*490*	*690*	*750*	—	—	—	*640*	*900*	*980*	—	—	—
P3	170	240	265	160	225	255	150	210	235	130	180	205	—	—	—	165	235	265	—	—	—
	560	*790*	*870*	*520*	*740*	*840*	*490*	*690*	*770*	*425*	*590*	*670*	—	—	—	*540*	*770*	*870*	—	—	—
P4	150	215	235	140	205	225	130	185	205	115	165	180	—	—	—	145	210	230	—	—	—
	490	*710*	*770*	*460*	*670*	*740*	*425*	*610*	*670*	*375*	*540*	*590*	—	—	—	*475*	*690*	*750*	—	—	—
P5	145	205	225	140	195	215	125	180	200	110	155	175	—	—	—	145	200	225	—	—	—
	475	*670*	*740*	*460*	*640*	*710*	*410*	*590*	*660*	*360*	*510*	*570*	—	—	—	*475*	*660*	*740*	—	—	—
P6	165	230	255	155	220	245	145	200	225	125	175	195	—	—	—	160	225	250	—	—	—
	540	*750*	*840*	*510*	*720*	*800*	*475*	*660*	*740*	*410*	*570*	*640*	—	—	—	*520*	*740*	*820*	—	—	—
P7	155	215	240	145	205	230	135	190	210	115	165	185	—	—	—	155	215	240	—	—	—
	510	*710*	*790*	*475*	*670*	*750*	*445*	*620*	*690*	*375*	*540*	*610*	—	—	—	*510*	*710*	*790*	—	—	—
P8	140	200	225	135	190	215	125	175	195	110	150	170	—	—	—	140	200	220	—	—	—
	460	*660*	*740*	*445*	*620*	*710*	*410*	*570*	*640*	*360*	*490*	*560*	—	—	—	*460*	*660*	*720*	—	—	—
P11	150	210	235	145	200	220	130	185	205	115	160	180	—	—	—	150	210	230	—	—	—
	490	*690*	*770*	*475*	*660*	*720*	*425*	*610*	*670*	*375*	*520*	*590*	—	—	—	*490*	*690*	*750*	—	—	—
P12	95	135	150	90	130	140	85	120	130	75	105	115	—	—	—	95	135	150	—	—	—
	310	*445*	*490*	*295*	*425*	*460*	*280*	*395*	*425*	*245*	*345*	*375*	—	—	—	*310*	*445*	*490*	—	—	—
M1	140	200	220	140	195	215	130	185	205	120	170	185	—	—	—	—	—	—	—	—	—
	460	*660*	*720*	*460*	*640*	*710*	*425*	*610*	*670*	*395*	*560*	*610*	—	—	—	—	—	—	—	—	—
M2	115	165	180	115	160	180	110	155	170	100	140	155	—	—	—	—	—	—	—	—	—
	375	*540*	*590*	*375*	*520*	*590*	*360*	*510*	*560*	*330*	*460*	*510*	—	—	—	—	—	—	—	—	—
M3	95	135	145	90	130	145	85	125	135	80	115	125	—	—	—	—	—	—	—	—	—
	310	*445*	*475*	*295*	*425*	*475*	*280*	*410*	*445*	*260*	*375*	*410*	—	—	—	—	—	—	—	—	—
M4	70	100	115	70	100	110	65	95	105	60	85	95	—	—	—	—	—	—	—	—	—
	230	*330*	*375*	*230*	*330*	*360*	*215*	*310*	*345*	*195*	*280*	*310*	—	—	—	—	—	—	—	—	—
M5	60	85	95	60	85	95	55	80	90	50	75	80	—	—	—	—	—	—	—	—	—
	195	*280*	*310*	*195*	*280*	*310*	*180*	*260*	*295*	*165*	*245*	*260*	—	—	—	—	—	—	—	—	—
K1	155	220	240	125	175	195	135	190	210	120	165	185	220	310	345	210	295	325	—	—	—
	510	*720*	*790*	*410*	*570*	*640*	*445*	*620*	*690*	*395*	*540*	*610*	*720*	*1025*	*1125*	*690*	*970*	*1075*	—	—	—
K2	140	195	215	110	155	170	120	170	190	105	150	165	195	275	305	185	260	290	—	—	—
	460	*640*	*710*	*360*	*510*	*560*	*395*	*560*	*620*	*345*	*490*	*540*	*640*	*900*	*1000*	*610*	*850*	*950*	—	—	—
K3	115	165	180	95	130	145	100	145	160	90	125	140	165	235	260	160	220	245	—	—	—
	375	*540*	*590*	*310*	*425*	*475*	*330*	*475*	*520*	*295*	*410*	*460*	*540*	*770*	*850*	*520*	*720*	*800*	—	—	—
K4	110	155	175	90	125	140	100	135	150	85	120	135	160	225	250	150	210	235	—	—	—
	360	*510*	*570*	*295*	*410*	*460*	*330*	*445*	*490*	*280*	*395*	*445*	*520*	*740*	*820*	*490*	*690*	*770*	—	—	—
K5	65	95	105	55	75	85	60	85	90	50	70	80	95	135	150	90	130	140	—	—	—
	215	*310*	*345*	*180*	*245*	*280*	*195*	*280*	*295*	*165*	*230*	*260*	*310*	*445*	*490*	*295*	*425*	*460*	—	—	—
K6	100	140	155	80	110	125	85	120	135	75	105	115	140	195	220	135	185	205	—	—	—
	330	*460*	*510*	*260*	*360*	*410*	*280*	*395*	*445*	*245*	*345*	*375*	*460*	*640*	*720*	*445*	*610*	*670*	—	—	—
K7	85	120	135	70	95	110	75	105	120	65	95	100	125	175	190	115	165	180	—	—	—
	280	*395*	*445*	*230*	*310*	*360*	*245*	*345*	*395*	*215*	*310*	*330*	*410*	*570*	*620*	*375*	*540*	*590*	—	—	—
N1	—	—	—	1075	1550	1700	—	—	—	860	1225	1375	—	—	—	—	—	—	900	1275	1400
	—	—	—	*3525*	*5075*	*5575*	—	—	—	*2825*	*4025*	*4500*	—	—	—	—	—	—	*2950*	*4175*	*4600*
N2	—	—	—	430	620	690	—	—	—	345	500	550	—	—	—	—	—	—	365	520	570
	—	—	—	*1400*	*2025*	*2275*	—	—	—	*1125*	*1650*	*1800*	—	—	—	—	—	—	*1200*	*1700*	*1875*
N3	—	—	—	290	415	460	—	—	—	230	330	370	—	—	—	—	—	—	240	345	380
	—	—	—	*950*	*1350*	*1500*	—	—	—	*750*	*1075*	*1225*	—	—	—	—	—	—	*790*	*1125*	*1250*
N11	—	—	—	330	475	530	—	—	—	265	380	420	—	—	—	—	—	—	275	395	435
	—	—	—	*1075*	*1550*	*1750*	—	—	—	*870*	*1250*	*1375*	—	—	—	—	—	—	*900*	*1300*	*1425*
S1	35	50	55	33	47	50	31	45	50	29	41	45	—	—	—	—	—	—	—	—	—
	115	*165*	*180*	*110*	*155*	*165*	*100*	*150*	*165*	*95*	*135*	*150*	—	—	—	—	—	—	—	—	—
S2	28	40	44	27	38	42	25	36	40	23	33	36	—	—	—	—	—	—	—	—	—
	90	*130*	*145*	*90*	*125*	*140*	*80*	*120*	*130*	*75*	*110*	*120*	—	—	—	—	—	—	—	—	—
S3	25	35	39	23	33	37	22	31	35	20	29	32	—	—	—	—	—	—	—	—	—
	80	*115*	*130*	*75*	*110*	*120*	*70*	*100*	*115*	*65*	*95*	*105*	—	—	—	—	—	—	—	—	—
S11	49	70	75	46	65	75	44	65	70	40	55	65	—	—	—	—	—	—	—	—	—
	160	*230*	*245*	*150*	*215*	*245*	*145*	*215*	*230*	*130*	*180*	*215*	—	—	—	—	—	—	—	—	—
S12	41	60	65	39	55	60	37	55	60	34	48	55	—	—	—	—	—	—	—	—	—
	135	*195*	*215*	*130*	*180*	*195*	*120*	*180*	*195*	*110*	*155*	*180*	—	—	—	—	—	—	—	—	—
S13	24	34	38	23	32	36	21	31	34	20	28	31	—	—	—	—	—	—	—	—	—
	80	*110*	*125*	*75*	*105*	*120*	*70*	*100*	*110*	*65*	*90*	*100*	—	—	—	—	—	—	—	—	—
H5	29	41	45	26	36	40	28	39	43	24	34	38	—	—	—	—	—	—	—	—	—
	95	*135*	*150*	*85*	*120*	*130*	*90*	*130*	*140*	*80*	*110*	*125*	—	—	—	—	—	—	—	—	—
H8	31	43	48	27	38	42	30	41	46	26	36	40	—	—	—	—	—	—	—	—	—
	100	*140*	*155*	*90*	*125*	*140*	*100*	*135*	*150*	*85*	*120*	*130*	—	—	—	—	—	—	—	—	—
H11	37	50	55	33	46	50	36	50	55	31	44	48	—	—	—	—	—	—	—	—	—
	120	*165*	*180*	*110*	*150*	*165*	*120*	*165*	*180*	*100*	*145*	*155*	—	—	—	—	—	—	—	—	—
H12	36	50	55	31	44	49	34	48	55	30	42	47	—	—	—	—	—	—	—	—	—
	120	*165*	*180*	*100*	*145*	*160*	*110*	*155*	*180*	*100*	*140*	*155*	—	—	—	—	—	—	—	—	—
H21	31	43	48	27	38	42	30	41	46	26	36	40	—	—	—	—	—	—	—	—	—
	100	*140*	*155*	*90*	*125*	*140*	*100*	*135*	*150*	*85*	*120*	*130*	—	—	—	—	—	—	—	—	—

Code keys metric and *inch*

R	217	.	21	-	12	25	.	RE	-	LP06	.	4	A
1	2		3		4	5		6		7		8	9

R	217	.	21	-	01.00	0	-	LP06	.	3	A
1	2		3		5	6		7		8	9

1.	2.	3.
R = Right hand rotation Cx = For Seco-Capto	217 = With shank 220 = For arbor	Cutter system
4. (Not for inch designation)	**5.**	**6.**
Connecting diameter	Cutter diameter	Shank type .RE for Combimaster .0 for Cylindrical .3 for Weldon .3S for Seco Weldon
7.	**8.**	**9.**
Insert type and size	No. of teeth	A = Through coolant supply E = Solid carbide shank



Dimensions in mm					
DCB	DCSFMS	DBC1	DBC2	KWW	C
16	30-35	–	–	8,4	5,6
22	42-47	–	–	10,4	6.3
27	48-62	–	–	12,4	7
32	60-90	–	–	14,4	8
40	90-130	66,7	–	16,4	9
60	130-270	101,6	177,8	25,7	14

Dimensions in inch					
DCB	DCSFMS	DBC1	DBC2	KWW	C
0.500	*1.181 - 1.378*			*0.258*	*0.165*
0.750	*1.378 - 1.850*	–	–	*0.321*	*0.193*
1.000	*1.803 - 2.441*	–	–	*0.382*	*0.224*
1.250	*2.250 - 3.031*	–	–	*0.508*	*0.287*
1.500	*2.750 - 3.543*	–	–	*0.630*	*0.382*
2.000	*4.331*	–	–	*0.756*	*0.445*
2.500	*5.118 - 6.299 (8.858)*	*4.000*	*(7.000)*	*1.000*	*0.551*

Selection – Metric

Insert	a_p max	Material suitability									
		P	M	K	N	S	H				
LP05	0,65	■	■	■	□	■	■	■	□	■	■
LP06	0,8	■	■	■	■	■	■	■	□	■	■
LP09	1,8	■	■	■	□	■	□	■	■	■	■
LO06	0,9	■	◪	■	–	■	■	■	◪	◪	◪
218.19-080	0,6	■	◪	■	■	◪	■	■	◪	■	■
218.19-100	0,7	■	◪	■	■	◪	■	■	◪	■	■
218.19-125	1,0	■	◪	■	■	◪	■	◪	■	■	■
218.19-160	1,8	■	◪	■	■	◪	□	-	■	■	■
218.21-230	1,8	■	■	■	-	◪	◪	-	■	□	■
SCET	1,5	■	■	■	-	■	-	-	■	□	■
ON09	2,0	■	-	■	-	-	-	-	■	-	-

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Metric

Insert	No. of cutting edges	Application	Cutter diameter (mm) available with effective number of teeth																									See page
			12	14	16	18	20	25	27	32	35	40	42	50	52	63	66	80	84	88	100	108	125	133	160	168	208	
LP05	2				2		3																					469
			2	2	3	3	4																					
LP06	2										4																	476
							2	3	3	4	5	6																
					2	2	3	4		5	6	7																
LP09	2									3				5														483
								2		4	4	4	4	6	5	6	6	7										
												5	5	7	7	8	8	9	7		10							
LO06	4											5																491
							2	3	3	4	5	6																
								4		5	6	7	7	8	8	9												
218.19-080	3				2																							499
218.19-100	3							2																				
							2	3																				
218.19-125	3									2																		
								2		3	3	4																
218.19-160	3													3		4												
														4	4	5	5	6	6		7							
										2		3		5	5	6	6	7			9							
218.21-230	6													4		5		6	6		7		9		10			517
												3	3	5	5	6	6	7	8		9							
SCET	4															4	4	5	5		5							523
														4	4	5		6	6		7		6		7			
														5	5	6	6	7			8							
ON09	16																	6			7		8		10			528

x — x indicates number of teeth (first choice)

x — x indicates number of teeth

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

Selection – Inch

Insert	a_p max	Material suitability									
		P	M	K	N	S	H				
LP05	0.020	■	■	■	□	■	■	■	□	■	■
LP06	0.031	■	■	■	■	■	■	■	□	■	■
LP09	0.071	■	■	■	□	■	□	■	■	■	■
LO06	0.031	■	◪	■	–	■	■	■	◪	◪	◪
218.19-080	0.025	■	◪	■	■	◪	■	■	◪	■	■
218.19-100	0,028	■	◪	■	■	◪	■	■	◪	■	■
218.19-125	0.039	■	◪	■	■	◪	■	◪	■	■	■
218.19-160	0.071	■	◪	■	■	◪	□	-	■	■	■
218.21-230	0.071	■	■	■	-	◪	◪	-	■	□	■
SCET	0.059	■	■	■	-	■	-	-	■	□	■
ON09	0.079	■	-	■	-	-	-	-	■	-	-

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Inch

Insert	No. of cutting edges	Application	Cutter diameter available (inch)/number of teeth													See page
			0.50	0.625	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	
LP05	2			2	3											469
			2	3	4											
LP06	2				2	3	4	6								476
				2	3	4	5	7								
LP09	2						4	5	6	6	6	8	9			483
									7	8	8		10			
LO06	4					3	4	5								491
						4	5	6	8	9						
218.19-080	3			2												499
218.19-100	3				2	3										
218.19-125	3					2	3	4								
218.19-160	3						2	3	3	5	6		7			
									4	6	7		9			
									5							
218.21-230	6							3	4	5	5		7			517
									5	6	6	8	9			
SCET	4									4	5		5			523
									4	6	6		8			
									5	6						
ON09	16										6		7	8	10	528

x	x indicates number of teeth (first choice)
x	x indicates number of teeth

Troubleshooter for unstable fixturing and/or unstable conditions

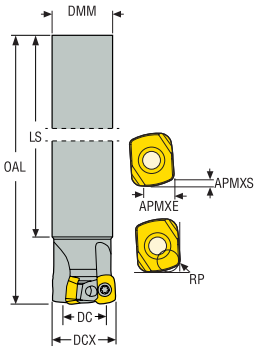
Basic choice

R217/220.21 HIGH FEED 2

Highfeed 2 for LP05/06/09 insert types, 2-cutting edge, single sided positive inserts.
The inserts have modern geometries that provide the lowest possible cutting forces in all materials. These low forces lead to superior tool life.

- Cutter range 12-100 mm (.5 - 4 inch)
- Max depths of cut by insert type: LP05/0.65 mm, LP06/0.8 mm, LP09/1.8 mm
- First choice for ISO M & S materials in small-to-medium size machines
- Excellent solution for plunge milling

R217.21-LP05 – Metric



- For insert selection and cutting data recommendations, see page(s) 473-475
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm		kg	
R217.21-1012.0-LP05.2A	02952509	Cylindrical	5,4	12,0	2	0,65	3,5	10,0	84,0	100,0	1,5	3,9	17,4	22,0	45000	0,1	LP..05
R217.21-1214.0-LP05.2A	02881032	Cylindrical	7,4	14,0	2	0,65	3,5	12,0	104,0	120,0	1,5	3,5	21,4	26,0	42000	0,1	LP..05
R217.21-1416.0-LP05.2A	02881033	Cylindrical	9,4	16,0	2	0,65	3,5	14,0	132,0	150,0	1,5	3,0	25,4	30,0	39000	0,2	LP..05
R217.21-1618.0-LP05.3A	02881034	Cylindrical	11,4	18,0	3	0,65	3,5	16,0	142,0	160,0	1,5	2,2	29,4	34,0	37000	0,3	LP..05
R217.21-1820.0-LP05.3A	02881035	Cylindrical	13,4	20,0	3	0,65	3,5	18,0	142,0	160,0	1,5	1,9	33,4	38,0	35000	0,3	LP..05

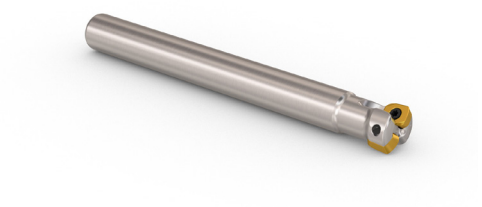
Spare Parts

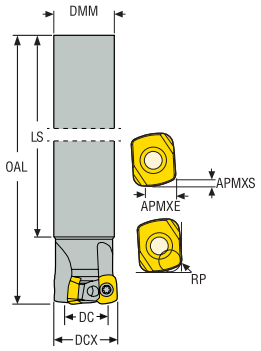
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-1012	C02005-T06P	T00-06P05	0.5NM
R217.21-1214-1820	C02053-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-LP05 – Inch





- For insert selection and cutting data recommendations, see page(s) 473-475
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

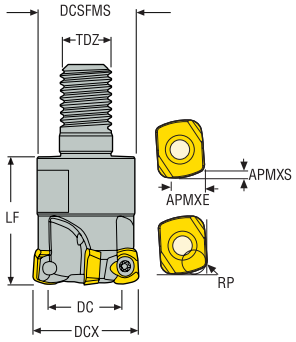
Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.21-00.500-0-LP05-2A	02881043	Cylindrical	0.240	0.500	2	0.026	0.138	0.500	4.370	5.000	0.059	5,4	0.740	0.921	45000	0.440	LP..05
R217.21-00.625-0-LP05-2A	02881044	Cylindrical	0.362	0.625	2	0.026	0.138	0.625	5.000	6.000	0.059	3,0	0.987	1.171	39000	0.440	LP..05
R217.21-00.750-0-LP05-3A	02881045	Cylindrical	0.488	0.750	3	0.026	0.138	0.750	5.520	6.500	0.059	1,9	1.238	1.421	35000	0.750	LP..05

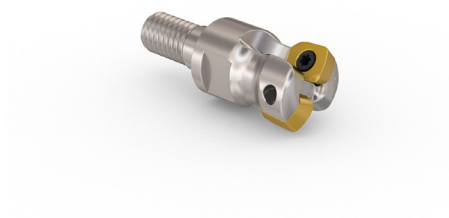
Spare Parts / Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-0.500	C02005-T06P	T00-06P05	4.4IN.LBS
R217.21-0.625-0.750	C02053-T06P	T00-06P05	4.4IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-LP05 – Metric





- For insert selection and cutting data recommendations, see page(s) 473-475
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	TDZ	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm		mm	mm	mm		mm	mm	kg		
R217.21-0612.RE-LP05.2A	02952506	Combimaster	5,4	12,0	2	0,65	3,5	M6	11,0	18,0	1,5	3,9	17,4	22,0	0,1	45000	LP..05
R217.21-0812.RE-LP05.2A	02952507	Combimaster	5,4	12,0	2	0,65	3,5	M8	13,5	20,0	1,5	3,9	17,4	22,0	0,1	45000	LP..05
R217.21-0614.RE-LP05.2A	02881029	Combimaster	7,4	14,0	2	0,65	3,5	M6	11,0	18,0	1,5	3,5	21,4	26,0	0,1	42000	LP..05
R217.21-0814.RE-LP05.2A	02952508	Combimaster	7,4	14,0	2	0,65	3,5	M8	13,5	20,0	1,5	3,5	21,4	26,0	0,1	42000	LP..05
R217.21-0816.RE-LP05.3A	02881030	Combimaster	9,4	16,0	3	0,65	3,5	M8	13,5	20,0	1,5	3,0	25,4	30,0	0,1	39000	LP..05
R217.21-1020.RE-LP05.4A	02881031	Combimaster	13,4	20,0	4	0,65	3,5	M10	18,5	23,0	1,5	1,9	33,4	38,0	0,1	35000	LP..05

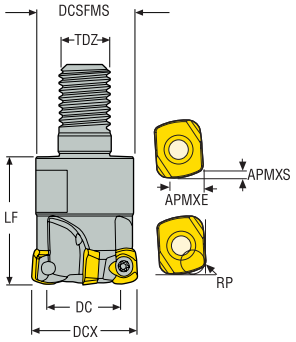
For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts / Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-.. Ø12	C02005-T06P	T00-06P05	0.5NM
R217.21-.. Ø14-20	C02053-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-LP05 – Inch



- For insert selection and cutting data recommendations, see page(s) 473-475
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	TDZ	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.21-00.500-06RE-LP05-2A	02881039	Combimaster	0.240	0.500	2	0.026	0.138	M6	0.433	0.709	0.059	3,9	0.740	0.921	0.220	45000	LP..05
R217.21-00.500-08RE-LP05-2A	02952518	Combimaster	0.240	0.500	2	0.026	0.138	M8	0.531	0.787	0.059	3,9	0.740	0.921	0.220	45000	LP..05
R217.21-00.625-08RE-LP05-3A	02881040	Combimaster	0.362	0.625	3	0.026	0.138	M8	0.531	0.787	0.059	3,0	0.987	1.171	0.220	39000	LP..05
R217.21-00.750-10RE-LP05-4A	02881041	Combimaster	0.488	0.750	4	0.026	0.138	M10	0.728	0.906	0.059	1,9	1.238	1.421	0.220	35000	LP..05

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-0.500-00.625	C02005-T06P	T00-06P05	4.4IN.LBS
R217.21-0.750	C02053-T06P	T00-06P05	4.4IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-LP05 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	LPHT05T210TR-ME04 T350M	0,60 *0.024*	0,44 *0.017*	0,44 *0.017*	0,55 *0.022*
P2	LPHT05T210TR-ME04 T350M	0,60 *0.024*	0,44 *0.017*	0,44 *0.017*	0,55 *0.022*
P3	LPHT05T210TR-ME04 T350M	0,60 *0.024*	0,42 *0.017*	0,42 *0.017*	0,50 *0.020*
P4	LPKT05T210TR-M05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
P5	LPKT05T210TR-M05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
P6	LPKT05T210TR-M05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
P7	LPKT05T210TR-M05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
P8	LPKT05T210TR-M05 MS2500	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P11	LPKT05T210TR-M05 MS2500	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
P12	LPKT05T210TR-M05 MS2500	0,46 *0.018*	0,40 *0.016*	0,40 *0.016*	0,48 *0.019*
M1	LPKT05T210TR-M05 MS2050	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
M2	LPKT05T210TR-M05 MS2050	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
M3	LPKT05T210TR-M05 MS2050	0,46 *0.018*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
M4	LPHT05T210TR-ME04 T350M	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,42 *0.017*
M5	LPHT05T210TR-ME04 T350M	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,42 *0.017*
K1	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
K2	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
K3	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
K4	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
K5	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
K6	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
K7	LPKW05T210TR-MD05 MP2501	0,60 *0.024*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
N1	LPHT05T210TR-ME04 F40M	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
N2	LPHT05T210TR-ME04 F40M	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
N3	LPHT05T210TR-ME04 F40M	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
N11	LPHT05T210TR-ME04 F40M	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
S1	LPHT05T210TR-ME04 F40M	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,42 *0.017*
S2	LPHT05T210TR-ME04 F40M	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,42 *0.017*
S3	LPKT05T210TR-M05 F40M	0,36 *0.014*	0,42 *0.017*	0,42 *0.017*	0,50 *0.020*
S11	LPHT05T210TR-ME04 MS2050	0,40 *0.016*	0,40 *0.016*	0,40 *0.016*	0,48 *0.019*
S12	LPHT05T210TR-ME04 MS2050	0,40 *0.016*	0,40 *0.016*	0,40 *0.016*	0,48 *0.019*
S13	LPHT05T210TR-ME04 MS2050	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,42 *0.017*
H5	LPHW05T210TR-MD05 MH1000	0,36 *0.014*	0,38 *0.015*	0,38 *0.015*	0,44 *0.017*
H8	LPHW05T210TR-MD05 MH1000	0,32 *0.013*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
H11	LPKT05T210TR-M05 MP2501	0,36 *0.014*	0,38 *0.015*	0,38 *0.015*	0,44 *0.017*
H12	LPKT05T210TR-M05 MP2501	0,32 *0.013*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*
H21	LPHW05T210TR-MD05 MH1000	0,32 *0.013*	0,28 *0.011*	0,28 *0.011*	0,34 *0.013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

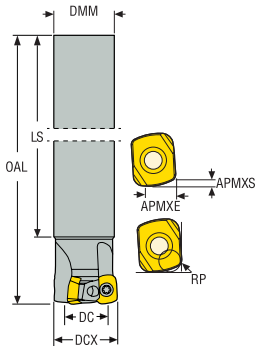
R217.21-LP05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2050			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	325 *1075*	385 *1275*	450 *1475*	330 *1075*	395 *1300*	460 *1500*	315 *1025*	375 *1225*	435 *1425*	315 *1025*	375 *1225*	440 *1450*	250 *820*	300 *980*	350 *1150*
P2	320 *1050*	375 *1225*	440 *1450*	325 *1075*	385 *1275*	445 *1450*	305 *1000*	365 *1200*	425 *1400*	310 *1025*	365 *1200*	425 *1400*	245 *800*	290 *950*	340 *1125*
P3	275 *900*	325 *1075*	385 *1275*	280 *920*	330 *1075*	390 *1275*	265 *870*	310 *1025*	370 *1225*	270 *890*	320 *1050*	375 *1225*	210 *690*	250 *820*	295 *970*
P4	245 *800*	290 *950*	340 *1125*	250 *820*	300 *980*	345 *1125*	240 *790*	280 *920*	325 *1075*	235 *770*	280 *920*	330 *1075*	190 *620*	225 *740*	260 *850*
P5	235 *770*	280 *920*	325 *1075*	240 *790*	285 *940*	330 *1075*	225 *740*	270 *890*	310 *1025*	230 *750*	270 *890*	315 *1025*	180 *590*	215 *710*	250 *820*
P6	265 *870*	315 *1025*	370 *1225*	270 *890*	320 *1050*	375 *1225*	255 *840*	300 *980*	355 *1175*	255 *840*	305 *1000*	355 *1175*	205 *670*	240 *790*	285 *940*
P7	250 *820*	295 *970*	350 *1150*	255 *840*	300 *980*	355 *1175*	240 *790*	285 *940*	335 *1100*	240 *790*	285 *940*	335 *1100*	195 *640*	230 *750*	270 *890*
P8	230 *750*	270 *890*	325 *1075*	235 *770*	275 *900*	330 *1075*	220 *720*	265 *870*	310 *1025*	225 *740*	270 *890*	315 *1025*	175 *570*	210 *690*	250 *820*
P11	240 *790*	285 *940*	340 *1125*	245 *800*	295 *970*	345 *1125*	235 *770*	275 *900*	325 *1075*	235 *770*	280 *920*	325 *1075*	185 *610*	220 *720*	260 *850*
P12	155 *510*	185 *610*	215 *710*	160 *520*	185 *610*	220 *720*	150 *490*	175 *570*	210 *690*	150 *490*	175 *570*	210 *690*	120 *395*	140 *460*	165 *540*
M1	230 *750*	270 *890*	315 *1025*	235 *770*	275 *900*	320 *1050*	230 *750*	270 *890*	315 *1025*	240 *790*	280 *920*	330 *1075*	200 *660*	235 *770*	275 *900*
M2	190 *620*	225 *740*	260 *850*	195 *640*	230 *750*	265 *870*	190 *620*	225 *740*	260 *850*	195 *640*	235 *770*	270 *890*	165 *540*	195 *640*	225 *740*
M3	150 *490*	180 *590*	210 *690*	155 *510*	180 *590*	215 *710*	155 *510*	180 *590*	210 *690*	160 *520*	185 *610*	220 *720*	130 *425*	155 *510*	180 *590*
M4	120 *395*	140 *460*	160 *520*	120 *395*	140 *460*	165 *540*	120 *395*	140 *460*	160 *520*	120 *395*	140 *460*	170 *560*	100 *330*	120 *395*	140 *460*
M5	100 *330*	115 *375*	135 *445*	100 *330*	120 *395*	135 *445*	100 *330*	115 *375*	135 *445*	100 *330*	120 *395*	140 *460*	85 *280*	100 *330*	115 *375*
K1	250 *820*	300 *980*	345 *1125*	255 *840*	305 *1000*	355 *1175*	245 *800*	290 *950*	335 *1100*	— —	— —	— —	195 *640*	230 *750*	270 *890*
K2	225 *740*	265 *870*	305 *1000*	230 *750*	270 *890*	310 *1025*	215 *710*	255 *840*	295 *970*	— —	— —	— —	170 *560*	205 *670*	235 *770*
K3	190 *620*	225 *740*	260 *850*	195 *640*	230 *750*	265 *870*	180 *590*	215 *710*	250 *820*	— —	— —	— —	145 *475*	175 *570*	200 *660*
K4	180 *590*	215 *710*	250 *820*	185 *610*	220 *720*	250 *820*	175 *570*	205 *670*	240 *790*	— —	— —	— —	140 *460*	165 *540*	190 *620*
K5	110 *360*	130 *425*	155 *510*	110 *360*	130 *425*	155 *510*	105 *345*	125 *410*	150 *490*	— —	— —	— —	85 *280*	100 *330*	120 *395*
K6	160 *520*	190 *620*	220 *720*	160 *520*	190 *620*	220 *720*	155 *510*	180 *590*	210 *690*	— —	— —	— —	125 *410*	145 *475*	170 *560*
K7	140 *460*	165 *540*	195 *640*	145 *475*	170 *560*	200 *660*	135 *445*	160 *520*	190 *620*	— —	— —	— —	110 *360*	130 *425*	150 *490*
N1	— —	— —	— —	— —	— —	— —	1800 *5900*	2125 *6975*	2475 *8125*	— —	— —	— —	1450 *4750*	1700 *5575*	1975 *6475*
N2	— —	— —	— —	— —	— —	— —	730 *2400*	860 *2825*	1000 *3275*	— —	— —	— —	580 *1900*	690 *2275*	800 *2625*
N3	— —	— —	— —	— —	— —	— —	485 *1600*	570 *1875*	670 *2200*	— —	— —	— —	390 *1275*	460 *1500*	530 *1750*
N11	— —	— —	— —	— —	— —	— —	550 *1800*	660 *2175*	760 *2500*	— —	— —	— —	445 *1450*	530 *1750*	610 *2000*
S1	60 *195*	65 *215*	80 *260*	60 *195*	70 *230*	80 *260*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	80 *260*	48 *155*	55 *180*	65 *215*
S2	46 *150*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	45 *150*	50 *165*	60 *195*	46 *150*	55 *180*	65 *215*	39 *130*	45 *150*	50 *165*
S3	40 *130*	47 *155*	55 *180*	41 *135*	48 *155*	55 *180*	39 *130*	45 *150*	55 *180*	40 *130*	47 *155*	55 *180*	34 *110*	39 *130*	46 *150*
S11	80 *260*	95 *310*	110 *360*	80 *260*	95 *310*	110 *360*	75 *245*	90 *295*	105 *345*	80 *260*	95 *310*	110 *360*	65 *215*	80 *260*	90 *295*
S12	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	80 *260*	55 *180*	60 *195*	75 *245*	55 *180*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*
S13	32 *105*	38 *125*	44 *145*	33 *110*	39 *130*	45 *150*	31 *100*	36 *120*	42 *140*	32 *105*	37 *120*	44 *145*	27 *90*	31 *100*	37 *120*
H5	49 *160*	55 *180*	65 *215*	50 *165*	60 *195*	70 *230*	49 *160*	55 *180*	65 *215*	50 *165*	60 *195*	70 *230*	41 *135*	48 *155*	55 *180*
H8	50 *165*	60 *195*	70 *230*	55 *180*	60 *195*	75 *245*	50 *165*	60 *195*	70 *230*	55 *180*	65 *215*	75 *245*	45 *150*	50 *165*	60 *195*
H11	60 *195*	70 *230*	85 *280*	65 *215*	75 *245*	85 *280*	60 *195*	70 *230*	85 *280*	65 *215*	75 *245*	90 *295*	55 *180*	60 *195*	75 *245*
H12	105 *345*	120 *395*	140 *460*	105 *345*	125 *410*	145 *475*	100 *330*	115 *375*	135 *445*	100 *330*	115 *375*	135 *445*	80 *260*	95 *310*	110 *360*
H21	50 *165*	60 *195*	70 *230*	55 *180*	60 *195*	75 *245*	50 *165*	60 *195*	70 *230*	55 *180*	65 *215*	75 *245*	45 *150*	50 *165*	60 *195*

R217.21-LP05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500			MS2050			MS2500			MH1000		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	225 *740*	265 *870*	310 *1025*	275 *900*	330 *1075*	380 *1250*	365 *1200*	430 *1400*	500 *1650*	— —	— —	— —
P2	220 *720*	260 *850*	300 *980*	270 *890*	320 *1050*	370 *1225*	355 *1175*	420 *1375*	485 *1600*	— —	— —	— —
P3	190 *620*	225 *740*	265 *870*	230 *750*	275 *900*	325 *1075*	305 *1000*	360 *1175*	425 *1400*	— —	— —	— —
P4	165 *540*	200 *660*	235 *770*	210 *690*	250 *820*	285 *940*	275 *900*	325 *1075*	375 *1225*	— —	— —	— —
P5	160 *520*	190 *620*	225 *740*	200 *660*	235 *770*	275 *900*	260 *850*	310 *1025*	360 *1175*	— —	— —	— —
P6	180 *590*	215 *710*	250 *820*	225 *740*	265 *870*	315 *1025*	295 *970*	350 *1150*	410 *1350*	— —	— —	— —
P7	170 *560*	200 *660*	235 *770*	210 *690*	250 *820*	295 *970*	275 *900*	330 *1075*	390 *1275*	— —	— —	— —
P8	160 *520*	190 *620*	225 *740*	195 *640*	230 *750*	275 *900*	255 *840*	305 *1000*	360 *1175*	— —	— —	— —
P11	165 *540*	195 *640*	230 *750*	205 *670*	245 *800*	290 *950*	270 *890*	320 *1050*	375 *1225*	— —	— —	— —
P12	105 *345*	125 *410*	145 *475*	130 *425*	155 *510*	185 *610*	175 *570*	205 *670*	240 *790*	— —	— —	— —
M1	185 *610*	220 *720*	260 *850*	215 *710*	260 *850*	300 *980*	255 *840*	300 *980*	350 *1150*	— —	— —	— —
M2	155 *510*	185 *610*	215 *710*	180 *590*	215 *710*	245 *800*	210 *690*	250 *820*	285 *940*	— —	— —	— —
M3	125 *410*	145 *475*	170 *560*	145 *475*	170 *560*	200 *660*	170 *560*	200 *660*	235 *770*	— —	— —	— —
M4	95 *310*	110 *360*	130 *425*	115 *375*	130 *425*	155 *510*	130 *425*	155 *510*	180 *590*	— —	— —	— —
M5	80 *260*	95 *310*	110 *360*	95 *310*	110 *360*	130 *425*	110 *360*	130 *425*	150 *490*	— —	— —	— —
K1	— —	— —	— —	— —	— —	— —	— —	— —	— —	260 *850*	310 *1025*	360 *1175*
K2	— —	— —	— —	— —	— —	— —	— —	— —	— —	230 *750*	275 *900*	315 *1025*
K3	— —	— —	— —	— —	— —	— —	— —	— —	— —	195 *640*	230 *750*	270 *890*
K4	— —	— —	— —	— —	— —	— —	— —	— —	— —	185 *610*	220 *720*	255 *840*
K5	— —	— —	— —	— —	— —	— —	— —	— —	— —	115 *375*	135 *445*	160 *520*
K6	— —	— —	— —	— —	— —	— —	— —	— —	— —	165 *540*	195 *640*	225 *740*
K7	— —	— —	— —	— —	— —	— —	— —	— —	— —	145 *475*	170 *560*	205 *670*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	29 *95*	34 *110*	40 *130*	55 *180*	60 *195*	70 *230*	65 *215*	75 *245*	85 *280*	— —	— —	— —
S2	24 *80*	27 *90*	32 *105*	42 *140*	49 *160*	60 *195*	50 *165*	60 *195*	70 *230*	— —	— —	— —
S3	21 *70*	24 *80*	28 *90*	37 *120*	43 *140*	50 *165*	45 *150*	50 *165*	60 *195*	— —	— —	— —
S11	41 *135*	48 *155*	55 *180*	75 *245*	85 *280*	100 *330*	90 *295*	105 *345*	120 *395*	— —	— —	— —
S12	38 *125*	44 *145*	50 *165*	50 *165*	60 *195*	70 *230*	60 *195*	70 *230*	85 *280*	— —	— —	— —
S13	22 *70*	26 *85*	30 *100*	30 *100*	35 *115*	40 *130*	36 *120*	42 *140*	49 *160*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	65 *215*	75 *245*
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	60 *195*	70 *230*	80 *260*
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	70 *230*	85 *280*	100 *330*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	105 *345*	125 *410*	145 *475*
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	60 *195*	70 *230*	80 *260*

R217.21-LP06 – Metric



- For insert selection and cutting data recommendations, see page(s) 480-482
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm		kg	
R217.21-1416.0-LP06.2A	02789713	Cylindrical	7,5	16,0	2	0,8	4,5	14,0	132,0	150,0	1,8	5,0	23,5	30,0	39000	0,2	LP..06
R217.21-1618.0-LP06.2A	02789715	Cylindrical	9,5	18,0	2	0,8	4,5	16,0	142,0	160,0	1,8	3,5	27,5	34,0	37000	0,4	LP..06
R217.21-1820.0-LP06.2A	02789717	Cylindrical	11,6	20,0	2	0,8	4,5	18,0	142,0	160,0	1,8	3,0	31,6	38,0	35000	0,4	LP..06
R217.21-2525.0-LP06.3A	02789720	Cylindrical	16,5	25,0	3	0,8	4,5	25,0	140,0	180,0	1,8	2,0	41,5	48,0	30000	0,4	LP..06
R217.21-2527.0-LP06.3A	02789722	Cylindrical	18,5	27,0	3	0,8	4,5	25,0	228,0	250,0	1,8	1,5	45,5	52,0	30000	0,4	LP..06
R217.21-3232.0-LP06.4A	02789725	Cylindrical	23,5	32,0	4	0,8	4,5	32,0	160,0	200,0	1,8	1,5	55,5	62,0	27000	0,4	LP..06
R217.21-3235.0-LP06.4A	02789729	Cylindrical	26,5	35,0	4	0,8	4,5	32,0	228,0	250,0	1,8	1,2	61,5	68,0	26000	0,4	LP..06

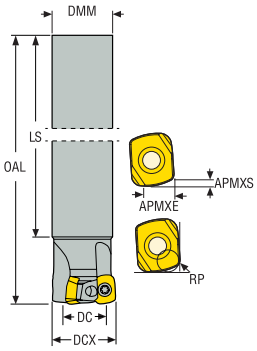
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-1416-1820	C02555-T08P	T00-08P12	1.2NM
R217.21-2525-3235	C02506-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-LP06 – Inch



- For insert selection and cutting data recommendations, see page(s) 480-482
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.21-00.625-0-LP06-2A	02789777	Cylindrical	0.290	0.625	2	0.030	0.177	0.625	5.000	6.000	0.071	5,0	0.915	1.171	39000	0.440	LP..06
R217.21-00.750-0-LP06-2A	02789778	Cylindrical	0.410	0.750	2	0.030	0.177	0.750	5.591	6.500	0.071	3,0	1.160	1.421	35000	0.660	LP..06
R217.21-01.00-0-LP06-3A	02789782	Cylindrical	0.660	1.000	3	0.030	0.177	1.000	5.512	7.000	0.071	2,0	1.660	1.921	30000	1.540	LP..06
R217.21-01.25-0-LP06-4A	02789785	Cylindrical	0.659	1.250	4	0.030	0.177	1.250	6.299	8.000	0.071	1,5	1.909	2.421	27000	2.200	LP..06

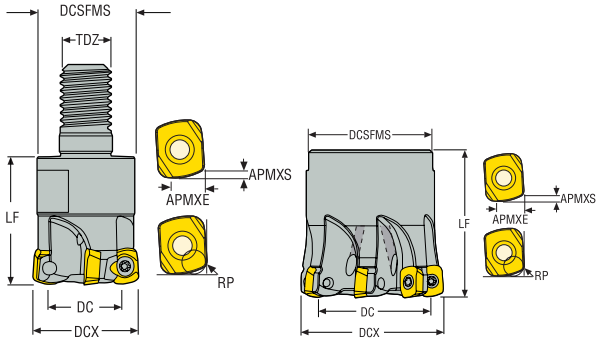
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-0.625-0.750	C02555-T08P	T00-08P12	10.6IN.LBS
R217.21-1.00-1.50	C02506-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LP06 – Metric



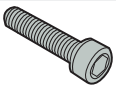
- For insert selection and cutting data recommendations, see page(s) 480-482
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm		mm	mm	mm		mm	mm	kg		
R217.21-0816.RE-LP06.2A	02789697	Combimaster	7,5	16,0	2	0,8	4,5	–	M8	13,5	20,0	1,8	5,0	23,5	30,0	0,3	39000	LP..06
R217.21-1020.RE-LP06.2A	02789700	Combimaster	11,5	20,0	2	0,8	4,5	–	M10	18,5	28,0	1,8	3,0	31,5	38,0	0,3	35000	LP..06
R217.21-1020.RE-LP06.3A	02789701	Combimaster	11,5	20,0	3	0,8	4,5	–	M10	18,5	28,0	1,8	3,0	31,5	38,0	0,4	35000	LP..06
R217.21-1225.RE-LP06.3A	02789702	Combimaster	16,5	25,0	3	0,8	4,5	–	M12	23,0	30,0	1,8	2,0	41,5	48,0	0,3	30000	LP..06
R217.21-1225.RE-LP06.4A	02789705	Combimaster	16,5	25,0	4	0,8	4,5	–	M12	23,0	30,0	1,8	2,0	41,5	48,0	0,4	30000	LP..06
R217.21-1632.RE-LP06.5A	02789708	Combimaster	23,5	32,0	5	0,8	4,5	–	M16	30,0	35,0	1,8	1,5	55,5	62,0	0,2	27000	LP..06
R217.21-1635.RE-LP06.5A	02789711	Combimaster	26,5	35,0	5	0,8	4,5	–	M16	30,0	35,0	1,8	1,5	61,5	68,0	0,3	26000	LP..06
R217.21-2040.RE-LP06.7A	02928084	Combimaster	31,5	40,0	7	0,8	4,5	–	M20	36,5	40,0	1,8	0,9	71,5	78,0	0,4	24000	LP..06
R220.21-0035-LP06.6A	02789734	Arbor	26,5	35,0	6	0,8	4,5	16,0	–	32,0	35,0	1,8	1,29	61,5	68,0	0,4	26000	LP..06
R220.21-0040-LP06.6A	02892228	Arbor	31,5	40,0	6	0,8	4,5	16,0	–	32,0	40,0	1,8	0,9	71,5	78,0	0,2	24000	LP..06

For Combimaster Shanks, see Machining Navigator Tooling System

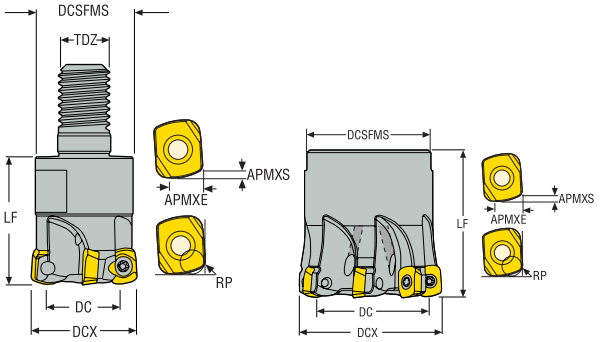
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.21-0816-1020	–	C02555-T08P	T00-08P12	1.2NM
R217.21-1225-2040	–	C02506-T08P	T00-08P12	1.2NM
R220.21-..	220.17-689	C02506-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LP06 – Inch



- For insert selection and cutting data recommendations, see page(s) 480-482
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation_Ansi	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch	Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.21-00.625-08RE-LP06-2A	02789772	Combimaster	0.290	0.625	2	0.031	0.177	–	M8	0.531	0.787	0.071	5,0	0.915	1.171	0.040	39000	LP..06
R217.21-00.750-10RE-LP06-2A	02833585	Combimaster	0.409	0.750	2	0.031	0.177	–	M10	0.728	1.102	0.071	3,0	1.159	1.421	0.220	35000	LP..06
R217.21-00.750-10RE-LP06-3A	02789773	Combimaster	0.409	0.750	3	0.031	0.177	–	M10	0.728	1.102	0.071	3,0	1.159	1.421	0.110	35000	LP..06
R217.21-01.00-12RE-LP06-3A	02789774	Combimaster	0.660	1.000	3	0.031	0.177	–	M12	0.906	1.181	0.071	2,0	1.660	1.921	0.440	30000	LP..06
R217.21-01.00-12RE-LP06-4A	02789775	Combimaster	0.660	1.000	4	0.031	0.177	–	M12	0.906	1.181	0.071	2,0	1.660	1.921	0.220	30000	LP..06
R217.21-01.25-16RE-LP06-5A	02789776	Combimaster	0.909	1.250	5	0.031	0.177	–	M16	1.181	1.378	0.071	1,2	2.159	2.421	0.440	27000	LP..06
R217.21-01.50-20RE-LP06.7A	02928069	Combimaster	1.181	1.500	7	0.031	0.177	–	M20	1.437	1.575	0.071	0,9	2.681	2.921	0.660	24000	LP..06
R220.21-01.50-LP06-6A	02892229	Arbor	1.165	1.500	6	0.031	0.177	0.500	–	1.260	1.500	0.071	1,0	2.665	2.921	0.440	25000	LP..06

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.21-0.625-0.750	–	C02555-T08P	T00-08P12	10.6IN.LBS
R217.21-1.00-1.50	–	C02506-T08P	T00-08P12	10.6IN.LBS
R220.21-..	UC6S1/4UNFX1	C02506-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LP06 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	LPHT060310TR-M06 MP2501	0,70 *0.028*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
P2	LPHT060310TR-M06 MP2501	0,70 *0.028*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
P3	LPHT060310TR-M06 MP2501	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,80 *0.032*
P4	LPHT060310TR-M06 MP2501	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,80 *0.032*
P5	LPHT060310TR-M06 MP2501	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
P6	LPHT060310TR-M06 MP2501	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
P7	LPHW060310TR-MD07 MP2501	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
P8	LPHW060310TR-MD07 MS2500	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
P11	LPHW060310TR-MD07 MS2500	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
P12	LPHW060310TR-MD07 MS2500	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
M1	LPHT060310TR-ME05 MS2050	0,70 *0.028*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
M2	LPHT060310TR-ME05 MS2050	0,70 *0.028*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
M3	LPHT060310TR-ME05 MS2050	0,60 *0.024*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
M4	LPHT060310TR-M06 T350M	0,44 *0.017*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
M5	LPHT060310TR-M06 T350M	0,44 *0.017*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
K1	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
K2	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K3	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K4	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K5	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
K6	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K7	LPHW060310TR-D06 MP3000	0,70 *0.028*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
N1	LPHT060310ER-E05 H25	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
N2	LPHT060310ER-E05 H25	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
N3	LPHT060310ER-E05 H25	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
N11	LPHT060310ER-E05 H25	0,70 *0.028*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
S1	LPHT060310TR-M06 MS2500	0,44 *0.017*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
S2	LPHT060310TR-M06 MS2500	0,44 *0.017*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
S3	LPHT060310TR-M06 MS2500	0,44 *0.017*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S11	LPHT060310TR-M06 MS2050	0,50 *0.020*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S12	LPHT060310TR-M06 MS2050	0,50 *0.020*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S13	LPHT060310TR-M06 MS2050	0,44 *0.017*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H5	LPHW060310TR-D06 MH1000	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,55 *0.022*
H8	LPHW060310TR-D06 MH1000	0,40 *0.016*	0,34 *0.013*	0,34 *0.013*	0,40 *0.016*
H11	LPHW060310TR-D06 MP3000	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,55 *0.022*
H12	LPHW060310TR-D06 MH1000	0,40 *0.016*	0,34 *0.013*	0,34 *0.013*	0,40 *0.016*
H21	LPHW060310TR-D06 MH1000	0,40 *0.016*	0,34 *0.013*	0,34 *0.013*	0,40 *0.016*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

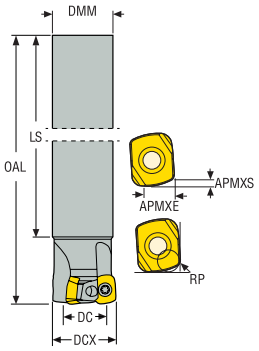
R217/220.21-LP06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2050			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	295 *970*	335 *1100*	405 *1325*	300 *980*	340 *1125*	410 *1350*	280 *920*	325 *1075*	390 *1275*	260 *850*	300 *980*	360 *1175*	225 *740*	260 *850*	310 *1025*
P2	285 *940*	325 *1075*	395 *1300*	290 *950*	335 *1100*	400 *1300*	275 *900*	315 *1025*	380 *1250*	255 *840*	290 *950*	350 *1150*	220 *720*	250 *820*	305 *1000*
P3	250 *820*	285 *940*	345 *1125*	255 *840*	295 *970*	350 *1150*	240 *790*	275 *900*	330 *1075*	220 *720*	255 *840*	305 *1000*	195 *640*	220 *720*	265 *870*
P4	220 *720*	255 *840*	305 *1000*	225 *740*	260 *850*	310 *1025*	215 *710*	245 *800*	290 *950*	195 *640*	225 *740*	270 *890*	170 *560*	195 *640*	235 *770*
P5	210 *690*	240 *790*	290 *950*	215 *710*	245 *800*	295 *970*	205 *670*	235 *770*	280 *920*	185 *610*	215 *710*	255 *840*	160 *520*	185 *610*	225 *740*
P6	235 *770*	270 *890*	325 *1075*	240 *790*	275 *900*	330 *1075*	230 *750*	260 *850*	315 *1025*	210 *690*	240 *790*	290 *950*	180 *590*	210 *690*	250 *820*
P7	225 *740*	255 *840*	305 *1000*	225 *740*	260 *850*	310 *1025*	215 *710*	245 *800*	295 *970*	200 *660*	225 *740*	270 *890*	170 *560*	195 *640*	235 *770*
P8	210 *690*	240 *790*	290 *950*	215 *710*	245 *800*	295 *970*	205 *670*	235 *770*	280 *920*	185 *610*	215 *710*	255 *840*	160 *520*	185 *610*	225 *740*
P11	215 *710*	250 *820*	300 *980*	220 *720*	255 *840*	305 *1000*	210 *690*	240 *790*	285 *940*	190 *620*	220 *720*	265 *870*	165 *540*	190 *620*	230 *750*
P12	145 *475*	165 *540*	195 *640*	145 *475*	165 *540*	195 *640*	140 *460*	160 *520*	185 *610*	125 *410*	145 *475*	170 *560*	110 *360*	125 *410*	150 *490*
M1	205 *670*	235 *770*	280 *920*	210 *690*	240 *790*	290 *950*	205 *670*	235 *770*	285 *940*	195 *640*	225 *740*	270 *890*	175 *570*	205 *670*	245 *800*
M2	170 *560*	195 *640*	230 *750*	170 *560*	200 *660*	235 *770*	170 *560*	195 *640*	235 *770*	160 *520*	185 *610*	220 *720*	145 *475*	170 *560*	200 *660*
M3	135 *445*	155 *510*	185 *610*	140 *460*	160 *520*	190 *620*	140 *460*	160 *520*	185 *610*	130 *425*	150 *490*	180 *590*	120 *395*	135 *445*	160 *520*
M4	105 *345*	120 *395*	145 *475*	110 *360*	125 *410*	150 *490*	110 *360*	125 *410*	150 *490*	100 *330*	115 *375*	140 *460*	95 *310*	105 *345*	125 *410*
M5	90 *295*	100 *330*	120 *395*	90 *295*	105 *345*	125 *410*	90 *295*	100 *330*	125 *410*	85 *280*	95 *310*	115 *375*	75 *245*	90 *295*	105 *345*
K1	225 *740*	260 *850*	310 *1025*	230 *750*	265 *870*	315 *1025*	220 *720*	250 *820*	300 *980*	200 *660*	230 *750*	275 *900*	175 *570*	200 *660*	240 *790*
K2	200 *660*	230 *750*	275 *900*	205 *670*	235 *770*	280 *920*	195 *640*	220 *720*	265 *870*	175 *570*	205 *670*	245 *800*	155 *510*	175 *570*	210 *690*
K3	170 *560*	195 *640*	230 *750*	170 *560*	200 *660*	235 *770*	165 *540*	185 *610*	225 *740*	150 *490*	170 *560*	205 *670*	130 *425*	150 *490*	180 *590*
K4	160 *520*	185 *610*	220 *720*	165 *540*	190 *620*	225 *740*	155 *510*	180 *590*	215 *710*	145 *475*	165 *540*	195 *640*	125 *410*	145 *475*	170 *560*
K5	100 *330*	115 *375*	135 *445*	100 *330*	115 *375*	140 *460*	95 *310*	110 *360*	130 *425*	90 *295*	100 *330*	120 *395*	75 *245*	90 *295*	105 *345*
K6	140 *460*	165 *540*	195 *640*	145 *475*	165 *540*	200 *660*	135 *445*	155 *510*	190 *620*	125 *410*	145 *475*	175 *570*	110 *360*	125 *410*	150 *490*
K7	130 *425*	150 *490*	175 *570*	130 *425*	150 *490*	180 *590*	125 *410*	140 *460*	170 *560*	115 *375*	130 *425*	155 *510*	100 *330*	115 *375*	135 *445*
N1	— —	— —	— —	— —	— —	— —	1600 *5250*	1850 *6075*	2225 *7300*	— —	— —	— —	1275 *4175*	1475 *4850*	1775 *5825*
N2	— —	— —	— —	— —	— —	— —	650 *2125*	740 *2425*	900 *2950*	— —	— —	— —	520 *1700*	590 *1925*	720 *2350*
N3	— —	— —	— —	— —	— —	— —	430 *1400*	495 *1625*	600 *1975*	— —	— —	— —	345 *1125*	395 *1300*	480 *1575*
N11	— —	— —	— —	— —	— —	— —	495 *1625*	570 *1875*	690 *2275*	— —	— —	— —	395 *1300*	455 *1500*	550 *1800*
S1	50 *165*	60 *195*	70 *230*	55 *180*	60 *195*	75 *245*	50 *165*	55 *180*	70 *230*	48 *155*	55 *180*	65 *215*	43 *140*	49 *160*	60 *195*
S2	42 *140*	48 *155*	60 *195*	43 *140*	49 *160*	60 *195*	40 *130*	46 *150*	55 *180*	38 *125*	44 *145*	55 *180*	35 *115*	40 *130*	48 *155*
S3	37 *120*	42 *140*	50 *165*	38 *125*	43 *140*	50 *165*	36 *120*	41 *135*	49 *160*	34 *110*	39 *130*	46 *150*	31 *100*	35 *115*	42 *140*
S11	75 *245*	85 *280*	100 *330*	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	65 *215*	75 *245*	90 *295*	60 *195*	70 *230*	80 *260*
S12	50 *165*	55 *180*	70 *230*	50 *165*	60 *195*	70 *230*	48 *155*	55 *180*	65 *215*	46 *150*	50 *165*	60 *195*	42 *140*	48 *155*	55 *180*
S13	29 *95*	33 *110*	40 *130*	30 *100*	34 *110*	41 *135*	28 *90*	32 *105*	39 *130*	27 *90*	31 *100*	37 *120*	24 *80*	28 *90*	33 *110*
H5	45 *150*	50 *165*	60 *195*	46 *150*	50 *165*	60 *195*	45 *150*	50 *165*	60 *195*	44 *145*	50 *165*	60 *195*	38 *125*	44 *145*	50 *165*
H8	48 *155*	55 *180*	65 *215*	49 *160*	55 *180*	65 *215*	48 *155*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	41 *135*	47 *155*	55 *180*
H11	55 *180*	65 *215*	75 *245*	60 *195*	65 *215*	80 *260*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*	49 *160*	55 *180*	65 *215*
H12	95 *310*	110 *360*	130 *425*	95 *310*	110 *360*	130 *425*	90 *295*	105 *345*	125 *410*	85 *280*	95 *310*	115 *375*	75 *245*	85 *280*	100 *330*
H21	48 *155*	55 *180*	65 *215*	49 *160*	55 *180*	65 *215*	48 *155*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	41 *135*	47 *155*	55 *180*

R217/220.21-LP06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500			MS2050			MS2500			MH1000			H25		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	200	230	275	250	285	345	325	375	450	—	—	—	—	—	—
	660	*750*	*900*	*820*	*940*	*1125*	*1075*	*1225*	*1475*	—	—	—	—	—	—
P2	190	220	265	240	280	335	315	365	435	—	—	—	—	—	—
	620	*720*	*870*	*790*	*920*	*1100*	*1025*	*1200*	*1425*	—	—	—	—	—	—
P3	170	195	230	210	245	290	280	320	380	—	—	—	—	—	—
	560	*640*	*750*	*690*	*800*	*950*	*920*	*1050*	*1250*	—	—	—	—	—	—
P4	150	170	205	185	215	255	245	280	335	—	—	—	—	—	—
	490	*560*	*670*	*610*	*710*	*840*	*800*	*920*	*1100*	—	—	—	—	—	—
P5	140	165	200	180	205	245	235	270	320	—	—	—	—	—	—
	460	*540*	*660*	*590*	*670*	*800*	*770*	*890*	*1050*	—	—	—	—	—	—
P6	165	190	220	200	230	275	260	300	360	—	—	—	—	—	—
	540	*620*	*720*	*660*	*750*	*900*	*850*	*980*	*1175*	—	—	—	—	—	—
P7	155	180	210	190	215	260	250	285	340	—	—	—	—	—	—
	510	*590*	*690*	*620*	*710*	*850*	*820*	*940*	*1125*	—	—	—	—	—	—
P8	140	165	195	180	205	245	235	270	320	—	—	—	—	—	—
	460	*540*	*640*	*590*	*670*	*800*	*770*	*890*	*1050*	—	—	—	—	—	—
P11	150	170	205	185	210	255	240	275	330	—	—	—	—	—	—
	490	*560*	*670*	*610*	*690*	*840*	*790*	*900*	*1075*	—	—	—	—	—	—
P12	95	110	130	120	140	165	160	180	215	—	—	—	—	—	—
	310	*360*	*425*	*395*	*460*	*540*	*520*	*590*	*710*	—	—	—	—	—	—
M1	165	190	225	195	225	270	225	260	315	—	—	—	—	—	—
	540	*620*	*740*	*640*	*740*	*890*	*740*	*850*	*1025*	—	—	—	—	—	—
M2	135	155	190	160	185	220	185	215	255	—	—	—	—	—	—
	445	*510*	*620*	*520*	*610*	*720*	*610*	*710*	*840*	—	—	—	—	—	—
M3	110	125	150	130	150	180	150	175	205	—	—	—	—	—	—
	360	*410*	*490*	*425*	*490*	*590*	*490*	*570*	*670*	—	—	—	—	—	—
M4	85	100	120	100	115	140	120	135	165	—	—	—	—	—	—
	280	*330*	*395*	*330*	*375*	*460*	*395*	*445*	*540*	—	—	—	—	—	—
M5	75	85	100	85	95	115	100	115	135	—	—	—	—	—	—
	245	*280*	*330*	*280*	*310*	*375*	*330*	*375*	*445*	—	—	—	—	—	—
K1	—	—	—	—	—	—	—	—	—	235	270	320	—	—	—
	—	—	—	—	—	—	—	—	—	*770*	*890*	*1050*	—	—	—
K2	—	—	—	—	—	—	—	—	—	205	235	285	—	—	—
	—	—	—	—	—	—	—	—	—	*670*	*770*	*940*	—	—	—
K3	—	—	—	—	—	—	—	—	—	175	200	240	—	—	—
	—	—	—	—	—	—	—	—	—	*570*	*660*	*790*	—	—	—
K4	—	—	—	—	—	—	—	—	—	165	190	230	—	—	—
	—	—	—	—	—	—	—	—	—	*540*	*620*	*750*	—	—	—
K5	—	—	—	—	—	—	—	—	—	105	120	140	—	—	—
	—	—	—	—	—	—	—	—	—	*345*	*395*	*460*	—	—	—
K6	—	—	—	—	—	—	—	—	—	145	170	200	—	—	—
	—	—	—	—	—	—	—	—	—	*475*	*560*	*660*	—	—	—
K7	—	—	—	—	—	—	—	—	—	135	155	180	—	—	—
	—	—	—	—	—	—	—	—	—	*445*	*510*	*590*	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	1325	1525	1825
	—	—	—	—	—	—	—	—	—	—	—	—	*4350*	*5000*	*6000*
N2	—	—	—	—	—	—	—	—	—	—	—	—	540	620	740
	—	—	—	—	—	—	—	—	—	—	—	—	*1775*	*2025*	*2425*
N3	—	—	—	—	—	—	—	—	—	—	—	—	360	410	495
	—	—	—	—	—	—	—	—	—	—	—	—	*1175*	*1350*	*1625*
N11	—	—	—	—	—	—	—	—	—	—	—	—	410	470	570
	—	—	—	—	—	—	—	—	—	—	—	—	*1350*	*1550*	*1875*
S1	27	30	36	48	55	65	60	65	80	—	—	—	—	—	—
	90	*100*	*120*	*155*	*180*	*215*	*195*	*215*	*260*	—	—	—	—	—	—
S2	21	25	29	38	44	55	47	55	65	—	—	—	—	—	—
	70	*80*	*95*	*125*	*145*	*180*	*155*	*180*	*215*	—	—	—	—	—	—
S3	19	21	25	34	39	46	41	47	55	—	—	—	—	—	—
	60	*70*	*80*	*110*	*130*	*150*	*135*	*155*	*180*	—	—	—	—	—	—
S11	37	42	50	65	75	90	80	90	110	—	—	—	—	—	—
	120	*140*	*165*	*215*	*245*	*295*	*260*	*295*	*360*	—	—	—	—	—	—
S12	34	39	46	46	50	60	55	65	75	—	—	—	—	—	—
	110	*130*	*150*	*150*	*165*	*195*	*180*	*215*	*245*	—	—	—	—	—	—
S13	20	23	27	27	31	37	33	37	45	—	—	—	—	—	—
	65	*75*	*90*	*90*	*100*	*120*	*110*	*120*	*150*	—	—	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	50	60	70	—	—	—
	—	—	—	—	—	—	—	—	—	*165*	*195*	*230*	—	—	—
H8	—	—	—	—	—	—	—	—	—	55	60	75	—	—	—
	—	—	—	—	—	—	—	—	—	*180*	*195*	*245*	—	—	—
H11	—	—	—	—	—	—	—	—	—	65	75	90	—	—	—
	—	—	—	—	—	—	—	—	—	*215*	*245*	*295*	—	—	—
H12	—	—	—	—	—	—	—	—	—	100	110	130	—	—	—
	—	—	—	—	—	—	—	—	—	*330*	*360*	*425*	—	—	—
H21	—	—	—	—	—	—	—	—	—	55	60	75	—	—	—
	—	—	—	—	—	—	—	—	—	*180*	*195*	*245*	—	—	—

R217.21-LP09 – Inch



- For insert selection and cutting data recommendations, see page(s) 487-489
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.21-01.25-0-LP09-4A	03212900	Cylindrical	0.744	1.250	4	0.071	0.287	1.250	6.102	8.000	0.137	4,9	1.994	2.421	31200	2.430	LP..09
R217.21-01.50-0-LP09-5A	03212901	Cylindrical	0.992	1.500	5	0.071	0.287	1.500	6.102	8.000	0.137	3,4	2.492	2.921	28500	3.530	LP..09

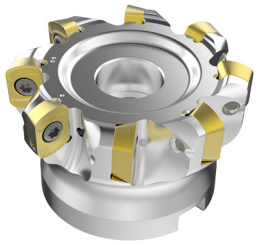
Spare Parts

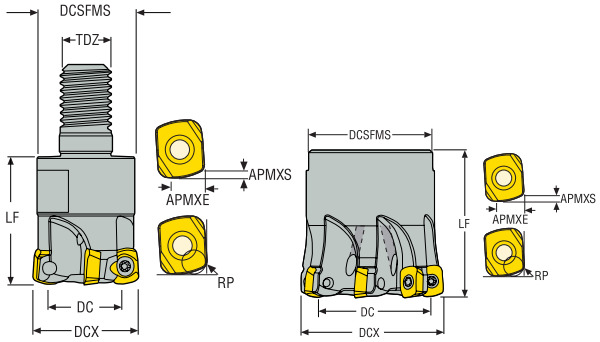
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-..	C04009-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-LP09 – Metric



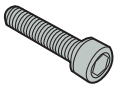


- For insert selection and cutting data recommendations, see page(s) 487-489
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm		mm	mm	mm		mm	mm	kg		
R217.21-1225.RE-LP09.2A	03212883	Combimaster	12,0	25,0	2	1,8	7,3	–	M12	23,0	35,0	3,49	8,8	37,0	48,0	0,1	35200	LP..09
R217.21-1632.RE-LP09.3A	03212884	Combimaster	19,1	32,0	3	1,8	7,3	–	M16	30,0	35,0	3,45	4,8	51,1	62,0	0,2	31100	LP..09
R217.21-1632.RE-LP09.4A	03212885	Combimaster	19,1	32,0	4	1,8	7,3	–	M16	30,0	35,0	3,47	4,8	51,1	62,0	0,2	31100	LP..09
R217.21-1635.RE-LP09.4A	03212886	Combimaster	22,1	35,0	4	1,8	7,3	–	M16	30,0	35,0	3,47	4,0	57,1	68,0	0,2	29700	LP..09
R217.21-2040.RE-LP09.5A	03212887	Combimaster	27,0	40,0	5	1,8	7,3	–	M20	36,5	40,0	3,48	3,2	67,0	78,0	0,3	27800	LP..09
R217.21-2042.RE-LP09.4A	03252421	Combimaster	29,0	42,0	4	1,8	7,3	–	M20	36,5	40,0	3,45	2,9	71,0	82,0	0,3	27100	LP..09
R217.21-2042.RE-LP09.5A	03212888	Combimaster	28,9	42,0	5	1,8	7,3	–	M20	36,5	40,0	3,48	2,9	70,9	82,0	0,3	27100	LP..09
R220.21-0040-LP09.4A	03212889	Arbor	27,5	40,0	4	1,8	7,3	16,0	–	32,0	40,0	3,46	3,2	67,5	78,0	0,3	27800	LP..09
R220.21-0050-LP09.5A	03212890	Arbor	37,0	50,0	5	1,8	7,3	22,0	–	40,0	40,0	3,45	2,2	87,0	98,0	0,3	24800	LP..09
R220.21-0050-LP09.6A	03212891	Arbor	37,0	50,0	6	1,8	7,3	22,0	–	40,0	40,0	3,45	2,2	87,0	98,0	0,3	24800	LP..09
R220.21-0050-LP09.7A	03212892	Arbor	37,1	50,0	7	1,8	7,3	22,0	–	40,0	40,0	3,47	2,2	87,1	98,0	0,3	24800	LP..09
R220.21-0052-LP09.5A	03252422	Arbor	39,0	51,98	5	1,8	7,3	22,0	–	49,0	40,0	3,45	2,1	90,98	101,96	0,4	24400	LP..09
R220.21-0052-LP09.7A	03212893	Arbor	39,1	51,98	7	1,8	7,3	22,0	–	48,0	40,0	3,47	2,1	91,08	101,96	0,4	24400	LP..09
R220.21-0063-LP09.6A	03212894	Arbor	50,0	63,0	6	1,8	7,3	22,0	–	48,0	40,0	3,45	2,7	113,0	124,0	0,5	22100	LP..09
R220.21-0063-LP09.6A-27	03317247	Arbor	50,0	63,0	6	1,8	7,3	27,0	–	61,0	50,0	3,45	2,7	113,0	124,0	0,7	22100	LP..09
R220.21-0063-LP09.8A	03212895	Arbor	50,1	63,0	8	1,8	7,3	22,0	–	48,0	40,0	3,47	1,6	113,1	124,0	0,5	22100	LP..09
R220.21-0063-LP09.8A-27	03317248	Arbor	50,1	63,0	8	1,8	7,3	27,0	–	61,0	50,0	3,47	1,6	113,1	124,0	0,7	22100	LP..09
R220.21-0066-LP09.6A	03252423	Arbor	53,1	66,0	6	1,8	7,3	27,0	–	61,0	50,0	3,47	1,5	119,1	130,0	0,8	21600	LP..09
R220.21-0066-LP09.8A	03212896	Arbor	53,1	66,0	8	1,8	7,3	27,0	–	60,0	50,0	3,47	1,5	119,1	130,0	0,8	21600	LP..09
R220.21-0080-LP09.7A	03212897	Arbor	67,0	80,0	7	1,8	7,3	27,0	–	60,0	50,0	3,45	1,1	147,0	158,0	0,9	19600	LP..09
R220.21-0080-LP09.9A	03212898	Arbor	67,0	80,0	9	1,8	7,3	27,0	–	60,0	50,0	3,45	1,1	147,0	158,0	0,9	19600	LP..09
R220.21-0084-LP09.7A	03252424	Arbor	71,0	84,0	7	1,8	7,3	32,0	–	79,0	50,0	3,44	1,1	155,0	166,0	1,3	18600	LP..09
R220.21-0100-LP09.10A	03212899	Arbor	87,0	100,0	10	1,8	7,3	32,0	–	78,0	50,0	3,44	0,8	187,0	198,0	1,5	17600	LP..09

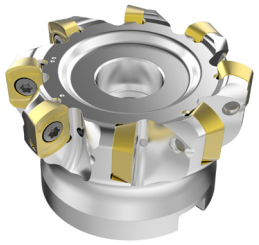
Spare Parts

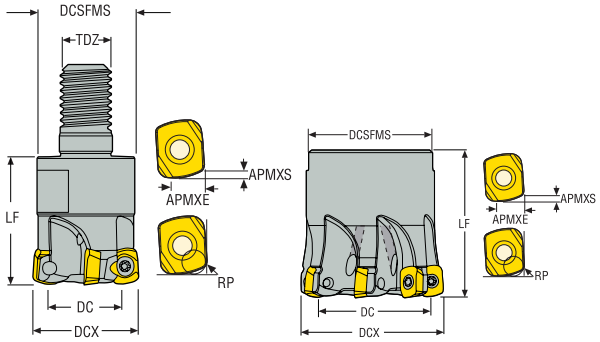
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.21-..	–	C04009-T15P	T00-15P35	3.5NM
R220.21-0040	MC6S8X30	C04009-T15P	T00-15P35	3.5NM
R220.21-0050-0063	220.17-692	C04009-T15P	T00-15P35	3.5NM
R220.21-0063-6A	220.17-692	C04011-T15P	T00-15P35	3.5NM
R220.21-0063-6A-27	MC6S12X40	C04011-T15P	T00-15P35	3.5NM
R220.21-0063-8A-27	MC6S12X40	C04009-T15P	T00-15P35	3.5NM
R220.21-0066	MC6S12X35	C04009-T15P	T00-15P35	3.5NM
R220.21-0080	MC6S12X35	C04011-T15P	T00-15P35	3.5NM
R220.21-0084	MLC6S16X35	C04009-T15P	T00-15P35	3.5NM
R220.21-0100	MLC6S16X35	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-LP09 – Inch





- For insert selection and cutting data recommendations, see page(s) 487-489
- For complete insert programme, see page(s) 742
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch	Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.21-01.25-16RE-LP09-4A	03212902	Combimaster	0.744	1.250	4	0.071	0.287	–	M16	1.181	1.378	0.137	4,9	1.994	2.421	0.440	31100	LP..09
R220.21-02.00-LP09-6A	03212903	Arbor	1.488	2.000	6	0.071	0.287	0.750	–	1.750	1.500	0.136	2,2	3.488	3.921	0.660	24600	LP..09
R220.21-02.00-LP09-7A	03212904	Arbor	1.492	2.000	7	0.071	0.287	0.750	–	1.750	1.500	0.137	2,2	3.492	3.921	0.660	24600	LP..09
R220.21-02.50-LP09-6A	03212905	Arbor	1.988	2.500	6	0.071	0.287	0.750	–	1.750	1.500	0.136	1,6	4.488	4.921	1.100	22000	LP..09
R220.21-02.50-LP09-8A	03212906	Arbor	1.992	2.500	8	0.071	0.287	0.750	–	1.750	1.500	0.137	1,6	4.492	4.921	1.100	22000	LP..09
R220.21-03.00-LP09-6A	03212907	Arbor	2.488	3.000	6	0.071	0.287	1.000	–	2.250	2.000	0.136	1,2	5.488	5.921	1.980	19600	LP..09
R220.21-03.00-LP09-8A	03212908	Arbor	2.488	3.000	8	0.071	0.287	1.000	–	2.250	2.000	0.136	1,2	5.488	5.921	1.980	20100	LP..09
R220.21-03.50-LP09-8A	03212909	Arbor	2.988	3.500	8	0.071	0.287	1.250	–	2.750	2.000	0.135	1,0	6.488	6.921	2.650	19600	LP..09
R220.21-04.00-LP09-9A	03212910	Arbor	3.488	4.000	9	0.071	0.287	1.500	–	3.500	2.000	0.135	0,8	7.488	7.921	3.970	17600	LP..09
R220.21-04.00-LP09-10A	03212911	Arbor	3.488	4.000	10	0.071	0.287	1.500	–	3.500	2.000	0.135	0,8	7.488	7.921	3.970	17400	LP..09

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.21-..	–	C04009-T15P	T00-15P35	31.0IN.LBS
R220.21-02.00-02.50	UC6S3/8UNFX1-1/4	C04009-T15P	T00-15P35	31.0IN.LBS
R220.21-03.00	UC6S1/2UNFX1-1/2	C04011-T15P	T00-15P35	31.0IN.LBS
R220.21-03.50	ULC6S5/8UNFX11/2	C04011-T15P	T00-15P35	31.0IN.LBS
R220.21-04.00	ULC6S3/4UNFX11/2	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LP09 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	LPKT09T420TR-M13 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P2	LPKT09T420TR-M13 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P3	LPKT09T420TR-M13 MP2501	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,3 *0.050*
P4	LPKT09T420TR-M13 MP2501	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P5	LPKT09T420TR-M13 MP2501	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P6	LPKT09T420TR-M13 MP2501	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P7	LPKW09T420TR-MD15 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
P8	LPKW09T420TR-MD15 MP2501	1,6 *0.065*	1,2 *0.048*	1,2 *0.048*	1,5 *0.060*
P11	LPKW09T420TR-MD15 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
P12	LPKW09T420TR-MD15 MP2501	1,3 *0.050*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
M1	LPKT09T420TR-ME08 MS2050	1,6 *0.065*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
M2	LPKT09T420TR-ME08 MS2050	1,6 *0.065*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
M3	LPKT09T420TR-ME08 MS2050	1,3 *0.050*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
M4	LPKT09T420TR-M13 T350M	0,95 *0.038*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
M5	LPKT09T420TR-M13 T350M	0,95 *0.038*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
K1	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,3 *0.050*	1,3 *0.050*	1,5 *0.060*
K2	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
K3	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
K4	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
K5	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,3 *0.050*
K6	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
K7	LPKW09T420TR-D15 MK2050	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,3 *0.050*
N1	LPHT09T420R-E08 H25	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
N2	LPHT09T420R-E08 H25	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
N3	LPHT09T420R-E08 H25	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
N11	LPHT09T420R-E08 H25	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
S1	LPKT09T420TR-M13 MS2500	0,95 *0.038*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
S2	LPKT09T420TR-M13 MS2500	0,95 *0.038*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
S3	LPKT09T420TR-M13 MS2500	0,95 *0.038*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
S11	LPKT09T420TR-ME08 MS2050	1,1 *0.044*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S12	LPKT09T420TR-ME08 MS2050	1,1 *0.044*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S13	LPKT09T420TR-ME08 MS2050	0,95 *0.038*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H5	LPHW09T420TR-D12 MH1000	1,0 *0.040*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
H8	LPHW09T420TR-D12 MH1000	0,90 *0.036*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H11	LPHW09T420TR-D12 MH1000	1,0 *0.040*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
H12	LPHW09T420TR-D12 MH1000	0,90 *0.036*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H21	LPHW09T420TR-D12 MH1000	0,90 *0.036*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

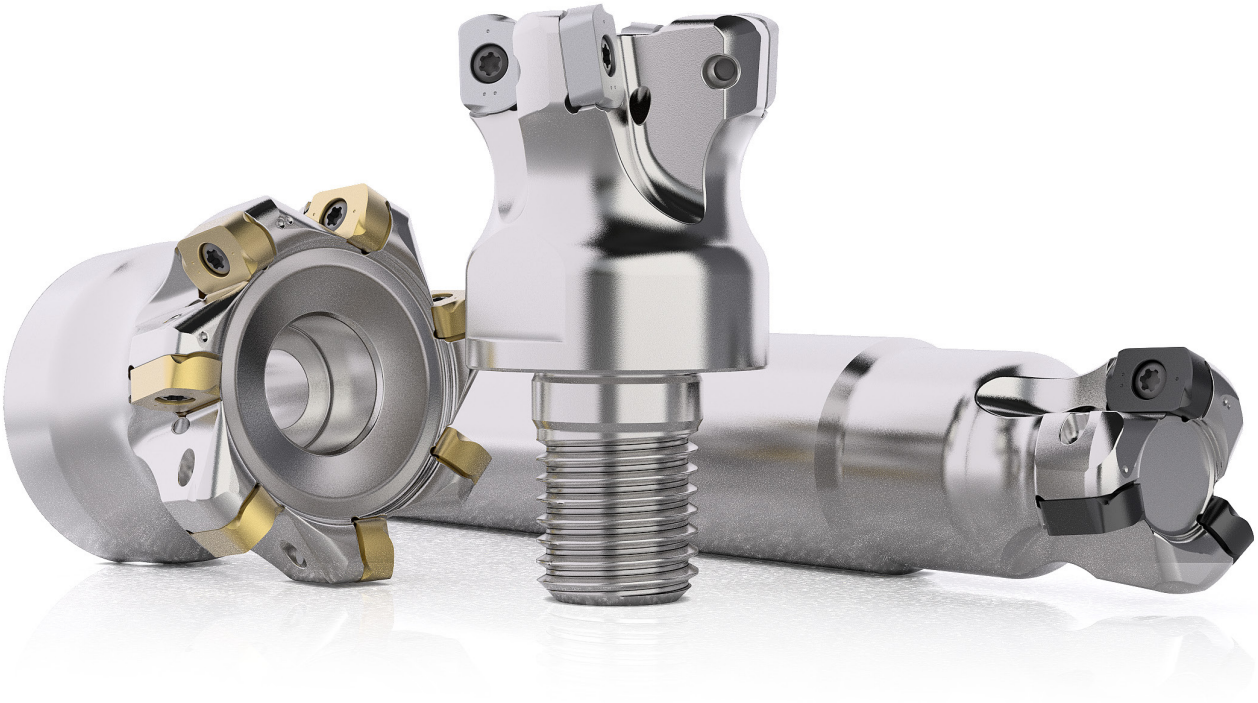
SECO

R217/220.21-LP09 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			MP3000			T350M			F40M			MM4500			MK2050		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	240 *790*	280 *920*	335 *1100*	225 *740*	265 *870*	320 *1050*	210 *690*	245 *800*	295 *970*	220 *720*	260 *850*	305 *1000*	180 *590*	210 *690*	250 *820*	215 *710*	250 *820*	295 *970*
P2	235 *770*	270 *890*	325 *1075*	220 *720*	255 *840*	310 *1025*	205 *670*	235 *770*	285 *940*	210 *690*	245 *800*	300 *980*	170 *560*	200 *660*	240 *790*	200 *660*	235 *770*	285 *940*
P3	205 *670*	240 *790*	280 *920*	195 *640*	230 *750*	265 *870*	180 *590*	210 *690*	245 *800*	185 *610*	215 *710*	260 *850*	150 *490*	175 *570*	210 *690*	180 *590*	210 *690*	245 *800*
P4	180 *590*	210 *690*	255 *840*	170 *560*	200 *660*	240 *790*	160 *520*	185 *610*	220 *720*	165 *540*	190 *620*	230 *750*	135 *445*	155 *510*	185 *610*	155 *510*	185 *610*	220 *720*
P5	175 *570*	205 *670*	245 *800*	165 *540*	190 *620*	230 *750*	150 *490*	175 *570*	210 *690*	160 *520*	185 *610*	220 *720*	130 *425*	150 *490*	180 *590*	150 *490*	175 *570*	210 *690*
P6	195 *640*	230 *750*	275 *900*	185 *610*	215 *710*	260 *850*	170 *560*	200 *660*	235 *770*	180 *590*	210 *690*	245 *800*	145 *475*	170 *560*	200 *660*	175 *570*	200 *660*	235 *770*
P7	185 *610*	215 *710*	255 *840*	175 *570*	205 *670*	245 *800*	160 *520*	185 *610*	225 *740*	170 *560*	200 *660*	235 *770*	140 *460*	160 *520*	190 *620*	165 *540*	190 *620*	225 *740*
P8	175 *570*	205 *670*	235 *770*	165 *540*	190 *620*	225 *740*	150 *490*	175 *570*	205 *670*	155 *510*	185 *610*	220 *720*	125 *410*	150 *490*	180 *590*	150 *490*	175 *570*	205 *670*
P11	180 *590*	210 *690*	250 *820*	170 *560*	200 *660*	235 *770*	155 *510*	180 *590*	220 *720*	165 *540*	195 *640*	225 *740*	135 *445*	155 *510*	185 *610*	160 *520*	185 *610*	220 *720*
P12	120 *395*	140 *460*	165 *540*	115 *375*	130 *425*	155 *510*	105 *345*	120 *395*	145 *475*	110 *360*	125 *410*	150 *490*	90 *295*	100 *330*	120 *395*	105 *345*	125 *410*	145 *475*
M1	170 *560*	195 *640*	235 *770*	165 *540*	190 *620*	230 *750*	155 *510*	180 *590*	220 *720*	170 *560*	200 *660*	240 *790*	145 *475*	170 *560*	210 *690*	— —	— —	— —
M2	140 *460*	165 *540*	195 *640*	135 *445*	160 *520*	190 *620*	130 *425*	150 *490*	180 *590*	145 *475*	170 *560*	200 *660*	125 *410*	145 *475*	170 *560*	— —	— —	— —
M3	115 *375*	135 *445*	155 *510*	110 *360*	130 *425*	155 *510*	105 *345*	125 *410*	145 *475*	115 *375*	135 *445*	160 *520*	100 *330*	115 *375*	140 *460*	— —	— —	— —
M4	90 *295*	105 *345*	125 *410*	90 *295*	100 *330*	120 *395*	85 *280*	95 *310*	115 *375*	90 *295*	105 *345*	125 *410*	80 *260*	90 *295*	110 *360*	— —	— —	— —
M5	75 *245*	85 *280*	100 *330*	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	75 *245*	85 *280*	105 *345*	65 *215*	75 *245*	90 *295*	— —	— —	— —
K1	185 *610*	215 *710*	260 *850*	175 *570*	205 *670*	245 *800*	160 *520*	185 *610*	225 *740*	170 *560*	195 *640*	235 *770*	— —	— —	— —	215 *710*	255 *840*	310 *1025*
K2	165 *540*	190 *620*	230 *750*	155 *510*	180 *590*	220 *720*	145 *475*	170 *560*	200 *660*	150 *490*	180 *590*	210 *690*	— —	— —	— —	195 *640*	225 *740*	275 *900*
K3	140 *460*	165 *540*	195 *640*	130 *425*	155 *510*	185 *610*	120 *395*	140 *460*	170 *560*	130 *425*	150 *490*	175 *570*	— —	— —	— —	165 *540*	190 *620*	230 *750*
K4	135 *445*	155 *510*	185 *610*	125 *410*	145 *475*	175 *570*	115 *375*	135 *445*	160 *520*	125 *410*	145 *475*	170 *560*	— —	— —	— —	155 *510*	180 *590*	220 *720*
K5	80 *260*	95 *310*	115 *375*	80 *260*	90 *295*	110 *360*	70 *230*	85 *280*	100 *330*	75 *245*	90 *295*	105 *345*	— —	— —	— —	100 *330*	115 *375*	135 *445*
K6	115 *375*	135 *445*	165 *540*	110 *360*	130 *425*	155 *510*	100 *330*	120 *395*	145 *475*	110 *360*	125 *410*	150 *490*	— —	— —	— —	140 *460*	160 *520*	195 *640*
K7	105 *345*	125 *410*	145 *475*	100 *330*	115 *375*	140 *460*	90 *295*	105 *345*	125 *410*	95 *310*	110 *360*	135 *445*	— —	— —	— —	125 *410*	150 *490*	170 *560*
N1	— —	— —	— —	1275 *4175*	1475 *4850*	1775 *5825*	— —	— —	— —	1250 *4100*	1450 *4750*	1750 *5750*	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	510 *1675*	600 *1975*	720 *2350*	— —	— —	— —	500 *1650*	590 *1925*	710 *2325*	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	340 *1125*	400 *1300*	475 *1550*	— —	— —	— —	335 *1100*	390 *1275*	470 *1550*	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	390 *1275*	455 *1500*	550 *1800*	— —	— —	— —	385 *1275*	445 *1450*	540 *1775*	— —	— —	— —	— —	— —	— —
S1	44 *145*	50 *165*	60 *195*	41 *135*	48 *155*	55 *180*	39 *130*	45 *150*	55 *180*	43 *140*	49 *160*	60 *195*	24 *80*	28 *90*	33 *110*	— —	— —	— —
S2	35 *115*	41 *135*	48 *155*	33 *110*	38 *125*	45 *150*	32 *105*	36 *120*	43 *140*	34 *110*	39 *130*	47 *155*	19 *60*	22 *70*	27 *90*	— —	— —	— —
S3	31 *100*	36 *120*	43 *140*	29 *95*	34 *110*	40 *130*	28 *90*	32 *105*	38 *125*	30 *100*	35 *115*	41 *135*	17 *55*	20 *65*	23 *75*	— —	— —	— —
S11	60 *195*	70 *230*	85 *280*	55 *180*	65 *215*	80 *260*	55 *180*	65 *215*	75 *245*	60 *195*	70 *230*	80 *260*	33 *110*	38 *125*	46 *150*	— —	— —	— —
S12	42 *140*	49 *160*	60 *195*	40 *130*	46 *150*	55 *180*	38 *125*	44 *145*	50 *165*	41 *135*	47 *155*	55 *180*	31 *100*	35 *115*	42 *140*	— —	— —	— —
S13	25 *80*	28 *90*	34 *110*	23 *75*	27 *90*	32 *105*	22 *70*	25 *80*	30 *100*	24 *80*	28 *90*	33 *110*	18 *60*	21 *70*	25 *80*	— —	— —	— —
H5	38 *125*	43 *140*	50 *165*	37 *120*	42 *140*	50 *165*	36 *120*	42 *140*	49 *160*	37 *120*	43 *140*	50 *165*	— —	— —	— —	— —	— —	— —
H8	41 *135*	47 *155*	55 *180*	40 *130*	46 *150*	55 *180*	39 *130*	45 *150*	55 *180*	40 *130*	46 *150*	55 *180*	— —	— —	— —	— —	— —	— —
H11	48 *155*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	46 *150*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —
H12	80 *260*	95 *310*	110 *360*	75 *245*	90 *295*	105 *345*	70 *230*	80 *260*	95 *310*	70 *230*	85 *280*	95 *310*	— —	— —	— —	— —	— —	— —
H21	41 *135*	47 *155*	55 *180*	40 *130*	46 *150*	55 *180*	39 *130*	45 *150*	55 *180*	40 *130*	46 *150*	55 *180*	— —	— —	— —	— —	— —	— —

R217/220.21-LP09 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MS2050			MS2500			MP2050			MH1000			H25		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	200 *660*	230 *750*	280 *920*	260 *850*	305 *1000*	365 *1200*	235 *770*	275 *900*	330 *1075*	— —	— —	— —	— —	— —	— —
P2	195 *640*	225 *740*	270 *890*	255 *840*	295 *970*	355 *1175*	230 *750*	265 *870*	320 *1050*	— —	— —	— —	— —	— —	— —
P3	170 *560*	200 *660*	235 *770*	225 *740*	265 *870*	305 *1000*	205 *670*	235 *770*	275 *900*	— —	— —	— —	— —	— —	— —
P4	150 *490*	175 *570*	210 *690*	200 *660*	230 *750*	275 *900*	180 *590*	210 *690*	250 *820*	— —	— —	— —	— —	— —	— —
P5	145 *475*	170 *560*	200 *660*	190 *620*	220 *720*	265 *870*	170 *560*	200 *660*	240 *790*	— —	— —	— —	— —	— —	— —
P6	165 *540*	190 *620*	225 *740*	215 *710*	250 *820*	295 *970*	190 *620*	225 *740*	270 *890*	— —	— —	— —	— —	— —	— —
P7	155 *510*	180 *590*	215 *710*	200 *660*	235 *770*	280 *920*	180 *590*	210 *690*	255 *840*	— —	— —	— —	— —	— —	— —
P8	145 *475*	170 *560*	195 *640*	190 *620*	220 *720*	260 *850*	170 *560*	200 *660*	230 *750*	— —	— —	— —	— —	— —	— —
P11	150 *490*	175 *570*	210 *690*	195 *640*	230 *750*	275 *900*	175 *570*	205 *670*	245 *800*	— —	— —	— —	— —	— —	— —
P12	100 *330*	115 *375*	140 *460*	130 *425*	150 *490*	180 *590*	120 *395*	135 *445*	165 *540*	— —	— —	— —	— —	— —	— —
M1	155 *510*	180 *590*	220 *720*	180 *590*	210 *690*	255 *840*	165 *540*	190 *620*	230 *750*	— —	— —	— —	— —	— —	— —
M2	130 *425*	150 *490*	180 *590*	150 *490*	175 *570*	210 *690*	135 *445*	160 *520*	190 *620*	— —	— —	— —	— —	— —	— —
M3	105 *345*	125 *410*	145 *475*	125 *410*	145 *475*	170 *560*	110 *360*	130 *425*	155 *510*	— —	— —	— —	— —	— —	— —
M4	85 *280*	95 *310*	115 *375*	100 *330*	115 *375*	135 *445*	90 *295*	100 *330*	120 *395*	— —	— —	— —	— —	— —	— —
M5	70 *230*	80 *260*	95 *310*	80 *260*	95 *310*	110 *360*	75 *245*	85 *280*	100 *330*	— —	— —	— —	— —	— —	— —
K1	— —	— —	— —	— —	— —	— —	180 *590*	210 *690*	255 *840*	195 *640*	225 *740*	270 *890*	— —	— —	— —
K2	— —	— —	— —	— —	— —	— —	160 *520*	190 *620*	225 *740*	175 *570*	205 *670*	240 *790*	— —	— —	— —
K3	— —	— —	— —	— —	— —	— —	135 *445*	160 *520*	190 *620*	150 *490*	170 *560*	205 *670*	— —	— —	— —
K4	— —	— —	— —	— —	— —	— —	130 *425*	155 *510*	185 *610*	140 *460*	165 *540*	195 *640*	— —	— —	— —
K5	— —	— —	— —	— —	— —	— —	80 *260*	95 *310*	110 *360*	85 *280*	100 *330*	120 *395*	— —	— —	— —
K6	— —	— —	— —	— —	— —	— —	115 *375*	135 *445*	160 *520*	125 *410*	145 *475*	170 *560*	— —	— —	— —
K7	— —	— —	— —	— —	— —	— —	105 *345*	120 *395*	145 *475*	110 *360*	130 *425*	155 *510*	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	1225 *4025*	1425 *4675*	1725 *5650*
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	495 *1625*	580 *1900*	690 *2275*
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	330 *1075*	385 *1275*	460 *1500*
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	375 *1225*	440 *1450*	530 *1750*
S1	39 *130*	45 *150*	55 *180*	48 *155*	55 *180*	65 *215*	43 *140*	49 *160*	60 *195*	— —	— —	— —	— —	— —	— —
S2	32 *105*	36 *120*	43 *140*	39 *130*	44 *145*	50 *165*	35 *115*	40 *130*	47 *155*	— —	— —	— —	— —	— —	— —
S3	28 *90*	32 *105*	38 *125*	34 *110*	39 *130*	46 *150*	30 *100*	35 *115*	42 *140*	— —	— —	— —	— —	— —	— —
S11	55 *180*	65 *215*	75 *245*	65 *215*	75 *245*	90 *295*	60 *195*	70 *230*	85 *280*	— —	— —	— —	— —	— —	— —
S12	38 *125*	44 *145*	50 *165*	46 *150*	55 *180*	65 *215*	41 *135*	48 *155*	55 *180*	— —	— —	— —	— —	— —	— —
S13	22 *70*	25 *80*	30 *100*	27 *90*	31 *100*	37 *120*	24 *80*	28 *90*	33 *110*	— —	— —	— —	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	37 *120*	42 *140*	50 *165*	43 *140*	50 *165*	60 *195*	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	40 *130*	46 *150*	55 *180*	47 *155*	55 *180*	65 *215*	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	47 *155*	55 *180*	65 *215*	55 *180*	65 *215*	75 *245*	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	80 *260*	90 *295*	110 *360*	85 *280*	95 *310*	115 *375*	— —	— —	— —
H21	— —	— —	— —	— —	— —	— —	40 *130*	46 *150*	55 *180*	47 *155*	55 *180*	65 *215*	— —	— —	— —

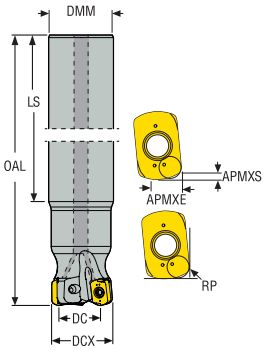


R217/220.21 HIGH FEED 4

Highfeed 4 for LO06 insert types, 4-cutting edge, double sided inserts.
The inserts is strong and reliable for applications with low demands on ramping capability. A wide selection of inserts and geometries make it easy to find the right combination for your application.

- Cutter range 20-63 mm (1 - 2.5 inch)
- Max depth of cut 0.9 mm
- First choice for ISO P & K materials in small-to-medium-size machines

R217.21-LO06 – Metric



- For insert selection and cutting data recommendations, see page(s) 495-497
- For complete insert programme, see page(s) 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm		kg	
R217.21-1820.0-LO06.2A	02952673	Cylindrical	13,3	20,0	2	0,9	2,5	18,0	134,9	160,0	1,8	1,0	33,3	38,0	35000	0,3	LO..06
R217.21-2525.0-LO06.3A	02828469	Cylindrical	18,3	25,0	3	0,9	2,5	25,0	140,0	180,0	1,8	0,8	43,3	48,0	30000	0,7	LO..06
R217.21-2527.0-LO06.3A	02828470	Cylindrical	20,3	27,0	3	0,9	2,5	25,0	175,0	200,0	1,8	0,7	47,3	52,0	29000	0,7	LO..06
R217.21-3232.0-LO06.4A	02828474	Cylindrical	25,3	32,0	4	0,9	2,5	32,0	160,0	200,0	1,8	0,5	57,3	62,0	27000	1,2	LO..06

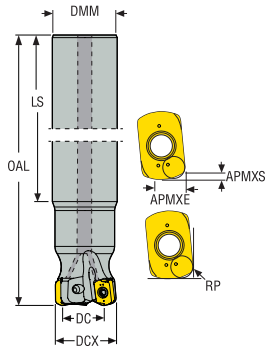
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-..	C02508-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-LO06 – Inch



- For insert selection and cutting data recommendations, see page(s) 495-497
- For complete insert programme, see page(s) 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.21-01.00-0-LO06-3A	02842018	Cylindrical	0.736	1.000	3	0.035	0.098	1.000	5.500	7.000	0.071	0,7	1.736	1.921	30000	1.540	LO..06
R217.21-01.25-0-LO06-4A	02842021	Cylindrical	0.984	1.250	4	0.035	0.098	1.250	6.500	8.000	0.071	0,5	2.234	2.421	27000	2.650	LO..06

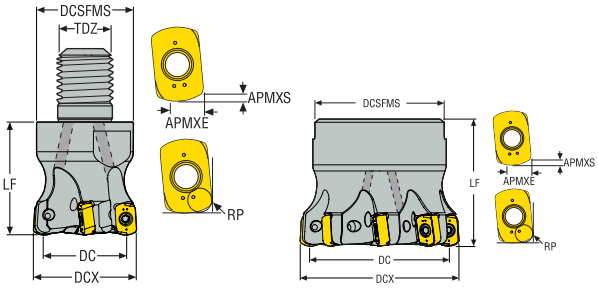
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21..	C02508-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LO06 – Metric



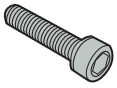
- For insert selection and cutting data recommendations, see page(s) 495-497
- For complete insert programme, see page(s) 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm		mm	mm	mm		mm	mm	kg		
R217.21-1020.RE-LO06.2A	03020137	Combimaster	13,3	20,0	2	0,9	2,5	–	M10	18,5	28,0	1,8	1,0	33,3	38,0	0,1	35000	LO..06
R217.21-1225.RE-LO06.3A	03020140	Combimaster	18,3	25,0	3	0,9	2,5	–	M12	23,0	30,0	1,8	0,8	43,3	48,0	0,1	30000	LO..06
R217.21-1225.RE-LO06.4A	02828468	Combimaster	18,3	25,0	4	0,9	2,5	–	M12	23,0	30,0	1,8	0,8	43,3	48,0	0,1	30000	LO..06
R217.21-1632.RE-LO06.4A	02927092	Combimaster	25,3	32,0	4	0,9	2,5	–	M16	30,0	35,0	1,8	0,5	57,3	62,0	0,2	27000	LO..06
R217.21-1632.RE-LO06.5A	02828471	Combimaster	25,3	32,0	5	0,9	2,5	–	M16	30,0	35,0	1,8	0,5	57,3	62,0	0,2	27000	LO..06
R217.21-1635.RE-LO06.5A	02828472	Combimaster	28,3	35,0	5	0,9	2,5	–	M16	30,0	35,0	1,8	0,5	63,3	68,0	0,2	26000	LO..06
R217.21-1640.RE-LO06.5A	02828478	Combimaster	33,3	40,0	5	0,9	2,5	–	M16	30,0	35,0	1,8	0,4	73,3	78,0	0,2	18000	LO..06
R217.21-2040.RE-LO06.6A	02991177	Combimaster	33,0	40,0	6	0,9	2,5	–	M20	36,5	40,0	1,8	0,4	73,3	78,0	0,4	18000	LO..06
R220.21-0035-LO06.6A	02952739	Arbor	28,3	35,0	6	0,9	2,5	16,0	–	32,0	35,0	1,8	0,5	63,3	68,0	0,2	24500	LO..06
R220.21-0040-LO06.7A	02927090	Arbor	33,3	40,0	7	0,9	2,5	16,0	–	35,0	40,0	1,8	0,4	73,3	78,0	0,2	18000	LO..06
R220.21-0042-LO06.7A	02828477	Arbor	35,3	42,0	7	0,9	2,5	16,0	–	35,0	40,0	1,8	0,4	77,3	82,0	0,2	18000	LO..06
R220.21-0050-LO06.8A	02927091	Arbor	43,3	50,0	8	0,9	2,5	22,0	–	42,0	40,0	1,8	0,3	93,3	98,0	0,3	16000	LO..06
R220.21-0052-LO06.8A	02952735	Arbor	45,3	52,0	8	0,9	2,5	22,0	–	42,0	40,0	1,8	0,3	97,3	102,0	0,4	16000	LO..06
R220.21-0063-LO06.9A	02952736	Arbor	56,3	63,0	9	0,9	2,5	22,0	–	47,0	40,0	1,8	0,25	119,3	124,0	0,5	15000	LO..06

For Combimaster Shanks, see Machining Navigator Tooling System

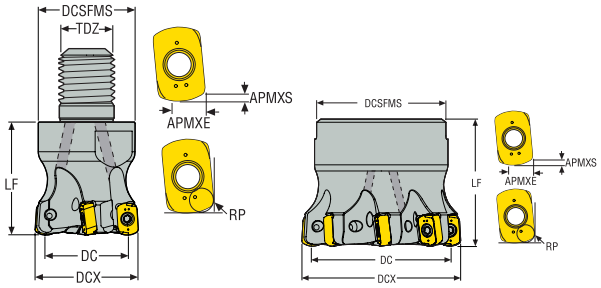
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.21-..	–	C02508-T08P	T00-08P12	1.2NM
R220.21- Ø35	MC6S8X25	C02508-T08P	T00-08P12	1.2NM
R220.21- Ø40-42	220.17-689	C02508-T08P	T00-08P12	1.2NM
R220.21- Ø50-63	220.17-692	C02508-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LO06 – Inch



- For insert selection and cutting data recommendations, see page(s) 495-497
- For complete insert programme, see page(s) 738
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch	Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.21-01.00-12RE-LO06-3A	02842016	Combimaster	0.736	1.000	3	0.035	0.098	–	M12	0.906	1.181	0.071	0,7	1.736	1.921	0.220	30000	LO..06
R217.21-01.00-12RE-LO06-4A	02842017	Combimaster	0.736	1.000	4	0.035	0.098	–	M12	0.906	1.181	0.071	0,7	1.736	1.921	0.220	30000	LO..06
R217.21-01.25-16RE-LO06-4A	02952694	Combimaster	0.984	1.250	4	0.035	0.098	–	M16	1.181	1.378	0.071	0,5	2.234	2.421	0.440	27000	LO..06
R217.21-01.25-16RE-LO06-5A	02842019	Combimaster	0.984	1.250	5	0.035	0.098	–	M16	1.181	1.378	0.071	0,5	2.234	2.421	0.440	27000	LO..06
R217.21-01.50-16RE-LO06-5A	02952695	Combimaster	1.236	1.500	5	0.035	0.098	–	M16	1.181	1.378	0.071	0,4	2.736	2.921	0.440	18000	LO..06
R217.21-01.50-20RE-LO06.6A	03002406	Combimaster	1.299	1.500	6	0.035	0.098	–	M20	1.437	1.575	0.071	0,4	2.736	2.921	0.660	18000	LO..06
R220.21-01.50-LO06-6A	02842022	Arbor	1.236	1.500	6	0.035	0.098	0.500	–	1.260	1.500	0.071	0,4	2.736	2.921	0.440	18000	LO..06
R220.21-02.00-LO06-8A	02952697	Arbor	1.736	2.000	8	0.035	0.098	0.750	–	1.654	1.500	0.071	0,3	3.736	3.921	0.880	16000	LO..06
R220.21-02.50-LO06-9A	02952698	Arbor	2.236	2.500	9	0.035	0.098	0.750	–	1.850	1.500	0.071	0,25	4.736	4.921	1.100	15000	LO..06

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.21-..	–	C02508-T08P	T00-08P12	10.6IN.LBS
R220.21-1.50	UC6S1/4UNFX1	C02508-T08P	T00-08P12	10.6IN.LBS
R220.21-2.00-2.50	UC6S3/8UNFX1	C02508-T08P	T00-08P12	10.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-LO06 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	LOHT060310TR-ME06 T350M	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
P2	LOHT060310TR-ME06 T350M	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
P3	LOHT060310TR-ME06 T350M	0,80 *0.032*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
P4	LOHT060310TR-M07 MP2501	0,80 *0.032*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
P5	LOHT060310TR-M07 MP2501	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P6	LOHT060310TR-M07 MP2501	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P7	LOHT060310TR-M07 MP2501	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P8	LOHT060310TR-M07 MS2500	0,80 *0.032*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
P11	LOHT060310TR-M07 MS2500	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P12	LOHT060310TR-M07 MS2500	0,65 *0.026*	0,42 *0.017*	0,42 *0.017*	0,48 *0.019*
M1	LOHT060310TR-ME06 MS2050	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
M2	LOHT060310TR-ME06 MS2050	0,80 *0.032*	0,48 *0.019*	0,48 *0.019*	0,55 *0.022*
M3	LOHT060310TR-ME06 MS2050	0,65 *0.026*	0,44 *0.017*	0,44 *0.017*	0,48 *0.019*
M4	LOHT060310TR-ME06 T350M	0,48 *0.019*	0,44 *0.017*	0,44 *0.017*	0,50 *0.020*
M5	LOHT060310TR-ME06 T350M	0,48 *0.019*	0,44 *0.017*	0,44 *0.017*	0,50 *0.020*
K1	LOHT060310TR-MD07 MK2050	0,80 *0.032*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
K2	LOHT060310TR-MD07 MK2050	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
K3	LOHT060310TR-MD07 MK2050	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
K4	LOHW060310TR-D07 MP1500	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
K5	LOHW060310TR-D07 MP1500	0,80 *0.032*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
K6	LOHT060310TR-MD07 MK2050	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
K7	LOHT060310TR-MD07 MK2050	0,80 *0.032*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S1	LOHT060310TR-M07 MS2500	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S2	LOHT060310TR-M07 MS2500	0,48 *0.019*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S3	LOHT060310TR-M07 MS2500	0,48 *0.019*	0,48 *0.019*	0,48 *0.019*	0,55 *0.022*
S11	LOHT060310TR-ME06 MS2050	0,55 *0.022*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
S12	LOHT060310TR-ME06 MS2050	0,55 *0.022*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
S13	LOHT060310TR-ME06 MS2050	0,48 *0.019*	0,44 *0.017*	0,44 *0.017*	0,50 *0.020*
H5	LOHW060310TR-D07 MH1000	0,50 *0.020*	0,42 *0.017*	0,42 *0.017*	0,48 *0.019*
H8	LOHW060310TR-D07 MH1000	0,44 *0.017*	0,34 *0.013*	0,34 *0.013*	0,38 *0.015*
H11	LOHT060310TR-M07 T350M	0,50 *0.020*	0,42 *0.017*	0,42 *0.017*	0,48 *0.019*
H12	LOHT060310TR-M07 T350M	0,44 *0.017*	0,34 *0.013*	0,34 *0.013*	0,38 *0.015*
H21	LOHW060310TR-D07 MH1000	0,44 *0.017*	0,34 *0.013*	0,34 *0.013*	0,38 *0.015*

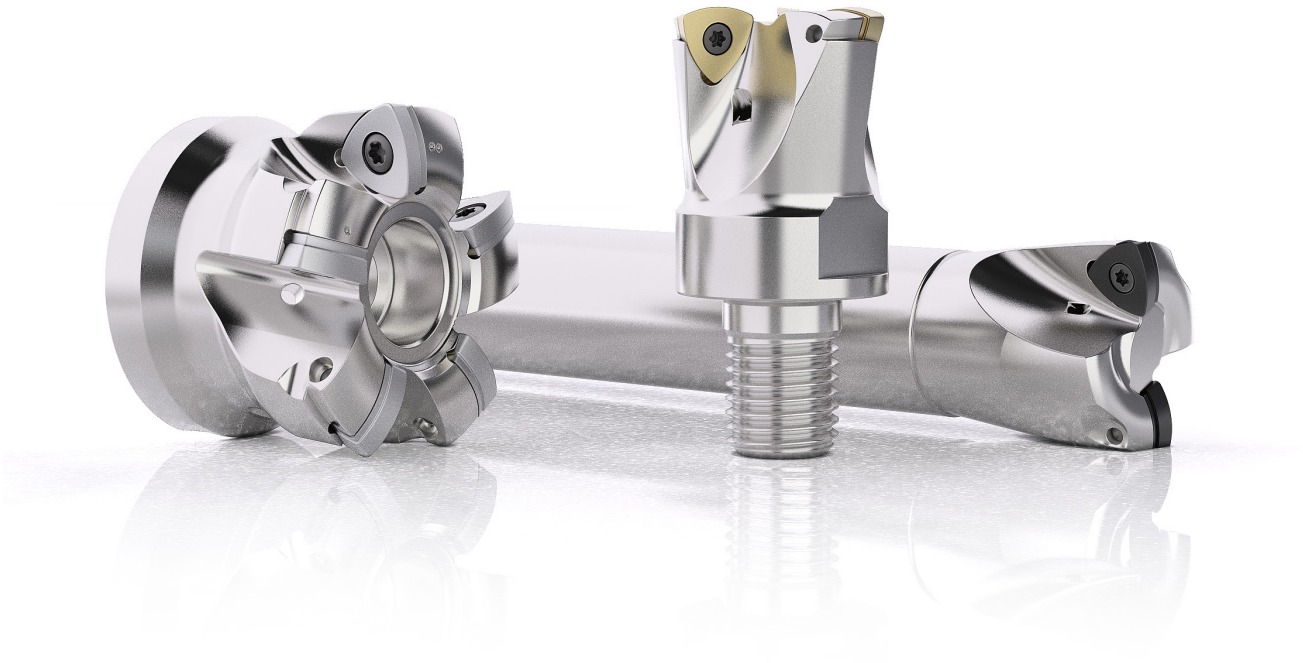
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.21-LO06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	285	320	380	270	305	365	275	310	375	260	295	355	240	270	325	210	235	285
	940	*1050*	*1250*	*890*	*1000*	*1200*	*900*	*1025*	*1225*	*850*	*970*	*1175*	*790*	*890*	*1075*	*690*	*770*	*940*
P2	275	310	370	265	300	355	270	305	365	255	285	345	235	265	315	205	230	275
	900	*1025*	*1225*	*870*	*980*	*1175*	*890*	*1000*	*1200*	*840*	*940*	*1125*	*770*	*870*	*1025*	*670*	*750*	*900*
P3	240	270	325	230	255	315	230	260	320	220	245	300	200	225	280	175	200	240
	790	*890*	*1075*	*750*	*840*	*1025*	*750*	*850*	*1050*	*720*	*800*	*980*	*660*	*740*	*920*	*570*	*660*	*790*
P4	210	235	290	200	225	275	205	230	280	195	220	265	180	200	245	155	175	215
	690	*770*	*950*	*660*	*740*	*900*	*670*	*750*	*920*	*640*	*720*	*870*	*590*	*660*	*800*	*510*	*570*	*710*
P5	205	230	275	195	220	265	200	225	270	190	215	255	175	195	235	150	170	205
	670	*750*	*900*	*640*	*720*	*870*	*660*	*740*	*890*	*620*	*710*	*840*	*570*	*640*	*770*	*490*	*560*	*670*
P6	230	260	310	220	250	295	225	255	300	210	240	285	195	220	260	170	190	230
	750	*850*	*1025*	*720*	*820*	*970*	*740*	*840*	*980*	*690*	*790*	*940*	*640*	*720*	*850*	*560*	*620*	*750*
P7	215	245	290	210	235	280	210	240	285	200	225	270	185	210	250	160	180	215
	710	*800*	*950*	*690*	*770*	*920*	*690*	*790*	*940*	*660*	*740*	*890*	*610*	*690*	*820*	*520*	*590*	*710*
P8	200	225	275	190	215	265	195	220	270	185	210	255	170	190	235	150	165	205
	660	*740*	*900*	*620*	*710*	*870*	*640*	*720*	*890*	*610*	*690*	*840*	*560*	*620*	*770*	*490*	*540*	*670*
P11	210	235	285	200	225	270	205	230	275	195	220	260	180	200	240	155	175	210
	690	*770*	*940*	*660*	*740*	*890*	*670*	*750*	*900*	*640*	*720*	*850*	*590*	*660*	*790*	*510*	*570*	*690*
P12	140	155	185	130	150	180	135	150	180	125	145	170	115	130	160	100	115	135
	460	*510*	*610*	*425*	*490*	*590*	*445*	*490*	*590*	*410*	*475*	*560*	*375*	*425*	*520*	*330*	*375*	*445*
M1	—	—	—	190	215	255	195	220	260	190	215	255	180	205	245	165	185	220
	—	—	—	*620*	*710*	*840*	*640*	*720*	*850*	*620*	*710*	*840*	*590*	*670*	*800*	*540*	*610*	*720*
M2	—	—	—	155	175	210	160	180	215	160	180	210	150	170	200	135	155	185
	—	—	—	*510*	*570*	*690*	*520*	*590*	*710*	*520*	*590*	*690*	*490*	*560*	*660*	*445*	*510*	*610*
M3	—	—	—	125	140	170	130	145	175	130	145	175	120	135	165	110	125	150
	—	—	—	*410*	*460*	*560*	*425*	*475*	*570*	*425*	*475*	*570*	*395*	*445*	*540*	*360*	*410*	*490*
M4	—	—	—	100	110	130	100	115	135	100	110	130	95	105	125	85	95	115
	—	—	—	*330*	*360*	*425*	*330*	*375*	*445*	*330*	*360*	*425*	*310*	*345*	*410*	*280*	*310*	*375*
M5	—	—	—	85	95	110	85	95	110	85	95	110	80	90	105	70	80	95
	—	—	—	*280*	*310*	*360*	*280*	*310*	*360*	*280*	*310*	*360*	*260*	*295*	*345*	*230*	*260*	*310*
K1	220	245	295	210	235	280	215	240	290	200	230	270	185	210	250	160	180	220
	720	*800*	*970*	*690*	*770*	*920*	*710*	*790*	*950*	*660*	*750*	*890*	*610*	*690*	*820*	*520*	*590*	*720*
K2	195	220	260	185	210	250	190	215	255	180	200	240	165	185	220	145	160	195
	640	*720*	*850*	*610*	*690*	*820*	*620*	*710*	*840*	*590*	*660*	*790*	*540*	*610*	*720*	*475*	*520*	*640*
K3	165	185	220	160	175	210	160	180	215	150	170	205	140	155	190	120	135	165
	540	*610*	*720*	*520*	*570*	*690*	*520*	*590*	*710*	*490*	*560*	*670*	*460*	*510*	*620*	*395*	*445*	*540*
K4	155	175	210	150	170	200	155	175	205	145	165	195	135	150	180	115	130	155
	510	*570*	*690*	*490*	*560*	*660*	*510*	*570*	*670*	*475*	*540*	*640*	*445*	*490*	*590*	*375*	*425*	*510*
K5	95	110	130	90	105	125	95	105	125	90	100	120	80	90	110	70	80	95
	310	*360*	*425*	*295*	*345*	*410*	*310*	*345*	*410*	*295*	*330*	*395*	*260*	*295*	*360*	*230*	*260*	*310*
K6	140	155	185	135	150	180	135	150	180	130	145	170	120	130	160	100	115	135
	460	*510*	*610*	*445*	*490*	*590*	*445*	*490*	*590*	*425*	*475*	*560*	*395*	*425*	*520*	*330*	*375*	*445*
K7	125	140	165	120	135	155	120	135	160	115	130	150	105	120	140	90	100	120
	410	*460*	*540*	*395*	*445*	*510*	*395*	*445*	*520*	*375*	*425*	*490*	*345*	*395*	*460*	*295*	*330*	*395*
S1	—	—	—	48	55	65	49	55	65	47	50	60	44	50	60	40	45	55
	—	—	—	*155*	*180*	*215*	*160*	*180*	*215*	*155*	*165*	*195*	*145*	*165*	*195*	*130*	*150*	*180*
S2	—	—	—	39	44	50	40	45	55	38	42	50	36	40	47	32	36	43
	—	—	—	*130*	*145*	*165*	*130*	*150*	*180*	*125*	*140*	*165*	*120*	*130*	*155*	*105*	*120*	*140*
S3	—	—	—	34	38	45	35	39	46	33	37	44	31	35	41	28	32	38
	—	—	—	*110*	*125*	*150*	*115*	*130*	*150*	*110*	*120*	*145*	*100*	*115*	*135*	*90*	*105*	*125*
S11	—	—	—	65	75	90	70	75	95	65	70	90	60	70	85	55	60	75
	—	—	—	*215*	*245*	*295*	*230*	*245*	*310*	*215*	*230*	*295*	*195*	*230*	*280*	*180*	*195*	*245*
S12	—	—	—	46	50	65	47	55	65	45	50	60	42	47	60	38	43	50
	—	—	—	*150*	*165*	*215*	*155*	*180*	*215*	*150*	*165*	*195*	*140*	*155*	*195*	*125*	*140*	*165*
S13	—	—	—	27	31	36	28	31	37	26	29	35	25	28	33	23	25	30
	—	—	—	*90*	*100*	*120*	*90*	*100*	*120*	*85*	*95*	*115*	*80*	*90*	*110*	*75*	*80*	*100*
H5	47	55	65	41	46	55	42	47	55	41	46	55	40	45	55	35	39	47
	155	*180*	*215*	*135*	*150*	*180*	*140*	*155*	*180*	*135*	*150*	*180*	*130*	*150*	*180*	*115*	*130*	*155*
H8	50	55	70	44	49	60	45	50	60	44	49	60	43	48	60	37	42	50
	165	*180*	*230*	*145*	*160*	*195*	*150*	*165*	*195*	*145*	*160*	*195*	*140*	*155*	*195*	*120*	*140*	*165*
H11	60	70	80	50	60	70	55	60	70	50	60	70	50	60	70	45	50	60
	195	*230*	*260*	*165*	*195*	*230*	*180*	*195*	*230*	*165*	*195*	*230*	*165*	*195*	*230*	*150*	*165*	*195*
H12	90	100	120	85	100	115	90	100	120	85	95	110	75	85	105	65	75	90
	295	*330*	*395*	*280*	*330*	*375*	*295*	*330*	*395*	*280*	*310*	*360*	*245*	*280*	*345*	*215*	*245*	*295*
H21	50	55	70	44	49	60	45	50	60	44	49	60	43	48	60	37	42	50
	165	*180*	*230*	*145*	*160*	*195*	*150*	*165*	*195*	*145*	*160*	*195*	*140*	*155*	*195*	*120*	*140*	*165*

R217/220.21-LO06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500			MK2050			MS2050			MS2500			MH1000		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	185 *610*	205 *670*	250 *820*	250 *820*	280 *920*	335 *1100*	230 *750*	260 *850*	310 *1025*	300 *980*	340 *1125*	405 *1325*	— —	— —	— —
P2	180 *590*	200 *660*	245 *800*	240 *790*	270 *890*	325 *1075*	225 *740*	255 *840*	305 *1000*	295 *970*	330 *1075*	395 *1300*	— —	— —	— —
P3	155 *510*	175 *570*	210 *690*	205 *670*	235 *770*	285 *940*	195 *640*	220 *720*	265 *870*	255 *840*	285 *940*	350 *1150*	— —	— —	— —
P4	140 *460*	155 *510*	190 *620*	185 *610*	205 *670*	250 *820*	170 *560*	190 *620*	235 *770*	225 *740*	250 *820*	305 *1000*	— —	— —	— —
P5	135 *445*	150 *490*	180 *590*	180 *590*	200 *660*	240 *790*	165 *540*	190 *620*	225 *740*	220 *720*	245 *800*	290 *950*	— —	— —	— —
P6	150 *490*	170 *560*	205 *670*	200 *660*	225 *740*	270 *890*	185 *610*	210 *690*	250 *820*	245 *800*	275 *900*	330 *1075*	— —	— —	— —
P7	140 *460*	160 *520*	190 *620*	190 *620*	215 *710*	255 *840*	175 *570*	200 *660*	235 *770*	230 *750*	260 *850*	310 *1025*	— —	— —	— —
P8	130 *425*	150 *490*	175 *570*	175 *570*	195 *640*	240 *790*	160 *520*	185 *610*	225 *740*	215 *710*	240 *790*	290 *950*	— —	— —	— —
P11	140 *460*	155 *510*	185 *610*	185 *610*	205 *670*	245 *800*	170 *560*	195 *640*	230 *750*	225 *740*	255 *840*	300 *980*	— —	— —	— —
P12	90 *295*	100 *330*	120 *395*	120 *395*	135 *445*	160 *520*	110 *360*	125 *410*	150 *490*	145 *475*	165 *540*	195 *640*	— —	— —	— —
M1	155 *510*	170 *560*	210 *690*	— —	— —	— —	180 *590*	205 *670*	245 *800*	210 *690*	235 *770*	285 *940*	— —	— —	— —
M2	130 *425*	145 *475*	175 *570*	— —	— —	— —	150 *490*	170 *560*	200 *660*	175 *570*	195 *640*	235 *770*	— —	— —	— —
M3	105 *345*	115 *375*	140 *460*	— —	— —	— —	120 *395*	135 *445*	165 *540*	140 *460*	160 *520*	190 *620*	— —	— —	— —
M4	80 *260*	90 *295*	110 *360*	— —	— —	— —	95 *310*	105 *345*	125 *410*	110 *360*	125 *410*	145 *475*	— —	— —	— —
M5	65 *215*	75 *245*	90 *295*	— —	— —	— —	80 *260*	90 *295*	105 *345*	90 *295*	105 *345*	120 *395*	— —	— —	— —
K1	— —	— —	— —	260 *850*	295 *970*	350 *1150*	— —	— —	— —	— —	— —	— —	200 *660*	225 *740*	270 *890*
K2	— —	— —	— —	230 *750*	260 *850*	310 *1025*	— —	— —	— —	— —	— —	— —	180 *590*	200 *660*	240 *790*
K3	— —	— —	— —	195 *640*	220 *720*	260 *850*	— —	— —	— —	— —	— —	— —	150 *490*	170 *560*	205 *670*
K4	— —	— —	— —	185 *610*	210 *690*	250 *820*	— —	— —	— —	— —	— —	— —	145 *475*	165 *540*	195 *640*
K5	— —	— —	— —	115 *375*	130 *425*	150 *490*	— —	— —	— —	— —	— —	— —	90 *295*	100 *330*	120 *395*
K6	— —	— —	— —	165 *540*	185 *610*	220 *720*	— —	— —	— —	— —	— —	— —	125 *410*	145 *475*	170 *560*
K7	— —	— —	— —	145 *475*	165 *540*	195 *640*	— —	— —	— —	— —	— —	— —	115 *375*	125 *410*	150 *490*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	25 *80*	28 *90*	33 *110*	— —	— —	— —	44 *145*	50 *165*	60 *195*	55 *180*	60 *195*	70 *230*	— —	— —	— —
S2	20 *65*	22 *70*	27 *90*	— —	— —	— —	36 *120*	40 *130*	47 *155*	43 *140*	49 *160*	55 *180*	— —	— —	— —
S3	17 *55*	20 *65*	23 *75*	— —	— —	— —	31 *100*	35 *115*	41 *135*	38 *125*	42 *140*	50 *165*	— —	— —	— —
S11	34 *110*	39 *130*	46 *150*	— —	— —	— —	60 *195*	70 *230*	85 *280*	75 *245*	85 *280*	100 *330*	— —	— —	— —
S12	32 *105*	36 *120*	42 *140*	— —	— —	— —	42 *140*	47 *155*	60 *195*	50 *165*	60 *195*	70 *230*	— —	— —	— —
S13	18 *60*	21 *70*	25 *80*	— —	— —	— —	25 *80*	28 *90*	33 *110*	30 *100*	34 *110*	40 *130*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	44 *145*	49 *160*	60 *195*
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	47 *155*	50 *165*	60 *195*
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	60 *195*	75 *245*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	85 *280*	95 *310*	110 *360*
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	47 *155*	50 *165*	60 *195*

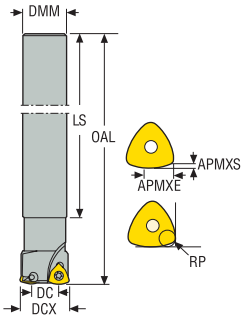


R217/220.21 HIGH FEED

High feed mills for general purpose applications, 3-cutting edge, single sided inserts.
218.19 insert range include a wide selection of cutting geometries and grades for many different materials.

- Cutter range 16-208 mm (.75 - 8 inch)
- Suitable for long overhangs and/or unstable conditions
- Small-to-medium sized CNC machines with high rpms and high feed rates
- Also works for machines that run lower rpms and feed rates

R217.21 – Metric



- For insert selection and cutting data recommendations, see page(s) 505-515
- For complete insert programme, see page(s) 787
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm		kg	
R217.21-1416.0-R080.2A	02554443	Cylindrical	9,25	16,0	2	0,63	5,0	14,0	127,0	150,0	1,0	6,1	25,25	30,0	53400	0,2	218.19-080
R217.21-1820.0-R100.2A	02554439	Cylindrical	11,4	20,0	2	0,74	7,0	18,0	132,0	160,0	1,47	5,7	31,4	38,0	32600	0,3	218.19-100
R217.21-2025.0-R100.2A	02616308	Cylindrical	16,46	25,0	2	0,74	7,0	20,0	140,0	170,0	1,47	3,48	41,46	48,0	29100	0,4	218.19-100
R217.21-2525.0-R100.3A	02616320	Cylindrical	16,46	25,0	3	0,74	7,0	25,0	135,0	170,0	1,47	3,48	41,46	48,0	29100	0,6	218.19-100
R217.21-2532.0-R125.2A	02616323	Cylindrical	21,16	32,0	2	1,0	9,0	25,0	161,0	195,0	1,74	3,67	53,16	62,0	19700	0,8	218.19-125
R217.21-3232.0-R125.3A	02616325	Cylindrical	21,16	32,0	3	1,0	9,0	32,0	155,0	195,0	1,74	3,67	53,16	62,0	19700	1,1	218.19-125

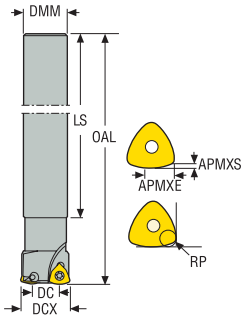
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.21-R080	C02205-T07P	T00-07P09	0.9NM
R217.21-R100	C02506-T08P	T00-08P12	1.2NM
R217.21-R125	C03007-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21 – Inch



- For insert selection and cutting data recommendations, see page(s) 505-515
- For complete insert programme, see page(s) 787
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DMM	LS	OAL	RP	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.21-00.625-0-R080.2A	02559352	Cylindrical	0.360	0.625	2	0.025	0.197	0.625	5.000	6.000	0.039	6,0	0.985	1.171	53400	0.660	218.19-080
R217.21-00.750-0-R100.2A	02559353	Cylindrical	0.410	0.750	2	0.029	0.276	0.750	5.250	6.500	0.058	6,45	1.160	1.421	32600	1.100	218.19-100
R217.21-00.750-0-R100.2HA	02548132	Cylindrical	0.357	0.750	2	0.043	0.276	0.750	5.250	6.500	0.071	4,5	1.107	1.421	32600	1.100	218.19-100
R217.21-01.00-0-R100.3A	02559354	Cylindrical	0.660	1.000	3	0.029	0.276	1.000	5.512	7.000	0.058	3,38	1.660	1.921	29100	1.320	218.19-100
R217.21-01.00-0-R125-2HA	02553724	Cylindrical	0.502	1.000	2	0.059	0.354	1.000	5.512	7.039	0.086	4,1	1.502	1.921	29100	1.540	218.19-125
R217.21-01.25-0-R125-3A	02553726	Cylindrical	0.823	1.250	3	0.039	0.354	1.250	5.906	7.500	0.069	3,73	2.073	2.421	19700	2.430	218.19-125
R217.21-01.25-0-R160-2HA	02553730	Cylindrical	0.583	1.250	2	0.080	0.433	1.250	5.906	7.500	0.121	3,37	1.833	2.421	16200	2.650	218.19-160
R217.21-01.50-0-R160-3HA	02553733	Cylindrical	0.591	1.500	3	0.080	0.433	1.500	5.906	8.000	0.120	3,09	2.091	2.921	17600	3.750	218.19-160

Spare Parts

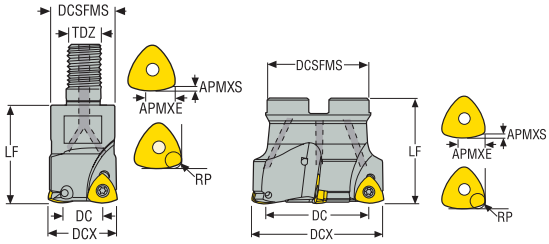
For cutter	Insert screw
R217.21-00.625	C02205-T07P
R217.21-0.75/1.00/0.75HA	C02506-T08P
R217.21-1.25/1.50/1.00HA	C03007-T09P
R217.21-1.25HA/1.50HA	C03510-T15P

Accessories

Torque key	Torque value
T00-07P09	8.0IN.LBS
T00-08P12	10.6IN.LBS
T00-09P20	17.7IN.LBS
T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21 – Metric



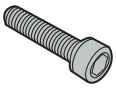
- For insert selection and cutting data recommendations, see page(s) 505-515
- For complete insert programme, see page(s) 787
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm		mm	mm	mm		mm	mm	kg		
R217.21-0816.RE-R080.2	00030707	Combimaster	9,25	16,0	2	0,6	5,0	–	M8	13,5	23,0	1,0	6,1	25,25	30,0	0,1	53400	218.19-080
R217.21-1020.RE-R100.2A	00030708	Combimaster	11,45	20,0	2	0,7	7,0	–	M10	18,5	28,0	1,47	5,71	31,45	38,0	0,1	32600	218.19-100
R217.21-1020.RE-R100.2HA	02546332	Combimaster	10,44	20,0	2	1,0	7,0	–	M10	18,5	28,0	1,7	4,32	30,44	38,0	0,1	32600	218.19-100
R217.21-1225.RE-R100.3A	00030710	Combimaster	16,46	25,0	3	0,7	7,0	–	M12	23,0	35,0	1,47	3,48	41,46	48,0	0,1	29100	218.19-100
R217.21-1225.RE-R125.2HA	02502370	Combimaster	12,36	25,0	2	1,5	9,0	–	M12	23,0	35,0	2,18	4,25	37,36	48,0	0,1	29100	218.19-125
R217.21-1632.RE-R125.3A	00030714	Combimaster	21,21	32,0	3	1,0	9,0	–	M16	30,0	40,0	1,74	3,7	53,21	62,0	0,3	19700	218.19-125
R217.21-1632.RE-R160.2HA	02546333	Combimaster	16,09	32,0	2	1,8	11,0	–	M16	30,0	40,0	2,87	3,76	48,09	62,0	0,2	16200	218.19-160
R217.21-1635.RE-R125.3A	00030715	Combimaster	24,16	35,0	3	1,0	9,0	–	M16	30,0	40,0	1,74	3,1	59,16	68,0	0,2	18800	218.19-125
R217.21-1640.RE-R125.4A	00039503	Combimaster	29,25	40,0	4	1,0	9,0	–	M16	30,0	40,0	1,74	2,47	69,25	78,0	0,3	17600	218.19-125
R217.21-1640.RE-R160.3HA	02546335	Combimaster	23,99	40,0	3	1,8	11,0	–	M16	30,0	40,0	2,87	2,18	63,99	78,0	0,2	14500	218.19-160
R220.21-0040-R125.4A	00030717	Arbor	29,2	40,0	4	1,0	9,0	16,0	–	35,0	40,0	1,75	2,47	69,2	78,0	0,2	17600	218.19-125
R220.21-0042-R125.4A	00030720	Arbor	31,2	42,0	4	1,0	9,0	16,0	–	35,0	40,0	1,75	2,28	73,2	82,0	0,2	17200	218.19-125
R220.21-0050-R160.4A	00030723	Arbor	34,17	50,0	4	1,8	11,0	22,0	–	47,0	40,0	2,85	1,47	84,17	98,0	0,3	12900	218.19-160
R220.21-0050-R160.5A	03136664	Arbor	33,7	50,0	5	1,8	11,0	22,0	–	47,0	40,0	3,01	0,9	83,7	98,0	0,4	12900	218.19-160
R220.21-0052-R160.4A	02425827	Arbor	36,19	52,0	4	1,8	11,0	22,0	–	47,0	40,0	2,85	1,38	88,19	102,0	0,4	12700	218.19-160
R220.21-0052-R160.5A	03136665	Arbor	35,7	52,0	5	1,8	11,0	22,0	–	47,0	40,0	3,03	0,8	87,7	102,0	0,4	12700	218.19-160
R220.21-0063-R160.4A	00030724	Arbor	47,2	63,0	4	1,8	11,0	27,0	–	50,0	50,0	2,85	1,0	110,2	124,0	0,5	11500	218.19-160
R220.21-0063-R160.5A	00030726	Arbor	47,2	63,0	5	1,8	11,0	27,0	–	50,0	50,0	2,85	1,0	110,2	124,0	0,6	11500	218.19-160
R220.21-0063-R160.6A	03136666	Arbor	47,9	63,0	6	1,8	11,0	27,0	–	50,0	50,0	3,0	0,6	110,9	124,0	0,6	11500	218.19-160
R220.21-0066-R160.5A	02409011	Arbor	50,21	66,0	5	1,8	11,0	27,0	–	50,0	50,0	2,85	0,95	116,21	130,0	0,6	11200	218.19-160
R220.21-0066-R160.6A	03136667	Arbor	50,9	66,0	6	1,8	11,0	27,0	–	62,0	50,0	3,0	0,5	116,9	130,0	0,8	11200	218.19-160
R220.21-0080-R160.6A	02530950	Arbor	64,15	80,0	6	1,8	11,0	27,0	–	62,0	50,0	2,85	0,73	144,15	158,0	1,0	10200	218.19-160
R220.21-0080-R160.7A	03136668	Arbor	63,6	80,0	7	1,8	11,0	27,0	–	62,0	50,0	3,0	0,4	143,6	158,0	1,3	10200	218.19-160
R220.21-0084-R160.6A	02969095	Arbor	68,0	84,0	6	1,8	11,0	32,0	–	77,0	50,0	2,85	0,7	152,0	166,0	1,4	10000	218.19-160
R220.21-0100-R160.7A	02530946	Arbor	84,13	100,0	7	1,8	11,0	32,0	–	77,0	50,0	2,85	0,54	184,13	198,0	1,6	9700	218.19-160
R220.21-0100-R160.9A	03136671	Arbor	83,6	100,0	9	1,8	11,0	32,0	–	77,0	50,0	3,0	0,3	183,6	198,0	1,6	9700	218.19-160

For Combimaster Shanks, see Machining Navigator Tooling System

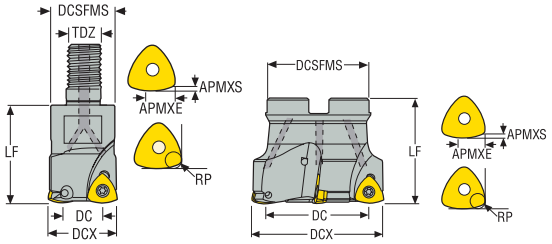
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.21-R080	–	C02205-T07P	T00-07P09	0.9NM
R217.21-R100	–	C02506-T08P	T00-08P12	1.2NM
R217.21-R125	–	C03007-T09P	T00-09P20	2.0NM
R217.21-R160	–	C03510-T15P	T00-15P30	3.0NM
R220.21-0040-0042	220.17-689	C03007-T09P	T00-09P20	2.0NM
R220.21-0050-0052	220.17-692	C03510-T15P	T00-15P30	3.0NM
R220.21-0063-0080	MC6S12X35	C03510-T15P	T00-15P30	3.0NM
R220.21-0084	950E1645	C03510-T15P	T00-15P30	3.0NM
R220.21-0100	220.17-694	C03510-T15P	T00-15P30	3.0NM
R220.21-0100.9A	950E1645	C03510-T15P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21 – Inch



- For insert selection and cutting data recommendations, see page(s) 505-515
- For complete insert programme, see page(s) 787
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch	Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.21-00.750-10RE-R100-2A	00098320	Combimaster	0.414	0.750	2	0.028	0.276	–	M10	0.728	1.100	0.058	6,45	1.164	1.421	0.440	32600	218.19-100
R217.21-00.750-10RE-R100-2HA	02548133	Combimaster	0.357	0.750	2	0.043	0.276	–	M10	0.728	1.100	0.071	4,5	1.107	1.421	0.440	32600	218.19-100
R217.21-01.00-12RE-R100-3A	00098330	Combimaster	0.663	1.000	3	0.028	0.276	–	M12	0.906	1.400	0.058	3,38	1.663	1.921	0.440	29100	218.19-100
R217.21-01.25-16RE-R160-2HA	02548129	Combimaster	0.543	1.250	2	0.079	0.433	–	M16	1.181	1.600	0.121	3,37	1.793	2.421	0.660	16200	218.19-160
R217.21-01.25-16RE-R125-3A	00098351	Combimaster	0.823	1.250	3	0.039	0.354	–	M16	1.181	1.600	0.069	3,73	2.073	2.421	0.660	19700	218.19-125
R217.21-01.50-16RE-R160-3HA	02548130	Combimaster	0.791	1.498	3	0.079	0.433	–	M16	1.181	1.600	0.121	1,96	2.289	2.917	0.880	14500	218.19-160
R217.21-01.50-16RE-R125-4A	02435615	Combimaster	1.002	1.500	4	0.059	0.354	–	M16	1.181	1.600	0.086	1,69	2.502	2.921	0.660	17600	218.19-125
R217.21-01.50-20RE-R160-3HA	02928067	Combimaster	0.906	1.500	3	0.079	0.433	–	M20	1.437	1.600	0.113	2,18	2.406	2.921	0.660	14500	218.19-160
R220.21-01.50-R125-4A	00098850	Arbor	1.002	1.500	4	0.060	0.354	0.500	–	1.378	1.600	0.087	1,69	2.502	2.921	0.660	17600	218.19-125
R220.21-02.00-R160-3A	00098930	Arbor	1.346	2.000	3	0.079	0.433	0.750	–	1.850	1.600	0.119	1,17	3.346	3.921	1.100	12900	218.19-160
R220.21-02.00-R160-4A	00098952	Arbor	1.346	2.000	4	0.079	0.433	0.750	–	1.850	1.600	0.119	1,17	3.346	3.921	1.100	12900	218.19-160
R220.21-02.00-R160-5A	02789050	Arbor	1.327	2.000	5	0.079	0.433	0.750	–	1.850	1.600	0.119	1,17	3.327	3.921	1.100	12900	218.19-160
R220.21-02.50-R160-5A	00099029	Arbor	1.843	2.500	5	0.079	0.433	0.750	–	2.350	2.000	0.119	0,83	4.343	4.921	1.540	11500	218.19-160
R220.21-02.50-R160-6A	02825654	Arbor	1.827	2.500	6	0.079	0.433	0.750	–	2.350	2.000	0.119	0,83	4.327	4.921	1.980	11500	218.19-160
R220.21-03.00-R160-6A	02427189	Arbor	2.280	3.000	6	0.098	0.433	1.000	–	2.441	2.000	0.138	0,39	5.280	5.921	2.200	10200	218.19-160
R220.21-03.00-R160-7A	02828389	Arbor	2.348	3.000	7	0.079	0.433	1.000	–	2.441	2.000	0.119	0,39	5.348	5.921	2.430	10200	218.19-160
R220.21-04.00-R160-7A	02427191	Arbor	3.286	4.000	7	0.098	0.433	1.500	–	3.543	2.000	0.138	0,27	7.286	7.921	4.630	9100	218.19-160
R220.21-04.00-R160-9A	02810684	Arbor	3.348	4.000	9	0.083	0.433	1.500	–	3.543	2.000	0.119	0,27	7.348	7.921	4.630	9100	218.19-160

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.21-0.75/1.00/0.75HA	–	C02506-T08P	T00-08P12	10.6IN.LBS
R217.21-1.25HA/1.50HA	–	C03510-T15P	T00-15P30	26.6IN.LBS
R217.21-1.25/1.50/1.00HA	–	C03007-T09P	T00-09P20	17.7IN.LBS
R220.21-01.50	UC6S1/4UNFX1	C03007-T09P	T00-09P20	17.7IN.LBS
R220.21-02.00	UC6S3/8UNFX1	C03510-T15P	T00-15P30	26.6IN.LBS
R220.21-02.00.5A	UC6S3/8UNFX1	C03508-T15P	T00-15P30	26.6IN.LBS
R220.21-02.50	UC6S3/8UNFX11/2	C03510-T15P	T00-15P30	26.6IN.LBS
R220.21-02.50.5A	UC6S3/8UNFX11/2	C03508-T15P	T00-15P30	26.6IN.LBS
R220.21-03.00	UC6S1/2UNFX1-1/4	C03510-T15P	T00-15P30	26.6IN.LBS
R220.21-03.00.7A	UC6S1/2UNFX1-1/4	C03508-T15P	T00-15P30	26.6IN.LBS
R220.21-04.00	UC6S3/4UNFX1-1/4	C03510-T15P	T00-15P30	26.6IN.LBS
R220.21-04.00.9A	UC6S3/4UNFX1-1/4	C03508-T15P	T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.21-080 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.19-080T-M04 MP2501	0,55 *0.022*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
P2	218.19-080T-M04 MP2501	0,55 *0.022*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*
P3	218.19-080T-M04 MP2501	0,55 *0.022*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
P4	218.19-080T-M04 MP2501	0,55 *0.022*	0,48 *0.019*	0,48 *0.019*	0,65 *0.026*
P5	218.19-080T-M04 MP2501	0,55 *0.022*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*
P6	218.19-080T-MD04 MS2500	0,55 *0.022*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*
P7	218.19-080T-MD04 MS2500	0,55 *0.022*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*
P8	218.19-080T-MD04 MS2500	0,55 *0.022*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
P11	218.19-080T-MD04 MS2500	0,55 *0.022*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*
P12	218.19-080T-MD04 MS2500	0,44 *0.017*	0,34 *0.013*	0,34 *0.013*	0,44 *0.017*
M1	218.19-080T-M04 F40M	0,55 *0.022*	0,50 *0.020*	0,55 *0.022*	0,70 *0.028*
M2	218.19-080T-M04 F40M	0,55 *0.022*	0,48 *0.019*	0,48 *0.019*	0,60 *0.024*
M3	218.19-080T-M04 F40M	0,44 *0.017*	0,40 *0.016*	0,40 *0.016*	0,50 *0.020*
M4	218.19-080T-M04 F40M	0,32 *0.013*	0,36 *0.014*	0,36 *0.014*	0,44 *0.017*
M5	218.19-080T-M04 F40M	0,32 *0.013*	0,36 *0.014*	0,36 *0.014*	0,44 *0.017*
S1	218.19-080T-M04 F40M	0,32 *0.013*	0,36 *0.014*	0,36 *0.014*	0,44 *0.017*
S2	218.19-080T-M04 F40M	0,32 *0.013*	0,36 *0.014*	0,36 *0.014*	0,44 *0.017*
S3	218.19-080T-M04 F40M	0,32 *0.013*	0,32 *0.013*	0,32 *0.013*	0,40 *0.016*
S11	218.19-080T-M04 F40M	0,38 *0.015*	0,40 *0.016*	0,40 *0.016*	0,50 *0.020*
S12	218.19-080T-M04 F40M	0,38 *0.015*	0,40 *0.016*	0,40 *0.016*	0,50 *0.020*
S13	218.19-080T-M04 F40M	0,32 *0.013*	0,36 *0.014*	0,36 *0.014*	0,44 *0.017*
H5	218.19-080T-MD04 F15M	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
H8	218.19-080T-MD04 F15M	0,30 *0.012*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
H11	218.19-080T-MD04 F15M	0,34 *0.013*	0,30 *0.012*	0,30 *0.012*	0,38 *0.015*
H12	218.19-080T-MD04 F15M	0,30 *0.012*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
H21	218.19-080T-MD04 F15M	0,30 *0.012*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217.21-080 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			F15M			F30M			F40M			MS2500		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	360 *1175*	440 *1450*	510 *1675*	— —	— —	— —	285 *940*	350 *1150*	405 *1325*	270 *890*	330 *1075*	385 *1275*	375 *1225*	455 *1500*	520 *1700*
P2	350 *1150*	415 *1350*	485 *1600*	— —	— —	— —	280 *920*	330 *1075*	385 *1275*	265 *870*	315 *1025*	365 *1200*	365 *1200*	430 *1400*	500 *1650*
P3	300 *980*	365 *1200*	425 *1400*	— —	— —	— —	240 *790*	290 *950*	335 *1100*	230 *750*	280 *920*	320 *1050*	310 *1025*	380 *1250*	440 *1450*
P4	270 *890*	325 *1075*	375 *1225*	— —	— —	— —	215 *710*	260 *850*	295 *970*	205 *670*	245 *800*	285 *940*	280 *920*	340 *1125*	385 *1275*
P5	255 *840*	310 *1025*	365 *1200*	— —	— —	— —	205 *670*	250 *820*	290 *950*	195 *640*	235 *770*	275 *900*	265 *870*	325 *1075*	375 *1225*
P6	285 *940*	350 *1150*	410 *1350*	— —	— —	— —	230 *750*	280 *920*	325 *1075*	215 *710*	265 *870*	310 *1025*	300 *980*	365 *1200*	425 *1400*
P7	270 *890*	330 *1075*	385 *1275*	— —	— —	— —	215 *710*	260 *850*	305 *1000*	205 *670*	250 *820*	290 *950*	280 *920*	340 *1125*	400 *1300*
P8	255 *840*	310 *1025*	355 *1175*	— —	— —	— —	200 *660*	245 *800*	285 *940*	190 *620*	235 *770*	270 *890*	265 *870*	320 *1050*	370 *1225*
P11	265 *870*	320 *1050*	375 *1225*	— —	— —	— —	210 *690*	255 *840*	295 *970*	200 *660*	245 *800*	285 *940*	275 *900*	330 *1075*	390 *1275*
P12	170 *560*	205 *670*	240 *790*	— —	— —	— —	135 *445*	165 *540*	190 *620*	130 *425*	155 *510*	180 *590*	180 *590*	215 *710*	250 *820*
M1	250 *820*	300 *980*	350 *1150*	— —	— —	— —	225 *740*	265 *870*	310 *1025*	215 *710*	255 *840*	295 *970*	260 *850*	310 *1025*	360 *1175*
M2	205 *670*	250 *820*	290 *950*	— —	— —	— —	185 *610*	225 *740*	260 *850*	175 *570*	210 *690*	245 *800*	210 *690*	260 *850*	300 *980*
M3	165 *540*	200 *660*	235 *770*	— —	— —	— —	150 *490*	180 *590*	210 *690*	140 *460*	170 *560*	200 *660*	175 *570*	210 *690*	240 *790*
M4	130 *425*	160 *520*	185 *610*	— —	— —	— —	120 *395*	140 *460*	165 *540*	110 *360*	135 *445*	155 *510*	135 *445*	165 *540*	190 *620*
M5	110 *360*	130 *425*	155 *510*	— —	— —	— —	100 *330*	115 *375*	135 *445*	95 *310*	110 *360*	130 *425*	115 *375*	135 *445*	160 *520*
K1	275 *900*	330 *1075*	385 *1275*	240 *790*	285 *940*	330 *1075*	220 *720*	260 *850*	305 *1000*	210 *690*	250 *820*	290 *950*	— —	— —	— —
K2	245 *800*	295 *970*	345 *1125*	210 *690*	255 *840*	300 *980*	195 *640*	235 *770*	275 *900*	185 *610*	225 *740*	260 *850*	— —	— —	— —
K3	205 *670*	250 *820*	290 *950*	180 *590*	215 *710*	250 *820*	165 *540*	200 *660*	230 *750*	155 *510*	190 *620*	220 *720*	— —	— —	— —
K4	195 *640*	240 *790*	280 *920*	170 *560*	205 *670*	240 *790*	155 *510*	190 *620*	220 *720*	150 *490*	180 *590*	210 *690*	— —	— —	— —
K5	120 *395*	145 *475*	170 *560*	105 *345*	125 *410*	145 *475*	95 *310*	115 *375*	135 *445*	90 *295*	110 *360*	130 *425*	— —	— —	— —
K6	175 *570*	210 *690*	245 *800*	150 *490*	180 *590*	210 *690*	135 *445*	165 *540*	195 *640*	130 *425*	160 *520*	185 *610*	— —	— —	— —
K7	155 *510*	190 *620*	215 *710*	135 *445*	160 *520*	185 *610*	125 *410*	150 *490*	170 *560*	115 *375*	140 *460*	165 *540*	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	1625 *5325*	2000 *6550*	2300 *7550*	1550 *5075*	1900 *6225*	2200 *7225*	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	660 *2175*	800 *2625*	930 *3050*	630 *2075*	770 *2525*	880 *2875*	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	440 *1450*	540 *1775*	620 *2025*	420 *1375*	510 *1675*	590 *1925*	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	500 *1650*	610 *2000*	710 *2325*	480 *1575*	580 *1900*	670 *2200*	— —	— —	— —
S1	65 *215*	75 *245*	90 *295*	— —	— —	— —	55 *180*	65 *215*	75 *245*	50 *165*	60 *195*	75 *245*	65 *215*	80 *260*	95 *310*
S2	50 *165*	60 *195*	70 *230*	— —	— —	— —	44 *145*	55 *180*	60 *195*	42 *140*	50 *165*	60 *195*	55 *180*	65 *215*	75 *245*
S3	46 *150*	55 *180*	65 *215*	— —	— —	— —	39 *130*	47 *155*	55 *180*	37 *120*	44 *145*	50 *165*	47 *155*	55 *180*	65 *215*
S11	90 *295*	105 *345*	125 *410*	— —	— —	— —	75 *245*	90 *295*	105 *345*	75 *245*	85 *280*	100 *330*	95 *310*	110 *360*	130 *425*
S12	60 *195*	75 *245*	85 *280*	— —	— —	— —	44 *145*	55 *180*	60 *195*	50 *165*	60 *195*	70 *230*	65 *215*	75 *245*	90 *295*
S13	36 *120*	43 *140*	50 *165*	— —	— —	— —	26 *85*	31 *100*	36 *120*	29 *95*	35 *115*	41 *135*	37 *120*	45 *150*	50 *165*
H5	55 *180*	65 *215*	75 *245*	50 *165*	60 *195*	70 *230*	48 *155*	55 *180*	65 *215*	45 *150*	55 *180*	60 *195*	— —	— —	— —
H8	60 *195*	70 *230*	80 *260*	55 *180*	65 *215*	75 *245*	50 *165*	60 *195*	70 *230*	48 *155*	55 *180*	65 *215*	— —	— —	— —
H11	70 *230*	85 *280*	95 *310*	65 *215*	80 *260*	90 *295*	60 *195*	70 *230*	85 *280*	60 *195*	70 *230*	80 *260*	— —	— —	— —
H12	115 *375*	135 *445*	155 *510*	100 *330*	120 *395*	135 *445*	90 *295*	110 *360*	125 *410*	85 *280*	105 *345*	120 *395*	— —	— —	— —
H21	60 *195*	70 *230*	80 *260*	55 *180*	65 *215*	75 *245*	50 *165*	60 *195*	70 *230*	48 *155*	55 *180*	65 *215*	— —	— —	— —

R217.21-100 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.19-100T-M06 MP2501	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,0 *0.040*
P2	218.19-100T-M06 MP2501	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*
P3	218.19-100T-M06 MP2501	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*
P4	218.19-100T-M06 MP2501	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	1,0 *0.040*
P5	218.19-100T-M06 MP2501	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
P6	218.19-100T-MD08 MS2500	0,65 *0.026*	0,95 *0.038*	1,0 *0.040*	1,3 *0.050*
P7	218.19-100T-MD08 MS2500	0,65 *0.026*	0,95 *0.038*	1,0 *0.040*	1,3 *0.050*
P8	218.19-100T-MD08 MS2500	0,65 *0.026*	1,0 *0.040*	1,0 *0.040*	1,3 *0.050*
P11	218.19-100T-MD08 MS2500	0,65 *0.026*	0,95 *0.038*	1,0 *0.040*	1,3 *0.050*
P12	218.19-100T-MD08 MS2500	0,50 *0.020*	0,70 *0.028*	0,70 *0.028*	0,90 *0.036*
M1	218.19-100T-M06 F40M	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*
M2	218.19-100T-M06 F40M	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
M3	218.19-100T-M06 F40M	0,50 *0.020*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
M4	218.19-100T-M06 F40M	0,38 *0.015*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
M5	218.19-100T-M06 F40M	0,38 *0.015*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
K1	218.19-100T-M06 MP3000	0,65 *0.026*	0,80 *0.032*	0,80 *0.032*	1,1 *0.044*
K2	218.19-100T-M06 MP3000	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
K3	218.19-100T-M06 MP3000	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
K4	218.19-100T-M06 MP3000	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
K5	218.19-100T-M06 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*
K6	218.19-100T-M06 MP3000	0,65 *0.026*	0,75 *0.030*	0,75 *0.030*	0,95 *0.038*
K7	218.19-100T-M06 MP3000	0,65 *0.026*	0,65 *0.026*	0,65 *0.026*	0,85 *0.034*
S1	218.19-100T-M06 MS2500	0,38 *0.015*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
S2	218.19-100T-M06 MS2500	0,38 *0.015*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
S3	218.19-100T-M06 MS2500	0,38 *0.015*	0,50 *0.020*	0,50 *0.020*	0,60 *0.024*
S11	218.19-100T-M06 MS2050	0,44 *0.017*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
S12	218.19-100T-M06 MS2050	0,44 *0.017*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
S13	218.19-100T-M06 MS2050	0,38 *0.015*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H5	218.19-100T-MD08 MH1000	0,40 *0.016*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
H8	218.19-100T-MD08 MH1000	0,34 *0.013*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
H11	218.19-100T-MD08 MH1000	0,40 *0.016*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
H12	218.19-100T-M06 MP3000	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,42 *0.017*
H21	218.19-100T-MD08 MH1000	0,34 *0.013*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217.21-100 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501			MP3000			T350M			F15M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	270 *890*	320 *1050*	380 *1250*	295 *970*	350 *1150*	410 *1350*	270 *890*	320 *1050*	375 *1225*	— —	— —	— —
P2	265 *870*	310 *1025*	370 *1225*	285 *940*	340 *1125*	395 *1300*	265 *870*	310 *1025*	365 *1200*	— —	— —	— —
P3	235 *770*	275 *900*	320 *1050*	250 *820*	295 *970*	345 *1125*	230 *750*	275 *900*	320 *1050*	— —	— —	— —
P4	205 *670*	240 *790*	290 *950*	220 *720*	260 *850*	310 *1025*	205 *670*	240 *790*	285 *940*	— —	— —	— —
P5	195 *640*	230 *750*	275 *900*	210 *690*	250 *820*	295 *970*	195 *640*	230 *750*	270 *890*	— —	— —	— —
P6	225 *740*	265 *870*	310 *1025*	235 *770*	280 *920*	330 *1075*	220 *720*	260 *850*	305 *1000*	— —	— —	— —
P7	210 *690*	250 *820*	290 *950*	225 *740*	265 *870*	315 *1025*	205 *670*	245 *800*	290 *950*	— —	— —	— —
P8	195 *640*	230 *750*	270 *890*	210 *690*	250 *820*	290 *950*	195 *640*	230 *750*	270 *890*	— —	— —	— —
P11	205 *670*	240 *790*	285 *940*	215 *710*	255 *840*	305 *1000*	200 *660*	235 *770*	280 *920*	— —	— —	— —
P12	135 *445*	160 *520*	185 *610*	145 *475*	170 *560*	200 *660*	135 *445*	160 *520*	185 *610*	— —	— —	— —
M1	190 *620*	225 *740*	270 *890*	215 *710*	255 *840*	295 *970*	205 *670*	240 *790*	280 *920*	— —	— —	— —
M2	160 *520*	185 *610*	220 *720*	175 *570*	210 *690*	245 *800*	165 *540*	200 *660*	235 *770*	— —	— —	— —
M3	130 *425*	155 *510*	180 *590*	145 *475*	175 *570*	200 *660*	140 *460*	165 *540*	190 *620*	— —	— —	— —
M4	105 *345*	125 *410*	145 *475*	115 *375*	135 *445*	160 *520*	110 *360*	130 *425*	150 *490*	— —	— —	— —
M5	90 *295*	105 *345*	120 *395*	95 *310*	115 *375*	135 *445*	90 *295*	105 *345*	125 *410*	— —	— —	— —
K1	210 *690*	245 *800*	295 *970*	225 *740*	270 *890*	315 *1025*	210 *690*	245 *800*	290 *950*	190 *620*	225 *740*	265 *870*
K2	185 *610*	220 *720*	260 *850*	200 *660*	235 *770*	280 *920*	185 *610*	220 *720*	260 *850*	170 *560*	200 *660*	235 *770*
K3	155 *510*	185 *610*	220 *720*	170 *560*	200 *660*	235 *770*	155 *510*	185 *610*	220 *720*	145 *475*	170 *560*	200 *660*
K4	150 *490*	175 *570*	210 *690*	160 *520*	190 *620*	225 *740*	150 *490*	175 *570*	210 *690*	135 *445*	160 *520*	190 *620*
K5	90 *295*	110 *360*	130 *425*	100 *330*	120 *395*	140 *460*	90 *295*	110 *360*	130 *425*	85 *280*	100 *330*	115 *375*
K6	130 *425*	155 *510*	185 *610*	145 *475*	170 *560*	200 *660*	130 *425*	155 *510*	185 *610*	120 *395*	140 *460*	170 *560*
K7	120 *395*	140 *460*	165 *540*	130 *425*	150 *490*	180 *590*	120 *395*	140 *460*	165 *540*	105 *345*	125 *410*	150 *490*
N1	— —	— —	— —	1700 *5575*	2000 *6550*	2325 *7625*	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	680 *2225*	810 *2650*	940 *3075*	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	455 *1500*	540 *1775*	620 *2025*	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	520 *1700*	610 *2000*	710 *2325*	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	55 *180*	65 *215*	75 *245*	50 *165*	60 *195*	70 *230*	— —	— —	— —
S2	— —	— —	— —	44 *145*	50 *165*	60 *195*	41 *135*	48 *155*	55 *180*	— —	— —	— —
S3	— —	— —	— —	39 *130*	45 *150*	55 *180*	37 *120*	43 *140*	50 *165*	— —	— —	— —
S11	— —	— —	— —	75 *245*	90 *295*	105 *345*	70 *230*	85 *280*	100 *330*	— —	— —	— —
S12	— —	— —	— —	50 *165*	60 *195*	70 *230*	50 *165*	60 *195*	70 *230*	— —	— —	— —
S13	— —	— —	— —	31 *100*	36 *120*	42 *140*	29 *95*	34 *110*	40 *130*	— —	— —	— —
H5	— —	— —	— —	48 *155*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	44 *145*	50 *165*	60 *195*
H8	— —	— —	— —	50 *165*	60 *195*	70 *230*	50 *165*	60 *195*	70 *230*	47 *155*	55 *180*	65 *215*
H11	— —	— —	— —	60 *195*	70 *230*	85 *280*	60 *195*	70 *230*	80 *260*	55 *180*	65 *215*	75 *245*
H12	— —	— —	— —	100 *330*	115 *375*	135 *445*	90 *295*	105 *345*	125 *410*	85 *280*	100 *330*	115 *375*
H21	— —	— —	— —	50 *165*	60 *195*	70 *230*	50 *165*	60 *195*	70 *230*	47 *155*	55 *180*	65 *215*

R217.21-100 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MS2050			MS2500			MH1000		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	235 *770*	280 *920*	325 *1075*	260 *850*	305 *1000*	360 *1175*	340 *1125*	400 *1300*	470 *1550*	— —	— —	— —
P2	230 *750*	270 *890*	320 *1050*	255 *840*	300 *980*	350 *1150*	330 *1075*	390 *1275*	460 *1500*	— —	— —	— —
P3	200 *660*	240 *790*	275 *900*	220 *720*	260 *850*	305 *1000*	290 *950*	340 *1125*	400 *1300*	— —	— —	— —
P4	175 *570*	210 *690*	250 *820*	195 *640*	230 *750*	270 *890*	255 *840*	300 *980*	355 *1175*	— —	— —	— —
P5	170 *560*	200 *660*	235 *770*	185 *610*	220 *720*	260 *850*	245 *800*	290 *950*	340 *1125*	— —	— —	— —
P6	190 *620*	225 *740*	265 *870*	210 *690*	245 *800*	290 *950*	275 *900*	325 *1075*	380 *1250*	— —	— —	— —
P7	180 *590*	210 *690*	250 *820*	195 *640*	235 *770*	275 *900*	260 *850*	305 *1000*	360 *1175*	— —	— —	— —
P8	170 *560*	200 *660*	235 *770*	185 *610*	220 *720*	255 *840*	245 *800*	290 *950*	335 *1100*	— —	— —	— —
P11	175 *570*	205 *670*	245 *800*	190 *620*	225 *740*	270 *890*	250 *820*	295 *970*	350 *1150*	— —	— —	— —
P12	115 *375*	140 *460*	160 *520*	130 *425*	150 *490*	175 *570*	170 *560*	200 *660*	230 *750*	— —	— —	— —
M1	185 *610*	220 *720*	255 *840*	205 *670*	240 *790*	280 *920*	235 *770*	280 *920*	330 *1075*	— —	— —	— —
M2	150 *490*	180 *590*	215 *710*	165 *540*	200 *660*	235 *770*	195 *640*	230 *750*	270 *890*	— —	— —	— —
M3	125 *410*	150 *490*	175 *570*	140 *460*	165 *540*	190 *620*	160 *520*	190 *620*	220 *720*	— —	— —	— —
M4	100 *330*	115 *375*	140 *460*	110 *360*	130 *425*	150 *490*	130 *425*	150 *490*	175 *570*	— —	— —	— —
M5	85 *280*	95 *310*	115 *375*	90 *295*	105 *345*	125 *410*	105 *345*	125 *410*	145 *475*	— —	— —	— —
K1	180 *590*	215 *710*	250 *820*	— —	— —	— —	— —	— —	— —	230 *750*	270 *890*	325 *1075*
K2	160 *520*	190 *620*	225 *740*	— —	— —	— —	— —	— —	— —	205 *670*	240 *790*	285 *940*
K3	135 *445*	160 *520*	190 *620*	— —	— —	— —	— —	— —	— —	175 *570*	205 *670*	240 *790*
K4	130 *425*	155 *510*	180 *590*	— —	— —	— —	— —	— —	— —	165 *540*	195 *640*	230 *750*
K5	80 *260*	95 *310*	110 *360*	— —	— —	— —	— —	— —	— —	100 *330*	120 *395*	140 *460*
K6	115 *375*	135 *445*	160 *520*	— —	— —	— —	— —	— —	— —	145 *475*	170 *560*	205 *670*
K7	105 *345*	120 *395*	140 *460*	— —	— —	— —	— —	— —	— —	130 *425*	155 *510*	180 *590*
N1	1350 *4425*	1600 *5250*	1850 *6075*	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	550 *1800*	640 *2100*	750 *2450*	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	365 *1200*	430 *1400*	500 *1650*	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	415 *1350*	490 *1600*	570 *1875*	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	47 *155*	55 *180*	65 *215*	50 *165*	60 *195*	70 *230*	65 *215*	75 *245*	85 *280*	— —	— —	— —
S2	38 *125*	44 *145*	50 *165*	41 *135*	48 *155*	55 *180*	50 *165*	60 *195*	70 *230*	— —	— —	— —
S3	33 *110*	39 *130*	45 *150*	37 *120*	43 *140*	50 *165*	44 *145*	50 *165*	60 *195*	— —	— —	— —
S11	65 *215*	75 *245*	90 *295*	70 *230*	85 *280*	100 *330*	85 *280*	100 *330*	120 *395*	— —	— —	— —
S12	45 *150*	55 *180*	60 *195*	50 *165*	60 *195*	70 *230*	60 *195*	70 *230*	80 *260*	— —	— —	— —
S13	26 *85*	31 *100*	36 *120*	29 *95*	34 *110*	40 *130*	35 *115*	41 *135*	48 *155*	— —	— —	— —
H5	41 *135*	48 *155*	55 *180*	— —	— —	— —	— —	— —	— —	55 *180*	60 *195*	75 *245*
H8	44 *145*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —	55 *180*	65 *215*	80 *260*
H11	50 *165*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —	65 *215*	80 *260*	95 *310*
H12	80 *260*	90 *295*	105 *345*	— —	— —	— —	— —	— —	— —	100 *330*	120 *395*	140 *460*
H21	44 *145*	50 *165*	60 *195*	— —	— —	— —	— —	— —	— —	55 *180*	65 *215*	80 *260*

R217/220.21-125 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.19-125T-T3-M07 MP2501	0,90 *0.036*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
P2	218.19-125T-T3-M07 MP2501	0,90 *0.036*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
P3	218.19-125T-T3-M07 MP2501	0,90 *0.036*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
P4	218.19-125T-T3-M07 MP2501	0,90 *0.036*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
P5	218.19-125T-T3-M07 MP2501	0,90 *0.036*	0,80 *0.032*	0,80 *0.032*	1,0 *0.040*
P6	218.19-125T-T3-M07 MP2501	0,90 *0.036*	0,80 *0.032*	0,80 *0.032*	1,0 *0.040*
P7	218.19-125T-T3-MD10 MP2501	0,90 *0.036*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
P8	218.19-125T-T3-MD10 MS2500	0,90 *0.036*	1,2 *0.048*	1,2 *0.048*	1,5 *0.060*
P11	218.19-125T-T3-MD10 MS2500	0,90 *0.036*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
P12	218.19-125T-T3-MD10 MS2500	0,70 *0.028*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
M1	218.19-125T-T3-M07 F40M	0,90 *0.036*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
M2	218.19-125T-T3-M07 F40M	0,90 *0.036*	0,80 *0.032*	0,80 *0.032*	1,0 *0.040*
M3	218.19-125T-T3-M07 F40M	0,70 *0.028*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
M4	218.19-125T-T3-M07 F40M	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
M5	218.19-125T-T3-M07 F40M	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
K1	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	1,0 *0.040*	1,0 *0.040*	1,3 *0.050*
K2	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
K3	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
K4	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
K5	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
K6	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
K7	218.19-125T-T3-MD08 MP3000	0,90 *0.036*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
S1	218.19-125T-T3-M07 MS2500	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
S2	218.19-125T-T3-M07 MS2500	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
S3	218.19-125T-T3-M07 MS2500	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
S11	218.19-125T-T3-M07 MS2050	0,65 *0.026*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
S12	218.19-125T-T3-M07 MS2050	0,65 *0.026*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
S13	218.19-125T-T3-M07 MS2050	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,75 *0.030*
H5	218.19-125T-T3-MD10 MH1000	0,55 *0.022*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
H8	218.19-125T-T3-MD10 MH1000	0,50 *0.020*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*
H11	218.19-125T-T3-MD08 MP3000	0,55 *0.022*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
H12	218.19-125T-T3-M07 T350M	0,50 *0.020*	0,40 *0.016*	0,40 *0.016*	0,48 *0.019*
H21	218.19-125T-T3-MD10 MH1000	0,50 *0.020*	0,55 *0.022*	0,55 *0.022*	0,70 *0.028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.21-125 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2501			MP3000			T350M			F40M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	275 *900*	320 *1050*	385 *1275*	295 *970*	340 *1125*	415 *1350*	280 *920*	325 *1075*	390 *1275*	255 *840*	295 *970*	360 *1175*	225 *740*	260 *850*	315 *1025*
P2	270 *890*	310 *1025*	375 *1225*	285 *940*	330 *1075*	390 *1275*	270 *890*	315 *1025*	370 *1225*	250 *820*	290 *950*	340 *1125*	215 *710*	250 *820*	295 *970*
P3	240 *790*	275 *900*	330 *1075*	250 *820*	290 *950*	345 *1125*	235 *770*	275 *900*	330 *1075*	220 *720*	255 *840*	300 *980*	190 *620*	220 *720*	265 *870*
P4	210 *690*	240 *790*	290 *950*	220 *720*	255 *840*	305 *1000*	210 *690*	240 *790*	290 *950*	190 *620*	225 *740*	265 *870*	165 *540*	195 *640*	230 *750*
P5	200 *660*	230 *750*	280 *920*	215 *710*	250 *820*	295 *970*	205 *670*	235 *770*	280 *920*	185 *610*	215 *710*	260 *850*	165 *540*	190 *620*	225 *740*
P6	225 *740*	260 *850*	310 *1025*	240 *790*	280 *920*	330 *1075*	230 *750*	265 *870*	315 *1025*	210 *690*	245 *800*	290 *950*	180 *590*	210 *690*	250 *820*
P7	210 *690*	245 *800*	295 *970*	225 *740*	265 *870*	315 *1025*	215 *710*	250 *820*	295 *970*	200 *660*	230 *750*	275 *900*	170 *560*	200 *660*	235 *770*
P8	200 *660*	230 *750*	280 *920*	210 *690*	245 *800*	290 *950*	200 *660*	230 *750*	275 *900*	185 *610*	215 *710*	255 *840*	160 *520*	185 *610*	220 *720*
P11	205 *670*	240 *790*	285 *940*	220 *720*	255 *840*	305 *1000*	210 *690*	240 *790*	290 *950*	190 *620*	225 *740*	265 *870*	165 *540*	195 *640*	230 *750*
P12	140 *460*	160 *520*	190 *620*	145 *475*	170 *560*	200 *660*	140 *460*	160 *520*	190 *620*	125 *410*	145 *475*	175 *570*	110 *360*	125 *410*	150 *490*
M1	— —	— —	— —	205 *670*	240 *790*	285 *940*	205 *670*	235 *770*	280 *920*	195 *640*	225 *740*	265 *870*	175 *570*	205 *670*	240 *790*
M2	— —	— —	— —	175 *570*	200 *660*	240 *790*	170 *560*	195 *640*	235 *770*	160 *520*	185 *610*	220 *720*	145 *475*	170 *560*	200 *660*
M3	— —	— —	— —	140 *460*	165 *540*	190 *620*	140 *460*	160 *520*	190 *620*	130 *425*	150 *490*	180 *590*	120 *395*	140 *460*	165 *540*
M4	— —	— —	— —	115 *375*	130 *425*	150 *490*	110 *360*	130 *425*	150 *490*	105 *345*	120 *395*	140 *460*	95 *310*	110 *360*	130 *425*
M5	— —	— —	— —	95 *310*	110 *360*	125 *410*	95 *310*	105 *345*	125 *410*	90 *295*	100 *330*	120 *395*	80 *260*	90 *295*	105 *345*
K1	215 *710*	245 *800*	300 *980*	225 *740*	265 *870*	310 *1025*	215 *710*	250 *820*	295 *970*	200 *660*	230 *750*	270 *890*	170 *560*	200 *660*	235 *770*
K2	190 *620*	220 *720*	265 *870*	205 *670*	235 *770*	280 *920*	195 *640*	225 *740*	265 *870*	175 *570*	205 *670*	245 *800*	155 *510*	180 *590*	215 *710*
K3	160 *520*	185 *610*	225 *740*	170 *560*	200 *660*	235 *770*	165 *540*	190 *620*	225 *740*	150 *490*	175 *570*	205 *670*	130 *425*	150 *490*	180 *590*
K4	155 *510*	175 *570*	215 *710*	165 *540*	190 *620*	225 *740*	155 *510*	180 *590*	215 *710*	145 *475*	165 *540*	195 *640*	125 *410*	145 *475*	170 *560*
K5	95 *310*	110 *360*	135 *445*	100 *330*	115 *375*	140 *460*	95 *310*	110 *360*	130 *425*	85 *280*	100 *330*	120 *395*	75 *245*	85 *280*	105 *345*
K6	135 *445*	155 *510*	190 *620*	145 *475*	170 *560*	200 *660*	135 *445*	160 *520*	190 *620*	125 *410*	145 *475*	175 *570*	110 *360*	125 *410*	150 *490*
K7	125 *410*	145 *475*	170 *560*	130 *425*	150 *490*	180 *590*	120 *395*	140 *460*	170 *560*	110 *360*	130 *425*	155 *510*	95 *310*	110 *360*	135 *445*
N1	— —	— —	— —	— —	— —	— —	1600 *5250*	1850 *6075*	2175 *7125*	— —	— —	— —	1275 *4175*	1475 *4850*	1725 *5650*
N2	— —	— —	— —	— —	— —	— —	650 *2125*	750 *2450*	880 *2875*	— —	— —	— —	520 *1700*	600 *1975*	700 *2300*
N3	— —	— —	— —	— —	— —	— —	430 *1400*	500 *1650*	580 *1900*	— —	— —	— —	345 *1125*	400 *1300*	465 *1525*
N11	— —	— —	— —	— —	— —	— —	495 *1625*	570 *1875*	670 *2200*	— —	— —	— —	395 *1300*	455 *1500*	530 *1750*
S1	— —	— —	— —	55 *180*	65 *215*	75 *245*	50 *165*	60 *195*	70 *230*	49 *160*	55 *180*	65 *215*	45 *150*	50 *165*	60 *195*
S2	— —	— —	— —	44 *145*	50 *165*	60 *195*	42 *140*	48 *155*	55 *180*	40 *130*	46 *150*	55 *180*	36 *120*	41 *135*	48 *155*
S3	— —	— —	— —	38 *125*	44 *145*	55 *180*	36 *120*	41 *135*	50 *165*	34 *110*	39 *130*	47 *155*	31 *100*	36 *120*	43 *140*
S11	— —	— —	— —	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	65 *215*	75 *245*	90 *295*	60 *195*	70 *230*	85 *280*
S12	— —	— —	— —	50 *165*	60 *195*	70 *230*	49 *160*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	42 *140*	49 *160*	55 *180*
S13	— —	— —	— —	31 *100*	36 *120*	42 *140*	29 *95*	34 *110*	39 *130*	28 *90*	32 *105*	37 *120*	25 *80*	29 *95*	34 *110*
H5	50 *165*	55 *180*	70 *230*	47 *155*	55 *180*	65 *215*	46 *150*	55 *180*	60 *195*	45 *150*	50 *165*	60 *195*	39 *130*	45 *150*	55 *180*
H8	55 *180*	60 *195*	75 *245*	50 *165*	55 *180*	70 *230*	49 *160*	55 *180*	65 *215*	48 *155*	55 *180*	65 *215*	42 *140*	48 *155*	55 *180*
H11	65 *215*	70 *230*	85 *280*	60 *195*	70 *230*	80 *260*	60 *195*	65 *215*	80 *260*	60 *195*	65 *215*	80 *260*	50 *165*	60 *195*	70 *230*
H12	95 *310*	110 *360*	130 *425*	100 *330*	115 *375*	135 *445*	95 *310*	105 *345*	125 *410*	85 *280*	100 *330*	115 *375*	75 *245*	85 *280*	100 *330*
H21	55 *180*	60 *195*	75 *245*	50 *165*	55 *180*	70 *230*	49 *160*	55 *180*	65 *215*	48 *155*	55 *180*	65 *215*	42 *140*	48 *155*	55 *180*

R217/220.21-125 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500			MS2050			MS2500			MH1000		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	180 *590*	210 *690*	255 *840*	245 *800*	285 *940*	345 *1125*	320 *1050*	370 *1225*	450 *1475*	— —	— —	— —
P2	175 *570*	205 *670*	240 *790*	240 *790*	275 *900*	325 *1075*	315 *1025*	360 *1175*	430 *1400*	— —	— —	— —
P3	155 *510*	180 *590*	215 *710*	210 *690*	240 *790*	290 *950*	275 *900*	315 *1025*	380 *1250*	— —	— —	— —
P4	135 *445*	155 *510*	185 *610*	185 *610*	215 *710*	255 *840*	240 *790*	280 *920*	335 *1100*	— —	— —	— —
P5	130 *425*	150 *490*	180 *590*	180 *590*	205 *670*	245 *800*	235 *770*	270 *890*	325 *1075*	— —	— —	— —
P6	150 *490*	170 *560*	205 *670*	200 *660*	230 *750*	275 *900*	265 *870*	305 *1000*	360 *1175*	— —	— —	— —
P7	140 *460*	160 *520*	190 *620*	190 *620*	220 *720*	260 *850*	250 *820*	285 *940*	340 *1125*	— —	— —	— —
P8	130 *425*	150 *490*	180 *590*	175 *570*	205 *670*	245 *800*	230 *750*	265 *870*	320 *1050*	— —	— —	— —
P11	135 *445*	155 *510*	185 *610*	185 *610*	215 *710*	255 *840*	240 *790*	280 *920*	330 *1075*	— —	— —	— —
P12	90 *295*	105 *345*	120 *395*	120 *395*	140 *460*	165 *540*	160 *520*	185 *610*	220 *720*	— —	— —	— —
M1	150 *490*	175 *570*	205 *670*	195 *640*	225 *740*	265 *870*	225 *740*	260 *850*	305 *1000*	— —	— —	— —
M2	125 *410*	145 *475*	175 *570*	160 *520*	185 *610*	220 *720*	185 *610*	215 *710*	260 *850*	— —	— —	— —
M3	105 *345*	120 *395*	140 *460*	130 *425*	150 *490*	180 *590*	155 *510*	175 *570*	210 *690*	— —	— —	— —
M4	85 *280*	95 *310*	110 *360*	105 *345*	120 *395*	140 *460*	125 *410*	140 *460*	165 *540*	— —	— —	— —
M5	70 *230*	80 *260*	95 *310*	90 *295*	100 *330*	120 *395*	105 *345*	120 *395*	135 *445*	— —	— —	— —
K1	— —	— —	— —	— —	— —	— —	— —	— —	— —	210 *690*	240 *790*	290 *950*
K2	— —	— —	— —	— —	— —	— —	— —	— —	— —	185 *610*	215 *710*	255 *840*
K3	— —	— —	— —	— —	— —	— —	— —	— —	— —	155 *510*	180 *590*	215 *710*
K4	— —	— —	— —	— —	— —	— —	— —	— —	— —	150 *490*	175 *570*	205 *670*
K5	— —	— —	— —	— —	— —	— —	— —	— —	— —	95 *310*	110 *360*	130 *425*
K6	— —	— —	— —	— —	— —	— —	— —	— —	— —	130 *425*	150 *490*	185 *610*
K7	— —	— —	— —	— —	— —	— —	— —	— —	— —	120 *395*	140 *460*	165 *540*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	25 *80*	29 *95*	34 *110*	49 *160*	55 *180*	65 *215*	60 *195*	70 *230*	80 *260*	— —	— —	— —
S2	20 *65*	23 *75*	27 *90*	40 *130*	46 *150*	55 *180*	48 *155*	55 *180*	65 *215*	— —	— —	— —
S3	18 *60*	20 *65*	24 *80*	34 *110*	39 *130*	47 *155*	42 *140*	48 *155*	60 *195*	— —	— —	— —
S11	35 *115*	40 *130*	47 *155*	65 *215*	75 *245*	90 *295*	80 *260*	95 *310*	110 *360*	— —	— —	— —
S12	32 *105*	37 *120*	43 *140*	47 *155*	55 *180*	65 *215*	55 *180*	65 *215*	75 *245*	— —	— —	— —
S13	19 *60*	22 *70*	25 *80*	28 *90*	32 *105*	37 *120*	34 *110*	39 *130*	45 *150*	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	48 *155*	55 *180*	65 *215*
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	60 *195*	70 *230*
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	60 *195*	70 *230*	85 *280*
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	95 *310*	110 *360*	130 *425*
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	55 *180*	60 *195*	70 *230*

R217/220.21-160 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.19-160T-04-M08 MP2501	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
P2	218.19-160T-04-M08 MP2501	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
P3	218.19-160T-04-M08 MP2501	1,6 *0.065*	0,80 *0.032*	0,80 *0.032*	1,0 *0.040*
P4	218.19-160T-04-M08 MP2501	1,6 *0.065*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
P5	218.19-160T-04-M11 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P6	218.19-160T-04-M11 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P7	218.19-160T-04-M11 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P8	218.19-160T-04-MD11 MS2500	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,4 *0.055*
P11	218.19-160T-04-MD11 MS2500	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P12	218.19-160T-04-MD11 MS2500	1,3 *0.050*	0,80 *0.032*	0,80 *0.032*	1,0 *0.040*
M1	218.19-160T-04-M08 MS2050	1,6 *0.065*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
M2	218.19-160T-04-M08 MS2050	1,6 *0.065*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
M3	218.19-160T-04-M08 MS2050	1,3 *0.050*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
M4	218.19-160T-04-M08 T350M	0,95 *0.038*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
M5	218.19-160T-04-M08 T350M	0,95 *0.038*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
K1	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,2 *0.048*	1,2 *0.048*	1,4 *0.055*
K2	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K3	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K4	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K5	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K6	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K7	218.19-160T-04-MD11 MK2050	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
N1	218.19-160-04-E07 H25	1,6 *0.065*	0,95 *0.038*	0,95 *0.038*	1,2 *0.048*
N2	218.19-160-04-E07 H25	1,6 *0.065*	0,95 *0.038*	0,95 *0.038*	1,2 *0.048*
N3	218.19-160-04-E07 H25	1,6 *0.065*	0,95 *0.038*	0,95 *0.038*	1,2 *0.048*
N11	218.19-160-04-E07 H25	1,6 *0.065*	0,95 *0.038*	0,95 *0.038*	1,2 *0.048*
S1	218.19-160T-04-M08 MS2500	0,95 *0.038*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
S2	218.19-160T-04-M08 MS2500	0,95 *0.038*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
S3	218.19-160T-04-M08 MS2500	0,95 *0.038*	0,65 *0.026*	0,65 *0.026*	0,80 *0.032*
S11	218.19-160T-04-M08 MS2050	1,1 *0.044*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
S12	218.19-160T-04-M08 MS2050	1,1 *0.044*	0,75 *0.030*	0,75 *0.030*	0,90 *0.036*
S13	218.19-160T-04-M08 MS2050	0,95 *0.038*	0,70 *0.028*	0,70 *0.028*	0,85 *0.034*
H5	218.19-160T-04-MD11 MH1000	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
H8	218.19-160T-04-MD11 MH1000	0,90 *0.036*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
H11	218.19-160T-04-MD09 MP3000	1,0 *0.040*	0,65 *0.026*	0,65 *0.026*	0,80 *0.032*
H12	218.19-160T-04-M08 T350M	0,90 *0.036*	0,46 *0.018*	0,46 *0.018*	0,55 *0.022*
H21	218.19-160T-04-MD11 MH1000	0,90 *0.036*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.21-160 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			T350M			F15M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	270 *890*	315 *1025*	385 *1275*	280 *920*	330 *1075*	395 *1300*	290 *950*	335 *1100*	405 *1325*	270 *890*	320 *1050*	385 *1275*	250 *820*	295 *970*	355 *1175*	— —	— —	— —
P2	265 *870*	310 *1025*	375 *1225*	275 *900*	325 *1075*	385 *1275*	280 *920*	330 *1075*	395 *1300*	265 *870*	310 *1025*	375 *1225*	245 *800*	285 *940*	345 *1125*	— —	— —	— —
P3	235 *770*	275 *900*	320 *1050*	240 *790*	285 *940*	335 *1100*	245 *800*	290 *950*	340 *1125*	230 *750*	275 *900*	320 *1050*	215 *710*	250 *820*	295 *970*	— —	— —	— —
P4	205 *670*	240 *790*	290 *950*	210 *690*	250 *820*	295 *970*	215 *710*	255 *840*	305 *1000*	205 *670*	240 *790*	285 *940*	190 *620*	220 *720*	265 *870*	— —	— —	— —
P5	195 *640*	230 *750*	275 *900*	205 *670*	240 *790*	285 *940*	205 *670*	240 *790*	290 *950*	195 *640*	230 *750*	275 *900*	180 *590*	210 *690*	250 *820*	— —	— —	— —
P6	220 *720*	260 *850*	310 *1025*	225 *740*	265 *870*	320 *1050*	230 *750*	270 *890*	325 *1075*	220 *720*	255 *840*	310 *1025*	200 *660*	235 *770*	285 *940*	— —	— —	— —
P7	210 *690*	245 *800*	295 *970*	215 *710*	250 *820*	300 *980*	220 *720*	255 *840*	305 *1000*	205 *670*	245 *800*	290 *950*	190 *620*	225 *740*	265 *870*	— —	— —	— —
P8	195 *640*	230 *750*	270 *890*	205 *670*	240 *790*	280 *920*	205 *670*	240 *790*	285 *940*	195 *640*	230 *750*	270 *890*	180 *590*	210 *690*	250 *820*	— —	— —	— —
P11	200 *660*	235 *770*	285 *940*	210 *690*	245 *800*	290 *950*	210 *690*	250 *820*	300 *980*	200 *660*	235 *770*	280 *920*	185 *610*	215 *710*	260 *850*	— —	— —	— —
P12	135 *445*	160 *520*	185 *610*	140 *460*	160 *520*	190 *620*	140 *460*	165 *540*	195 *640*	135 *445*	155 *510*	185 *610*	120 *395*	145 *475*	170 *560*	— —	— —	— —
M1	— —	— —	— —	195 *640*	230 *750*	275 *900*	200 *660*	235 *770*	285 *940*	200 *660*	235 *770*	280 *920*	190 *620*	220 *720*	265 *870*	— —	— —	— —
M2	— —	— —	— —	160 *520*	190 *620*	225 *740*	165 *540*	195 *640*	235 *770*	165 *540*	190 *620*	230 *750*	155 *510*	180 *590*	215 *710*	— —	— —	— —
M3	— —	— —	— —	130 *425*	155 *510*	185 *610*	135 *445*	160 *520*	185 *610*	135 *445*	155 *510*	185 *610*	125 *410*	145 *475*	175 *570*	— —	— —	— —
M4	— —	— —	— —	105 *345*	120 *395*	140 *460*	105 *345*	125 *410*	145 *475*	105 *345*	120 *395*	145 *475*	100 *330*	115 *375*	135 *445*	— —	— —	— —
M5	— —	— —	— —	85 *280*	100 *330*	120 *395*	90 *295*	100 *330*	120 *395*	85 *280*	100 *330*	120 *395*	80 *260*	95 *310*	115 *375*	— —	— —	— —
K1	210 *690*	245 *800*	295 *970*	220 *720*	255 *840*	305 *1000*	220 *720*	260 *850*	310 *1025*	210 *690*	245 *800*	295 *970*	195 *640*	225 *740*	270 *890*	170 *560*	195 *640*	240 *790*
K2	185 *610*	220 *720*	260 *850*	190 *620*	225 *740*	270 *890*	195 *640*	230 *750*	275 *900*	185 *610*	220 *720*	260 *850*	170 *560*	200 *660*	240 *790*	150 *490*	175 *570*	210 *690*
K3	160 *520*	185 *610*	220 *720*	165 *540*	190 *620*	230 *750*	165 *540*	195 *640*	230 *750*	155 *510*	185 *610*	220 *720*	145 *475*	170 *560*	200 *660*	125 *410*	150 *490*	180 *590*
K4	150 *490*	175 *570*	210 *690*	155 *510*	180 *590*	220 *720*	160 *520*	185 *610*	220 *720*	150 *490*	175 *570*	210 *690*	140 *460*	160 *520*	195 *640*	120 *395*	140 *460*	170 *560*
K5	90 *295*	110 *360*	130 *425*	95 *310*	115 *375*	135 *445*	100 *330*	115 *375*	135 *445*	95 *310*	110 *360*	130 *425*	85 *280*	100 *330*	120 *395*	75 *245*	85 *280*	105 *345*
K6	130 *425*	155 *510*	185 *610*	135 *445*	160 *520*	190 *620*	140 *460*	165 *540*	195 *640*	130 *425*	155 *510*	185 *610*	120 *395*	140 *460*	170 *560*	105 *345*	125 *410*	150 *490*
K7	120 *395*	140 *460*	165 *540*	125 *410*	145 *475*	170 *560*	125 *410*	145 *475*	175 *570*	120 *395*	140 *460*	165 *540*	110 *360*	130 *425*	150 *490*	95 *310*	110 *360*	135 *445*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	1525 *5000*	1800 *5900*	2150 *7050*	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	620 *2025*	730 *2400*	870 *2850*	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	410 *1350*	485 *1600*	580 *1900*	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	470 *1550*	550 *1800*	660 *2175*	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	50 *165*	60 *195*	70 *230*	50 *165*	60 *195*	70 *230*	49 *160*	55 *180*	65 *215*	46 *150*	55 *180*	65 *215*	— —	— —	— —
S2	— —	— —	— —	41 *135*	47 *155*	55 *180*	42 *140*	48 *155*	55 *180*	39 *130*	45 *150*	55 *180*	37 *120*	43 *140*	50 *165*	— —	— —	— —
S3	— —	— —	— —	36 *120*	41 *135*	49 *160*	37 *120*	42 *140*	50 *165*	35 *115*	40 *130*	47 *155*	33 *110*	38 *125*	44 *145*	— —	— —	— —
S11	— —	— —	— —	70 *230*	80 *260*	95 *310*	70 *230*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	65 *215*	75 *245*	90 *295*	— —	— —	— —
S12	— —	— —	— —	49 *160*	55 *180*	65 *215*	50 *165*	60 *195*	70 *230*	47 *155*	55 *180*	65 *215*	44 *145*	50 *165*	60 *195*	— —	— —	— —
S13	— —	— —	— —	28 *90*	33 *110*	39 *130*	29 *95*	34 *110*	40 *130*	27 *90*	32 *105*	37 *120*	26 *85*	30 *100*	35 *115*	— —	— —	— —
H5	47 *155*	55 *180*	65 *215*	43 *140*	49 *160*	60 *195*	44 *145*	50 *165*	60 *195*	43 *140*	49 *160*	60 *195*	42 *140*	49 *160*	60 *195*	38 *125*	44 *145*	50 *165*
H8	50 *165*	60 *195*	70 *230*	46 *150*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	46 *150*	55 *180*	65 *215*	45 *150*	55 *180*	60 *195*	40 *130*	47 *155*	55 *180*
H11	60 *195*	70 *230*	80 *260*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*	55 *180*	60 *195*	75 *245*	48 *155*	55 *180*	65 *215*
H12	90 *295*	105 *345*	125 *410*	90 *295*	105 *345*	125 *410*	95 *310*	110 *360*	130 *425*	90 *295*	105 *345*	120 *395*	80 *260*	95 *310*	110 *360*	75 *245*	85 *280*	100 *330*
H21	50 *165*	60 *195*	70 *230*	46 *150*	55 *180*	65 *215*	47 *155*	55 *180*	65 *215*	46 *150*	55 *180*	65 *215*	45 *150*	55 *180*	60 *195*	40 *130*	47 *155*	55 *180*

R217/220.21-160 – Cutting data v_c = (m/min)/*(sf/min)*

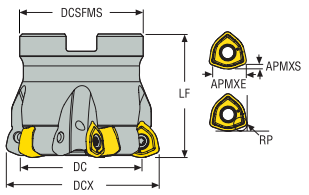
SMG	F40M			MK2050			MS2050			MS2500			MH1000			H25		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	220	255	305	235	275	335	240	280	335	315	370	440	—	—	—	—	—	—
	720	*840*	*1000*	*770*	*900*	*1100*	*790*	*920*	*1100*	*1025*	*1225*	*1450*	—	—	—	—	—	—
P2	210	250	300	230	270	325	235	275	330	305	360	430	—	—	—	—	—	—
	690	*820*	*980*	*750*	*890*	*1075*	*770*	*900*	*1075*	*1000*	*1175*	*1400*	—	—	—	—	—	—
P3	185	220	255	205	240	280	205	240	280	270	315	370	—	—	—	—	—	—
	610	*720*	*840*	*670*	*790*	*920*	*670*	*790*	*920*	*890*	*1025*	*1225*	—	—	—	—	—	—
P4	165	190	230	180	210	255	180	210	250	235	275	330	—	—	—	—	—	—
	540	*620*	*750*	*590*	*690*	*840*	*590*	*690*	*820*	*770*	*900*	*1075*	—	—	—	—	—	—
P5	155	185	220	170	200	240	170	200	240	225	265	315	—	—	—	—	—	—
	510	*610*	*720*	*560*	*660*	*790*	*560*	*660*	*790*	*740*	*870*	*1025*	—	—	—	—	—	—
P6	175	205	245	190	225	270	195	225	270	255	295	355	—	—	—	—	—	—
	570	*670*	*800*	*620*	*740*	*890*	*640*	*740*	*890*	*840*	*970*	*1175*	—	—	—	—	—	—
P7	165	195	230	180	215	255	180	215	255	240	280	335	—	—	—	—	—	—
	540	*640*	*750*	*590*	*710*	*840*	*590*	*710*	*840*	*790*	*920*	*1100*	—	—	—	—	—	—
P8	155	185	215	170	200	235	170	200	235	225	265	310	—	—	—	—	—	—
	510	*610*	*710*	*560*	*660*	*770*	*560*	*660*	*770*	*740*	*870*	*1025*	—	—	—	—	—	—
P11	160	190	225	175	205	250	175	210	250	230	270	325	—	—	—	—	—	—
	520	*620*	*740*	*570*	*670*	*820*	*570*	*690*	*820*	*750*	*890*	*1075*	—	—	—	—	—	—
P12	105	125	150	120	140	160	115	135	165	155	180	215	—	—	—	—	—	—
	345	*410*	*490*	*395*	*460*	*520*	*375*	*445*	*540*	*510*	*590*	*710*	—	—	—	—	—	—
M1	170	200	240	—	—	—	190	220	265	220	255	310	—	—	—	—	—	—
	560	*660*	*790*	—	—	—	*620*	*720*	*870*	*720*	*840*	*1025*	—	—	—	—	—	—
M2	140	165	195	—	—	—	155	180	215	180	210	250	—	—	—	—	—	—
	460	*540*	*640*	—	—	—	*510*	*590*	*710*	*590*	*690*	*820*	—	—	—	—	—	—
M3	115	135	160	—	—	—	125	145	175	145	170	205	—	—	—	—	—	—
	375	*445*	*520*	—	—	—	*410*	*475*	*570*	*475*	*560*	*670*	—	—	—	—	—	—
M4	90	105	125	—	—	—	100	115	135	115	135	155	—	—	—	—	—	—
	295	*345*	*410*	—	—	—	*330*	*375*	*445*	*375*	*445*	*510*	—	—	—	—	—	—
M5	75	85	100	—	—	—	80	95	115	95	110	130	—	—	—	—	—	—
	245	*280*	*330*	—	—	—	*260*	*310*	*375*	*310*	*360*	*425*	—	—	—	—	—	—
K1	170	195	235	250	290	350	—	—	—	—	—	—	205	240	290	—	—	—
	560	*640*	*770*	*820*	*950*	*1150*	—	—	—	—	—	—	*670*	*790*	*950*	—	—	—
K2	150	175	210	220	260	310	—	—	—	—	—	—	180	215	255	—	—	—
	490	*570*	*690*	*720*	*850*	*1025*	—	—	—	—	—	—	*590*	*710*	*840*	—	—	—
K3	125	145	175	185	220	265	—	—	—	—	—	—	155	180	215	—	—	—
	410	*475*	*570*	*610*	*720*	*870*	—	—	—	—	—	—	*510*	*590*	*710*	—	—	—
K4	120	140	170	180	210	250	—	—	—	—	—	—	145	170	205	—	—	—
	395	*460*	*560*	*590*	*690*	*820*	—	—	—	—	—	—	*475*	*560*	*670*	—	—	—
K5	75	85	105	110	130	155	—	—	—	—	—	—	90	105	125	—	—	—
	245	*280*	*345*	*360*	*425*	*510*	—	—	—	—	—	—	*295*	*345*	*410*	—	—	—
K6	105	125	150	155	185	220	—	—	—	—	—	—	130	150	180	—	—	—
	345	*410*	*490*	*510*	*610*	*720*	—	—	—	—	—	—	*425*	*490*	*590*	—	—	—
K7	95	110	130	140	165	195	—	—	—	—	—	—	115	135	160	—	—	—
	310	*360*	*425*	*460*	*540*	*640*	—	—	—	—	—	—	*375*	*445*	*520*	—	—	—
N1	1225	1425	1725	—	—	—	—	—	—	—	—	—	—	—	—	1300	1525	1800
	4025	*4675*	*5650*	—	—	—	—	—	—	—	—	—	—	—	—	*4275*	*5000*	*5900*
N2	495	580	700	—	—	—	—	—	—	—	—	—	—	—	—	530	620	730
	1625	*1900*	*2300*	—	—	—	—	—	—	—	—	—	—	—	—	*1750*	*2025*	*2400*
N3	330	385	465	—	—	—	—	—	—	—	—	—	—	—	—	350	410	485
	1075	*1275*	*1525*	—	—	—	—	—	—	—	—	—	—	—	—	*1150*	*1350*	*1600*
N11	375	440	530	—	—	—	—	—	—	—	—	—	—	—	—	400	470	550
	1225	*1450*	*1750*	—	—	—	—	—	—	—	—	—	—	—	—	*1300*	*1550*	*1800*
S1	42	49	55	—	—	—	46	55	65	55	65	75	—	—	—	—	—	—
	140	*160*	*180*	—	—	—	*150*	*180*	*215*	*180*	*215*	*245*	—	—	—	—	—	—
S2	34	39	46	—	—	—	37	43	50	45	50	60	—	—	—	—	—	—
	110	*130*	*150*	—	—	—	*120*	*140*	*165*	*150*	*165*	*195*	—	—	—	—	—	—
S3	30	34	40	—	—	—	33	38	44	40	46	55	—	—	—	—	—	—
	100	*110*	*130*	—	—	—	*110*	*125*	*145*	*130*	*150*	*180*	—	—	—	—	—	—
S11	60	70	80	—	—	—	65	75	90	80	90	110	—	—	—	—	—	—
	195	*230*	*260*	—	—	—	*215*	*245*	*295*	*260*	*295*	*360*	—	—	—	—	—	—
S12	40	47	55	—	—	—	44	50	60	55	65	75	—	—	—	—	—	—
	130	*155*	*180*	—	—	—	*145*	*165*	*195*	*180*	*215*	*245*	—	—	—	—	—	—
S13	24	27	32	—	—	—	26	30	35	32	37	43	—	—	—	—	—	—
	80	*90*	*105*	—	—	—	*85*	*100*	*115*	*105*	*120*	*140*	—	—	—	—	—	—
H5	37	42	50	—	—	—	—	—	—	—	—	—	46	55	65	—	—	—
	120	*140*	*165*	—	—	—	—	—	—	—	—	—	*150*	*180*	*215*	—	—	—
H8	40	46	55	—	—	—	—	—	—	—	—	—	49	55	70	—	—	—
	130	*150*	*180*	—	—	—	—	—	—	—	—	—	*160*	*180*	*230*	—	—	—
H11	46	55	65	—	—	—	—	—	—	—	—	—	60	65	80	—	—	—
	150	*180*	*215*	—	—	—	—	—	—	—	—	—	*195*	*215*	*260*	—	—	—
H12	70	80	95	—	—	—	—	—	—	—	—	—	90	100	120	—	—	—
	230	*260*	*310*	—	—	—	—	—	—	—	—	—	*295*	*330*	*395*	—	—	—
H21	40	46	55	—	—	—	—	—	—	—	—	—	49	55	70	—	—	—
	130	*150*	*180*	—	—	—	—	—	—	—	—	—	*160*	*180*	*230*	—	—	—

R217/220.21 HIGH FEED 6

High feed 6, for 218.21 insert type, 6-cutting edge, double sided inserts.
This familly consists of shell end mill bodies with fixed pockets and very strong negative inserts with six cutting edges.

- Cutter range 40-160 mm (1.5 - 6 inch)
- Max depth of cut 1.8 mm
- First choice for ISO P & K materials for medium-size machines

R220.21-R230 – Metric

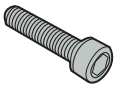
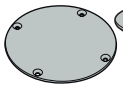


- For insert selection and cutting data recommendations, see page(s) 519-521
- For complete insert programme, see page(s) 789
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm		mm	mm	mm		mm	mm	kg		
R217.21-2040.RE-R230.3A	03136708	Combimaster	25,6	40,0	3	1,8	10,0	–	M20	36,5	45,0	3,32	1,4	65,6	78,0	0,4	12100	218.21-..
R217.21-2042.RE-R230.3A	03136709	Combimaster	27,6	42,0	3	1,8	10,0	–	M20	36,5	45,0	3,32	1,3	69,6	82,0	0,4	12100	218.21-..
R220.21-0050-R230.4A	02826551	Arbor	35,6	50,0	4	1,8	10,0	22,0	–	42,0	40,0	3,32	0,9	85,6	98,0	0,3	12100	218.21-..
R220.21-0050-R230.5A	02826550	Arbor	35,6	50,0	5	1,8	10,0	22,0	–	42,0	40,0	3,32	0,9	85,6	98,0	0,3	12100	218.21-..
R220.21-0052-R230.5A	02826552	Arbor	37,6	52,0	5	1,8	10,0	22,0	–	42,0	40,0	3,32	0,9	89,6	102,0	0,3	11900	218.21-..
R220.21-0063-R230.5A	02826553	Arbor	48,3	63,0	5	1,8	10,0	27,0	–	50,0	50,0	3,32	0,6	111,3	124,0	0,6	10800	218.21-..
R220.21-0063-R230.6A	02826554	Arbor	48,3	63,0	6	1,8	10,0	27,0	–	50,0	50,0	3,32	0,6	111,3	124,0	0,6	10800	218.21-..
R220.21-0066-R230.6A	02826555	Arbor	51,3	66,0	6	1,8	10,0	27,0	–	62,0	50,0	3,32	0,6	117,3	130,0	0,8	10600	218.21-..
R220.21-0080-R230.6A	02826556	Arbor	65,6	80,0	6	1,8	10,0	27,0	–	62,0	50,0	3,32	0,4	145,6	158,0	1,0	9600	218.21-..
R220.21-0080-R230.7A	02826557	Arbor	65,6	80,0	7	1,8	10,0	27,0	–	62,0	50,0	3,32	0,4	145,6	158,0	1,0	9600	218.21-..
R220.21-0084-R230.6A	03317249	Arbor	69,6	84,0	6	1,8	10,0	32,0	–	79,0	50,0	3,32	0,4	153,6	166,0	1,3	9600	218.21-..
R220.21-0084-R230.8A	02826558	Arbor	69,6	84,0	8	1,8	10,0	32,0	–	77,0	50,0	3,32	0,4	153,6	166,0	1,3	9400	218.21-..
R220.21-0100-R230.7A	02950391	Arbor	85,6	100,0	7	1,8	10,0	32,0	–	77,0	50,0	3,3	0,3	185,6	198,0	1,5	8600	218.21-..
R220.21-0100-R230.9A	02826559	Arbor	85,6	100,0	9	1,8	10,0	32,0	–	77,0	50,0	3,32	0,3	185,6	198,0	1,6	8600	218.21-..
R220.21-0125-R230.9A	02826560	Arbor	110,2	125,0	9	1,8	10,0	40,0	–	90,0	63,0	3,32	0,2	235,2	248,0	2,8	7700	218.21-..
R220.21-8160-R230.10A	02826561	Arbor	145,2	160,0	10	1,8	10,0	40,0	–	90,0	63,0	3,32	0,1	305,2	318,0	4,1	6800	218.21-..

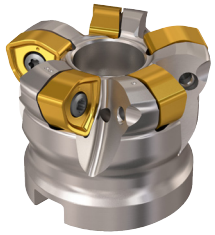
Spare Parts

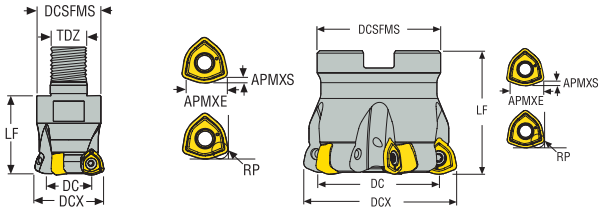
Accessories

For cutter	Arbor screw	Insert screw	Lid	Screw	Torque key	Torque value
						
R217.21-2040-2042	–	C04011-T15P	–	–	T00-15P35	3.5NM
R220.21-0050	220.17-692	C04011-T15P	–	–	T00-15P35	3.5NM
R220.21-0063-0066	MC6S12X35	C04011-T15P	–	–	T00-15P35	3.5NM
R220.21-0080	MC6S12X35	C04011-T15P	–	–	T00-15P35	3.5NM
R220.21-0084-0100	MLC6S16X35	C04011-T15P	–	–	T00-15P35	3.5NM
R220.21-0125	MLC6S20X40	C04011-T15P	–	–	T00-15P35	3.5NM
R220.21-8160	–	C04011-T15P	SC160-53	MF6S4X10	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-R230 – Inch





- For insert selection and cutting data recommendations, see page(s) 519-521
- For complete insert programme, see page(s) 789
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	TDZ	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch	Inch		Inch	Inch	Inch		Inch	Inch	lbs		
R217.21-01.50-20RE-R230-3A	03136710	Combimaster	0.937	1.500	3	0.071	0.394	–	M20	1.437	1.772	0.131	1,5	2.437	2.921	0.660	12100	218.21-..
R220.21-02.00-R230-4A	02842027	Arbor	1.421	2.000	4	0.071	0.394	0.750	–	1.654	1.575	0.131	0,9	3.421	3.921	0.660	12100	218.21-..
R220.21-02.00-R230-5A	02842026	Arbor	1.421	2.000	5	0.071	0.394	0.750	–	1.654	1.575	0.131	0,9	3.421	3.921	0.660	12100	218.21-..
R220.21-02.50-R230-5A	02842028	Arbor	1.921	2.500	5	0.071	0.394	0.750	–	1.850	1.575	0.131	0,6	4.421	4.921	1.100	9600	218.21-..
R220.21-02.50-R230-6A	02842029	Arbor	1.921	2.500	6	0.071	0.394	0.750	–	1.850	1.575	0.131	0,6	4.421	4.921	1.100	9600	218.21-..
R220.21-03.00-R230-5A	02842030	Arbor	2.429	2.996	5	0.071	0.394	1.000	–	2.441	1.969	0.131	0,5	5.425	5.913	1.980	9800	218.21-..
R220.21-03.00-R230-6A	02842031	Arbor	2.429	2.996	6	0.071	0.394	1.000	–	2.441	1.969	0.131	0,5	5.425	5.913	2.200	9800	218.21-..
R220.21-04.00-R230-7A	03067226	Arbor	3.433	4.000	7	0.071	0.394	1.500	–	3.543	1.969	0.130	0,3	7.433	7.921	3.970	8500	218.21-..
R220.21-04.00-R230-9A	02842032	Arbor	3.433	4.000	9	0.071	0.394	1.500	–	3.543	1.969	0.130	0,3	7.433	7.921	3.970	8500	218.21-..

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.21-..	–	C04011-T15P	T00-15P35	31.0IN.LBS
R220.21-02.00-02.50	UC6S3/8UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.21-03.00	UC6S1/2UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R220.21-04.00	ULC6S3/4UNFX11/2	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.21-R230 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.21-230TR-06-ME13 T350M	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P2	218.21-230TR-06-ME13 T350M	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P3	218.21-230TR-06-ME13 T350M	1,6 *0.065*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
P4	218.21-230TR-06-M15 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P5	218.21-230TR-06-M15 MP2501	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,2 *0.048*
P6	218.21-230TR-06-M15 MP2501	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P7	218.21-230TR-06-M15 MP2501	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P8	218.21-230TR-06-M15 MS2500	1,6 *0.065*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
P11	218.21-230TR-06-M15 MS2500	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
P12	218.21-230TR-06-M15 MS2500	1,3 *0.050*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
M1	218.21-230TR-06-ME13 MS2050	1,6 *0.065*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
M2	218.21-230TR-06-ME13 MS2050	1,6 *0.065*	0,90 *0.036*	0,90 *0.036*	1,1 *0.044*
M3	218.21-230TR-06-ME13 MS2050	1,3 *0.050*	0,80 *0.032*	0,80 *0.032*	0,95 *0.038*
M4	218.21-230TR-06-M15 MS2500	0,95 *0.038*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
M5	218.21-230TR-06-M15 MS2500	0,95 *0.038*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
K1	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,2 *0.048*	1,2 *0.048*	1,5 *0.060*
K2	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K3	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K4	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K5	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
K6	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,1 *0.044*	1,1 *0.044*	1,3 *0.050*
K7	218.21-230TR-06-MD17 MK2050	1,8 *0.070*	1,0 *0.040*	1,0 *0.040*	1,2 *0.048*
S1	218.21-230TR-06-M15 MS2500	0,95 *0.038*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
S2	218.21-230TR-06-M15 MS2500	0,95 *0.038*	0,95 *0.038*	0,95 *0.038*	1,1 *0.044*
S3	218.21-230TR-06-M15 MS2500	0,95 *0.038*	0,90 *0.036*	0,90 *0.036*	1,0 *0.040*
S11	218.21-230TR-06-ME13 MS2050	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,0 *0.040*
S12	218.21-230TR-06-ME13 MS2050	1,1 *0.044*	0,90 *0.036*	0,90 *0.036*	1,0 *0.040*
S13	218.21-230TR-06-ME13 MS2050	0,95 *0.038*	0,85 *0.034*	0,85 *0.034*	0,95 *0.038*
H5	218.21-230TR-06-MD17 MP3000	1,1 *0.044*	0,85 *0.034*	0,85 *0.034*	1,0 *0.040*
H8	218.21-230TR-06-MD17 MP3000	1,0 *0.040*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
H11	218.21-230TR-06-M15 T350M	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
H12	218.21-230TR-06-M15 T350M	0,90 *0.036*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
H21	218.21-230TR-06-MD17 MP3000	1,0 *0.040*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*

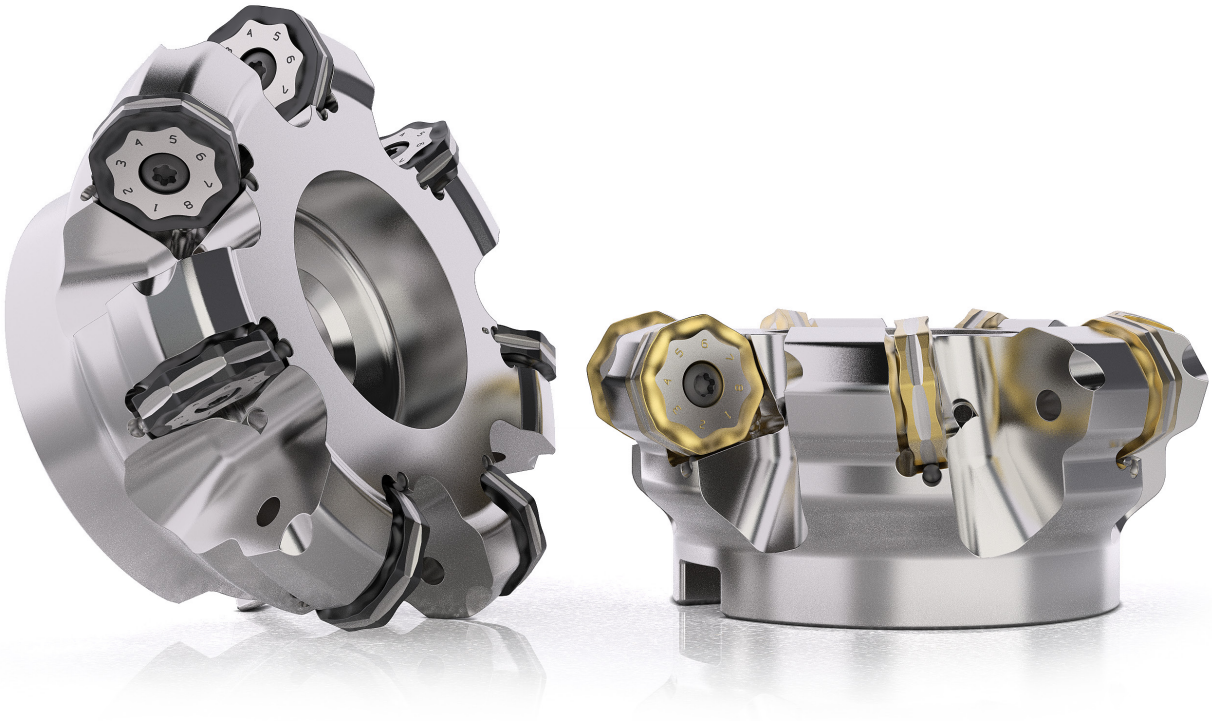
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.21-R230 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			T350M		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	215 *710*	245 *800*	300 *980*	210 *690*	245 *800*	295 *970*	215 *710*	250 *820*	300 *980*	205 *670*	235 *770*	285 *940*	190 *620*	215 *710*	260 *850*
P2	210 *690*	240 *790*	285 *940*	200 *660*	230 *750*	280 *920*	205 *670*	235 *770*	285 *940*	195 *640*	220 *720*	270 *890*	180 *590*	205 *670*	245 *800*
P3	180 *590*	205 *670*	250 *820*	180 *590*	205 *670*	245 *800*	180 *590*	210 *690*	250 *820*	170 *560*	195 *640*	235 *770*	160 *520*	180 *590*	220 *720*
P4	160 *520*	180 *590*	220 *720*	155 *510*	180 *590*	215 *710*	160 *520*	185 *610*	220 *720*	150 *490*	175 *570*	210 *690*	140 *460*	160 *520*	190 *620*
P5	155 *510*	180 *590*	215 *710*	150 *490*	170 *560*	210 *690*	150 *490*	175 *570*	215 *710*	145 *475*	165 *540*	205 *670*	130 *425*	150 *490*	190 *620*
P6	175 *570*	200 *660*	240 *790*	175 *570*	200 *660*	240 *790*	175 *570*	200 *660*	240 *790*	165 *540*	190 *620*	230 *750*	155 *510*	175 *570*	210 *690*
P7	165 *540*	190 *620*	230 *750*	165 *540*	190 *620*	225 *740*	165 *540*	190 *620*	230 *750*	160 *520*	180 *590*	215 *710*	145 *475*	165 *540*	200 *660*
P8	150 *490*	175 *570*	210 *690*	150 *490*	170 *560*	205 *670*	150 *490*	175 *570*	210 *690*	145 *475*	165 *540*	200 *660*	130 *425*	150 *490*	185 *610*
P11	160 *520*	185 *610*	220 *720*	160 *520*	180 *590*	220 *720*	160 *520*	185 *610*	220 *720*	155 *510*	175 *570*	210 *690*	140 *460*	160 *520*	195 *640*
P12	110 *360*	125 *410*	150 *490*	105 *345*	120 *395*	145 *475*	105 *345*	120 *395*	145 *475*	100 *330*	115 *375*	140 *460*	95 *310*	105 *345*	125 *410*
M1	— —	— —	— —	145 *475*	165 *540*	200 *660*	145 *475*	170 *560*	205 *670*	145 *475*	165 *540*	200 *660*	135 *445*	155 *510*	190 *620*
M2	— —	— —	— —	120 *395*	135 *445*	170 *560*	120 *395*	140 *460*	175 *570*	120 *395*	140 *460*	170 *560*	115 *375*	130 *425*	160 *520*
M3	— —	— —	— —	100 *330*	115 *375*	135 *445*	100 *330*	115 *375*	140 *460*	100 *330*	115 *375*	140 *460*	95 *310*	110 *360*	130 *425*
M4	— —	— —	— —	80 *260*	90 *295*	110 *360*	80 *260*	90 *295*	110 *360*	80 *260*	90 *295*	110 *360*	75 *245*	85 *280*	105 *345*
M5	— —	— —	— —	65 *215*	75 *245*	90 *295*	65 *215*	75 *245*	90 *295*	65 *215*	75 *245*	90 *295*	65 *215*	70 *230*	85 *280*
K1	165 *540*	190 *620*	225 *740*	160 *520*	180 *590*	220 *720*	160 *520*	185 *610*	225 *740*	155 *510*	175 *570*	215 *710*	140 *460*	160 *520*	195 *640*
K2	150 *490*	170 *560*	205 *670*	140 *460*	165 *540*	200 *660*	145 *475*	165 *540*	205 *670*	135 *445*	155 *510*	195 *640*	125 *410*	145 *475*	180 *590*
K3	125 *410*	145 *475*	175 *570*	120 *395*	140 *460*	170 *560*	120 *395*	140 *460*	175 *570*	115 *375*	135 *445*	165 *540*	105 *345*	120 *395*	150 *490*
K4	120 *395*	135 *445*	165 *540*	115 *375*	130 *425*	165 *540*	115 *375*	135 *445*	165 *540*	110 *360*	125 *410*	155 *510*	100 *330*	115 *375*	145 *475*
K5	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	100 *330*	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	65 *215*	75 *245*	90 *295*
K6	105 *345*	120 *395*	145 *475*	100 *330*	115 *375*	145 *475*	105 *345*	120 *395*	145 *475*	95 *310*	110 *360*	140 *460*	90 *295*	105 *345*	125 *410*
K7	95 *310*	110 *360*	130 *425*	90 *295*	105 *345*	125 *410*	95 *310*	105 *345*	130 *425*	90 *295*	100 *330*	125 *410*	80 *260*	95 *310*	115 *375*
S1	— —	— —	— —	39 *130*	44 *145*	55 *180*	39 *130*	45 *150*	55 *180*	37 *120*	42 *140*	50 *165*	35 *115*	40 *130*	48 *155*
S2	— —	— —	— —	31 *100*	35 *115*	43 *140*	32 *105*	36 *120*	43 *140*	30 *100*	34 *110*	41 *135*	28 *90*	32 *105*	39 *130*
S3	— —	— —	— —	27 *90*	31 *100*	38 *125*	28 *90*	32 *105*	39 *130*	26 *85*	30 *100*	36 *120*	25 *80*	28 *90*	34 *110*
S11	— —	— —	— —	55 *180*	60 *195*	75 *245*	55 *180*	60 *195*	75 *245*	50 *165*	60 *195*	70 *230*	49 *160*	55 *180*	65 *215*
S12	— —	— —	— —	37 *120*	42 *140*	50 *165*	38 *125*	43 *140*	50 *165*	36 *120*	41 *135*	48 *155*	34 *110*	38 *125*	46 *150*
S13	— —	— —	— —	22 *70*	25 *80*	30 *100*	22 *70*	25 *80*	30 *100*	21 *70*	24 *80*	29 *95*	20 *65*	23 *75*	27 *90*
H5	37 *120*	43 *140*	50 *165*	33 *110*	37 *120*	45 *150*	34 *110*	38 *125*	47 *155*	33 *110*	37 *120*	45 *150*	32 *105*	37 *120*	45 *150*
H8	40 *130*	46 *150*	55 *180*	35 *115*	40 *130*	49 *160*	36 *120*	42 *140*	50 *165*	35 *115*	40 *130*	49 *160*	35 *115*	40 *130*	48 *155*
H11	48 *155*	55 *180*	65 *215*	42 *140*	48 *155*	60 *195*	43 *140*	49 *160*	60 *195*	42 *140*	48 *155*	60 *195*	41 *135*	47 *155*	55 *180*
H12	75 *245*	85 *280*	100 *330*	70 *230*	80 *260*	95 *310*	70 *230*	80 *260*	100 *330*	70 *230*	80 *260*	95 *310*	65 *215*	70 *230*	85 *280*
H21	40 *130*	46 *150*	55 *180*	35 *115*	40 *130*	49 *160*	36 *120*	42 *140*	50 *165*	35 *115*	40 *130*	49 *160*	35 *115*	40 *130*	48 *155*

R217/220.21-R230 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M			MM4500			MK2050			MS2050			MS2500		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	165 *540*	190 *620*	225 *740*	140 *460*	160 *520*	195 *640*	185 *610*	215 *710*	260 *850*	180 *590*	205 *670*	250 *820*	235 *770*	270 *890*	325 *1075*
P2	155 *510*	175 *570*	215 *710*	135 *445*	160 *520*	190 *620*	180 *590*	210 *690*	250 *820*	170 *560*	195 *640*	235 *770*	220 *720*	255 *840*	310 *1025*
P3	135 *445*	155 *510*	190 *620*	120 *395*	140 *460*	165 *540*	155 *510*	180 *590*	220 *720*	150 *490*	175 *570*	210 *690*	195 *640*	225 *740*	275 *900*
P4	120 *395*	140 *460*	165 *540*	105 *345*	120 *395*	145 *475*	140 *460*	160 *520*	190 *620*	135 *445*	150 *490*	185 *610*	175 *570*	200 *660*	240 *790*
P5	115 *375*	130 *425*	165 *540*	105 *345*	120 *395*	140 *460*	135 *445*	155 *510*	190 *620*	125 *410*	145 *475*	180 *590*	165 *540*	190 *620*	235 *770*
P6	135 *445*	155 *510*	185 *610*	115 *375*	135 *445*	160 *520*	150 *490*	175 *570*	210 *690*	145 *475*	170 *560*	200 *660*	190 *620*	220 *720*	265 *870*
P7	125 *410*	145 *475*	175 *570*	110 *360*	125 *410*	150 *490*	145 *475*	165 *540*	200 *660*	140 *460*	160 *520*	190 *620*	180 *590*	210 *690*	250 *820*
P8	115 *375*	130 *425*	160 *520*	100 *330*	115 *375*	140 *460*	130 *425*	150 *490*	185 *610*	125 *410*	145 *475*	175 *570*	165 *540*	190 *620*	230 *750*
P11	120 *395*	140 *460*	170 *560*	105 *345*	120 *395*	145 *475*	140 *460*	160 *520*	195 *640*	135 *445*	155 *510*	185 *610*	175 *570*	200 *660*	245 *800*
P12	80 *260*	90 *295*	110 *360*	70 *230*	80 *260*	95 *310*	95 *310*	110 *360*	130 *425*	90 *295*	100 *330*	120 *395*	115 *375*	135 *445*	160 *520*
M1	125 *410*	145 *475*	175 *570*	120 *395*	135 *445*	160 *520*	— —	— —	— —	135 *445*	155 *510*	190 *620*	160 *520*	185 *610*	220 *720*
M2	105 *345*	120 *395*	145 *475*	100 *330*	115 *375*	135 *445*	— —	— —	— —	115 *375*	130 *425*	160 *520*	135 *445*	150 *490*	190 *620*
M3	85 *280*	100 *330*	120 *395*	80 *260*	95 *310*	110 *360*	— —	— —	— —	95 *310*	110 *360*	130 *425*	110 *360*	125 *410*	155 *510*
M4	70 *230*	80 *260*	95 *310*	65 *215*	70 *230*	85 *280*	— —	— —	— —	75 *245*	85 *280*	105 *345*	90 *295*	100 *330*	120 *395*
M5	55 *180*	65 *215*	80 *260*	50 *165*	60 *195*	75 *245*	— —	— —	— —	65 *215*	70 *230*	85 *280*	75 *245*	85 *280*	100 *330*
K1	120 *395*	140 *460*	170 *560*	— —	— —	— —	195 *640*	225 *740*	265 *870*	— —	— —	— —	— —	— —	— —
K2	110 *360*	125 *410*	155 *510*	— —	— —	— —	175 *570*	200 *660*	245 *800*	— —	— —	— —	— —	— —	— —
K3	95 *310*	105 *345*	130 *425*	— —	— —	— —	150 *490*	170 *560*	205 *670*	— —	— —	— —	— —	— —	— —
K4	90 *295*	100 *330*	125 *410*	— —	— —	— —	140 *460*	165 *540*	195 *640*	— —	— —	— —	— —	— —	— —
K5	55 *180*	65 *215*	75 *245*	— —	— —	— —	85 *280*	100 *330*	120 *395*	— —	— —	— —	— —	— —	— —
K6	80 *260*	90 *295*	110 *360*	— —	— —	— —	125 *410*	145 *475*	175 *570*	— —	— —	— —	— —	— —	— —
K7	70 *230*	80 *260*	100 *330*	— —	— —	— —	110 *360*	130 *425*	155 *510*	— —	— —	— —	— —	— —	— —
S1	32 *105*	36 *120*	44 *145*	19 *60*	22 *70*	27 *90*	— —	— —	— —	35 *115*	40 *130*	48 *155*	43 *140*	49 *160*	60 *195*
S2	26 *85*	29 *95*	35 *115*	15 *49*	18 *60*	21 *70*	— —	— —	— —	28 *90*	32 *105*	39 *130*	34 *110*	39 *130*	47 *155*
S3	23 *75*	26 *85*	31 *100*	14 *46*	16 *50*	19 *60*	— —	— —	— —	25 *80*	28 *90*	34 *110*	30 *100*	34 *110*	42 *140*
S11	44 *145*	50 *165*	60 *195*	27 *90*	30 *100*	37 *120*	— —	— —	— —	49 *160*	55 *180*	65 *215*	60 *195*	70 *230*	80 *260*
S12	31 *100*	35 *115*	42 *140*	25 *80*	28 *90*	34 *110*	— —	— —	— —	34 *110*	38 *125*	46 *150*	41 *135*	47 *155*	55 *180*
S13	18 *60*	20 *65*	25 *80*	14 *46*	16 *50*	20 *65*	— —	— —	— —	20 *65*	23 *75*	27 *90*	24 *80*	27 *90*	33 *110*
H5	28 *90*	32 *105*	39 *130*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	30 *100*	35 *115*	42 *140*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	36 *120*	41 *135*	49 *160*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	55 *180*	60 *195*	75 *245*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	30 *100*	35 *115*	42 *140*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

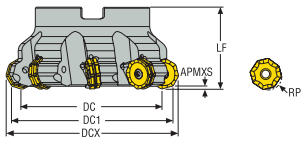


R220.21 (ON09) HIGH FEED

High feed double octomill insert cutters. ON09 inserts have 16 cutting edges, making them the most cost-effective choice for face milling applications using a high feed strategy.
HSS pins securely position inserts in the fixed pockets of the cutter and decrease the time required for indexing.

- Cutter range 80-160 mm (3 - 6 inch)
- Max depth of cut 2 mm (.078 inch)
- Facing applications only

R220.21-ON09 – Metric

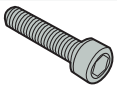


- For insert selection and cutting data recommendations, see page(s) 525-526
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DC1	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	Weight	RPMX	Insert
			mm	mm	mm		mm	mm	mm	mm	mm	mm	kg		
R220.21-0080-ON09-6A	02848781	Arbor	65,35	80,0	89,9	6	2,0	7,0	27,0	62,0	–	10,28	1,0	4400	ON..09
R220.21-0100-ON09-7A	02848782	Arbor	85,35	100,0	109,9	7	2,0	7,0	32,0	77,0	–	10,28	1,5	3900	ON..09
R220.21-0125-ON09-8A	02848783	Arbor	110,35	125,0	134,9	8	2,0	7,0	40,0	90,0	–	10,28	2,9	3500	ON..09
R220.21-8160-ON09-10	02848784	Arbor	145,35	160,0	169,9	10	2,0	7,0	40,0	90,0	–	10,28	4,1	3100	ON..09

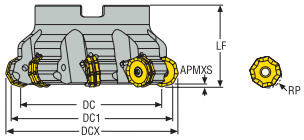
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.21-0080	MC6S12X35	C05013-T20P	T00-20P50	5.0NM
R220.21-0100-8160	–	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-ON09 – Inch



- For insert selection and cutting data recommendations, see page(s) 525-526
- For complete insert programme, see page(s) 745
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DC1	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	Weight	RPMX	Insert
			Inch	Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch	lbs		
R220.21-03.00-ON09-6A	02848785	Arbor	2.423	3.000	3.389	6	0.079	0.276	1.000	2.441	–	0.405	1.980	4400	ON..09
R220.21-04.00-ON09-7A	02848786	Arbor	3.423	4.000	4.389	7	0.079	0.276	1.500	3.031	–	0.405	3.310	3900	ON..09
R220.21-05.00-ON09-8A	02848787	Arbor	4.423	5.000	5.389	8	0.079	0.276	1.500	3.543	–	0.405	7.050	3500	ON..09
R220.21-06.00-ON09-10	02848788	Arbor	5.423	6.000	6.389	10	0.079	0.276	2.000	4.331	–	0.405	7.720	3200	ON..09

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.21-03.00	UC6S1/2UNFX1-1/4	C05013-T20P	T00-20P50	44.3IN.LBS
R220.21-04.00	UF6S3/4UNFX2	C05013-T20P	T00-20P50	44.3IN.LBS
R220.21-05.00	UF6S3/4UNFX2	C05013-T20P	T00-20P50	44.3IN.LBS
R220.21-06.00	–	C05013-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-ON09 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	ONMU090520ANTN-M12 MP2501	1,2 *0.048*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
P2	ONMU090520ANTN-M12 MP2501	1,2 *0.048*	0,60 *0.024*	0,60 *0.024*	0,70 *0.028*
P3	ONMU090520ANTN-M12 MP2501	1,2 *0.048*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
P4	ONMU090520ANTN-M12 MP2501	1,2 *0.048*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
P5	ONMU090520ANTN-M12 MP2501	1,2 *0.048*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P6	ONMU090520ANTN-M12 MP2501	1,2 *0.048*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
P7	ONMU090520ANTN-MD16 MP1501	1,2 *0.048*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
P8	ONMU090520ANTN-MD16 MP1501	1,2 *0.048*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
P11	ONMU090520ANTN-MD16 MP1501	1,2 *0.048*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
P12	ONMU090520ANTN-MD16 MP1501	0,95 *0.038*	0,50 *0.020*	0,50 *0.020*	0,55 *0.022*
K1	ONMU090520ANTN-M14 MK2050	1,2 *0.048*	0,75 *0.030*	0,75 *0.030*	0,80 *0.032*
K2	ONMU090520ANTN-M14 MK2050	1,2 *0.048*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K3	ONMU090520ANTN-M14 MK2050	1,2 *0.048*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K4	ONMU090520ANTN-M14 MK2050	1,2 *0.048*	0,65 *0.026*	0,65 *0.026*	0,75 *0.030*
K5	ONMU090520ANTN-M14 MK2050	1,2 *0.048*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
K6	ONMU090520ANTN-MD16 MK1500	1,2 *0.048*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
K7	ONMU090520ANTN-MD16 MK1500	1,2 *0.048*	0,70 *0.028*	0,70 *0.028*	0,75 *0.030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.21-ON09 – Cutting data v_c = (m/min)/*(sf/min)*

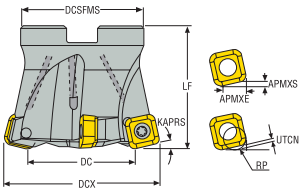
SMG	MP1501			MP2050			MP2501			MK1500			MK2050		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	315 *1025*	350 *1150*	420 *1375*	275 *900*	305 *1000*	365 *1200*	280 *920*	310 *1025*	370 *1225*	— —	— —	— —	275 *900*	305 *1000*	365 *1200*
P2	305 *1000*	340 *1125*	410 *1350*	265 *870*	295 *970*	355 *1175*	270 *890*	300 *980*	360 *1175*	— —	— —	— —	265 *870*	295 *970*	355 *1175*
P3	265 *870*	295 *970*	360 *1175*	230 *750*	255 *840*	310 *1025*	235 *770*	260 *850*	315 *1025*	— —	— —	— —	230 *750*	255 *840*	315 *1025*
P4	230 *750*	260 *850*	315 *1025*	200 *660*	225 *740*	275 *900*	205 *670*	230 *750*	280 *920*	— —	— —	— —	200 *660*	225 *740*	275 *900*
P5	225 *740*	250 *820*	300 *980*	195 *640*	220 *720*	260 *850*	200 *660*	225 *740*	265 *870*	— —	— —	— —	200 *660*	220 *720*	265 *870*
P6	255 *840*	285 *940*	340 *1125*	220 *720*	245 *800*	295 *970*	225 *740*	250 *820*	300 *980*	— —	— —	— —	220 *720*	245 *800*	295 *970*
P7	240 *790*	265 *870*	320 *1050*	210 *690*	235 *770*	280 *920*	215 *710*	235 *770*	285 *940*	— —	— —	— —	210 *690*	235 *770*	280 *920*
P8	220 *720*	245 *800*	300 *980*	190 *620*	215 *710*	260 *850*	195 *640*	220 *720*	265 *870*	— —	— —	— —	195 *640*	215 *710*	265 *870*
P11	235 *770*	260 *850*	310 *1025*	205 *670*	225 *740*	270 *890*	205 *670*	230 *750*	275 *900*	— —	— —	— —	205 *670*	225 *740*	270 *890*
P12	150 *490*	170 *560*	205 *670*	130 *425*	145 *475*	175 *570*	135 *445*	150 *490*	180 *590*	— —	— —	— —	135 *445*	145 *475*	180 *590*
K1	240 *790*	270 *890*	325 *1075*	210 *690*	235 *770*	280 *920*	215 *710*	240 *790*	285 *940*	305 *1000*	340 *1125*	405 *1325*	290 *950*	320 *1050*	385 *1275*
K2	215 *710*	240 *790*	285 *940*	185 *610*	210 *690*	250 *820*	190 *620*	210 *690*	255 *840*	270 *890*	300 *980*	360 *1175*	255 *840*	285 *940*	340 *1125*
K3	180 *590*	205 *670*	240 *790*	160 *520*	175 *570*	210 *690*	160 *520*	180 *590*	215 *710*	230 *750*	255 *840*	305 *1000*	215 *710*	240 *790*	285 *940*
K4	175 *570*	195 *640*	230 *750*	150 *490*	170 *560*	200 *660*	155 *510*	170 *560*	205 *670*	220 *720*	245 *800*	290 *950*	205 *670*	230 *750*	275 *900*
K5	105 *345*	120 *395*	145 *475*	95 *310*	105 *345*	125 *410*	95 *310*	105 *345*	130 *425*	135 *445*	150 *490*	180 *590*	125 *410*	140 *460*	170 *560*
K6	155 *510*	170 *560*	205 *670*	135 *445*	150 *490*	175 *570*	135 *445*	150 *490*	180 *590*	190 *620*	215 *710*	255 *840*	180 *590*	205 *670*	240 *790*
K7	135 *445*	150 *490*	185 *610*	120 *395*	130 *425*	160 *520*	120 *395*	135 *445*	165 *540*	170 *560*	190 *620*	230 *750*	160 *520*	180 *590*	220 *720*

R220.21 (SC12) HIGH FEED

High feed mills for high-torque machines, for SCET12 inserts, 4-cutting edge, single sided. These cutter bodies with fixed pockets are optimised for strong horizontal machines. SCET120630T is our 6.35-mm thick insert range with a corner radius of 3.0 mm.

- Cutter range 50-125 mm (2 - 5 inch)
- Max depth of cut 1,5 mm (.059 inch)
- Heavy roughing operations
- Large, powerful machines

R220.21-SC – Metric

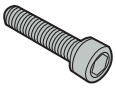


- For insert selection and cutting data recommendations, see page(s) 530-531
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	Cmin	Cmax	Weight	RPMX	Insert
			mm	mm		mm	mm	mm	mm	mm	mm		mm	mm	kg		
R220.21-0050-SC12.4A	02600275	Arbor	31,0	50,0	4	1,5	9,0	22,0	42,0	40,0	4,4	2,3	81,0	98,0	0,3	10700	SC..12
R220.21-0050-SC12.5A	03136672	Arbor	31,0	50,0	5	1,5	9,0	22,0	42,0	40,0	4,4	2,1	81,0	98,0	0,4	10700	SC..12
R220.21-0052-SC12.4A	02585965	Arbor	33,0	52,0	4	1,5	9,0	22,0	42,0	40,0	4,4	2,2	85,0	102,0	0,3	10500	SC..12
R220.21-0052-SC12.5A	03138188	Arbor	33,0	52,0	5	1,5	9,0	22,0	47,0	40,0	4,5	2,0	85,0	102,0	0,4	10500	SC..12
R220.21-0063-SC12.4A	02585966	Arbor	44,0	63,0	4	1,5	9,0	27,0	50,0	50,0	4,4	0,9	107,0	124,0	0,6	9600	SC..12
R220.21-0063-SC12.5A	02682416	Arbor	44,0	63,0	5	1,5	9,0	27,0	50,0	50,0	4,4	0,9	107,0	124,0	0,6	9600	SC..12
R220.21-0063-SC12.6A	03136673	Arbor	44,0	63,0	6	1,5	9,0	27,0	50,0	50,0	4,4	0,6	107,0	124,0	0,7	9600	SC..12
R220.21-0066-SC12.4A	02585968	Arbor	47,0	66,0	4	1,5	9,0	27,0	60,0	50,0	4,4	0,85	113,0	130,0	0,6	9400	SC..12
R220.21-0066-SC12.6A	03138192	Arbor	47,1	66,0	6	1,5	9,0	27,0	62,0	50,0	4,4	0,7	113,1	130,0	0,9	9400	SC..12
R220.21-0080-SC12.5A	02585971	Arbor	61,0	80,0	5	1,5	9,0	27,0	62,0	50,0	4,4	0,8	141,0	158,0	1,0	8500	SC..12
R220.21-0080-SC12.6A	02682419	Arbor	61,0	80,0	6	1,5	9,0	27,0	62,0	50,0	4,4	0,8	141,0	158,0	1,0	8500	SC..12
R220.21-0080-SC12.7A	03136674	Arbor	61,1	80,0	7	1,5	9,0	27,0	62,0	50,0	4,4	0,8	141,1	158,0	1,0	8500	SC..12
R220.21-0084-SC12.5A	02600279	Arbor	65,0	84,0	5	1,5	9,0	32,0	77,0	55,0	4,4	0,8	149,0	166,0	1,2	8300	SC..12
R220.21-0084-SC12.6A	03136675	Arbor	65,1	84,0	6	1,5	9,0	32,0	77,0	55,0	4,4	0,8	149,1	166,0	1,4	8300	SC..12
R220.21-0100-SC12.5A	02585973	Arbor	81,0	100,0	5	1,5	9,0	32,0	77,0	50,0	4,4	0,75	181,0	198,0	1,3	7600	SC..12
R220.21-0100-SC12.7A	02682422	Arbor	81,0	100,0	7	1,5	9,0	32,0	77,0	50,0	4,4	0,75	181,0	198,0	1,5	7600	SC..12
R220.21-0100-SC12.8A	03136676	Arbor	81,0	100,0	8	1,5	9,0	32,0	77,0	50,0	4,4	0,6	181,0	198,0	1,5	7600	SC..12
R220.21-0125-SC12.6A	02585974	Arbor	106,0	125,0	6	1,5	9,0	40,0	90,0	63,0	4,4	0,7	231,0	248,0	2,4	6800	SC..12
R220.21-8160-SC12.7	02585975	Arbor	141,0	160,0	7	1,5	9,0	40,0	90,0	63,0	4,4	0,7	–	–	3,8	6000	SC..12

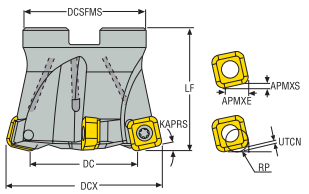
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.21-0050-0052	220.17-692M	C45011-T20P	T00-20P50	5.0NM
R220.21-0063-0066	MC6S12X35	C45011-T20P	T00-20P50	5.0NM
R220.21-0080	MC6S12X35	C45011-T20P	T00-20P50	5.0NM
R220.21-0084	MC6S16X40	C45011-T20P	T00-20P50	5.0NM
R220.21-0100	MLC6S16X35	C45011-T20P	T00-20P50	5.0NM
R220.21-0125-8160	–	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-SC – Inch



- For insert selection and cutting data recommendations, see page(s) 530-531
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	APMXE	DCB	DCSFMS	LF	RP	RMPX°	C min	C max	Weight	RPMX	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch	lbs		
R220.21-02.00-SC12-4A	02589073	Arbor	1.250	2.000	4	0.059	0.354	0.750	1.750	1.600	0.173	2,3	3.250	3.921	0.880	10700	SC..12
R220.21-02.00-SC12-5A	03136677	Arbor	1.248	2.000	5	0.059	0.354	0.750	1.750	1.600	0.173	2,1	3.248	3.921	1.100	10700	SC..12
R220.21-02.50-SC12-4A	02589074	Arbor	1.750	2.500	4	0.059	0.354	0.750	1.750	2.000	0.173	0,9	4.250	4.921	1.320	9600	SC..12
R220.21-02.50-SC12-5A	03136678	Arbor	1.752	2.500	5	0.059	0.354	0.750	1.750	2.000	0.173	0,6	4.252	4.921	1.100	9600	SC..12
R220.21-02.50-SC12-6A	03136679	Arbor	1.752	2.500	6	0.059	0.354	0.750	1.750	2.000	0.173	0,6	4.252	4.921	1.320	9600	SC..12
R220.21-03.00-SC12-5A	02589075	Arbor	2.250	3.000	5	0.059	0.354	1.000	2.250	2.000	0.173	0,8	5.250	5.921	1.980	8500	SC..12
R220.21-03.00-SC12-6A	03136680	Arbor	2.256	3.000	6	0.059	0.354	1.000	2.250	2.000	0.173	0,6	5.256	5.921	2.200	8500	SC..12
R220.21-04.00-SC12-5A	02589076	Arbor	3.250	4.000	5	0.059	0.354	1.500	3.500	2.000	0.173	0,75	7.250	7.921	3.530	7600	SC..12
R220.21-04.00-SC12-8A	03136681	Arbor	3.252	4.000	8	0.059	0.354	1.500	3.543	2.000	0.173	0,6	7.252	7.921	3.970	7600	SC..12

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.21-02.00	UC6S3/8UNFX1	C45011-T20P	T00-20P50	44.3IN.LBS
R220.21-02.00.5A	UC6S3/8UNFX1-1/4	C45011-T20P	T00-20P50	44.3IN.LBS
R220.21-02.50	UC6S3/8UNFX11/2	C45011-T20P	T00-20P50	44.3IN.LBS
R220.21-03.00	UC6S1/2UNFX1-1/4	C45011-T20P	T00-20P50	44.3IN.LBS
R220.21-03.00.6A	UC6S1/2UNFX1-1/2	C45011-T20P	T00-20P50	44.3IN.LBS
R220.21-04.00	58213810	C45011-T20P	T00-20P50	44.3IN.LBS
R220.21-04.00.8A	UC6S1/2UNFX1-1/2	C45011-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.21-SC12 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	SCET120630T-M14 MP2501	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,85 *0.034*
P2	SCET120630T-M14 MP2501	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
P3	SCET120630T-M14 MP2501	1,0 *0.040*	0,75 *0.030*	0,75 *0.030*	0,85 *0.034*
P4	SCET120630T-M14 MP2501	1,0 *0.040*	0,75 *0.030*	0,75 *0.030*	0,80 *0.032*
P5	SCET120630T-M14 MP2501	1,0 *0.040*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
P6	SCET120630T-MD16 MS2500	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
P7	SCET120630T-MD16 MS2500	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
P8	SCET120630T-MD16 MP2501	1,0 *0.040*	0,85 *0.034*	0,85 *0.034*	0,95 *0.038*
P11	SCET120630T-MD16 MS2500	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
P12	SCET120630T-MD16 MS2500	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
M1	SCET120630T-M14 F40M	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
M2	SCET120630T-M14 F40M	1,0 *0.040*	0,70 *0.028*	0,70 *0.028*	0,80 *0.032*
M3	SCET120630T-M14 F40M	0,80 *0.032*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
M4	SCET120630T-M14 F40M	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
M5	SCET120630T-M14 F40M	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
K1	SCET120630T-MD16 MP1501	1,0 *0.040*	0,90 *0.036*	0,90 *0.036*	1,0 *0.040*
K2	SCET120630T-MD16 MP1501	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
K3	SCET120630T-MD16 MP1501	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
K4	SCET120630T-MD16 MP1501	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
K5	SCET120630T-MD16 MP1501	1,0 *0.040*	0,75 *0.030*	0,75 *0.030*	0,80 *0.032*
K6	SCET120630T-MD16 MP1501	1,0 *0.040*	0,80 *0.032*	0,80 *0.032*	0,90 *0.036*
K7	SCET120630T-MD16 MP1501	1,0 *0.040*	0,75 *0.030*	0,75 *0.030*	0,80 *0.032*
S1	SCET120630T-M14 MS2500	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
S2	SCET120630T-M14 MS2500	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
S3	SCET120630T-M14 MS2500	0,60 *0.024*	0,50 *0.020*	0,50 *0.020*	0,55 *0.022*
S11	SCET120630T-M14 MS2500	0,70 *0.028*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
S12	SCET120630T-M14 MS2500	0,70 *0.028*	0,60 *0.024*	0,60 *0.024*	0,65 *0.026*
S13	SCET120630T-M14 MS2500	0,60 *0.024*	0,55 *0.022*	0,55 *0.022*	0,60 *0.024*
H5	SCET120630T-MD16 MP1501	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H8	SCET120630T-MD16 MP1501	0,70 *0.028*	0,44 *0.017*	0,44 *0.017*	0,48 *0.019*
H11	SCET120630T-MD16 T350M	0,80 *0.032*	0,55 *0.022*	0,55 *0.022*	0,65 *0.026*
H12	SCET120630T-MD16 T350M	0,70 *0.028*	0,44 *0.017*	0,44 *0.017*	0,48 *0.019*
H21	SCET120630T-MD16 MP1501	0,70 *0.028*	0,44 *0.017*	0,44 *0.017*	0,48 *0.019*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R220.21-SC12 – Cutting data v_c = (m/min)/(sf/min)

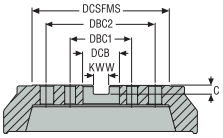
SMG	MP1501			MP2501			MP3000			T350M			F40M			MK2050			MS2500		
	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%	100%	70%	30%
P1	315	360	445	280	320	395	280	320	385	260	295	355	225	255	310	290	330	400	325	365	445
	1025	1175	1450	920	1050	1300	920	1050	1275	850	970	1175	740	840	1025	950	1075	1300	1075	1200	1450
P2	310	350	435	275	310	385	270	305	375	245	280	345	215	245	300	280	315	390	310	350	430
	1025	1150	1425	900	1025	1275	890	1000	1225	800	920	1125	710	800	980	920	1025	1275	1025	1150	1400
P3	270	305	375	240	270	330	235	265	330	215	245	300	190	215	260	245	280	340	270	310	375
	890	1000	1225	790	890	1075	770	870	1075	710	800	980	620	710	850	800	920	1125	890	1025	1225
P4	235	270	335	210	240	295	205	235	290	190	215	265	165	190	230	215	245	300	240	270	330
	770	890	1100	690	790	970	670	770	950	620	710	870	540	620	750	710	800	980	790	890	1075
P5	230	265	320	205	235	280	200	230	280	185	210	260	160	185	225	210	240	290	230	265	325
	750	870	1050	670	770	920	660	750	920	610	690	850	520	610	740	690	790	950	750	870	1075
P6	260	295	355	230	260	315	225	255	315	210	235	290	180	205	250	235	265	325	260	295	360
	850	970	1175	750	850	1025	740	840	1025	690	770	950	590	670	820	770	870	1075	850	970	1175
P7	245	280	335	215	245	300	215	245	295	195	225	275	170	195	235	220	250	310	245	280	340
	800	920	1100	710	800	980	710	800	970	640	740	900	560	640	770	720	820	1025	800	920	1125
P8	225	260	315	200	230	280	195	225	275	180	205	255	160	180	220	205	235	285	225	260	315
	740	850	1025	660	750	920	640	740	900	590	670	840	520	590	720	670	770	940	740	850	1025
P11	235	270	325	210	240	290	205	235	290	190	215	265	165	190	230	215	245	300	240	270	330
	770	890	1075	690	790	950	670	770	950	620	710	870	540	620	750	710	800	980	790	890	1075
P12	155	175	210	135	155	190	135	150	185	125	140	170	105	120	150	140	155	195	155	175	215
	510	570	690	445	510	620	445	490	610	410	460	560	345	395	490	460	510	640	510	570	710
M1	—	—	—	195	225	275	200	230	280	190	215	265	175	195	240	—	—	—	220	250	310
	—	—	—	640	740	900	660	750	920	620	710	870	570	640	790	—	—	—	720	820	1025
M2	—	—	—	165	185	225	170	190	235	160	180	220	145	165	200	—	—	—	185	210	260
	—	—	—	540	610	740	560	620	770	520	590	720	475	540	660	—	—	—	610	690	850
M3	—	—	—	135	150	180	135	150	185	125	145	175	115	130	160	—	—	—	145	165	205
	—	—	—	445	490	590	445	490	610	410	475	570	375	425	520	—	—	—	475	540	670
M4	—	—	—	100	115	140	100	115	140	95	110	135	90	100	120	—	—	—	115	125	155
	—	—	—	330	375	460	330	375	460	310	360	445	295	330	395	—	—	—	375	410	510
M5	—	—	—	85	95	115	85	95	115	80	90	110	75	85	100	—	—	—	95	105	130
	—	—	—	280	310	375	280	310	375	260	295	360	245	280	330	—	—	—	310	345	425
K1	245	280	345	215	245	305	210	240	295	195	220	275	170	195	235	300	340	420	—	—	—
	800	920	1125	710	800	1000	690	790	970	640	720	900	560	640	770	980	1125	1375	—	—	—
K2	220	250	300	195	220	265	190	215	265	175	200	245	155	175	215	270	310	375	—	—	—
	720	820	980	640	720	870	620	710	870	570	660	800	510	570	710	890	1025	1225	—	—	—
K3	185	210	255	165	185	225	160	185	225	150	170	205	130	145	180	230	260	320	—	—	—
	610	690	840	540	610	740	520	610	740	490	560	670	425	475	590	750	850	1050	—	—	—
K4	175	200	245	155	180	215	155	175	215	140	160	200	125	140	170	220	250	305	—	—	—
	570	660	800	510	590	710	510	570	710	460	520	660	410	460	560	720	820	1000	—	—	—
K5	105	120	150	95	110	135	95	105	130	85	100	120	75	85	105	135	150	185	—	—	—
	345	395	490	310	360	445	310	345	425	280	330	395	245	280	345	445	490	610	—	—	—
K6	155	175	215	140	155	190	135	155	190	125	140	175	110	125	150	190	220	270	—	—	—
	510	570	710	460	510	620	445	510	620	410	460	570	360	410	490	620	720	890	—	—	—
K7	135	155	190	120	140	170	120	135	165	110	125	155	95	110	135	170	195	235	—	—	—
	445	510	620	395	460	560	395	445	540	360	410	510	310	360	445	560	640	770	—	—	—
N1	—	—	—	—	—	—	1575	1775	2150	—	—	—	1250	1425	1725	—	—	—	—	—	—
	—	—	—	—	—	—	5175	5825	7050	—	—	—	4100	4675	5650	—	—	—	—	—	—
N2	—	—	—	—	—	—	630	720	870	—	—	—	510	580	700	—	—	—	—	—	—
	—	—	—	—	—	—	2075	2350	2850	—	—	—	1675	1900	2300	—	—	—	—	—	—
N3	—	—	—	—	—	—	420	480	580	—	—	—	340	385	465	—	—	—	—	—	—
	—	—	—	—	—	—	1375	1575	1900	—	—	—	1125	1275	1525	—	—	—	—	—	—
N11	—	—	—	—	—	—	485	550	660	—	—	—	385	440	530	—	—	—	—	—	—
	—	—	—	—	—	—	1600	1800	2175	—	—	—	1275	1450	1750	—	—	—	—	—	—
S1	—	—	—	—	—	—	48	55	65	45	50	60	41	46	55	—	—	—	55	60	75
	—	—	—	—	—	—	155	180	215	150	165	195	135	150	180	—	—	—	180	195	245
S2	—	—	—	—	—	—	38	43	55	36	41	50	33	37	45	—	—	—	44	50	60
	—	—	—	—	—	—	125	140	180	120	135	165	110	120	150	—	—	—	145	165	195
S3	—	—	—	—	—	—	34	38	46	32	36	44	29	33	40	—	—	—	39	44	55
	—	—	—	—	—	—	110	125	150	105	120	145	95	110	130	—	—	—	130	145	180
S11	—	—	—	—	—	—	65	75	95	65	70	90	60	65	80	—	—	—	80	90	110
	—	—	—	—	—	—	215	245	310	215	230	295	195	215	260	—	—	—	260	295	360
S12	—	—	—	—	—	—	47	55	65	44	50	60	40	45	55	—	—	—	55	60	75
	—	—	—	—	—	—	155	180	215	145	165	195	130	150	180	—	—	—	180	195	245
S13	—	—	—	—	—	—	27	30	37	25	29	35	23	26	32	—	—	—	31	35	43
	—	—	—	—	—	—	90	100	120	80	95	115	75	85	105	—	—	—	100	115	140
H5	50	60	70	—	—	—	41	47	60	41	46	55	35	40	49	—	—	—	—	—	—
	165	195	230	—	—	—	135	155	195	135	150	180	115	130	160	—	—	—	—	—	—
H8	55	60	75	—	—	—	44	50	60	44	49	60	38	43	50	—	—	—	—	—	—
	180	195	245	—	—	—	145	165	195	145	160	195	125	140	165	—	—	—	—	—	—
H11	65	75	90	—	—	—	55	60	75	50	60	70	45	50	65	—	—	—	—	—	—
	215	245	295	—	—	—	180	195	245	165	195	230	150	165	215	—	—	—	—	—	—
H12	100	110	135	—	—	—	85	95	115	80	90	105	70	75	90	—	—	—	—	—	—
	330	360	445	—	—	—	280	310	375	260	295	345	230	245	295	—	—	—	—	—	—
H21	55	60	75	—	—	—	44	50	60	44	49	60	38	43	50	—	—	—	—	—	—
	180	195	245	—	—	—	145	165	195	145	160	195	125	140	165	—	—	—	—	—	—

Code keys metric and *inch*

R	217	.	29	-	16	16	.	0	-	04	.	2	.	140	A
1	2		3		4	5		6		7		8		9	10

R	217	.	29I	-	01.00	-	0	-	06	.	2	A
1	2		3		4		6		7		8	9

1.	2.	3.
R = Right hand rotation Cx = For Seco-Capto	217 = With shank 220 = For arbor	Cutter system
4.	**5. (Not for inch designation)**	**6.**
Shank diameter (connecting thread diameter for Combimaster)	Outer cutting diameter/ball nose type = cutting diameter	Shank type RE = Combimaster 0. = Cylindrical 3. = Weldon
7.	**8.**	**9.**
Max. axial cutting depth	No. of teeth	Setting length (for the shank for combimaster)
10.		
A = Through coolant supply E = Solid carbide shank		



Dimensions in mm					
DCB	DCSFMS	DBC1	DBC2	KWW	C
16	30-35	–	–	8,4	5,6
22	42-47	–	–	10,4	6.3
27	48-62	–	–	12,4	7
32	60-90	–	–	14,4	8
40	90-130	66,7	–	16,4	9
60	130-270	101,6	177,8	25,7	14

Dimensions in inch					
DCB	DCSFMS	DBC1	DBC2	KWW	C
0.500	*1.181 - 1.378*			*0.258*	*0.165*
0.750	*1.378 - 1.850*	–	–	*0.321*	*0.193*
1.000	*1.803 - 2.441*	–	–	*0.382*	*0.224*
1.250	*2.250 - 3.031*	–	–	*0.508*	*0.287*
1.500	*2.750 - 3.543*	–	–	*0.630*	*0.382*
2.000	*4.331*	–	–	*0.756*	*0.445*
2.500	*5.118 - 6.299 (8.858)*	*4.000*	*(7.000)*	*1.000*	*0.551*

Selection – Metric

Cutter	Insert	Material suitability						Corner radius (mm)				No. of cutting edges	Diameters (mm) available and max depth of cut (mm)								See page
		P	M	K	N	S	H						12	16	20	25	30	32	40	50	
R218.20	218.20-060	■	■	■	◪	■	-	6,0	■	□	◪	2	10								601
	218.20-080	■	■	■	◪	■	◪	8,0	■	◪	◪	2		14							
	218.20-100	■	■	■	◪	■	◪	10,0	■	■	◪	2			18						
	218.20-125	■	■	■	◪	■	◪	12,5	■	■	◪	2				22					
	218.20-150	■	■	■	◪	■	◪	15,0	◪	■	◪	2					27				
	218.20-160	■	■	■	◪	■	◪	16,0	◪	■	◪	2						28			
	218.20-200	■	■	■	◪	■	-	20,0	□	■	◪	2							35		
	218.20-250	■	■	■	◪	■	-	25,0	□	■	◪	2								44	
R218.20 long cutting edge	218.20-150 / SPMT10	■	■	■	◪	■	◪	15,0	◪	■	◪	2/4					44				
	218.20-160 / SPMT10	■	■	■	◪	■	◪	16,0	◪	■	◪	2/4						54			
	218.20-200 / SC..12	■	■	■	◪	■	-	20,0	□	■	◪	2/4							60		
	218.20-250 / SC..12	■	■	■	◪	■	-	25,0	□	■	◪	2/4								70	

1st choice	■	High speed machine with low power/torque		x indicates the maximum depth of cut	x
Alternative choice	◪	Strong stable machine with rigid connecion			
Possible choice	□	Unstable condition suitability			
Not recommended	-				

Selection – Metric

Cutter	Insert	Material suitability						Corner radius (mm)				No. of cutting edges	Diameters (mm) available and max depth of cut (mm)							See page
		P	M	K	N	S	H						16	20	25	30	32	40	50	
R218.19	218.19-080/SPMX06	■	◩	■	◩	■	◩	8.0	■	◩	■	3/4	12 17							640
	218.19-100/SPMX07	■	◩	■	◩	■	◩	10.0	■	■	■	3/4		16 21						
	218.19-125/SPMX09	■	◩	■	◩	■	◩	16.0	■	■	■	3/4			26					
	218.19-160/SPMT10	■	◩	■	◩	■	◩	16.0	◩	■	■	3/4					31 38			
R218.19 HFA	218.19-125	■	■	■	◩	■	◩	12.5	■	■	■	3			12					642
	218.19-160	■	■	■	◩	■	◩	16.0	◩	■	■	3					16			
	218.19-200	■	■	■	◩	■	□	20.0	□	■	■	3						20		

1st choice	■	High speed machine with low power/torque	x indicates the maximum depth of cut	x
Alternative choice	◩	Strong stable machine with rigid connecion		
Possible choice	□	Unstable condition suitability		
Not recommended	-			

Selection – Inch

Cutter	Insert	Material suitability						Corner radius (inch)				No. of cutting edges	Diameters (mm) available and max depth of cut (mm)							See page
		P	M	K	N	S	H						0,50	0,63	0,75	1,00	1,25	1,50	2,00	
R218.20	218.20-0.250	■	■	■	◪	■	-	0,250	■	□	◪	2	0,433							601
	218.20-080	■	■	■	◪	■	◪	0,315	■	◪	◪	2			0,669					
	218.20-0.375	■	■	■	◪	■	◪	0,375	■	■	◪	2					1,102			
	218.20-125	■	■	■	◪	■	◪	0,492	■	■	◪	2							1,732	
	218.20-160	■	■	■	◪	■	◪	0,630	◪	■	◪	2					2,126			
	218.20-0.750	■	■	■	◪	■	◪	0,750	◪	■	◪	2							2,756	
	218.20-250	■	■	■	◪	■	-		□	■	◪	2		0,551						
R218.20 long cutting edge	218.20-125 / SPMT10	■	■	■	◪	■	◪	0,630	◪	■	◪	2/4				0,866				
	218.20-160 / SPMT10	■	■	■	◪	■	◪		◪	■	◪	2/4						1,339		
	218.20-0.750 / SC..12	■	■	■	◪	■	-	0,750	□	■	◪	2/4				1,772				
	218.20-250 / SC..12	■	■	■	◪	■	-	0,984	□	■	◪	2/4						2,362		

1st choice	■	High speed machine with low power/torque	x indicates the maximum depth of cut	x
Alternative choice	◪	Strong stable machine with rigid connecion		
Possible choice	□	Unstable condition suitability		
Not recommended	-			

Selection – Inch

Cutter	Insert	Material suitability						Corner radius (inch)				No. of cutting edges	Diameters (mm) available and max depth of cut (mm)							See page
		P	M	K	N	S	H						0,50	0,63	0,75	1,00	1,25	1,50	2,00	
R218.19	218.19-100/SPMX07	■	◩	■	◩	■	◩	0.394	■	■	■	3/4			0,835					640
	218.19-125/SPMX09	■	◩	■	◩	■	◩	0.492	■	■	■	3/4				1,063				
R218.19 HFA	218.19-125	■	■	■	◩	■	◩		■	■	■	3								642
	218.19-160	■	■	■	◩	■	◩		◩	■	■	3								
	218.19-200	■	■	■	◩	■	□		□	■	■	3								

1st choice	■	High speed machine with low power/torque		x indicates the maximum depth of cut	x
Alternative choice	◩	Strong stable machine with rigid connecion			
Possible choice	□	Unstable condition suitability			
Not recommended	-				

Selection – Metric

Insert	a_p max	a_p rec.	Material suitability									
			P	M	K	N	S	H				
Round 5	2,5	1	■	◪	■	□	■	■	■	◪	■	□
Round 6	3	1	■	■	■	■	◪	■	■	◪	■	□
Round 7	3,5	1,5	■	◪	■	■	◪	■	■	◪	■	□
Round 8	4	1,5	■	■	■	■	■	■	■	◪	■	◪
Round 10	5	2	■	■	■	■	■	■	■	■	■	◪
Round 12	6	3	■	■	■	■	■	■	□	■	■	◪
Round 16	8	5	■	■	■	-	■	◪	-	■	■	◪
Round 20	10	6	■	■	■	-	■	□	-	■	■	◪
Round 12 R217/220.28	6	3	■	■	■	□	■	◪	□	■	□	◪

1st choice	■
Alternative choice	□
Possible choice	◪

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

a_p max = Maximum depth of cut possible
a_p rec. = Recommended depth of cut for optimal result

Selection – Metric

Insert	Applica-tion	Cutter diameter available (mm)/number of teeth																										See page
		10	12	15	16	20	25	27	32	35	40	42	44	50	52	63	66	80	83	84	92	100	112	125	137	160	200	250	
Round 5		2	3	4		5																							544
Round 6			2		3	4	5		6	7	8																		548
Round 7					3	4	5																						553
Round 8						2	3							5															556
					2	3	4		5		6			7															
Round 10											4			4		6													561
							2		4		5	5																	
					1	2	3	3	5	5	6	6		6	7	8													
Round 12										3	3		4	4	4	5		6		6			7		8				568
														5	5	6	6	7			7								
							2		3	4	4	5		6		7		8				9		11					
Round 16																4	5	5		5		6		6		7			578, 579
									2		3			4	4	5/6	6	7				8		10		10			
Round 20																		4	4			5		5		6			587
							1				2			3		4		5				6		7			8	9	
Round 12 R217/220.28														5	5	6	7	8				10							594
									3		4			6		8						12							

x	x indicates number of teeth (first choice)
x	x indicates number of teeth

Coarse pitch-troubleshooter for unstable conditions and long overhang

Normal pitch-alternative choice

Close pitch-basic choice for productivity

Selection – Inch

Insert	a_p max	a_p rec.	Material suitability									
			P	M	K	N	S	H				
Round 5	0.059	0.039	■	◪	■	□	■	■	■	◪	■	□
Round 6	0.118	0.04	■	■	■	■	◪	■	■	◪	■	□
Round 7	0.138	0.059	■	◪	■	■	◪	■	■	◪	■	□
Round 8	0.158	0.059	■	■	■	■	■	■	■	◪	■	◪
Round 10	0.197	0.079	■	■	■	■	■	■	■	■	■	◪
Round 12	0.236	0.118	■	■	■	■	■	■	□	■	■	◪
Round 16	0.315	0.197	■	■	■	-	■	◪	-	■	■	◪
Round 19	0.374	0.160	■	■	■	-	■	□	-	■	■	◪
Round 20	0.394	0.236	■	■	■	-	■	□	-	■	■	◪
Round 12 R217/220.28			■	■	■	□	■	◪	□	■	□	◪

1st choice	■
Alternative choice	□
Possible choice	◪

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

a_p max = Maximum depth of cut possible
a_p rec. = Recommended depth of cut for optimal result

Selection – Inch

Insert	Application	Cutter diameter available (inch)/number of teeth										See page
		0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	
Round 5												544
Round 6		4	5	6								548
Round 7												553
Round 8												556
Round 10			3	4	5	6						561
Round 12			2	3	4	(4/5)	(6/7)	(6/7)	(7/9)		8	568
Round 16						4	5	6	7			578, 579
Round 19							4	6	5	7		587
									5	9		587
Round 20						3	4	4	5			587
Round 12												594
R217/220.28				3	4	(5/6)	7	8	(10/12)			

x	x indicates number of teeth (first choice)
x	x indicates number of teeth

Coarse pitch-troubleshooter for unstable conditions and long overhang

Normal pitch-alternative choice

Close pitch-basic choice for productivity

Selection – Metric

Cutter	Insert	Material suitability						Corner radius (mm)				No. of cutting edges	Diameters (mm) available and max depth of cut (mm)									See page
		P	M	K	N	S	H						16	20	25	32	40	50	63	80	100	
R217/220.97	R217/220.97-XP08				■				■	■	■		2	2/3	3/4							670
	R217/220.97-XP12				■				■	■	■				2	2/3	3	4				674
	R217/220.97-VP22				■					■	■					2	2	2/3	3/4	4	5	678

1st choice	■	High speed machine with low power/torque		x indicates the maximum depth of cut	x
Alternative choice	◪	Strong stable machine with rigid connecion			
Possible choice	□	Unstable condition suitability			
Not recommended	-				

Selection – Inch

Cutter	Insert	Material suitability						Corner radius (inch)				No. of cutting edges	Diameters (mm) available and max depth of cut (mm)									See page
		P	M	K	N	S	H						0,63	0,08	1,00	1,25	1,50	2,00	2,50	3,00	4,00	
R217/220.97	R217/220.97-XP08				■				■	■	■		2	2	3							670
	R217/220.97-XP12				■				■	■	■					2	2	(2/3)	4	4	5	674
	R217/220.97-VP22				■					■	■				2	3	3	(3/4)				678

1st choice	■	High speed machine with low power/torque		x indicates the maximum depth of cut	x
Alternative choice	◪	Strong stable machine with rigid connecion			
Possible choice	□	Unstable condition suitability			
Not recommended	-				

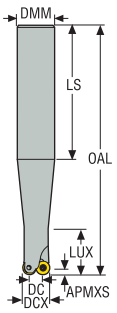
R217/220.29 ROUND INSERT CUTTERS

Our comprehensive range of round insert cutters, R217/220.29, is ideal for semi-finishing and roughing in all copy milling applications and materials.

- Insert size 05, cutter range 10-20mm
- Insert size 06, cutter range 12-40mm
- Insert size 07, cutter range 16-25mm
- Insert size 08, cutter range 16-50mm
- Insert size 10, cutter range 20-63mm (1 - 2.0 inch)
- Insert size 12, cutter range 25-137mm (1 - 6 inch)
- Insert size 16, cutter range 32-160mm (2.0 - 4.0 inch)
- Insert size 20, cutter range 40-250mm (1.575 - 9.843 inch)

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217.29-025 – Metric



- For insert selection and cutting data recommendations, see page(s) 546-547
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.29-1010.0-025.2.090E	02495669	Cylindrical	5,0	10,0	2	2,5	10,0	100,0	130,0	30,0	90,0	15,0	18,0	75000	0,2	RDH.0501

Spare Parts

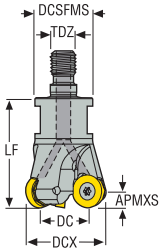
For cutter	Insert screw
R217.29-..	C02035-T06P

Accessories

Torque key	Torque value
T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.29-025 – Metric



- For insert selection and cutting data recommendations, see page(s) 546-547
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm		mm	mm		mm	mm		kg	
R217.29-0610.RE-025.2A	02642918	Combimaster	5,0	10,0	2	2,5	M6	11,0	18,0	90,0	15,0	18,0	75000	0,1	RDH.0501
R217.29-0612.RE-025.3A	02642920	Combimaster	7,0	12,0	3	2,5	M6	11,0	18,0	13,9	19,0	22,0	65000	0,1	RDH.0501
R217.29-0812.RE-025.3A	02495672	Combimaster	7,0	12,0	3	2,5	M8	13,5	20,0	13,9	19,0	22,0	65000	0,1	RDH.0501
R217.29-0815.RE-025.4A	02495675	Combimaster	10,0	15,0	4	2,5	M8	13,5	20,0	8,4	25,0	28,0	60000	0,1	RDH.0501
R217.29-1020.RE-025.5A	02643352	Combimaster	15,0	20,0	5	2,5	M10	18,0	23,0	5,0	35,0	38,0	50000	0,1	RDH.0501

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.29-..	C02035-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.29-025 – Insert selection – mm/*Inch*

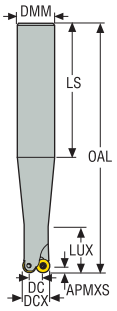
SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RDHW0501M0-MD01 F40M	1,0 *0.040*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,14 *0.0055*
P2	RDHW0501M0-MD01 F40M	1,0 *0.040*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,14 *0.0055*
P3	RDHW0501M0-MD01 F40M	1,0 *0.040*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,13 *0.0050*
P4	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,13 *0.0050*
P5	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
P6	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,12 *0.0048*
P7	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,12 *0.0048*
P8	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,13 *0.0050*
P11	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,12 *0.0048*
P12	RDHW0501M0-MD01 MP3000	0,80 *0.032*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
M1	RDHW0501M0-MD01 F40M	1,0 *0.040*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,14 *0.0055*
M2	RDHW0501M0-MD01 F40M	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
M3	RDHW0501M0-MD01 F40M	0,80 *0.032*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,10 *0.0040*
M4	RDHW0501M0-MD01 F40M	0,60 *0.024*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
M5	RDHW0501M0-MD01 F40M	0,60 *0.024*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
K1	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,14 *0.0055*
K2	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K3	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K4	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K5	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,11 *0.0044*
K6	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K7	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,11 *0.0044*
N1	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
N2	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
N3	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
N11	RDHW0501M0-MD01 MP3000	1,0 *0.040*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
S1	RDHW0501M0-MD01 F40M	0,60 *0.024*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
S2	RDHW0501M0-MD01 F40M	0,60 *0.024*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
S3	RDHW0501M0-MD01 F40M	0,60 *0.024*	0,075 *0.0030*	0,075 *0.0030*	0,070 *0.0028*	0,080 *0.0032*
S11	RDHW0501M0-MD01 F40M	0,70 *0.028*	0,085 *0.0034*	0,085 *0.0034*	0,080 *0.0032*	0,10 *0.0040*
S12	RDHW0501M0-MD01 F40M	0,70 *0.028*	0,085 *0.0034*	0,085 *0.0034*	0,080 *0.0032*	0,10 *0.0040*
S13	RDHW0501M0-MD01 F40M	0,60 *0.024*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
H5	RDHW0501M0-MD01 MP3000	0,80 *0.032*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
H8	RDHW0501M0-MD01 MP3000	0,70 *0.028*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
H11	RDHW0501M0-MD01 MP3000	0,80 *0.032*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,085 *0.0034*
H12	RDHW0501M0-MD01 F40M	0,70 *0.028*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*
H21	RDHW0501M0-MD01 MP3000	0,70 *0.028*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,065 *0.0026*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.29-025 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M			
	100%	70%	30%	10%	100%	70%	30%	10%
P1	360 *1175*	415 *1350*	485 *1600*	570 *1875*	285 *940*	330 *1075*	390 *1275*	455 *1500*
P2	350 *1150*	400 *1300*	475 *1550*	550 *1800*	280 *920*	320 *1050*	380 *1250*	440 *1450*
P3	300 *980*	350 *1150*	410 *1350*	480 *1575*	240 *790*	280 *920*	330 *1075*	385 *1275*
P4	265 *870*	305 *1000*	360 *1175*	420 *1375*	215 *710*	245 *800*	290 *950*	340 *1125*
P5	255 *840*	295 *970*	350 *1150*	405 *1325*	205 *670*	235 *770*	280 *920*	325 *1075*
P6	290 *950*	335 *1100*	390 *1275*	460 *1500*	230 *750*	265 *870*	315 *1025*	365 *1200*
P7	270 *890*	315 *1025*	370 *1225*	435 *1425*	220 *720*	250 *820*	295 *970*	345 *1125*
P8	255 *840*	295 *970*	345 *1125*	405 *1325*	205 *670*	235 *770*	275 *900*	325 *1075*
P11	265 *870*	305 *1000*	360 *1175*	420 *1375*	210 *690*	245 *800*	285 *940*	335 *1100*
P12	165 *540*	190 *620*	225 *740*	260 *850*	135 *445*	155 *510*	180 *590*	210 *690*
M1	260 *850*	300 *980*	355 *1175*	410 *1350*	225 *740*	260 *850*	305 *1000*	355 *1175*
M2	215 *710*	250 *820*	290 *950*	335 *1100*	185 *610*	215 *710*	250 *820*	290 *950*
M3	170 *560*	195 *640*	230 *750*	265 *870*	145 *475*	165 *540*	195 *640*	230 *750*
M4	130 *425*	150 *490*	175 *570*	205 *670*	110 *360*	125 *410*	150 *490*	175 *570*
M5	105 *345*	125 *410*	145 *475*	170 *560*	95 *310*	105 *345*	125 *410*	145 *475*
K1	275 *900*	320 *1050*	375 *1225*	435 *1425*	220 *720*	255 *840*	300 *980*	350 *1150*
K2	245 *800*	280 *920*	330 *1075*	385 *1275*	195 *640*	225 *740*	265 *870*	305 *1000*
K3	205 *670*	240 *790*	280 *920*	325 *1075*	165 *540*	190 *620*	225 *740*	260 *850*
K4	195 *640*	225 *740*	265 *870*	310 *1025*	160 *520*	180 *590*	215 *710*	245 *800*
K5	120 *395*	135 *445*	160 *520*	190 *620*	95 *310*	110 *360*	130 *425*	150 *490*
K6	175 *570*	200 *660*	235 *770*	270 *890*	140 *460*	160 *520*	190 *620*	220 *720*
K7	150 *490*	175 *570*	205 *670*	240 *790*	120 *395*	140 *460*	165 *540*	195 *640*
N1	2075 *6800*	2400 *7875*	2850 *9350*	3300 *10825*	1675 *5500*	1925 *6325*	2275 *7475*	2650 *8700*
N2	840 *2750*	970 *3175*	1150 *3775*	1325 *4350*	670 *2200*	780 *2550*	920 *3025*	1075 *3525*
N3	560 *1825*	650 *2125*	760 *2500*	890 *2925*	450 *1475*	520 *1700*	610 *2000*	710 *2325*
N11	640 *2100*	740 *2425*	870 *2850*	1025 *3375*	510 *1675*	590 *1925*	700 *2300*	810 *2650*
S1	60 *195*	70 *230*	80 *260*	95 *310*	50 *165*	60 *195*	70 *230*	80 *260*
S2	48 *155*	55 *180*	65 *215*	75 *245*	42 *140*	48 *155*	55 *180*	65 *215*
S3	42 *140*	48 *155*	55 *180*	65 *215*	36 *120*	42 *140*	49 *160*	60 *195*
S11	85 *280*	100 *330*	115 *375*	135 *445*	75 *245*	85 *280*	100 *330*	115 *375*
S12	60 *195*	70 *230*	80 *260*	95 *310*	50 *165*	60 *195*	70 *230*	80 *260*
S13	34 *110*	39 *130*	46 *150*	55 *180*	29 *95*	33 *110*	40 *130*	46 *150*
H5	50 *165*	60 *195*	70 *230*	80 *260*	44 *145*	50 *165*	60 *195*	70 *230*
H8	55 *180*	60 *195*	70 *230*	85 *280*	46 *150*	50 *165*	60 *195*	70 *230*
H11	65 *215*	75 *245*	90 *295*	105 *345*	55 *180*	65 *215*	75 *245*	90 *295*
H12	100 *330*	115 *375*	135 *445*	160 *520*	80 *260*	95 *310*	110 *360*	130 *425*
H21	55 *180*	60 *195*	70 *230*	85 *280*	46 *150*	50 *165*	60 *195*	70 *230*

R217.29-03 – Metric



- For insert selection and cutting data recommendations, see page(s) 551-552
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.29-1612.0-03.2.050	02427364	Cylindrical	6,0	12,0	2	3,0	16,0	60,0	110,0	20,0	90,0	18,0	22,0	32000	0,2	RD..06T1
R217.29-1212.0-03.2.070E	02427368	Cylindrical	6,0	12,0	2	3,0	12,0	80,0	130,0	50,0	90,0	18,0	22,0	32000	0,2	RD..06T1
R217.29-2016.0-03.3.070	02427371	Cylindrical	10,0	16,0	3	3,0	20,0	60,0	130,0	30,0	15,62	26,0	30,0	28800	0,3	RD..06T1
R217.29-1616.0-03.3.100E	02427379	Cylindrical	10,0	16,0	3	3,0	16,0	140,0	160,0	50,0	15,62	26,0	30,0	28800	0,5	RD..06T1
R217.29-1620.0-03.4.100E	02427381	Cylindrical	14,0	20,0	4	3,0	16,0	140,0	160,0	100,0	9,84	34,0	38,0	25600	0,5	RD..06T1

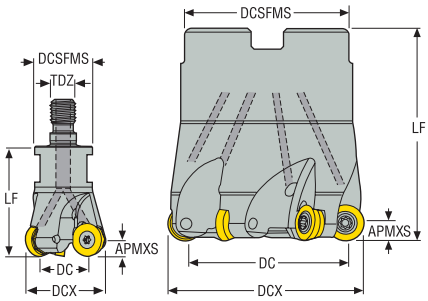
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.29- ø12-16	C02204-T07P	T00-07P09	0.9NM
R217.29- ø20-32	C02245-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-03 – Metric



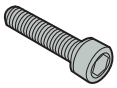
- For insert selection and cutting data recommendations, see page(s) 551-552
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm		mm	mm		mm	mm		kg	
R217.29-0816.RE-03.3	02435540	Combimaster	10,0	16,0	3	3,0	M8	13,5	23,0	15,62	26,0	30,0	28800	0,1	RD..06T1
R217.29-1020.RE-03.4A	02427383	Combimaster	14,0	20,0	4	3,0	M10	18,5	28,0	9,84	34,0	38,0	25600	0,1	RD..06T1
R217.29-1225.RE-03.5A	02427386	Combimaster	19,0	25,0	5	3,0	M12	23,0	28,0	6,76	44,0	48,0	23200	0,1	RD..06T1
R217.29-1632.RE-03.6A	02427388	Combimaster	26,0	32,0	6	3,0	M16	30,0	28,0	4,7	58,0	62,0	20000	0,2	RD..06T1
R217.29-1635.RE-03.7A	02427389	Combimaster	29,0	35,0	7	3,0	M16	30,0	28,0	4,16	64,0	68,0	19200	0,2	RD..06T1
R220.29-0040-03.8A	02427391	Arbor	34,0	40,0	8	3,0	–	35,0	35,0	3,49	74,0	78,0	17600	0,2	RD..06T1

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

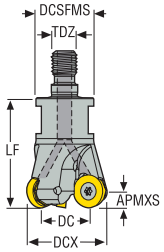
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.29- ø16	–	C02204-T07P	T00-07P09	0.9NM
R217.29- ø20-32	–	C02245-T07P	T00-07P09	0.9NM
R220.29-0040	220.17-689	C02245-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217/220.29-03 – Inch



- For insert selection and cutting data recommendations, see page(s) 551-552
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch		Inch	Inch		Inch	Inch		lbs	
R217.29-0.75-10RE-03.4A	00096942	Combimaster	0.514	0.750	4	0.118	M10	0.728	1.100	9,84	1.264	1.421	25600	0.220	RD..06T1
R217.29-1.00-12RE-03.5A	00096943	Combimaster	0.764	1.000	5	0.118	M12	0.906	1.100	6,76	1.764	1.921	23200	0.220	RD..06T1
R217.29-1.25-16RE-03.6A	00096944	Combimaster	1.014	1.250	6	0.118	M16	1.181	1.100	4,7	2.264	2.421	20000	0.440	RD..06T1

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts / Accessories

For cutter	Insert screw	Torque key	Torque value
R217.29-00.750	C02204-T07P	T00-07P09	8.0IN.LBS
R217.29-01.00-01.25	C02245-T07P	T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-03 – Insert selection – mm/*Inch*

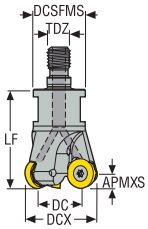
SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RDHT06T1M0-E02 F40M	1,2 *0.048*	0,065 *0.0026*	0,065 *0.0026*	0,060 *0.0024*	0,095 *0.0038*
P2	RDHT06T1M0-E02 F40M	1,2 *0.048*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,095 *0.0038*
P3	RDHT06T1M0-E02 F40M	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*	0,090 *0.0036*
P4	RDHW06T1M0-MD02 MP3000	1,2 *0.048*	0,090 *0.0036*	0,090 *0.0036*	0,085 *0.0034*	0,13 *0.0050*
P5	RDHW06T1M0-MD02 MP3000	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
P6	RDHW06T1M0-MD02 MP3000	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
P7	RDHW06T1M0-MD02 MP3000	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
P8	RDHW06T1M0-MD02 MP3000	1,2 *0.048*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,14 *0.0055*
P11	RDHW06T1M0-MD02 MP3000	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
P12	RDHW06T1M0-MD02 MP3000	0,95 *0.038*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
M1	RDHT06T1M0-E02 F40M	1,2 *0.048*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,095 *0.0038*
M2	RDHT06T1M0-E02 F40M	1,2 *0.048*	0,060 *0.0024*	0,060 *0.0024*	0,055 *0.0022*	0,085 *0.0034*
M3	RDHT06T1M0-E02 F40M	0,95 *0.038*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*	0,070 *0.0028*
M4	RDHW06T1M0-MD02 MP3000	0,70 *0.028*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
M5	RDHW06T1M0-MD02 MP3000	0,70 *0.028*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
K1	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,14 *0.0055*
K2	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K3	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K4	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K5	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,12 *0.0048*
K6	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,13 *0.0050*
K7	RDHW06T1M0-MD02 MK2050	1,2 *0.048*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,12 *0.0048*
N1	RDHT06T1M0-E02 H25	1,2 *0.048*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*
N2	RDHT06T1M0-E02 H25	1,2 *0.048*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*
N3	RDHT06T1M0-E02 H25	1,2 *0.048*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*
N11	RDHT06T1M0-E02 H25	1,2 *0.048*	0,080 *0.0032*	0,080 *0.0032*	0,080 *0.0032*	0,12 *0.0048*
S1	RDHW06T1M0-MD02 F40M	0,70 *0.028*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
S2	RDHW06T1M0-MD02 F40M	0,70 *0.028*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
S3	RDHW06T1M0-MD02 MP3000	0,70 *0.028*	0,075 *0.0030*	0,075 *0.0030*	0,070 *0.0028*	0,085 *0.0034*
S11	RDHW06T1M0-MD02 F40M	0,85 *0.034*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,10 *0.0040*
S12	RDHW06T1M0-MD02 F40M	0,85 *0.034*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*	0,10 *0.0040*
S13	RDHW06T1M0-MD02 F40M	0,70 *0.028*	0,080 *0.0032*	0,080 *0.0032*	0,075 *0.0030*	0,090 *0.0036*
H5	RDHW06T1M0-MD02 F15M	0,95 *0.038*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
H8	RDHW06T1M0-MD02 F15M	0,85 *0.034*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
H11	RDHW06T1M0-MD02 F15M	0,95 *0.038*	0,065 *0.0026*	0,065 *0.0026*	0,065 *0.0026*	0,090 *0.0036*
H12	RDHW06T1M0-MD02 F40M	0,85 *0.034*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*
H21	RDHW06T1M0-MD02 F15M	0,85 *0.034*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*	0,070 *0.0028*

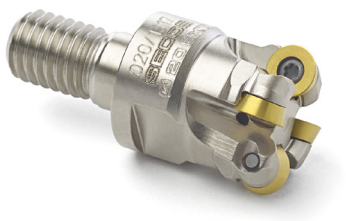
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.29-03 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F15M				F30M				F40M				MK2050				H25			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	345	395	465	550	—	—	—	—	290	330	390	460	275	315	375	440	360	410	485	570	—	—	—	—
	1125	*1300*	*1525*	*1800*	—	—	—	—	*950*	*1075*	*1275*	*1500*	*900*	*1025*	*1225*	*1450*	*1175*	*1350*	*1600*	*1875*	—	—	—	—
P2	335	385	455	530	—	—	—	—	285	320	380	450	270	305	365	430	350	400	470	560	—	—	—	—
	1100	*1275*	*1500*	*1750*	—	—	—	—	*940*	*1050*	*1250*	*1475*	*890*	*1000*	*1200*	*1400*	*1150*	*1300*	*1550*	*1825*	—	—	—	—
P3	295	335	395	460	—	—	—	—	245	280	330	385	235	265	315	370	305	345	410	480	—	—	—	—
	970	*1100*	*1300*	*1500*	—	—	—	—	*800*	*920*	*1075*	*1275*	*770*	*870*	*1025*	*1225*	*1000*	*1125*	*1350*	*1575*	—	—	—	—
P4	260	295	345	410	—	—	—	—	215	245	290	345	205	235	280	330	270	305	360	425	—	—	—	—
	850	*970*	*1125*	*1350*	—	—	—	—	*710*	*800*	*950*	*1125*	*670*	*770*	*920*	*1075*	*890*	*1000*	*1175*	*1400*	—	—	—	—
P5	250	285	335	390	—	—	—	—	210	240	280	330	200	225	270	315	260	295	350	405	—	—	—	—
	820	*940*	*1100*	*1275*	—	—	—	—	*690*	*790*	*920*	*1075*	*660*	*740*	*890*	*1025*	*850*	*970*	*1150*	*1325*	—	—	—	—
P6	280	320	375	440	—	—	—	—	235	265	315	370	225	255	300	350	290	330	390	455	—	—	—	—
	920	*1050*	*1225*	*1450*	—	—	—	—	*770*	*870*	*1025*	*1225*	*740*	*840*	*980*	*1150*	*950*	*1075*	*1275*	*1500*	—	—	—	—
P7	265	300	355	415	—	—	—	—	220	250	300	350	210	240	285	330	275	310	370	430	—	—	—	—
	870	*980*	*1175*	*1350*	—	—	—	—	*720*	*820*	*980*	*1150*	*690*	*790*	*940*	*1075*	*900*	*1025*	*1225*	*1400*	—	—	—	—
P8	245	280	330	385	—	—	—	—	205	235	280	325	195	225	265	310	255	290	345	400	—	—	—	—
	800	*920*	*1075*	*1275*	—	—	—	—	*670*	*770*	*920*	*1075*	*640*	*740*	*870*	*1025*	*840*	*950*	*1125*	*1300*	—	—	—	—
P11	255	290	345	405	—	—	—	—	215	245	290	340	205	235	275	325	265	305	360	420	—	—	—	—
	840	*950*	*1125*	*1325*	—	—	—	—	*710*	*800*	*950*	*1125*	*670*	*770*	*900*	*1075*	*870*	*1000*	*1175*	*1375*	—	—	—	—
P12	160	185	215	250	—	—	—	—	135	155	180	210	130	145	170	200	165	190	225	260	—	—	—	—
	520	*610*	*710*	*820*	—	—	—	—	*445*	*510*	*590*	*690*	*425*	*475*	*560*	*660*	*540*	*620*	*740*	*850*	—	—	—	—
M1	250	285	340	400	—	—	—	—	230	260	305	360	215	245	295	345	—	—	—	—	—	—	—	—
	820	*940*	*1125*	*1300*	—	—	—	—	*750*	*850*	*1000*	*1175*	*710*	*800*	*970*	*1125*	—	—	—	—	—	—	—	—
M2	210	235	280	325	—	—	—	—	190	215	255	295	180	205	240	280	—	—	—	—	—	—	—	—
	690	*770*	*920*	*1075*	—	—	—	—	*620*	*710*	*840*	*970*	*590*	*670*	*790*	*920*	—	—	—	—	—	—	—	—
M3	165	185	220	255	—	—	—	—	150	170	200	230	140	160	190	220	—	—	—	—	—	—	—	—
	540	*610*	*720*	*840*	—	—	—	—	*490*	*560*	*660*	*750*	*460*	*520*	*620*	*720*	—	—	—	—	—	—	—	—
M4	125	140	170	195	—	—	—	—	115	130	150	180	110	120	145	170	—	—	—	—	—	—	—	—
	410	*460*	*560*	*640*	—	—	—	—	*375*	*425*	*490*	*590*	*360*	*395*	*475*	*560*	—	—	—	—	—	—	—	—
M5	105	120	140	165	—	—	—	—	95	105	125	150	90	100	120	140	—	—	—	—	—	—	—	—
	345	*395*	*460*	*540*	—	—	—	—	*310*	*345*	*410*	*490*	*295*	*330*	*395*	*460*	—	—	—	—	—	—	—	—
K1	265	305	360	425	255	290	345	405	225	255	300	355	215	245	290	340	380	430	510	600	—	—	—	—
	870	*1000*	*1175*	*1400*	*840*	*950*	*1125*	*1325*	*740*	*840*	*980*	*1175*	*710*	*800*	*950*	*1125*	*1250*	*1400*	*1675*	*1975*	—	—	—	—
K2	235	270	320	370	225	260	305	355	200	225	265	310	190	215	255	295	335	380	450	530	—	—	—	—
	770	*890*	*1050*	*1225*	*740*	*850*	*1000*	*1175*	*660*	*740*	*870*	*1025*	*620*	*710*	*840*	*970*	*1100*	*1250*	*1475*	*1750*	—	—	—	—
K3	200	230	270	315	190	220	260	300	170	190	225	265	160	180	215	250	285	320	380	445	—	—	—	—
	660	*750*	*890*	*1025*	*620*	*720*	*850*	*980*	*560*	*620*	*740*	*870*	*520*	*590*	*710*	*820*	*940*	*1050*	*1250*	*1450*	—	—	—	—
K4	190	215	255	300	185	210	245	290	160	185	215	250	155	175	205	240	270	310	365	425	—	—	—	—
	620	*710*	*840*	*980*	*610*	*690*	*800*	*950*	*520*	*610*	*710*	*820*	*510*	*570*	*670*	*790*	*890*	*1025*	*1200*	*1400*	—	—	—	—
K5	115	130	155	180	110	125	150	175	95	110	130	150	90	105	125	145	165	185	220	255	—	—	—	—
	375	*425*	*510*	*590*	*360*	*410*	*490*	*570*	*310*	*360*	*425*	*490*	*295*	*345*	*410*	*475*	*540*	*610*	*720*	*840*	—	—	—	—
K6	170	190	225	265	160	185	215	255	140	160	190	220	135	155	180	210	240	270	320	375	—	—	—	—
	560	*620*	*740*	*870*	*520*	*610*	*710*	*840*	*460*	*520*	*620*	*720*	*445*	*510*	*590*	*690*	*790*	*890*	*1050*	*1225*	—	—	—	—
K7	145	165	195	230	140	160	190	225	125	140	165	195	120	135	160	185	210	235	280	330	—	—	—	—
	475	*540*	*640*	*750*	*460*	*520*	*620*	*740*	*410*	*460*	*540*	*640*	*395*	*445*	*520*	*610*	*690*	*770*	*920*	*1075*	—	—	—	—
N1	2025	2300	2725	3200	—	—	—	—	1700	1925	2275	2675	1625	1825	2175	2550	—	—	—	—	1875	2150	2525	2975
	6650	*7550*	*8950*	*10500*	—	—	—	—	*5575*	*6325*	*7475*	*8775*	*5325*	*6000*	*7125*	*8375*	—	—	—	—	*6150*	*7050*	*8275*	*9750*
N2	810	930	1100	1300	—	—	—	—	680	780	920	1075	650	740	880	1025	—	—	—	—	760	870	1025	1200
	2650	*3050*	*3600*	*4275*	—	—	—	—	*2225*	*2550*	*3025*	*3525*	*2125*	*2425*	*2875*	*3375*	—	—	—	—	*2500*	*2850*	*3375*	*3925*
N3	540	620	730	860	—	—	—	—	455	520	620	720	435	495	590	690	—	—	—	—	510	580	680	800
	1775	*2025*	*2400*	*2825*	—	—	—	—	*1500*	*1700*	*2025*	*2350*	*1425*	*1625*	*1925*	*2275*	—	—	—	—	*1675*	*1900*	*2225*	*2625*
N11	620	710	840	980	—	—	—	—	520	590	700	830	495	560	670	790	—	—	—	—	580	660	780	910
	2025	*2325*	*2750*	*3225*	—	—	—	—	*1700*	*1925*	*2300*	*2725*	*1625*	*1825*	*2200*	*2600*	—	—	—	—	*1900*	*2175*	*2550*	*2975*
S1	60	65	80	90	—	—	—	—	55	60	70	85	50	55	65	80	—	—	—	—	—	—	—	—
	195	*215*	*260*	*295*	—	—	—	—	*180*	*195*	*230*	*280*	*165*	*180*	*215*	*260*	—	—	—	—	—	—	—	—
S2	47	55	65	75	—	—	—	—	43	48	55	65	41	46	55	65	—	—	—	—	—	—	—	—
	155	*180*	*215*	*245*	—	—	—	—	*140*	*155*	*180*	*215*	*135*	*150*	*180*	*215*	—	—	—	—	—	—	—	—
S3	41	46	55	65	—	—	—	—	37	42	50	60	35	40	47	55	—	—	—	—	—	—	—	—
	135	*150*	*180*	*215*	—	—	—	—	*120*	*140*	*165*	*195*	*115*	*130*	*155*	*180*	—	—	—	—	—	—	—	—
S11	80	95	110	130	—	—	—	—	75	85	100	115	70	80	95	110	—	—	—	—	—	—	—	—
	260	*310*	*360*	*425*	—	—	—	—	*245*	*280*	*330*	*375*	*230*	*260*	*310*	*360*	—	—	—	—	—	—	—	—
S12	55	65	75	90	—	—	—	—	43	49	60	70	49	55	65	75	—	—	—	—	—	—	—	—
	180	*215*	*245*	*295*	—	—	—	—	*140*	*160*	*195*	*230*	*160*	*180*	*215*	*245*	—	—	—	—	—	—	—	—
S13	33	37	44	50	—	—	—	—	25	28	33	39	28	32	38	44	—	—	—	—	—	—	—	—
	110	*120*	*145*	*165*	—	—	—	—	*80*	*90*	*110*	*130*	*90*	*105*	*125*	*145*	—	—	—	—	—	—	—	—
H5	50	55	65	80	50	60	70	80	45	50	60	70	43	49	55	65	—	—	—	—	—	—	—	—
	165	*180*	*215*	*260*	*165*	*195*	*230*	*260*	*150*	*165*	*195*	*230*	*140*	*160*	*180*	*215*	—	—	—	—	—	—	—	—
H8	50	60	70	80	55	60	70	80	46	55	60	70	44	50	60	70	—	—	—	—	—	—	—	—
	165	*195*	*230*	*260*	*180*	*195*	*230*	*260*	*150*	*180*	*195*	*230*	*145*	*165*	*195*	*230*	—	—	—	—	—	—	—	—
H11	65	70	85	100	65	75	85	100	55	65	75	90	55	60	75	85	—	—	—	—	—	—	—	—
	215	*230*	*280*	*330*	*215*	*245*	*280*	*330*	*180*	*215*	*245*	*295*	*180*	*195*	*245*	*280*	—	—	—	—	—	—	—	—
H12	100	110	130	155	95	110	125	150	85	95	110	130	80	90	105	125	—	—	—	—	—	—	—	—
	330	*360*	*425*	*510*	*310*	*360*	*410*	*490*	*280*	*310*	*360*	*425*	*260*	*295*	*345*	*410*	—	—	—	—	—	—	—	—
H21	50	60	70	80	55	60	70	80	46	55	60	70	44	50	60	70	—	—	—	—	—	—	—	—
	165	*195*	*230*	*260*	*180*	*195*	*230*	*260*	*150*	*180*	*195*	*230*	*145*	*165*	*195*	*230*	—	—	—	—	—	—	—	—

R217.29-035 – Metric





- For insert selection and cutting data recommendations, see page(s) 554-555
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16, 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm		mm	mm		mm	mm		kg	
R217.29-0816.RE-035.3A	02643410	Combimaster	9,0	16,0	3	3,5	M8	13,5	20,0	17,8	25,0	30,0	48000	0,1	RDH.0702
R217.29-1020.RE-035.4A	02495678	Combimaster	13,0	20,0	4	3,5	M10	18,5	23,0	10,4	33,0	38,0	44000	0,1	RDH.0702
R217.29-1225.RE-035.5A	02643411	Combimaster	18,0	25,0	5	3,5	M12	23,0	28,0	6,9	43,0	48,0	35000	0,1	RDH.0702

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.29-..	C02545-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.29-035 – Insert selection – mm/*Inch*

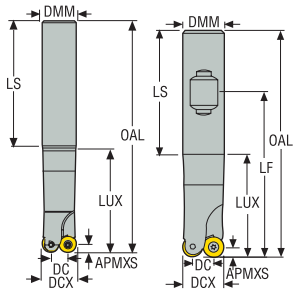
SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RDHW0702M0-MD03 F40M	1,4 *0.055*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,19 *0.0075*
P2	RDHW0702M0-MD03 F40M	1,4 *0.055*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,19 *0.0075*
P3	RDHW0702M0-MD03 F40M	1,4 *0.055*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
P4	RDHW0702M0-MD03 MP3000	1,4 *0.055*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
P5	RDHW0702M0-MD03 MP3000	1,4 *0.055*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
P6	RDHW0702M0-MD03 MP3000	1,4 *0.055*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,17 *0.0065*
P7	RDHW0702M0-MD03 MP3000	1,4 *0.055*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,17 *0.0065*
P8	RDHW0702M0-MD03 MP3000	1,4 *0.055*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,18 *0.0070*
P11	RDHW0702M0-MD03 MP3000	1,4 *0.055*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,17 *0.0065*
P12	RDHW0702M0-MD03 MP3000	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,085 *0.0034*	0,12 *0.0048*
M1	RDHW0702M0-MD03 F40M	1,4 *0.055*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,19 *0.0075*
M2	RDHW0702M0-MD03 F40M	1,4 *0.055*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
M3	RDHW0702M0-MD03 F40M	1,1 *0.044*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,14 *0.0055*
M4	RDHW0702M0-MD03 F40M	0,85 *0.034*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
M5	RDHW0702M0-MD03 F40M	0,85 *0.034*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
S1	RDHW0702M0-MD03 F40M	0,85 *0.034*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
S2	RDHW0702M0-MD03 F40M	0,85 *0.034*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
S3	RDHW0702M0-MD03 F40M	0,85 *0.034*	0,095 *0.0038*	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*
S11	RDHW0702M0-MD03 F40M	1,0 *0.040*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
S12	RDHW0702M0-MD03 F40M	1,0 *0.040*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
S13	RDHW0702M0-MD03 F40M	0,85 *0.034*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,12 *0.0048*
H5	RDHW0702M0T-MD04 F15M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,085 *0.0034*	0,12 *0.0048*
H8	RDHW0702M0T-MD04 F15M	1,0 *0.040*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H11	RDHW0702M0T-MD04 F15M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,085 *0.0034*	0,12 *0.0048*
H12	RDHW0702M0T-MD04 F15M	1,0 *0.040*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*
H21	RDHW0702M0T-MD04 F15M	1,0 *0.040*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*	0,090 *0.0036*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.29-035 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F15M				F40M			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	335 *1100*	400 *1300*	470 *1550*	550 *1800*	— —	— —	— —	— —	270 *890*	320 *1050*	375 *1225*	435 *1425*
P2	330 *1075*	385 *1275*	455 *1500*	530 *1750*	— —	— —	— —	— —	260 *850*	310 *1025*	365 *1200*	425 *1400*
P3	285 *940*	340 *1125*	400 *1300*	460 *1500*	— —	— —	— —	— —	230 *750*	270 *890*	320 *1050*	370 *1225*
P4	250 *820*	300 *980*	350 *1150*	405 *1325*	— —	— —	— —	— —	200 *660*	240 *790*	280 *920*	325 *1075*
P5	240 *790*	285 *940*	335 *1100*	390 *1275*	— —	— —	— —	— —	195 *640*	230 *750*	270 *890*	315 *1025*
P6	275 *900*	325 *1075*	375 *1225*	440 *1450*	— —	— —	— —	— —	220 *720*	260 *850*	300 *980*	350 *1150*
P7	260 *850*	305 *1000*	355 *1175*	415 *1350*	— —	— —	— —	— —	210 *690*	245 *800*	285 *940*	335 *1100*
P8	240 *790*	285 *940*	335 *1100*	390 *1275*	— —	— —	— —	— —	195 *640*	230 *750*	270 *890*	310 *1025*
P11	255 *840*	300 *980*	345 *1125*	405 *1325*	— —	— —	— —	— —	200 *660*	240 *790*	275 *900*	325 *1075*
P12	160 *520*	185 *610*	220 *720*	255 *840*	— —	— —	— —	— —	125 *410*	150 *490*	175 *570*	200 *660*
M1	245 *800*	290 *950*	340 *1125*	395 *1300*	— —	— —	— —	— —	210 *690*	250 *820*	295 *970*	340 *1125*
M2	200 *660*	240 *790*	280 *920*	330 *1075*	— —	— —	— —	— —	175 *570*	205 *670*	240 *790*	285 *940*
M3	165 *540*	190 *620*	225 *740*	260 *850*	— —	— —	— —	— —	140 *460*	165 *540*	195 *640*	225 *740*
M4	125 *410*	145 *475*	170 *560*	200 *660*	— —	— —	— —	— —	110 *360*	125 *410*	145 *475*	170 *560*
M5	105 *345*	120 *395*	140 *460*	165 *540*	— —	— —	— —	— —	90 *295*	105 *345*	125 *410*	145 *475*
K1	260 *850*	305 *1000*	360 *1175*	420 *1375*	250 *820*	295 *970*	350 *1150*	405 *1325*	210 *690*	245 *800*	290 *950*	335 *1100*
K2	230 *750*	270 *890*	320 *1050*	370 *1225*	220 *720*	260 *850*	305 *1000*	360 *1175*	185 *610*	215 *710*	255 *840*	300 *980*
K3	195 *640*	230 *750*	270 *890*	315 *1025*	185 *610*	220 *720*	260 *850*	305 *1000*	155 *510*	185 *610*	215 *710*	250 *820*
K4	185 *610*	220 *720*	260 *850*	300 *980*	175 *570*	210 *690*	245 *800*	290 *950*	150 *490*	175 *570*	205 *670*	240 *790*
K5	115 *375*	135 *445*	155 *510*	180 *590*	110 *360*	130 *425*	150 *490*	175 *570*	90 *295*	110 *360*	125 *410*	145 *475*
K6	165 *540*	195 *640*	225 *740*	265 *870*	155 *510*	185 *610*	220 *720*	255 *840*	130 *425*	155 *510*	180 *590*	210 *690*
K7	145 *475*	175 *570*	200 *660*	230 *750*	140 *460*	165 *540*	190 *620*	225 *740*	115 *375*	140 *460*	160 *520*	185 *610*
S1	60 *195*	70 *230*	80 *260*	95 *310*	— —	— —	— —	— —	50 *165*	60 *195*	70 *230*	80 *260*
S2	47 *155*	55 *180*	65 *215*	75 *245*	— —	— —	— —	— —	40 *130*	47 *155*	55 *180*	65 *215*
S3	41 *135*	48 *155*	55 *180*	65 *215*	— —	— —	— —	— —	35 *115*	41 *135*	48 *155*	55 *180*
S11	80 *260*	95 *310*	110 *360*	130 *425*	— —	— —	— —	— —	70 *230*	85 *280*	95 *310*	115 *375*
S12	55 *180*	65 *215*	80 *260*	90 *295*	— —	— —	— —	— —	49 *160*	55 *180*	65 *215*	80 *260*
S13	33 *110*	38 *125*	45 *150*	50 *165*	— —	— —	— —	— —	28 *90*	33 *110*	39 *130*	45 *150*
H5	49 *160*	60 *195*	70 *230*	80 *260*	50 *165*	60 *195*	70 *230*	80 *260*	42 *140*	49 *160*	60 *195*	65 *215*
H8	50 *165*	60 *195*	70 *230*	80 *260*	55 *180*	60 *195*	75 *245*	85 *280*	44 *145*	50 *165*	60 *195*	70 *230*
H11	65 *215*	75 *245*	85 *280*	100 *330*	65 *215*	75 *245*	90 *295*	105 *345*	55 *180*	65 *215*	75 *245*	85 *280*
H12	100 *330*	115 *375*	135 *445*	155 *510*	95 *310*	110 *360*	130 *425*	150 *490*	80 *260*	95 *310*	110 *360*	125 *410*
H21	50 *165*	60 *195*	70 *230*	80 *260*	55 *180*	60 *195*	75 *245*	85 *280*	44 *145*	50 *165*	60 *195*	70 *230*

R217.29-04 – Metric



- For insert selection and cutting data recommendations, see page(s) 558-560
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.29-1616.0-04.2.050	00040299	Cylindrical	8,0	16,0	2	4,0	16,0	60,0	110,0	50,0	90,0	24,0	30,0	36200	0,2	RD..0803
R217.29-1616.0-04.2.100E	00040300	Cylindrical	8,0	16,0	2	4,0	16,0	95,0	160,0	100,0	90,0	24,0	30,0	36200	0,5	RD..0803
R217.29-1616.3-04.2.040	00040302	Weldon	8,0	16,0	2	4,0	16,0	48,0	88,0	38,0	90,0	24,0	30,0	36200	0,2	RD..0803

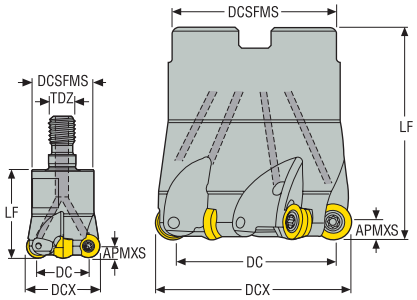
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.69-..Ø16	C02505-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-04 – Metric



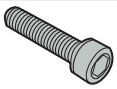
- For insert selection and cutting data recommendations, see page(s) 558-560
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.29-0816.RE-04.2	00047266	Combimaster	8,0	16,0	2	4,0	–	M8	13,5	23,0	90,0	24,0	30,0	36200	0,1	RD..0803
R217.29-1020.RE-04.2A	00040294	Combimaster	12,0	20,0	2	4,0	–	M10	18,5	28,0	16,43	32,0	38,0	32400	0,1	RD..0803
R217.29-1020.RE-04.3A	00040062	Combimaster	12,0	20,0	3	4,0	–	M10	18,5	28,0	16,43	32,0	38,0	32400	0,1	RD..0803
R217.29-1225.RE-04.3A	02410817	Combimaster	17,0	25,0	3	4,0	–	M12	23,0	30,0	10,01	42,0	48,0	29000	0,2	–
R217.29-1225.RE-04.4A	00040297	Combimaster	17,0	25,0	4	4,0	–	M12	23,0	30,0	10,01	42,0	48,0	29000	0,1	RD..0803
R217.29-1632.RE-04.5A	02410823	Combimaster	24,0	32,0	5	4,0	–	M16	30,0	40,0	6,51	56,0	62,0	26100	0,2	RD..0803
R217.29-1640.RE-04.6A	00040303	Combimaster	32,0	40,0	6	4,0	–	M16	30,0	40,0	4,66	72,0	78,0	23300	0,3	RD..0803
R217.29-2040.RE-04.6A	02928077	Combimaster	32,0	40,0	6	4,0	–	M20	36,5	40,0	4,66	72,0	78,0	23300	0,4	RD..0803
R220.29-0050-04.5A	02410828	Arbor	42,0	50,0	5	4,0	22,0	–	42,0	40,0	3,44	92,0	98,0	17300	0,4	RD..0803
R220.29-0050-04.7A	02410829	Arbor	42,0	50,0	7	4,0	22,0	–	42,0	40,0	3,44	92,0	98,0	17300	0,4	RD..0803

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.69-..Ø16	–	C02505-T08P	T00-08P12	1.2NM
R217.29-..Ø20-40	–	C02506-T08P	T00-08P12	1.2NM
R217.29-2040-04	–	C02506-T08P	T00-08P12	1.2NM
R220.29-..0050	220.17-692	C02506-T08P	T00-08P12	1.2NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-04 – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RDKW0803M0T-MD05 MP2501	1,6 *0.065*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
P2	RDKW0803M0T-MD05 MP2501	1,6 *0.065*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
P3	RDKW0803M0T-MD05 MP2501	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,22 *0.0085*
P4	RDKW0803M0T-MD05 MP2501	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,22 *0.0085*
P5	RDKW0803M0T-MD05 MP2501	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
P6	RDKW0803M0T-MD05 MS2500	1,6 *0.065*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	0,20 *0.0080*
P7	RDKW0803M0T-MD05 MS2500	1,6 *0.065*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	0,20 *0.0080*
P8	RDKW0803M0T-MD05 MS2500	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,22 *0.0085*
P11	RDKW0803M0T-MD05 MS2500	1,6 *0.065*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	0,20 *0.0080*
P12	RDKW0803M0T-MD05 MS2500	1,3 *0.050*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
M1	RDHW0803M0-MD03 F40M	1,6 *0.065*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,18 *0.0070*
M2	RDHW0803M0-MD03 F40M	1,6 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
M3	RDHW0803M0-MD03 F40M	1,3 *0.050*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*	0,13 *0.0050*
M4	RDHW0803M0-MD03 F40M	0,95 *0.038*	0,11 *0.0044*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*
M5	RDHW0803M0-MD03 F40M	0,95 *0.038*	0,11 *0.0044*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*
K1	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
K2	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
K3	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
K4	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
K5	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,19 *0.0075*
K6	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
K7	RDKW0803M0T-MD05 MK2050	1,6 *0.065*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*	0,19 *0.0075*
N1	RDHT0803M0-E03 H25	1,6 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
N2	RDHT0803M0-E03 H25	1,6 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
N3	RDHT0803M0-E03 H25	1,6 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
N11	RDHT0803M0-E03 H25	1,6 *0.065*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,17 *0.0065*
S1	RDHW0803M0-MD03 F40M	0,95 *0.038*	0,11 *0.0044*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*
S2	RDHW0803M0-MD03 F40M	0,95 *0.038*	0,11 *0.0044*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*
S3	RDHW0803M0-MD03 F40M	0,95 *0.038*	0,10 *0.0040*	0,10 *0.0040*	0,095 *0.0038*	0,11 *0.0044*
S11	RDHW0803M0-MD03 MS2050	1,1 *0.044*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*
S12	RDHW0803M0-MD03 MS2050	1,1 *0.044*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*
S13	RDHW0803M0-MD03 MS2050	0,95 *0.038*	0,11 *0.0044*	0,11 *0.0044*	0,10 *0.0040*	0,12 *0.0048*
H5	RDKW0803M0T-MD05 F15M	1,3 *0.050*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
H8	RDKW0803M0T-MD05 F15M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
H11	RDKW0803M0T-MD05 F15M	1,3 *0.050*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,14 *0.0055*
H12	RDKW0803M0T-MD05 F15M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*
H21	RDKW0803M0T-MD05 F15M	1,1 *0.044*	0,090 *0.0036*	0,090 *0.0036*	0,090 *0.0036*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

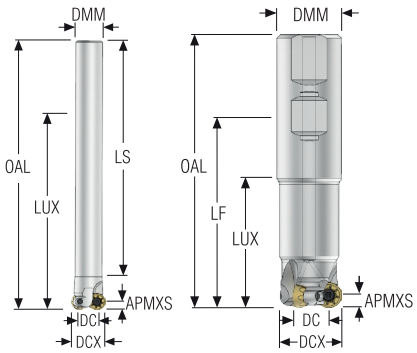
R217/220.29-04 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501				MP3000				T350M				F15M				F25M			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	330	375	450	530	330	370	445	520	370	420	500	590	—	—	—	—	275	310	375	440
	1075	*1225*	*1475*	*1750*	*1075*	*1225*	*1450*	*1700*	*1225*	*1375*	*1650*	*1925*	—	—	—	—	*900*	*1025*	*1225*	*1450*
P2	325	365	435	520	320	360	435	510	360	410	480	560	—	—	—	—	270	305	365	430
	1075	*1200*	*1425*	*1700*	*1050*	*1175*	*1425*	*1675*	*1175*	*1350*	*1575*	*1825*	—	—	—	—	*890*	*1000*	*1200*	*1400*
P3	280	320	380	445	280	315	380	445	315	355	420	490	—	—	—	—	235	265	320	370
	920	*1050*	*1250*	*1450*	*920*	*1025*	*1250*	*1450*	*1025*	*1175*	*1375*	*1600*	—	—	—	—	*770*	*870*	*1050*	*1225*
P4	250	280	335	390	245	280	335	390	275	315	370	435	—	—	—	—	205	235	280	325
	820	*920*	*1100*	*1275*	*800*	*920*	*1100*	*1275*	*900*	*1025*	*1225*	*1425*	—	—	—	—	*670*	*770*	*920*	*1075*
P5	235	265	320	380	235	265	320	375	265	300	355	420	—	—	—	—	195	225	265	320
	770	*870*	*1050*	*1250*	*770*	*870*	*1050*	*1225*	*870*	*980*	*1175*	*1375*	—	—	—	—	*640*	*740*	*870*	*1050*
P6	270	305	360	430	265	300	355	425	300	340	400	470	—	—	—	—	225	255	300	355
	890	*1000*	*1175*	*1400*	*870*	*980*	*1175*	*1400*	*980*	*1125*	*1300*	*1550*	—	—	—	—	*740*	*840*	*980*	*1175*
P7	255	290	340	405	250	280	335	400	280	320	375	445	—	—	—	—	215	240	285	335
	840	*950*	*1125*	*1325*	*820*	*920*	*1100*	*1300*	*920*	*1050*	*1225*	*1450*	—	—	—	—	*710*	*790*	*940*	*1100*
P8	235	265	320	375	235	265	320	375	265	300	355	415	—	—	—	—	195	225	265	310
	770	*870*	*1050*	*1225*	*770*	*870*	*1050*	*1225*	*870*	*980*	*1175*	*1350*	—	—	—	—	*640*	*740*	*870*	*1025*
P11	250	280	330	390	245	275	325	390	275	310	365	430	—	—	—	—	205	235	275	325
	820	*920*	*1075*	*1275*	*800*	*900*	*1075*	*1275*	*900*	*1025*	*1200*	*1400*	—	—	—	—	*670*	*770*	*900*	*1075*
P12	155	175	210	250	155	175	210	245	170	195	230	270	—	—	—	—	130	150	175	205
	510	*570*	*690*	*820*	*510*	*570*	*690*	*800*	*560*	*640*	*750*	*890*	—	—	—	—	*425*	*490*	*570*	*670*
M1	235	260	315	370	240	270	325	380	280	315	370	435	—	—	—	—	—	—	—	—
	770	*850*	*1025*	*1225*	*790*	*890*	*1075*	*1250*	*920*	*1025*	*1225*	*1425*	—	—	—	—	—	—	—	—
M2	190	215	260	305	195	220	265	310	230	260	305	360	—	—	—	—	—	—	—	—
	620	*710*	*850*	*1000*	*640*	*720*	*870*	*1025*	*750*	*850*	*1000*	*1175*	—	—	—	—	—	—	—	—
M3	155	175	205	240	160	180	210	250	180	205	240	285	—	—	—	—	—	—	—	—
	510	*570*	*670*	*790*	*520*	*590*	*690*	*820*	*590*	*670*	*790*	*940*	—	—	—	—	—	—	—	—
M4	120	135	155	185	120	135	160	190	140	155	185	215	—	—	—	—	—	—	—	—
	395	*445*	*510*	*610*	*395*	*445*	*520*	*620*	*460*	*510*	*610*	*710*	—	—	—	—	—	—	—	—
M5	100	110	130	155	100	115	135	160	115	130	155	180	—	—	—	—	—	—	—	—
	330	*360*	*425*	*510*	*330*	*375*	*445*	*520*	*375*	*425*	*510*	*590*	—	—	—	—	—	—	—	—
K1	255	290	345	410	255	285	345	405	—	—	—	—	230	260	315	370	215	240	290	340
	840	*950*	*1125*	*1350*	*840*	*940*	*1125*	*1325*	—	—	—	—	*750*	*850*	*1025*	*1225*	*710*	*790*	*950*	*1125*
K2	225	255	305	360	225	255	300	355	—	—	—	—	205	230	275	330	185	210	255	300
	740	*840*	*1000*	*1175*	*740*	*840*	*980*	*1175*	—	—	—	—	*670*	*750*	*900*	*1075*	*610*	*690*	*840*	*980*
K3	190	215	260	305	190	215	255	300	—	—	—	—	175	195	235	280	160	180	215	255
	620	*710*	*850*	*1000*	*620*	*710*	*840*	*980*	—	—	—	—	*570*	*640*	*770*	*920*	*520*	*590*	*710*	*840*
K4	180	205	245	290	180	205	245	285	—	—	—	—	165	185	225	265	150	170	205	245
	590	*670*	*800*	*950*	*590*	*670*	*800*	*940*	—	—	—	—	*540*	*610*	*740*	*870*	*490*	*560*	*670*	*800*
K5	110	125	150	175	110	125	150	175	—	—	—	—	100	115	135	160	95	105	125	145
	360	*410*	*490*	*570*	*360*	*410*	*490*	*570*	—	—	—	—	*330*	*375*	*445*	*520*	*310*	*345*	*410*	*475*
K6	160	180	215	260	160	180	215	250	—	—	—	—	145	165	195	235	135	150	180	215
	520	*590*	*710*	*850*	*520*	*590*	*710*	*820*	—	—	—	—	*475*	*540*	*640*	*770*	*445*	*490*	*590*	*710*
K7	145	160	195	225	145	160	190	225	—	—	—	—	130	145	175	205	120	135	160	190
	475	*520*	*640*	*740*	*475*	*520*	*620*	*740*	—	—	—	—	*425*	*475*	*570*	*670*	*395*	*445*	*520*	*620*
N1	—	—	—	—	1925	2150	2550	3000	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	*6325*	*7050*	*8375*	*9850*	—	—	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	770	870	1025	1225	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	*2525*	*2850*	*3375*	*4025*	—	—	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	520	580	690	810	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	*1700*	*1900*	*2275*	*2650*	—	—	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	590	670	790	930	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	*1925*	*2200*	*2600*	*3050*	—	—	—	—	—	—	—	—	—	—	—	—
S1	—	—	—	—	55	65	75	90	65	75	85	100	—	—	—	—	—	—	—	—
	—	—	—	—	*180*	*215*	*245*	*295*	*215*	*245*	*280*	*330*	—	—	—	—	—	—	—	—
S2	—	—	—	—	45	50	60	70	50	60	70	80	—	—	—	—	—	—	—	—
	—	—	—	—	*150*	*165*	*195*	*230*	*165*	*195*	*230*	*260*	—	—	—	—	—	—	—	—
S3	—	—	—	—	40	45	55	60	45	50	60	70	—	—	—	—	—	—	—	—
	—	—	—	—	*130*	*150*	*180*	*195*	*150*	*165*	*195*	*230*	—	—	—	—	—	—	—	—
S11	—	—	—	—	80	90	105	125	90	105	120	145	—	—	—	—	—	—	—	—
	—	—	—	—	*260*	*295*	*345*	*410*	*295*	*345*	*395*	*475*	—	—	—	—	—	—	—	—
S12	—	—	—	—	55	60	75	85	65	70	85	100	—	—	—	—	—	—	—	—
	—	—	—	—	*180*	*195*	*245*	*280*	*215*	*230*	*280*	*330*	—	—	—	—	—	—	—	—
S13	—	—	—	—	32	36	43	50	36	41	48	55	—	—	—	—	—	—	—	—
	—	—	—	—	*105*	*120*	*140*	*165*	*120*	*135*	*155*	*180*	—	—	—	—	—	—	—	—
H5	—	—	—	—	48	55	65	75	55	65	75	90	47	55	65	75	—	—	—	—
	—	—	—	—	*155*	*180*	*215*	*245*	*180*	*215*	*245*	*295*	*155*	*180*	*215*	*245*	—	—	—	—
H8	—	—	—	—	50	55	65	80	60	65	80	90	50	55	65	80	—	—	—	—
	—	—	—	—	*165*	*180*	*215*	*260*	*195*	*215*	*260*	*295*	*165*	*180*	*215*	*260*	—	—	—	—
H11	—	—	—	—	60	70	80	95	75	80	95	115	60	70	80	95	—	—	—	—
	—	—	—	—	*195*	*230*	*260*	*310*	*245*	*260*	*310*	*375*	*195*	*230*	*260*	*310*	—	—	—	—
H12	—	—	—	—	95	110	130	150	105	120	140	165	90	100	120	140	—	—	—	—
	—	—	—	—	*310*	*360*	*425*	*490*	*345*	*395*	*460*	*540*	*295*	*330*	*395*	*460*	—	—	—	—
H21	—	—	—	—	50	55	65	80	60	65	80	90	50	55	65	80	—	—	—	—
	—	—	—	—	*165*	*180*	*215*	*260*	*195*	*215*	*260*	*295*	*165*	*180*	*215*	*260*	—	—	—	—

R217/220.29-04 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				MK2050				MS2050				MS2500				H25			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	265	295	355	420	325	370	440	520	—	—	—	—	360	410	490	580	—	—	—	—
	870	*970*	*1175*	*1375*	*1075*	*1225*	*1450*	*1700*	—	—	—	—	*1175*	*1350*	*1600*	*1900*	—	—	—	—
P2	255	290	345	410	320	360	430	510	—	—	—	—	350	395	475	560	—	—	—	—
	840	*950*	*1125*	*1350*	*1050*	*1175*	*1400*	*1675*	—	—	—	—	*1150*	*1300*	*1550*	*1825*	—	—	—	—
P3	225	255	305	355	280	315	375	440	—	—	—	—	310	345	415	485	—	—	—	—
	740	*840*	*1000*	*1175*	*920*	*1025*	*1225*	*1450*	—	—	—	—	*1025*	*1125*	*1350*	*1600*	—	—	—	—
P4	195	225	265	310	245	275	330	385	—	—	—	—	270	305	365	425	—	—	—	—
	640	*740*	*870*	*1025*	*800*	*900*	*1075*	*1275*	—	—	—	—	*890*	*1000*	*1200*	*1400*	—	—	—	—
P5	190	215	255	300	235	265	315	375	—	—	—	—	260	290	350	415	—	—	—	—
	620	*710*	*840*	*980*	*770*	*870*	*1025*	*1225*	—	—	—	—	*850*	*950*	*1150*	*1350*	—	—	—	—
P6	210	240	285	340	265	300	355	420	—	—	—	—	295	335	395	465	—	—	—	—
	690	*790*	*940*	*1125*	*870*	*980*	*1175*	*1375*	—	—	—	—	*970*	*1100*	*1300*	*1525*	—	—	—	—
P7	200	225	270	320	250	285	335	400	—	—	—	—	280	315	370	440	—	—	—	—
	660	*740*	*890*	*1050*	*820*	*940*	*1100*	*1300*	—	—	—	—	*920*	*1025*	*1225*	*1450*	—	—	—	—
P8	190	215	255	300	235	265	315	370	—	—	—	—	260	290	350	410	—	—	—	—
	620	*710*	*840*	*980*	*770*	*870*	*1025*	*1225*	—	—	—	—	*850*	*950*	*1150*	*1350*	—	—	—	—
P11	195	220	260	310	245	275	325	385	—	—	—	—	270	305	360	430	—	—	—	—
	640	*720*	*850*	*1025*	*800*	*900*	*1075*	*1275*	—	—	—	—	*890*	*1000*	*1175*	*1400*	—	—	—	—
P12	125	140	165	195	155	175	205	245	—	—	—	—	170	195	230	270	—	—	—	—
	410	*460*	*540*	*640*	*510*	*570*	*670*	*800*	—	—	—	—	*560*	*640*	*750*	*890*	—	—	—	—
M1	205	235	280	330	—	—	—	—	—	—	—	—	250	285	340	405	—	—	—	—
	670	*770*	*920*	*1075*	—	—	—	—	—	—	—	—	*820*	*940*	*1125*	*1325*	—	—	—	—
M2	170	190	230	270	—	—	—	—	—	—	—	—	205	235	280	335	—	—	—	—
	560	*620*	*750*	*890*	—	—	—	—	—	—	—	—	*670*	*770*	*920*	*1100*	—	—	—	—
M3	135	155	185	215	—	—	—	—	—	—	—	—	165	185	225	260	—	—	—	—
	445	*510*	*610*	*710*	—	—	—	—	—	—	—	—	*540*	*610*	*740*	*850*	—	—	—	—
M4	105	115	140	165	—	—	—	—	—	—	—	—	130	145	170	200	—	—	—	—
	345	*375*	*460*	*540*	—	—	—	—	—	—	—	—	*425*	*475*	*560*	*660*	—	—	—	—
M5	85	95	115	135	—	—	—	—	—	—	—	—	105	120	140	165	—	—	—	—
	280	*310*	*375*	*445*	—	—	—	—	—	—	—	—	*345*	*395*	*460*	*540*	—	—	—	—
K1	205	230	275	325	345	385	465	550	—	—	—	—	—	—	—	—	—	—	—	—
	670	*750*	*900*	*1075*	*1125*	*1275*	*1525*	*1800*	—	—	—	—	—	—	—	—	—	—	—	—
K2	180	200	240	285	300	340	410	485	—	—	—	—	—	—	—	—	—	—	—	—
	590	*660*	*790*	*940*	*980*	*1125*	*1350*	*1600*	—	—	—	—	—	—	—	—	—	—	—	—
K3	150	170	205	240	255	290	345	410	—	—	—	—	—	—	—	—	—	—	—	—
	490	*560*	*670*	*790*	*840*	*950*	*1125*	*1350*	—	—	—	—	—	—	—	—	—	—	—	—
K4	145	165	195	230	245	275	330	390	—	—	—	—	—	—	—	—	—	—	—	—
	475	*540*	*640*	*750*	*800*	*900*	*1075*	*1275*	—	—	—	—	—	—	—	—	—	—	—	—
K5	90	100	120	140	150	170	200	235	—	—	—	—	—	—	—	—	—	—	—	—
	295	*330*	*395*	*460*	*490*	*560*	*660*	*770*	—	—	—	—	—	—	—	—	—	—	—	—
K6	125	145	170	200	215	240	290	345	—	—	—	—	—	—	—	—	—	—	—	—
	410	*475*	*560*	*660*	*710*	*790*	*950*	*1125*	—	—	—	—	—	—	—	—	—	—	—	—
K7	115	130	150	180	190	215	260	300	—	—	—	—	—	—	—	—	—	—	—	—
	375	*425*	*490*	*590*	*620*	*710*	*850*	*980*	—	—	—	—	—	—	—	—	—	—	—	—
N1	1525	1725	2050	2400	—	—	—	—	—	—	—	—	—	—	—	—	1775	2025	2400	2825
	5000	*5650*	*6725*	*7875*	—	—	—	—	—	—	—	—	—	—	—	—	*5825*	*6650*	*7875*	*9275*
N2	620	700	830	970	—	—	—	—	—	—	—	—	—	—	—	—	720	810	970	1150
	2025	*2300*	*2725*	*3175*	—	—	—	—	—	—	—	—	—	—	—	—	*2350*	*2650*	*3175*	*3775*
N3	415	465	550	650	—	—	—	—	—	—	—	—	—	—	—	—	480	540	650	760
	1350	*1525*	*1800*	*2125*	—	—	—	—	—	—	—	—	—	—	—	—	*1575*	*1775*	*2125*	*2500*
N11	470	530	630	740	—	—	—	—	—	—	—	—	—	—	—	—	550	620	740	870
	1550	*1750*	*2075*	*2425*	—	—	—	—	—	—	—	—	—	—	—	—	*1800*	*2025*	*2425*	*2850*
S1	48	55	65	75	—	—	—	—	55	60	70	85	65	70	85	100	—	—	—	—
	155	*180*	*215*	*245*	—	—	—	—	*180*	*195*	*230*	*280*	*215*	*230*	*280*	*330*	—	—	—	—
S2	39	44	55	60	—	—	—	—	43	48	60	65	50	55	65	80	—	—	—	—
	130	*145*	*180*	*195*	—	—	—	—	*140*	*155*	*195*	*215*	*165*	*180*	*215*	*260*	—	—	—	—
S3	34	38	46	55	—	—	—	—	38	42	50	60	44	50	60	70	—	—	—	—
	110	*125*	*150*	*180*	—	—	—	—	*125*	*140*	*165*	*195*	*145*	*165*	*195*	*230*	—	—	—	—
S11	70	80	90	110	—	—	—	—	75	85	100	120	90	100	115	140	—	—	—	—
	230	*260*	*295*	*360*	—	—	—	—	*245*	*280*	*330*	*395*	*295*	*330*	*375*	*460*	—	—	—	—
S12	48	55	65	75	—	—	—	—	50	60	70	85	60	70	80	95	—	—	—	—
	155	*180*	*215*	*245*	—	—	—	—	*165*	*195*	*230*	*280*	*195*	*230*	*260*	*310*	—	—	—	—
S13	27	31	37	43	—	—	—	—	30	34	40	47	35	40	47	55	—	—	—	—
	90	*100*	*120*	*140*	—	—	—	—	*100*	*110*	*130*	*155*	*115*	*130*	*155*	*180*	—	—	—	—
H5	41	46	55	65	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	135	*150*	*180*	*215*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	43	48	55	65	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	140	*155*	*180*	*215*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	50	60	70	85	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	165	*195*	*230*	*280*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	75	85	105	120	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	245	*280*	*345*	*395*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	43	48	55	65	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	140	*155*	*180*	*215*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

R217.29I-05 – Metric



- For insert selection and cutting data recommendations, see page(s) 565-567
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.29I-2016.0-05.1.100A	03278796	Cylindrical	5,9	16,0	1	5,0	20,0	90,0	150,0	60,0	6,9	21,8	30,0	29900	0,3	RD..10T3
R217.29I-1620.0-05.2.112E	03278795	Cylindrical	10,0	20,0	2	5,0	16,0	140,0	160,0	112,0	90,0	30,0	38,0	27400	0,5	RD..10T3
R217.29I-2025.0-05.2.120A	03278797	Cylindrical	15,0	25,0	2	5,0	20,0	140,0	170,0	120,0	14,5	40,0	48,0	24400	0,4	RD..10T3
R217.29I-2525.0-05.3.124A	03278798	Cylindrical	15,0	25,0	3	5,0	25,0	130,0	180,0	50,1	13,8	40,0	48,0	24400	0,7	RD..10T3
R217.29I-2527.0-05.3.124A	03278799	Cylindrical	17,0	27,0	3	5,0	25,0	25,0	180,0	124,0	11,6	44,0	52,0	24400	0,7	RD..10T3
R217.29I-2520.3-05.2.070A	03278800	Weldon	10,0	20,0	2	5,0	25,0	55,5	125,5	70,0	90,0	30,0	38,0	27400	0,4	RD..10T3
R217.29I-2525.3-05.3.050A	03278801	Weldon	15,0	25,0	3	5,0	25,0	55,5	105,5	50,0	14,4	40,0	48,0	24400	0,4	RD..10T3
R217.29I-3232.3-05.4.060A	03278802	Weldon	22,0	32,0	4	5,0	32,0	59,5	119,5	60,0	8,7	54,0	62,0	21600	0,7	RD..10T3

Spare Parts

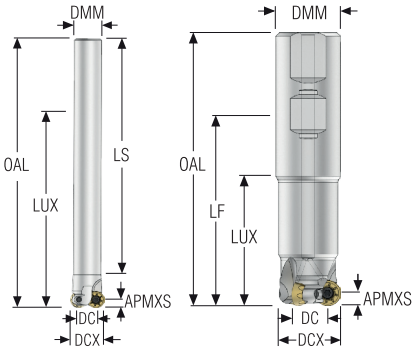
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.29I-2016-2520	C03006-T09P	T00-09P20	2.0NM
R217.29I-2025-3232	C03007-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217.29I-05 – Inch



- For insert selection and cutting data recommendations, see page(s) 565-567
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.29I-01.00-3-05.3A	03278812	Weldon	0.608	1.000	3	0.197	1.000	2.280	5.280	3.000	13,8	1.610	1.921	24400	1.100	RD..10T3

Spare Parts

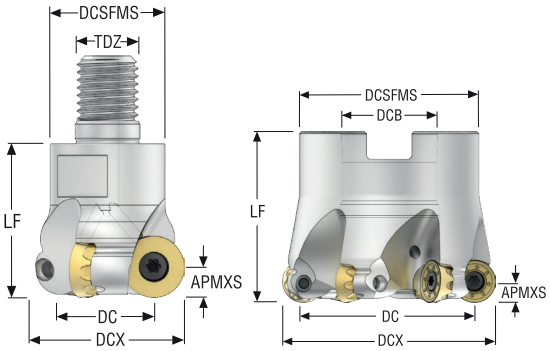
For cutter	Insert screw
R217.29I-..	C03007-T09P

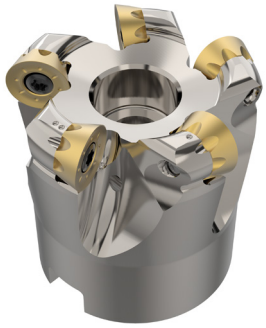
Accessories

Torque key	Torque value
T00-09P20	17.7IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29I-05 – Metric





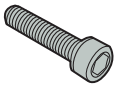
- For insert selection and cutting data recommendations, see page(s) 565-567
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.29I-1020.RE-05.2A	03278781	Combimaster	10,0	20,0	2	5,0	–	M10	18,5	28,0	90,0	30,0	38,0	27400	0,1	RD..10T3
R217.29I-1225.RE-05.3A	03278782	Combimaster	15,0	25,0	3	5,0	–	M12	23,0	30,0	13,8	40,0	48,0	24400	0,1	RD..10T3
R217.29I-1232.RE-05.4A	03278783	Combimaster	22,0	32,0	4	5,0	–	M12	23,0	30,0	8,0	54,0	62,0	21600	0,1	RD..10T3
R217.29I-1632.RE-05.4A	03278784	Combimaster	22,0	32,0	4	5,0	–	M16	30,0	40,0	8,8	54,0	62,0	21600	0,2	RD..10T3
R217.29I-1632.RE-05.5A	03278785	Combimaster	22,2	32,0	5	5,0	–	M16	30,0	40,0	4,1	54,4	62,0	21600	0,2	RD..10T3
R217.29I-1635.RE-05.5A	03278786	Combimaster	25,1	35,0	5	5,0	–	M16	30,0	40,0	7,5	60,2	68,0	15600	0,2	RD..10T3
R217.29I-1640.RE-05.4A	03278787	Combimaster	30,0	40,0	4	5,0	–	M16	30,0	40,0	5,5	70,0	78,0	19300	0,3	RD..10T3
R217.29I-1640.RE-05.5A	03278788	Combimaster	30,0	40,0	5	5,0	–	M16	30,0	40,0	5,5	70,0	78,0	19300	0,3	RD..10T3
R217.29I-2040.RE-05.6A	03278791	Combimaster	30,2	40,0	6	5,0	–	M20	36,5	40,0	5,9	70,4	78,0	19300	0,3	RD..10T3
R217.29I-1642.RE-05.5A	03278789	Combimaster	32,0	42,0	5	5,0	–	M16	30,0	40,0	5,6	74,0	82,0	18800	0,3	RD..10T3
R217.29I-1642.RE-05.6A	03278790	Combimaster	32,0	42,0	6	5,0	–	M16	30,0	40,0	6,0	74,0	82,0	18800	0,3	RD..10T3
R217.29I-2042.RE-05.6A	03278792	Combimaster	32,2	42,0	6	5,0	–	M20	36,5	40,0	5,5	74,4	82,0	18800	0,3	RD..10T3
R220.29I-0040-05.5A	03278803	Arbor	30,0	40,0	5	5,0	16,0	–	33,0	40,0	7,3	70,0	78,0	19300	0,2	RD..10T3
R220.29I-0050-05.4A	03278804	Arbor	40,0	50,0	4	5,0	22,0	–	41,0	40,0	4,3	90,0	98,0	17300	0,3	RD..10T3
R220.29I-0050-05.6A	03278805	Arbor	40,0	50,0	6	5,0	22,0	–	41,0	40,0	4,3	90,0	98,0	17300	0,3	RD..10T3
R220.29I-0052-05.7A	03278806	Arbor	42,1	52,0	7	5,0	22,0	–	41,0	40,0	4,3	94,2	102,0	17000	0,3	RD..10T3
R220.29I-0063-05.6A	03278807	Arbor	53,0	63,0	6	5,0	22,0	–	49,0	40,0	3,1	116,0	124,0	15800	0,5	RD..10T3
R220.29I-0063-05.8A	03278808	Arbor	53,0	63,0	8	5,0	22,0	–	49,0	40,0	3,9	116,0	124,0	15800	0,5	RD..10T3

For Combimaster Shanks, see Machining Navigator Tooling System

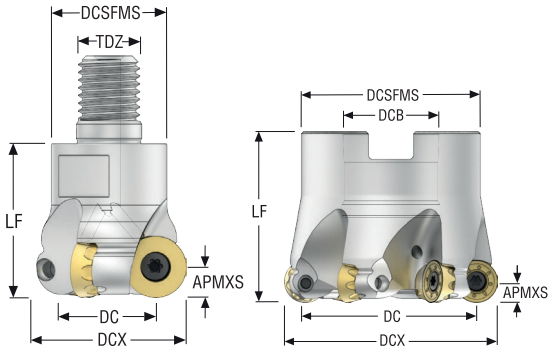
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.29I-1020	–	C03006-T09P	T00-09P20	2.0NM
R217.29I-1225-2042	–	C03007-T09P	T00-09P20	2.0NM
R220.29I-0040	220.17-689	C03007-T09P	T00-09P20	2.0NM
R220.29I-0050-0063	220.17-692	C03007-T09P	T00-09P20	2.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29I-05 – Inch



- For insert selection and cutting data recommendations, see page(s) 565-567
- For complete insert programme, see page(s) 746
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch		Inch	Inch		Inch	Inch		lbs	
R217.29I-1.00-12RE-05.3A	03278809	Combimaster	0.608	1.000	3	0.197	–	M12	0.906	1.181	13,3	1.610	1.921	24400	0.220	RD..10T3
R217.29I-1.25-16RE-05.4A	03278810	Combimaster	0.856	1.250	4	0.197	–	M16	1.181	1.575	8,9	2.106	2.421	21600	0.440	RD..10T3
R217.29I-1.50-16RE-05.5A	03278811	Combimaster	1.106	1.500	5	0.197	–	M16	1.181	1.575	6,0	2.606	2.921	19300	0.660	RD..10T3
R220.29I-01.50-05.5A	03278813	Arbor	1.106	1.500	5	0.197	0.500	–	1.339	1.500	6,5	2.606	2.921	14000	0.440	RD..10T3
R220.29I-02.00-05.6A	03278814	Arbor	1.606	2.000	6	0.197	0.750	–	1.614	1.500	4,2	3.606	3.921	12500	0.660	RD..10T3

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.29I-..	–	C03007-T09P	T00-09P20	17.7IN.LBS
R220.29I-01.50	UC6S1/4UNFX1	C03007-T09P	T00-09P20	17.7IN.LBS
R220.29I-02.00	UC6S3/8UNFX1	C03007-T09P	T00-09P20	17.7IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29I-05 – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RDKT10T3M0T-6-M05 MP2501	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
P2	RDKT10T3M0T-6-M05 MP2501	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
P3	RDKT10T3M0T-6-M05 MP2501	2,0 *0.080*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*	0,20 *0.0080*
P4	RDKT10T3M0T-6-M05 MP2501	2,0 *0.080*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
P5	RDKT10T3M0T-6-M05 MP2501	2,0 *0.080*	0,15 *0.0060*	0,15 *0.0060*	0,15 *0.0060*	0,20 *0.0080*
P6	RDKT10T3M0T-6-M05 MP2501	2,0 *0.080*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*	0,20 *0.0080*
P7	RDKW10T3M0T-6-MD06 MS2500	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
P8	RDKW10T3M0T-6-MD06 MS2500	2,0 *0.080*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*	0,25 *0.010*
P11	RDKW10T3M0T-6-MD06 MS2500	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
P12	RDKW10T3M0T-6-MD06 MS2500	1,6 *0.065*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*
M1	RDHT10T3M0T-8-M11 MP2050	2,0 *0.080*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,48 *0.019*
M2	RDHT10T3M0T-8-M11 MP2050	2,0 *0.080*	0,32 *0.013*	0,32 *0.013*	0,32 *0.013*	0,44 *0.017*
M3	RDHT10T3M0T-8-M11 MP2050	1,6 *0.065*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	0,36 *0.014*
M4	RDHT10T3M0T-8-M11 MP2050	1,2 *0.048*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,32 *0.013*
M5	RDHT10T3M0T-8-M11 MP2050	1,2 *0.048*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,32 *0.013*
K1	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,19 *0.0075*	0,19 *0.0075*	0,20 *0.0080*	0,26 *0.010*
K2	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K3	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K4	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K5	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
K6	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*	0,24 *0.0095*
K7	RDKW10T3M0T-8-MD06 MK2050	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,16 *0.0065*	0,22 *0.0085*
N1	RDHT10T3M0-8-E04 H25	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
N2	RDHT10T3M0-8-E04 H25	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
N3	RDHT10T3M0-8-E04 H25	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
N11	RDHT10T3M0-8-E04 H25	2,0 *0.080*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*	0,22 *0.0085*
S1	RDKT10T3M0T-8-M07 MS2500	1,2 *0.048*	0,18 *0.0070*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
S2	RDKT10T3M0T-8-M07 MS2500	1,2 *0.048*	0,18 *0.0070*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
S3	RDKT10T3M0T-6-M05 MS2500	1,2 *0.048*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
S11	RDHT10T3M0T-8-M11 MS2050	1,4 *0.055*	0,30 *0.012*	0,30 *0.012*	0,30 *0.012*	0,36 *0.014*
S12	RDHT10T3M0T-8-M11 MS2050	1,4 *0.055*	0,30 *0.012*	0,30 *0.012*	0,30 *0.012*	0,36 *0.014*
S13	RDHT10T3M0T-8-M11 MS2050	1,2 *0.048*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,32 *0.013*
H5	RDHW10T3M0T-8-MD06 MH1000	1,6 *0.065*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*
H8	RDHW10T3M0T-8-MD06 MH1000	1,4 *0.055*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*
H11	RDHW10T3M0T-8-MD06 MH1000	1,6 *0.065*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*
H12	RDHW10T3M0T-8-MD06 MH1000	1,4 *0.055*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*
H21	RDHW10T3M0T-8-MD06 MH1000	1,4 *0.055*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*	0,13 *0.0050*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

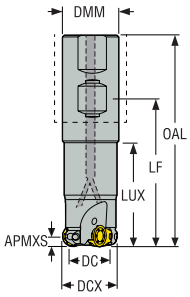
R217/220.29-05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501				MP2050				MP2501				T350M				F40M				MK2050			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	355	405	490	570	360	410	495	580	330	375	455	530	320	365	440	510	280	320	380	445	310	355	425	500
	1175	*1325*	*1600*	*1875*	*1175*	*1350*	*1625*	*1900*	*1075*	*1225*	*1500*	*1750*	*1050*	*1200*	*1450*	*1675*	*920*	*1050*	*1250*	*1450*	*1025*	*1175*	*1400*	*1650*
P2	350	395	470	560	355	400	480	560	320	365	430	510	315	355	430	500	270	310	370	435	305	345	410	485
	1150	*1300*	*1550*	*1825*	*1175*	*1300*	*1575*	*1825*	*1050*	*1200*	*1400*	*1675*	*1025*	*1175*	*1400*	*1650*	*890*	*1025*	*1225*	*1425*	*1000*	*1125*	*1350*	*1600*
P3	305	345	410	485	310	350	415	495	275	315	380	445	275	310	370	440	240	270	320	380	265	300	360	425
	1000	*1125*	*1350*	*1600*	*1025*	*1150*	*1350*	*1625*	*900*	*1025*	*1250*	*1450*	*900*	*1025*	*1225*	*1450*	*790*	*890*	*1050*	*1250*	*870*	*980*	*1175*	*1400*
P4	265	305	365	425	270	310	370	435	250	285	335	400	240	275	330	385	210	240	285	335	235	265	320	370
	870	*1000*	*1200*	*1400*	*890*	*1025*	*1225*	*1425*	*820*	*940*	*1100*	*1300*	*790*	*900*	*1075*	*1275*	*690*	*790*	*940*	*1100*	*770*	*870*	*1050*	*1225*
P5	260	295	350	410	260	295	355	415	240	270	325	380	230	260	315	370	200	225	275	320	225	255	305	360
	850	*970*	*1150*	*1350*	*850*	*970*	*1175*	*1350*	*790*	*890*	*1075*	*1250*	*750*	*850*	*1025*	*1225*	*660*	*740*	*900*	*1050*	*740*	*840*	*1000*	*1175*
P6	290	330	390	460	295	335	395	465	265	305	365	425	260	300	350	415	230	260	305	360	255	290	340	405
	950	*1075*	*1275*	*1500*	*970*	*1100*	*1300*	*1525*	*870*	*1000*	*1200*	*1400*	*850*	*980*	*1150*	*1350*	*750*	*850*	*1000*	*1175*	*840*	*950*	*1125*	*1325*
P7	275	310	370	435	280	315	375	440	250	285	345	405	245	280	335	390	215	245	290	340	240	270	325	380
	900	*1025*	*1225*	*1425*	*920*	*1025*	*1225*	*1450*	*820*	*940*	*1125*	*1325*	*800*	*920*	*1100*	*1275*	*710*	*800*	*950*	*1125*	*790*	*890*	*1075*	*1250*
P8	255	290	345	405	260	295	350	415	230	265	320	375	230	260	310	370	200	225	270	320	220	255	300	355
	840	*950*	*1125*	*1325*	*850*	*970*	*1150*	*1350*	*750*	*870*	*1050*	*1225*	*750*	*850*	*1025*	*1225*	*660*	*740*	*890*	*1050*	*720*	*840*	*980*	*1175*
P11	265	305	360	425	270	310	365	430	245	280	335	390	240	275	325	380	210	240	280	330	230	265	315	370
	870	*1000*	*1175*	*1400*	*890*	*1025*	*1200*	*1400*	*800*	*920*	*1100*	*1275*	*790*	*900*	*1075*	*1250*	*690*	*790*	*920*	*1075*	*750*	*870*	*1025*	*1225*
P12	170	195	230	270	170	195	230	270	160	180	215	250	150	175	205	240	130	150	180	210	150	170	200	235
	560	*640*	*750*	*890*	*560*	*640*	*750*	*890*	*520*	*590*	*710*	*820*	*490*	*570*	*670*	*790*	*425*	*490*	*590*	*690*	*490*	*560*	*660*	*770*
M1	—	—	—	—	255	290	345	405	230	265	310	365	240	275	330	385	220	250	300	350	—	—	—	—
	—	—	—	—	*840*	*950*	*1125*	*1325*	*750*	*870*	*1025*	*1200*	*790*	*900*	*1075*	*1275*	*720*	*820*	*980*	*1150*	—	—	—	—
M2	—	—	—	—	205	235	285	335	190	220	265	305	200	225	270	320	180	205	245	290	—	—	—	—
	—	—	—	—	*670*	*770*	*940*	*1100*	*620*	*720*	*870*	*1000*	*660*	*740*	*890*	*1050*	*590*	*670*	*800*	*950*	—	—	—	—
M3	—	—	—	—	165	190	225	265	155	175	205	245	160	180	215	255	145	165	195	230	—	—	—	—
	—	—	—	—	*540*	*620*	*740*	*870*	*510*	*570*	*670*	*800*	*520*	*590*	*710*	*840*	*475*	*540*	*640*	*750*	—	—	—	—
M4	—	—	—	—	130	145	175	205	120	135	160	190	125	140	165	195	110	125	150	175	—	—	—	—
	—	—	—	—	*425*	*475*	*570*	*670*	*395*	*445*	*520*	*620*	*410*	*460*	*540*	*640*	*360*	*410*	*490*	*570*	—	—	—	—
M5	—	—	—	—	105	120	145	170	100	110	135	155	100	115	135	160	95	105	125	145	—	—	—	—
	—	—	—	—	*345*	*395*	*475*	*560*	*330*	*360*	*445*	*510*	*330*	*375*	*445*	*520*	*310*	*345*	*410*	*475*	—	—	—	—
K1	275	315	375	440	280	320	380	445	255	290	340	405	250	280	340	395	215	245	295	345	325	370	445	530
	900	*1025*	*1225*	*1450*	*920*	*1050*	*1250*	*1450*	*840*	*950*	*1125*	*1325*	*820*	*920*	*1125*	*1300*	*710*	*800*	*970*	*1125*	*1075*	*1225*	*1450*	*1750*
K2	245	280	330	390	245	280	335	395	225	255	310	360	220	250	300	350	190	215	260	305	290	330	395	465
	800	*920*	*1075*	*1275*	*800*	*920*	*1100*	*1300*	*740*	*840*	*1025*	*1175*	*720*	*820*	*980*	*1150*	*620*	*710*	*850*	*1000*	*950*	*1075*	*1300*	*1525*
K3	210	235	280	330	210	235	285	335	190	215	260	305	185	210	250	295	160	185	220	260	245	280	335	390
	690	*770*	*920*	*1075*	*690*	*770*	*940*	*1100*	*620*	*710*	*850*	*1000*	*610*	*690*	*820*	*970*	*520*	*610*	*720*	*850*	*800*	*920*	*1100*	*1275*
K4	200	225	270	315	200	225	270	320	180	205	250	290	175	200	240	285	155	175	210	245	235	270	320	375
	660	*740*	*890*	*1025*	*660*	*740*	*890*	*1050*	*590*	*670*	*820*	*950*	*570*	*660*	*790*	*940*	*510*	*570*	*690*	*800*	*770*	*890*	*1050*	*1225*
K5	120	135	165	190	120	140	165	195	110	125	150	180	110	125	150	170	95	105	130	150	140	160	195	225
	395	*445*	*540*	*620*	*395*	*460*	*540*	*640*	*360*	*410*	*490*	*590*	*360*	*410*	*490*	*560*	*310*	*345*	*425*	*490*	*460*	*520*	*640*	*740*
K6	175	200	235	280	175	200	240	280	160	185	220	255	155	175	210	250	135	155	185	215	205	235	280	330
	570	*660*	*770*	*920*	*570*	*660*	*790*	*920*	*520*	*610*	*720*	*840*	*510*	*570*	*690*	*820*	*445*	*510*	*610*	*710*	*670*	*770*	*920*	*1075*
K7	155	175	210	245	155	180	215	250	145	160	195	230	140	160	190	220	120	135	165	190	180	205	250	290
	510	*570*	*690*	*800*	*510*	*590*	*710*	*820*	*475*	*520*	*640*	*750*	*460*	*520*	*620*	*720*	*395*	*445*	*540*	*620*	*590*	*670*	*820*	*950*
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1625	1825	2225	2575	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*5325*	*6000*	*7300*	*8450*	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	650	740	900	1050	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*2125*	*2425*	*2950*	*3450*	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	435	495	600	700	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1425*	*1625*	*1975*	*2300*	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	495	570	680	790	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1625*	*1875*	*2225*	*2600*	—	—	—	—
S1	—	—	—	—	65	70	85	100	60	65	80	90	55	65	75	90	50	60	70	85	—	—	—	—
	—	—	—	—	*215*	*230*	*280*	*330*	*195*	*215*	*260*	*295*	*180*	*215*	*245*	*295*	*165*	*195*	*230*	*280*	—	—	—	—
S2	—	—	—	—	50	55	70	80	47	55	65	75	46	50	60	75	42	47	55	65	—	—	—	—
	—	—	—	—	*165*	*180*	*230*	*260*	*155*	*180*	*215*	*245*	*150*	*165*	*195*	*245*	*140*	*155*	*180*	*215*	—	—	—	—
S3	—	—	—	—	44	50	60	70	41	46	55	65	40	46	55	65	37	42	49	60	—	—	—	—
	—	—	—	—	*145*	*165*	*195*	*230*	*135*	*150*	*180*	*215*	*130*	*150*	*180*	*215*	*120*	*140*	*160*	*195*	—	—	—	—
S11	—	—	—	—	90	100	120	140	80	90	110	130	80	90	110	130	75	85	100	115	—	—	—	—
	—	—	—	—	*295*	*330*	*395*	*460*	*260*	*295*	*360*	*425*	*260*	*295*	*360*	*425*	*245*	*280*	*330*	*375*	—	—	—	—
S12	—	—	—	—	60	70	80	95	55	65	75	90	55	65	75	90	50	55	70	80	—	—	—	—
	—	—	—	—	*195*	*230*	*260*	*310*	*180*	*215*	*245*	*295*	*180*	*215*	*245*	*295*	*165*	*180*	*230*	*260*	—	—	—	—
S13	—	—	—	—	35	40	47	55	33	37	44	50	32	36	43	50	29	33	39	46	—	—	—	—
	—	—	—	—	*115*	*130*	*155*	*180*	*110*	*120*	*145*	*165*	*105*	*120*	*140*	*165*	*95*	*110*	*130*	*150*	—	—	—	—
H5	55	65	75	90	50	60	70	80	48	55	65	75	50	60	70	80	44	50	60	70	—	—	—	—
	180	*215*	*245*	*295*	*165*	*195*	*230*	*260*	*155*	*180*	*215*	*245*	*165*	*195*	*230*	*260*	*145*	*165*	*195*	*230*	—	—	—	—
H8	60	65	80	95	55	60	70	85	50	55	70	80	55	60	70	85	46	50	60	75	—	—	—	—
	195	*215*	*260*	*310*	*180*	*195*	*230*	*280*	*165*	*180*	*230*	*260*	*180*	*195*	*230*	*280*	*150*	*165*	*195*	*245*	—	—	—	—
H11	70	80	95	115	65	75	90	105	60	70	80	95	65	75	85	100	55	65	75	90	—	—	—	—
	230	*260*	*310*	*375*	*215*	*245*	*295*	*345*	*195*	*230*	*260*	*310*	*215*	*245*	*280*	*330*	*180*	*215*	*245*	*295*	—	—	—	—
H12	105	120	145	170	105	120	145	170	100	110	135	155	95	110	130	150	85	95	110	130	—	—	—	—
	345	*395*	*475*	*560*	*345*	*395*	*475*	*560*	*330*	*360*	*445*	*510*	*310*	*360*	*425*	*490*	*280*	*310*	*360*	*425*	—	—	—	—
H21	60	65	80	95	55	60	70	85	50	55	70	80	55	60	70	85	46	50	60	75	—	—	—	—
	195	*215*	*260*	*310*	*180*	*195*	*230*	*280*	*165*	*180*	*230*	*260*	*180*	*195*	*230*	*280*	*150*	*165*	*195*	*245*	—	—	—	—

R217/220.29-05 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MM4500				MS2050				MS2500				MH1000				H25			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	200	230	280	325	310	350	420	490	405	460	550	640	—	—	—	—	—	—	—	—
	660	*750*	*920*	*1075*	*1025*	*1150*	*1375*	*1600*	*1325*	*1500*	*1800*	*2100*	—	—	—	—	—	—	—	—
P2	195	225	265	315	300	340	410	480	390	445	540	630	—	—	—	—	—	—	—	—
	640	*740*	*870*	*1025*	*980*	*1125*	*1350*	*1575*	*1275*	*1450*	*1775*	*2075*	—	—	—	—	—	—	—	—
P3	170	195	235	275	260	300	350	420	340	390	460	550	—	—	—	—	—	—	—	—
	560	*640*	*770*	*900*	*850*	*980*	*1150*	*1375*	*1125*	*1275*	*1500*	*1800*	—	—	—	—	—	—	—	—
P4	155	175	205	245	230	260	315	370	300	345	410	485	—	—	—	—	—	—	—	—
	510	*570*	*670*	*800*	*750*	*850*	*1025*	*1225*	*980*	*1125*	*1350*	*1600*	—	—	—	—	—	—	—	—
P5	145	165	200	235	220	250	300	355	290	330	395	460	—	—	—	—	—	—	—	—
	475	*540*	*660*	*770*	*720*	*820*	*980*	*1175*	*950*	*1075*	*1300*	*1500*	—	—	—	—	—	—	—	—
P6	165	185	225	260	250	285	335	395	330	375	440	520	—	—	—	—	—	—	—	—
	540	*610*	*740*	*850*	*820*	*940*	*1100*	*1300*	*1075*	*1225*	*1450*	*1700*	—	—	—	—	—	—	—	—
P7	155	175	210	245	235	270	320	375	310	355	415	490	—	—	—	—	—	—	—	—
	510	*570*	*690*	*800*	*770*	*890*	*1050*	*1225*	*1025*	*1175*	*1350*	*1600*	—	—	—	—	—	—	—	—
P8	145	160	195	230	220	250	295	355	290	330	390	460	—	—	—	—	—	—	—	—
	475	*520*	*640*	*750*	*720*	*820*	*970*	*1175*	*950*	*1075*	*1275*	*1500*	—	—	—	—	—	—	—	—
P11	150	170	205	240	230	260	310	365	300	345	405	475	—	—	—	—	—	—	—	—
	490	*560*	*670*	*790*	*750*	*850*	*1025*	*1200*	*980*	*1125*	*1325*	*1550*	—	—	—	—	—	—	—	—
P12	95	110	130	155	145	165	195	230	190	215	260	300	—	—	—	—	—	—	—	—
	310	*360*	*425*	*510*	*475*	*540*	*640*	*750*	*620*	*710*	*850*	*980*	—	—	—	—	—	—	—	—
M1	170	190	225	270	240	275	330	385	280	320	385	450	—	—	—	—	—	—	—	—
	560	*620*	*740*	*890*	*790*	*900*	*1075*	*1275*	*920*	*1050*	*1275*	*1475*	—	—	—	—	—	—	—	—
M2	140	160	190	225	200	225	270	320	230	260	315	370	—	—	—	—	—	—	—	—
	460	*520*	*620*	*740*	*660*	*740*	*890*	*1050*	*750*	*850*	*1025*	*1225*	—	—	—	—	—	—	—	—
M3	110	125	150	180	160	180	215	255	185	210	250	295	—	—	—	—	—	—	—	—
	360	*410*	*490*	*590*	*520*	*590*	*710*	*840*	*610*	*690*	*820*	*970*	—	—	—	—	—	—	—	—
M4	85	100	115	140	125	140	165	195	145	160	190	225	—	—	—	—	—	—	—	—
	280	*330*	*375*	*460*	*410*	*460*	*540*	*640*	*475*	*520*	*620*	*740*	—	—	—	—	—	—	—	—
M5	70	80	100	115	100	115	135	160	120	135	160	190	—	—	—	—	—	—	—	—
	230	*260*	*330*	*375*	*330*	*375*	*445*	*520*	*395*	*445*	*520*	*620*	—	—	—	—	—	—	—	—
K1	—	—	—	—	—	—	—	—	—	—	—	—	270	305	365	430	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*890*	*1000*	*1200*	*1400*	—	—	—	—
K2	—	—	—	—	—	—	—	—	—	—	—	—	240	270	320	380	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*790*	*890*	*1050*	*1250*	—	—	—	—
K3	—	—	—	—	—	—	—	—	—	—	—	—	200	230	275	320	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*660*	*750*	*900*	*1050*	—	—	—	—
K4	—	—	—	—	—	—	—	—	—	—	—	—	195	220	260	305	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*640*	*720*	*850*	*1000*	—	—	—	—
K5	—	—	—	—	—	—	—	—	—	—	—	—	115	130	160	185	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*375*	*425*	*520*	*610*	—	—	—	—
K6	—	—	—	—	—	—	—	—	—	—	—	—	170	195	230	270	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*560*	*640*	*750*	*890*	—	—	—	—
K7	—	—	—	—	—	—	—	—	—	—	—	—	150	170	205	240	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*490*	*560*	*670*	*790*	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1675	1900	2250	2650
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*5500*	*6225*	*7375*	*8700*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	670	760	910	1075
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*2200*	*2500*	*2975*	*3525*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	450	510	600	720
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1475*	*1675*	*1975*	*2350*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	510	580	690	820
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1675*	*1900*	*2275*	*2700*
S1	27	30	36	42	55	65	75	90	70	80	95	110	—	—	—	—	—	—	—	—
	90	*100*	*120*	*140*	*180*	*215*	*245*	*295*	*230*	*260*	*310*	*360*	—	—	—	—	—	—	—	—
S2	21	24	29	34	46	50	60	75	55	65	75	90	—	—	—	—	—	—	—	—
	70	*80*	*95*	*110*	*150*	*165*	*195*	*245*	*180*	*215*	*245*	*295*	—	—	—	—	—	—	—	—
S3	19	21	25	30	40	46	55	65	49	55	65	80	—	—	—	—	—	—	—	—
	60	*70*	*80*	*100*	*130*	*150*	*180*	*215*	*160*	*180*	*215*	*260*	—	—	—	—	—	—	—	—
S11	37	42	50	60	80	90	110	130	100	110	130	155	—	—	—	—	—	—	—	—
	120	*140*	*165*	*195*	*260*	*295*	*360*	*425*	*330*	*360*	*425*	*510*	—	—	—	—	—	—	—	—
S12	34	39	46	55	55	65	75	90	70	75	90	110	—	—	—	—	—	—	—	—
	110	*130*	*150*	*180*	*180*	*215*	*245*	*295*	*230*	*245*	*295*	*360*	—	—	—	—	—	—	—	—
S13	20	23	27	32	32	36	43	50	39	44	55	60	—	—	—	—	—	—	—	—
	65	*75*	*90*	*105*	*105*	*120*	*140*	*165*	*130*	*145*	*180*	*195*	—	—	—	—	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	55	65	75	90	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*180*	*215*	*245*	*295*	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	60	65	75	90	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*195*	*215*	*245*	*295*	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	70	80	95	110	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*230*	*260*	*310*	*360*	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	105	120	140	165	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*345*	*395*	*460*	*540*	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	60	65	75	90	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*195*	*215*	*245*	*295*	—	—	—	—

R217.29I-06 – Metric



- For insert selection and cutting data recommendations, see page(s) 575-577
- For complete insert programme, see page(s) 749
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.29I-2525.3-06.2.050A	02949613	Weldon	13,0	25,0	2	6,0	25,0	46,0	106,0	21,6	13,0	38,0	48,0	17700	0,4	RP..1204
R217.29I-3232.3-06.3.060A	02949614	Weldon	20,0	32,0	3	6,0	32,0	60,0	120,0	26,6	7,0	52,0	62,0	15600	0,7	RP..1204
R217.29I-3240.3-06-055.4A	03024047	Weldon	28,0	40,0	4	6,0	32,0	60,0	115,0	55,0	8,0	68,0	78,0	14000	0,6	RP..1204
R217.29I-3240.3-06.4.075A	02949615	Weldon	28,0	40,0	4	6,0	32,0	60,0	135,0	72,0	8,0	68,0	78,0	14000	0,8	RP..1204

Centre coolant hole possibility by removning centre screw

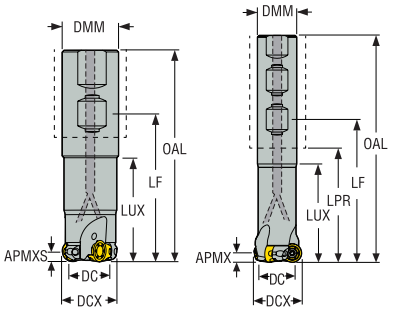
Spare Parts

Accessories

For cutter	Centre screw	Insert screw	Key	Screw	Torque key	Torque value
R217.29I-.. Ø25	–	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R217.29I-.. Ø32-40	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R217.29I-.. Ø32-40-4A	SH3040	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.29I-06 – Inch



- For insert selection and cutting data recommendations, see page(s) 575-577
- For complete insert programme, see page(s) 749
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	LPR	OAL	LUX	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.29I-01.00-0-06.2A	02949638	Cylindrical	0.528	1.000	2	0.236	1.000	4.008	4.295	6.500	2.480	12,0	1.528	1.921	17700	1.320	RP..1204
R217.29I-01.00-3F-06.2A	02949640	3 Flat Weldon	0.528	1.000	2	0.236	1.000	3.280	2.500	5.780	2.500	12,0	1.528	1.921	17700	1.100	RP..1204

Centre coolant hole possibility by removning centre screw

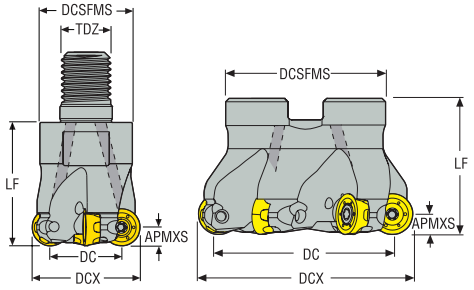
Spare Parts

Accessories

For cutter	Insert screw	Key	Screw	Torque key	Torque value
R217.29I-..	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.29I-06 – Metric

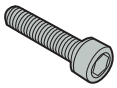


- For insert selection and cutting data recommendations, see page(s) 575-577
- For complete insert programme, see page(s) 749
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.29I-1225.RE-06.2A	02949605	Combimaster	13,0	25,0	2	6,0	–	M12	23,0	35,0	13,0	38,0	48,0	17700	1,0	RP..1204
R217.29I-1232.RE-06.3A	02949606	Combimaster	20,0	32,0	3	6,0	–	M12	23,0	40,0	7,0	52,0	62,0	15600	0,2	RP..1204
R217.29I-1632.RE-06.3A	02949607	Combimaster	20,0	32,0	3	6,0	–	M16	30,0	40,0	7,0	52,0	62,0	15600	0,2	RP..1204
R217.29I-1635.RE-06.3A	02949608	Combimaster	23,0	35,0	3	6,0	–	M16	30,0	40,0	10,0	58,0	68,0	15000	0,2	RP..1204
R217.29I-1635.RE-06.4A	02949609	Combimaster	23,0	35,0	4	6,0	–	M16	30,0	40,0	6,0	58,0	68,0	15000	0,2	RP..1204
R217.29I-1640.RE-06.3A	02949610	Combimaster	28,0	40,0	3	6,0	–	M16	30,0	40,0	8,0	68,0	78,0	14000	0,2	RP..1204
R217.29I-1640.RE-06.4A	02949611	Combimaster	28,0	40,0	4	6,0	–	M16	30,0	40,0	8,0	68,0	78,0	14000	0,2	RP..1204
R217.29I-2040.RE06.4A	02928079	Combimaster	28,0	40,0	4	6,0	–	M20	36,5	45,0	8,0	68,0	78,0	14000	0,4	RP..1204
R217.29I-1642.RE-06.5A	02949612	Combimaster	30,0	42,0	5	6,0	–	M16	30,0	40,0	4,0	72,0	82,0	13600	0,3	RP..1204
R217.29I-2042.RE-06.5A	02991174	Combimaster	30,0	42,0	5	6,0	–	M20	36,5	45,0	4,2	72,0	82,0	13600	0,4	RP..1204
R220.29I-0040-06.4A	02949616	Arbor	28,0	40,0	4	6,0	16,0	–	35,0	40,0	8,0	68,0	78,0	14000	0,2	RP..1204
R220.29I-0044-06.4A	03002205	Arbor	32,0	44,0	4	6,0	16,0	–	35,0	40,0	7,9	76,0	86,0	13300	0,2	RP..1204
R220.29I-0050-06.4A	02949617	Arbor	38,0	50,0	4	6,0	22,0	–	42,0	40,0	5,5	88,0	98,0	12500	0,3	RP..1204
R220.29I-0050-06.5A	02949618	Arbor	38,0	50,0	5	6,0	22,0	–	42,0	40,0	5,5	88,0	98,0	12500	0,3	RP..1204
R220.29I-0050-06.6A	03203202	Arbor	38,0	50,0	6	6,0	22,0	–	42,0	40,0	5,0	88,0	98,0	12500	0,3	RP..1204
R220.29I-0052-06.4A	02949619	Arbor	40,0	52,0	4	6,0	22,0	–	42,0	40,0	5,0	92,0	102,0	12300	0,3	RP..1204
R220.29I-0052-06.5A	02949620	Arbor	40,0	52,0	5	6,0	22,0	–	42,0	40,0	5,0	92,0	102,0	12300	0,3	RP..1204
R220.29I-0063-06.5A	02949621	Arbor	51,0	63,0	5	6,0	22,0	–	47,0	40,0	4,0	114,0	124,0	11200	0,4	RP..1204
R220.29I-0063-06.6A	02949622	Arbor	51,0	63,0	6	6,0	22,0	–	47,0	40,0	4,0	114,0	124,0	11200	0,5	RP..1204
R220.29I-0063-06.7A	02949623	Arbor	51,0	63,0	7	6,0	22,0	–	47,0	40,0	3,0	114,0	124,0	11200	0,5	RP..1204
R220.29I-0066-06.6A	02949624	Arbor	54,0	66,0	6	6,0	27,0	–	50,0	50,0	3,5	120,0	130,0	10900	0,6	RP..1204
R220.29I-0080-06.6A	02949625	Arbor	68,0	80,0	6	6,0	27,0	–	62,0	50,0	3,0	148,0	158,0	10000	1,0	RP..1204
R220.29I-0080-06.7A	02949626	Arbor	68,0	80,0	7	6,0	27,0	–	62,0	50,0	3,0	148,0	158,0	10000	1,0	RP..1204
R220.29I-0080-06.8A	02949627	Arbor	68,0	80,0	8	6,0	27,0	–	62,0	50,0	2,0	148,0	158,0	10000	1,0	RP..1204
R220.29I-0084-06.6A	02969096	Arbor	72,0	84,0	6	6,0	32,0	–	77,0	50,0	2,5	156,0	166,0	9500	1,2	RP..1204
R220.29I-0092-06.7A	02949628	Arbor	80,0	92,0	7	6,0	32,0	–	77,0	50,0	2,5	172,0	182,0	9200	1,4	RP..1204
R220.29I-0100-06.9A	02949629	Arbor	88,0	100,0	9	6,0	32,0	–	77,0	50,0	2,0	188,0	198,0	8800	1,6	RP..1204
R220.29I-0112-06.7A	02949630	Arbor	100,0	112,0	7	6,0	32,0	–	77,0	63,0	1,5	212,0	222,0	8400	1,8	RP..1204
R220.29I-0125-06.11A	02949631	Arbor	113,0	125,0	11	6,0	40,0	–	90,0	63,0	1,5	238,0	248,0	8000	3,1	RP..1204
R220.29I-0137-06.8A	02949632	Arbor	125,0	137,0	8	6,0	40,0	–	90,0	63,0	1,5	262,0	272,0	7600	3,3	RP..1204

Spare Parts

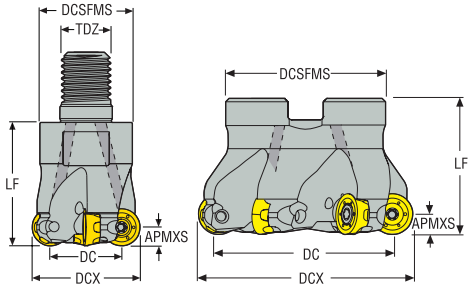
Accessories

For cutter	Arbor screw	Insert screw	Key	Screw	Torque key	Torque value
						
R217.29I-25/35-4A/42	–	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R217.29I-32/35-3A/40	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø40-44	220.17-689	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø50-52	220.17-692	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø50-6A	220.17-692	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø63	220.17-692	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø66-80	MC6S12X35	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø84-112	950E1645	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29I-.. Ø125-137	MC6S20X50	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R220.29I-06 – Inch



- For insert selection and cutting data recommendations, see page(s) 575-577
- For complete insert programme, see page(s) 749
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch		Inch	Inch		Inch	Inch		lbs	
R217.29I-01.00-12RE-06.2A	02949633	Combimaster	0.528	1.000	2	0.236	–	M12	0.906	1.378	12,0	1.528	1.921	17700	0.440	RP..1204
R217.29I-01.25-12RE-06.3A	02949635	Combimaster	0.778	1.250	3	0.236	–	M12	0.906	1.575	7,0	2.028	2.421	15600	0.440	RP..1204
R217.29I-01.25-16RE-06.3A	02949634	Combimaster	0.778	1.250	3	0.236	–	M16	1.181	1.575	7,0	2.028	2.421	15600	0.660	RP..1204
R217.29I-01.50-16RE-06.3A	02949636	Combimaster	1.028	1.500	3	0.236	–	M16	1.181	1.575	8,5	2.528	2.921	14000	0.660	RP..1204
R217.29I-01.50-16RE-06.4A	02949637	Combimaster	1.028	1.500	4	0.236	–	M16	1.181	1.575	8,5	2.528	2.921	14000	0.660	RP..1204
R217.29I-01.50-20RE-06.4A	03002402	Combimaster	1.028	1.500	4	0.236	–	M20	1.437	1.575	8,5	2.528	2.921	14000	0.660	RP..1204
R220.29I-01.50-06.4A	02949641	–	1.028	1.500	4	0.236	0.500	–	1.260	1.500	10,5	2.528	2.921	14000	0.440	RP..1204
R220.29I-02.00-06.4A	02949642	–	1.528	2.000	4	0.236	0.750	–	1.654	1.500	6,5	3.528	3.921	12500	0.660	RP..1204
R220.29I-02.00-06.5A	02949643	–	1.528	2.000	5	0.236	0.750	–	1.654	1.500	6,5	3.528	3.921	12500	0.660	RP..1204
R220.29I-02.00-06.6A	03279243	–	1.535	2.000	6	0.236	0.750	–	1.654	1.500	5,0	3.535	3.921	12500	0.660	RP..1204
R220.29I-02.50-06.6A	02949644	–	2.028	2.500	6	0.236	0.750	–	1.850	1.500	4,6	4.528	4.921	11200	1.100	RP..1204
R220.29I-02.50-06.7A	02949645	–	2.028	2.500	7	0.236	0.750	–	1.850	1.500	4,6	4.528	4.921	11200	1.100	RP..1204
R220.29I-03.00-06.6A	02949647	–	2.528	3.000	6	0.236	1.000	–	2.441	2.000	3,0	5.528	5.921	10000	2.200	RP..1204
R220.29I-03.00-06.7A	02949648	–	2.528	3.000	7	0.236	1.000	–	2.441	2.000	3,0	5.528	5.921	10000	2.200	RP..1204
R220.29I-04.00-06.7A	02949649	–	3.528	4.000	7	0.236	1.500	–	3.543	2.000	2,0	7.528	7.921	8800	4.410	RP..1204
R220.29I-04.00-06.9A	02949650	–	3.528	4.000	9	0.236	1.500	–	3.543	2.000	2,0	7.528	7.921	8800	4.410	RP..1204
R220.29I-06.00-06.8	02949652	–	5.528	6.000	8	0.236	2.000	–	4.331	2.000	1,2	11.528	11.921	7600	8.820	RP..1204

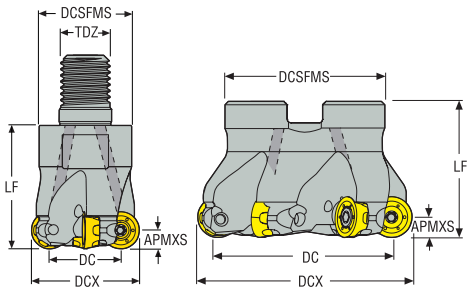
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Key	Screw	Torque key	Torque value
R217.29I-01.00	–	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R217.29I-01.25	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R217.29I-01.50	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R217.29I-01.50-4A	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29I-01.50	UC6S1/4UNFX1	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29I-02.00-02.50	UC6S3/8UNFX1	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29I-02.00-6A	UC6S3/8UNFX1	C03508-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29I-03.00	UC6S1/2UNFX1-1/2	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29I-04.00	ULC6S3/4UNFX11/2	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29I-06.00	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29B-06 – For blade machining – Metric



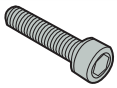
- For insert selection and cutting data recommendations, see page(s) 575-577
- For complete insert programme, see page(s) 749
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.29B-1632.RE-06.3A	03007484	Combimaster	20,0	32,0	3	6,0	–	M16	30,0	40,0	4,5	52,0	62,0	15600	0,2	RP..1204
R220.29B-0040-06.4A	03007485	Arbor	28,0	40,0	4	6,0	16,0	–	35,0	40,0	5,0	68,0	78,0	14000	0,2	RP..1204
R220.29B-0050-06.5A	03007486	Arbor	38,0	50,0	5	6,0	22,0	–	42,0	40,0	5,0	88,0	98,0	12500	0,3	RP..1204
R220.29B-0052-06.5A	03007487	Arbor	38,0	52,0	5	6,0	22,0	–	42,0	40,0	5,0	90,0	102,0	12300	0,3	RP..1204
R220.29B-0063-06.6A	03074236	Arbor	51,0	63,0	6	6,0	22,0	–	47,0	40,0	4,0	114,0	124,0	11200	0,5	RP..1204
R220.29B-0063-06.7A	03074237	Arbor	51,0	63,0	7	6,0	22,0	–	47,0	40,0	4,0	114,0	124,0	11200	0,5	RP..1204

For Combimaster Shanks, see Machining Navigator Tooling System

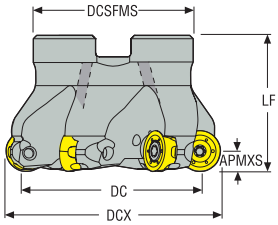
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Key	Screw	Torque key	Torque value
						
R217.29-..	–	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29-0040	220.17-689	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM
R220.29-0050-0063	220.17-692	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29B-06 – For blade machining – Inch



- For insert selection and cutting data recommendations, see page(s) 575-577
- For complete insert programme, see page(s) 749
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R220.29B-02.00-06.5A	03007490	Arbor	1.535	2.000	5	0.236	0.750	1.654	1.500	5,0	3.535	3.921	12500	0.660	RP..1204
R220.29B-02.50-06-6A	03074238	Arbor	2.031	2.500	6	0.236	0.750	1.850	1.500	4,6	4.531	4.921	11200	1.100	RP..1204
R220.29B-02.50-06-7A	03074239	Arbor	2.031	2.500	7	0.236	0.750	1.850	1.500	4,6	4.531	4.921	11200	1.100	RP..1204

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Key	Screw	Torque key	Torque value
R220.29B-02.00	UC6S3/8UNFX1	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS
R220.29B-02.50	UC6S3/8UNFX1-1/4	C03509-T15P	T05P-2	SX2035-T05P	T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-06I – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RPHT1204M0T-6-M08 MP2501	2,5 *0.10*	0,25 *0.010*	0,25 *0.010*	0,24 *0.0095*	0,36 *0.014*
P2	RPHT1204M0T-6-M08 MP2501	2,5 *0.10*	0,25 *0.010*	0,25 *0.010*	0,25 *0.010*	0,38 *0.015*
P3	RPHT1204M0T-6-M08 MP2501	2,5 *0.10*	0,24 *0.0095*	0,24 *0.0095*	0,24 *0.0095*	0,36 *0.014*
P4	RPHT1204M0T-6-M08 MP2501	2,5 *0.10*	0,24 *0.0095*	0,24 *0.0095*	0,24 *0.0095*	0,34 *0.013*
P5	RPKT1204M0T-6-M15 MP2501	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
P6	RPKT1204M0T-6-M15 MP2501	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
P7	RPKT1204M0T-6-M15 MP2501	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
P8	RPHT1204M0T-6-M13 MS2500	2,5 *0.10*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,55 *0.022*
P11	RPHT1204M0T-6-M13 MS2500	2,5 *0.10*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,55 *0.022*
P12	RPHT1204M0T-4-M13 MS2500	1,9 *0.075*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*	0,38 *0.015*
M1	RPHT1204M0T-6-ME07 MS2050	2,5 *0.10*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*	0,32 *0.013*
M2	RPHT1204M0T-6-ME07 MS2050	2,5 *0.10*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,30 *0.012*
M3	RPHT1204M0T-6-ME07 MS2050	1,9 *0.075*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*	0,24 *0.0095*
M4	RPHT1204M0T-6-M08 T350M	1,4 *0.055*	0,22 *0.0085*	0,22 *0.0085*	0,20 *0.0080*	0,24 *0.0095*
M5	RPHT1204M0T-6-M08 T350M	1,4 *0.055*	0,22 *0.0085*	0,22 *0.0085*	0,20 *0.0080*	0,24 *0.0095*
K1	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,46 *0.018*	0,46 *0.018*	0,46 *0.018*	0,70 *0.028*
K2	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
K3	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
K4	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
K5	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,55 *0.022*
K6	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,42 *0.017*	0,42 *0.017*	0,42 *0.017*	0,65 *0.026*
K7	RPKT1204M0T-6-M15 MK2050	2,5 *0.10*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,55 *0.022*
N1	RPHT1204M0-6-E05 H25	2,5 *0.10*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,30 *0.012*
N2	RPHT1204M0-6-E05 H25	2,5 *0.10*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,30 *0.012*
N3	RPHT1204M0-6-E05 H25	2,5 *0.10*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,30 *0.012*
N11	RPHT1204M0-6-E05 H25	2,5 *0.10*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*	0,30 *0.012*
S1	RPHT1204M0T-6-M13 MS2500	1,4 *0.055*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,38 *0.015*
S2	RPHT1204M0T-6-M13 MS2500	1,4 *0.055*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,38 *0.015*
S3	RPHT1204M0T-6-M13 MS2500	1,4 *0.055*	0,32 *0.013*	0,32 *0.013*	0,32 *0.013*	0,36 *0.014*
S11	RPHT1204M0T-6-M13 MS2050	1,7 *0.065*	0,36 *0.014*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*
S12	RPHT1204M0T-6-M13 MS2050	1,7 *0.065*	0,36 *0.014*	0,36 *0.014*	0,34 *0.013*	0,44 *0.017*
S13	RPHT1204M0T-6-M13 MS2050	1,4 *0.055*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,38 *0.015*
H5	RPHW1204M0T-6-MD12 MH1000	1,9 *0.075*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
H8	RPHW1204M0T-6-MD12 MH1000	1,7 *0.065*	0,22 *0.0085*	0,22 *0.0085*	0,20 *0.0080*	0,26 *0.010*
H11	RPHW1204M0T-6-MD12 MH1000	1,9 *0.075*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
H12	RPHT1204M0T-6-M13 T350M	1,7 *0.065*	0,24 *0.0095*	0,24 *0.0095*	0,22 *0.0085*	0,28 *0.011*
H21	RPHW1204M0T-6-MD12 MH1000	1,7 *0.065*	0,22 *0.0085*	0,22 *0.0085*	0,20 *0.0080*	0,26 *0.010*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

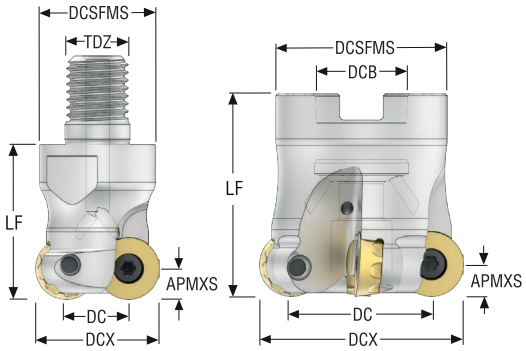
R217/220.29-06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501				MP2050				MP2501				MP3000				T350M			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	310	355	425	500	280	325	390	455	330	380	455	540	315	365	430	510	285	330	400	465
	1025	*1175*	*1400*	*1650*	*920*	*1075*	*1275*	*1500*	*1075*	*1250*	*1500*	*1775*	*1025*	*1200*	*1400*	*1675*	*940*	*1075*	*1300*	*1525*
P2	300	345	415	485	275	315	380	445	320	370	440	510	305	350	415	485	280	320	385	450
	980	*1125*	*1350*	*1600*	*900*	*1025*	*1250*	*1450*	*1050*	*1225*	*1450*	*1675*	*1000*	*1150*	*1350*	*1600*	*920*	*1050*	*1275*	*1475*
P3	260	300	360	425	240	275	330	395	280	320	385	450	265	305	360	425	245	280	335	390
	850	*980*	*1175*	*1400*	*790*	*900*	*1075*	*1300*	*920*	*1050*	*1275*	*1475*	*870*	*1000*	*1175*	*1400*	*800*	*920*	*1100*	*1275*
P4	230	265	320	375	210	240	290	345	245	280	335	400	235	270	325	375	215	245	295	350
	750	*870*	*1050*	*1225*	*690*	*790*	*950*	*1125*	*800*	*920*	*1100*	*1300*	*770*	*890*	*1075*	*1225*	*710*	*800*	*970*	*1150*
P5	225	255	310	360	200	230	285	330	240	275	330	385	225	260	310	365	210	240	285	335
	740	*840*	*1025*	*1175*	*660*	*750*	*940*	*1075*	*790*	*900*	*1075*	*1275*	*740*	*850*	*1025*	*1200*	*690*	*790*	*940*	*1100*
P6	250	285	345	405	230	265	315	370	270	310	370	430	255	295	345	410	235	270	320	375
	820	*940*	*1125*	*1325*	*750*	*870*	*1025*	*1225*	*890*	*1025*	*1225*	*1400*	*840*	*970*	*1125*	*1350*	*770*	*890*	*1050*	*1225*
P7	235	270	325	380	215	250	300	350	255	290	350	405	240	275	325	385	220	255	305	355
	770	*890*	*1075*	*1250*	*710*	*820*	*980*	*1150*	*840*	*950*	*1150*	*1325*	*790*	*900*	*1075*	*1275*	*720*	*840*	*1000*	*1175*
P8	220	250	305	360	200	230	280	330	235	270	320	375	225	255	305	355	205	235	280	330
	720	*820*	*1000*	*1175*	*660*	*750*	*920*	*1075*	*770*	*890*	*1050*	*1225*	*740*	*840*	*1000*	*1175*	*670*	*770*	*920*	*1075*
P11	230	265	315	370	210	240	290	340	245	285	340	395	235	270	320	375	215	245	295	345
	750	*870*	*1025*	*1225*	*690*	*790*	*950*	*1125*	*800*	*940*	*1125*	*1300*	*770*	*890*	*1050*	*1225*	*710*	*800*	*970*	*1125*
P12	150	170	210	245	140	160	190	220	160	180	215	255	150	170	200	235	140	160	190	225
	490	*560*	*690*	*800*	*460*	*520*	*620*	*720*	*520*	*590*	*710*	*840*	*490*	*560*	*660*	*770*	*460*	*520*	*620*	*740*
M1	—	—	—	—	195	225	270	320	230	265	315	370	225	260	310	365	215	245	295	345
	—	—	—	—	*640*	*740*	*890*	*1050*	*750*	*870*	*1025*	*1225*	*740*	*850*	*1025*	*1200*	*710*	*800*	*970*	*1125*
M2	—	—	—	—	160	185	225	265	195	220	265	310	190	220	260	305	180	205	245	285
	—	—	—	—	*520*	*610*	*740*	*870*	*640*	*720*	*870*	*1025*	*620*	*720*	*850*	*1000*	*590*	*670*	*800*	*940*
M3	—	—	—	—	130	150	185	215	155	180	210	250	150	175	205	240	145	165	195	235
	—	—	—	—	*425*	*490*	*610*	*710*	*510*	*590*	*690*	*820*	*490*	*570*	*670*	*790*	*475*	*540*	*640*	*770*
M4	—	—	—	—	105	120	140	165	120	135	165	190	115	135	155	185	110	125	155	180
	—	—	—	—	*345*	*395*	*460*	*540*	*395*	*445*	*540*	*620*	*375*	*445*	*510*	*610*	*360*	*410*	*510*	*590*
M5	—	—	—	—	85	100	115	140	100	115	135	160	95	110	130	155	90	105	125	150
	—	—	—	—	*280*	*330*	*375*	*460*	*330*	*375*	*445*	*520*	*310*	*360*	*425*	*510*	*295*	*345*	*410*	*490*
K1	240	270	330	385	220	250	300	350	255	290	350	405	240	275	330	385	220	255	305	355
	790	*890*	*1075*	*1275*	*720*	*820*	*980*	*1150*	*840*	*950*	*1150*	*1325*	*790*	*900*	*1075*	*1275*	*720*	*840*	*1000*	*1175*
K2	210	245	295	340	190	220	270	315	230	260	310	365	215	250	295	345	200	230	270	315
	690	*800*	*970*	*1125*	*620*	*720*	*890*	*1025*	*750*	*850*	*1025*	*1200*	*710*	*820*	*970*	*1125*	*660*	*750*	*890*	*1025*
K3	180	205	250	290	160	185	225	265	195	220	265	305	180	210	250	295	170	195	230	270
	590	*670*	*820*	*950*	*520*	*610*	*740*	*870*	*640*	*720*	*870*	*1000*	*590*	*690*	*820*	*970*	*560*	*640*	*750*	*890*
K4	170	195	235	275	155	175	215	255	185	210	250	295	175	200	235	280	160	185	220	255
	560	*640*	*770*	*900*	*510*	*570*	*710*	*840*	*610*	*690*	*820*	*970*	*570*	*660*	*770*	*920*	*520*	*610*	*720*	*840*
K5	105	120	145	170	95	110	130	155	110	130	155	180	105	120	145	170	100	110	135	155
	345	*395*	*475*	*560*	*310*	*360*	*425*	*510*	*360*	*425*	*510*	*590*	*345*	*395*	*475*	*560*	*330*	*360*	*445*	*510*
K6	150	175	210	240	135	155	190	225	160	185	220	260	155	175	210	245	140	160	195	225
	490	*570*	*690*	*790*	*445*	*510*	*620*	*740*	*520*	*610*	*720*	*850*	*510*	*570*	*690*	*800*	*460*	*520*	*640*	*740*
K7	135	155	185	220	120	140	170	200	145	165	195	230	135	155	185	215	125	145	170	200
	445	*510*	*610*	*720*	*395*	*460*	*560*	*660*	*475*	*540*	*640*	*750*	*445*	*510*	*610*	*710*	*410*	*475*	*560*	*660*
N1	—	—	—	—	—	—	—	—	—	—	—	—	1800	2075	2475	2900	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*5900*	*6800*	*8125*	*9525*	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	—	—	730	840	1000	1175	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*2400*	*2750*	*3275*	*3850*	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	—	—	485	560	660	780	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*1600*	*1825*	*2175*	*2550*	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	—	—	560	640	760	890	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*1825*	*2100*	*2500*	*2925*	—	—	—	—
S1	—	—	—	—	50	60	70	80	60	65	80	95	55	60	75	85	50	60	70	85
	—	—	—	—	*165*	*195*	*230*	*260*	*195*	*215*	*260*	*310*	*180*	*195*	*245*	*280*	*165*	*195*	*230*	*280*
S2	—	—	—	—	41	46	55	65	46	55	65	75	44	50	60	70	42	47	55	65
	—	—	—	—	*135*	*150*	*180*	*215*	*150*	*180*	*215*	*245*	*145*	*165*	*195*	*230*	*140*	*155*	*180*	*215*
S3	—	—	—	—	36	41	48	55	41	47	55	65	38	44	50	60	37	42	50	60
	—	—	—	—	*120*	*135*	*155*	*180*	*135*	*155*	*180*	*215*	*125*	*145*	*165*	*195*	*120*	*140*	*165*	*195*
S11	—	—	—	—	70	80	95	115	80	95	110	130	75	85	105	120	75	85	100	120
	—	—	—	—	*230*	*260*	*310*	*375*	*260*	*310*	*360*	*425*	*245*	*280*	*345*	*395*	*245*	*280*	*330*	*395*
S12	—	—	—	—	49	55	65	80	55	65	75	90	55	60	70	85	50	60	70	80
	—	—	—	—	*160*	*180*	*215*	*260*	*180*	*215*	*245*	*295*	*180*	*195*	*230*	*280*	*165*	*195*	*230*	*260*
S13	—	—	—	—	28	32	39	46	32	37	45	50	31	35	41	48	29	33	40	47
	—	—	—	—	*90*	*105*	*130*	*150*	*105*	*120*	*150*	*165*	*100*	*115*	*135*	*155*	*95*	*110*	*130*	*155*
H5	50	55	70	80	42	48	55	65	48	55	65	80	46	55	65	75	46	50	65	75
	165	*180*	*230*	*260*	*140*	*155*	*180*	*215*	*155*	*180*	*215*	*260*	*150*	*180*	*215*	*245*	*150*	*165*	*215*	*245*
H8	55	60	75	90	44	50	60	70	50	60	70	80	49	55	65	75	49	55	65	80
	180	*195*	*245*	*295*	*145*	*165*	*195*	*230*	*165*	*195*	*230*	*260*	*160*	*180*	*215*	*245*	*160*	*180*	*215*	*260*
H11	65	75	90	105	55	60	70	85	60	70	85	100	60	70	80	95	60	65	80	95
	215	*245*	*295*	*345*	*180*	*195*	*230*	*280*	*195*	*230*	*280*	*330*	*195*	*230*	*260*	*310*	*195*	*215*	*260*	*310*
H12	100	110	135	160	90	100	120	140	100	115	135	160	95	105	125	145	90	100	120	140
	330	*360*	*445*	*520*	*295*	*330*	*395*	*460*	*330*	*375*	*445*	*520*	*310*	*345*	*410*	*475*	*295*	*330*	*395*	*460*
H21	55	60	75	90	44	50	60	70	50	60	70	80	49	55	65	75	49	55	65	80
	180	*195*	*245*	*295*	*145*	*165*	*195*	*230*	*165*	*195*	*230*	*260*	*160*	*180*	*215*	*245*	*160*	*180*	*215*	*260*

R217/220.29-06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				MK2050				MS2050				MS2500				H25			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	250	285	345	405	270	310	370	435	240	275	330	390	360	415	500	580	—	—	—	—
	820	*940*	*1125*	*1325*	*890*	*1025*	*1225*	*1425*	*790*	*900*	*1075*	*1275*	*1175*	*1350*	*1650*	*1900*	—	—	—	—
P2	245	280	335	390	260	300	360	425	235	265	320	380	350	400	480	560	—	—	—	—
	800	*920*	*1100*	*1275*	*850*	*980*	*1175*	*1400*	*770*	*870*	*1050*	*1250*	*1150*	*1300*	*1575*	*1825*	—	—	—	—
P3	210	245	290	340	230	260	315	370	205	235	280	335	305	350	420	490	—	—	—	—
	690	*800*	*950*	*1125*	*750*	*850*	*1025*	*1225*	*670*	*770*	*920*	*1100*	*1000*	*1150*	*1375*	*1600*	—	—	—	—
P4	185	215	255	305	200	230	280	330	180	205	245	295	270	310	370	435	—	—	—	—
	610	*710*	*840*	*1000*	*660*	*750*	*920*	*1075*	*590*	*670*	*800*	*970*	*890*	*1025*	*1225*	*1425*	—	—	—	—
P5	180	210	250	290	195	225	270	315	170	195	240	280	260	300	360	415	—	—	—	—
	590	*690*	*820*	*950*	*640*	*740*	*890*	*1025*	*560*	*640*	*790*	*920*	*850*	*980*	*1175*	*1350*	—	—	—	—
P6	205	235	280	325	220	250	300	350	195	225	270	315	295	340	405	470	—	—	—	—
	670	*770*	*920*	*1075*	*720*	*820*	*980*	*1150*	*640*	*740*	*890*	*1025*	*970*	*1125*	*1325*	*1550*	—	—	—	—
P7	195	220	265	305	205	235	285	330	185	210	255	295	280	320	380	440	—	—	—	—
	640	*720*	*870*	*1000*	*670*	*770*	*940*	*1075*	*610*	*690*	*840*	*970*	*920*	*1050*	*1250*	*1450*	—	—	—	—
P8	180	205	245	285	190	220	265	315	170	195	235	280	255	295	350	410	—	—	—	—
	590	*670*	*800*	*940*	*620*	*720*	*870*	*1025*	*560*	*640*	*770*	*920*	*840*	*970*	*1150*	*1350*	—	—	—	—
P11	185	215	255	300	200	230	275	320	180	205	245	290	270	310	370	430	—	—	—	—
	610	*710*	*840*	*980*	*660*	*750*	*900*	*1050*	*590*	*670*	*800*	*950*	*890*	*1025*	*1225*	*1400*	—	—	—	—
P12	120	135	165	195	130	150	180	215	120	135	160	190	175	200	235	280	—	—	—	—
	395	*445*	*540*	*640*	*425*	*490*	*590*	*710*	*395*	*445*	*520*	*620*	*570*	*660*	*770*	*920*	—	—	—	—
M1	195	225	270	315	—	—	—	—	190	215	260	305	250	290	345	400	—	—	—	—
	640	*740*	*890*	*1025*	—	—	—	—	*620*	*710*	*850*	*1000*	*820*	*950*	*1125*	*1300*	—	—	—	—
M2	165	190	225	260	—	—	—	—	155	175	215	250	210	240	285	335	—	—	—	—
	540	*620*	*740*	*850*	—	—	—	—	*510*	*570*	*710*	*820*	*690*	*790*	*940*	*1100*	—	—	—	—
M3	130	150	175	210	—	—	—	—	125	145	175	205	170	195	225	270	—	—	—	—
	425	*490*	*570*	*690*	—	—	—	—	*410*	*475*	*570*	*670*	*560*	*640*	*740*	*890*	—	—	—	—
M4	100	115	140	160	—	—	—	—	100	110	135	160	130	145	180	205	—	—	—	—
	330	*375*	*460*	*520*	—	—	—	—	*330*	*360*	*445*	*520*	*425*	*475*	*590*	*670*	—	—	—	—
M5	85	95	115	135	—	—	—	—	80	95	110	135	105	120	150	175	—	—	—	—
	280	*310*	*375*	*445*	—	—	—	—	*260*	*310*	*360*	*445*	*345*	*395*	*490*	*570*	—	—	—	—
K1	195	220	265	310	285	325	390	455	—	—	—	—	—	—	—	—	—	—	—	—
	640	*720*	*870*	*1025*	*940*	*1075*	*1275*	*1500*	—	—	—	—	—	—	—	—	—	—	—	—
K2	175	200	235	275	250	290	350	405	—	—	—	—	—	—	—	—	—	—	—	—
	570	*660*	*770*	*900*	*820*	*950*	*1150*	*1325*	—	—	—	—	—	—	—	—	—	—	—	—
K3	145	170	200	235	215	245	295	340	—	—	—	—	—	—	—	—	—	—	—	—
	475	*560*	*660*	*770*	*710*	*800*	*970*	*1125*	—	—	—	—	—	—	—	—	—	—	—	—
K4	140	160	190	220	205	235	280	325	—	—	—	—	—	—	—	—	—	—	—	—
	460	*520*	*620*	*720*	*670*	*770*	*920*	*1075*	—	—	—	—	—	—	—	—	—	—	—	—
K5	85	100	115	135	125	145	170	205	—	—	—	—	—	—	—	—	—	—	—	—
	280	*330*	*375*	*445*	*410*	*475*	*560*	*670*	—	—	—	—	—	—	—	—	—	—	—	—
K6	125	140	170	195	180	205	250	290	—	—	—	—	—	—	—	—	—	—	—	—
	410	*460*	*560*	*640*	*590*	*670*	*820*	*950*	—	—	—	—	—	—	—	—	—	—	—	—
K7	110	125	150	175	160	185	220	260	—	—	—	—	—	—	—	—	—	—	—	—
	360	*410*	*490*	*570*	*520*	*610*	*720*	*850*	—	—	—	—	—	—	—	—	—	—	—	—
N1	1425	1625	1950	2300	—	—	—	—	—	—	—	—	—	—	—	—	1575	1800	2150	2525
	4675	*5325*	*6400*	*7550*	—	—	—	—	—	—	—	—	—	—	—	—	*5175*	*5900*	*7050*	*8275*
N2	570	660	790	930	—	—	—	—	—	—	—	—	—	—	—	—	640	730	870	1025
	1875	*2175*	*2600*	*3050*	—	—	—	—	—	—	—	—	—	—	—	—	*2100*	*2400*	*2850*	*3375*
N3	385	440	530	620	—	—	—	—	—	—	—	—	—	—	—	—	425	490	580	680
	1275	*1450*	*1750*	*2025*	—	—	—	—	—	—	—	—	—	—	—	—	*1400*	*1600*	*1900*	*2225*
N11	435	500	600	710	—	—	—	—	—	—	—	—	—	—	—	—	485	560	660	780
	1425	*1650*	*1975*	*2325*	—	—	—	—	—	—	—	—	—	—	—	—	*1600*	*1825*	*2175*	*2550*
S1	47	55	65	75	—	—	—	—	46	50	65	75	65	70	85	100	—	—	—	—
	155	*180*	*215*	*245*	—	—	—	—	*150*	*165*	*215*	*245*	*215*	*230*	*280*	*330*	—	—	—	—
S2	38	43	50	60	—	—	—	—	37	42	50	60	50	60	70	80	—	—	—	—
	125	*140*	*165*	*195*	—	—	—	—	*120*	*140*	*165*	*195*	*165*	*195*	*230*	*260*	—	—	—	—
S3	33	38	45	55	—	—	—	—	33	37	44	50	45	50	60	70	—	—	—	—
	110	*125*	*150*	*180*	—	—	—	—	*110*	*120*	*145*	*165*	*150*	*165*	*195*	*230*	—	—	—	—
S11	65	75	90	105	—	—	—	—	65	75	90	105	90	100	120	145	—	—	—	—
	215	*245*	*295*	*345*	—	—	—	—	*215*	*245*	*295*	*345*	*295*	*330*	*395*	*475*	—	—	—	—
S12	46	50	60	75	—	—	—	—	44	50	60	70	60	70	85	100	—	—	—	—
	150	*165*	*195*	*245*	—	—	—	—	*145*	*165*	*195*	*230*	*195*	*230*	*280*	*330*	—	—	—	—
S13	26	30	36	42	—	—	—	—	26	30	35	42	35	40	49	55	—	—	—	—
	85	*100*	*120*	*140*	—	—	—	—	*85*	*100*	*115*	*140*	*115*	*130*	*160*	*180*	—	—	—	—
H5	40	46	55	65	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	130	*150*	*180*	*215*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	43	49	60	70	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	140	*160*	*195*	*230*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	50	60	70	80	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	165	*195*	*230*	*260*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	75	90	105	120	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	245	*295*	*345*	*395*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	43	49	60	70	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	140	*160*	*195*	*230*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

R217/220.29I-08 – Metric



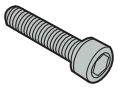
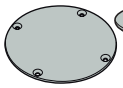
- For insert selection and cutting data recommendations, see page(s) 581-583
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.29I-1632.RE-08.2A	03278975	Combimaster	15,9	32,0	2	8,0	–	M16	30,0	40,0	17,8	47,8	62,0	12200	0,2	RP..1605
R217.29I-1640.RE-08.3A	03278976	Combimaster	24,2	40,0	3	8,0	–	M16	30,0	40,0	2,4	64,4	78,0	10900	0,2	RP..1605
R217.29I-2040.RE-08.3A	03278977	Combimaster	24,2	40,0	3	8,0	–	M20	36,5	40,0	2,4	64,4	78,0	10900	0,3	RP..1605
R220.29I-0050-08.4A	03278978	Arbor	34,2	50,0	4	8,0	22,0	–	41,0	50,0	4,8	84,4	98,0	9700	0,4	RP..1605
R220.29I-0052-08.4A	03278979	Arbor	36,2	52,0	4	8,0	22,0	–	41,0	50,0	5,7	88,4	102,0	9600	0,4	RP..1605
R220.29I-0063-08.4A	03278980	Arbor	47,1	63,0	4	8,0	22,0	–	49,0	50,0	7,5	110,2	124,0	8700	0,6	RP..1605
R220.29I-0063-08.5A	03278981	Arbor	47,1	63,0	5	8,0	22,0	–	49,0	50,0	7,1	110,2	124,0	8700	0,6	RP..1605
R220.29I-0063-08.6A	03278982	Arbor	47,1	63,0	6	8,0	22,0	–	49,0	50,0	7,1	110,2	124,0	8700	0,6	RP..1605
R220.29I-0066-08.5A	03278983	Arbor	50,1	66,0	5	8,0	27,0	–	61,0	50,0	6,9	116,2	130,0	8400	0,7	RP..1605
R220.29I-0066-08.6A	03278984	Arbor	50,0	66,0	6	8,0	27,0	–	61,0	50,0	6,7	116,0	130,0	8400	0,7	RP..1605
R220.29I-0080-08.5A	03278985	Arbor	64,1	80,0	5	8,0	27,0	–	61,0	50,0	5,0	144,2	158,0	7700	1,0	RP..1605
R220.29I-0080-08.7A	03278986	Arbor	64,1	80,0	7	8,0	27,0	–	61,0	50,0	5,0	144,2	158,0	7700	1,0	RP..1605
R220.29I-0084-08.5A	03278987	Arbor	68,1	84,0	5	8,0	32,0	–	79,0	50,0	4,6	152,2	166,0	7500	1,2	RP..1605
R220.29I-0100-08.6MA	03278992	Arbor	84,1	100,0	6	8,0	32,0	–	79,0	50,0	3,8	184,2	198,0	6800	1,6	RP..1605
R220.29I-0100-08.8A	03278988	Arbor	84,1	100,0	8	8,0	32,0	–	79,0	50,0	3,7	184,2	198,0	6800	1,6	RP..1605
R220.29I-0125-08.6MA	03278991	Arbor	109,1	125,0	6	8,0	40,0	–	90,0	63,0	2,8	234,2	248,0	6100	2,9	RP..1605
R220.29I-0125-08.10A	03278989	Arbor	109,1	125,0	10	8,0	40,0	–	90,0	63,0	2,8	234,2	248,0	6100	2,9	RP..1605
R220.29I-8160-08.7MA	03278993	Arbor	143,1	160,0	7	8,0	40,0	–	90,0	63,0	2,2	302,2	318,0	5400	4,2	RP..1605
R220.29I-8160-08.10A	03278990	Arbor	144,1	160,0	10	8,0	40,0	–	90,0	63,0	2,1	304,2	318,0	5400	4,3	RP..1605

For Combimaster Shanks, see Machining Navigator Tooling System

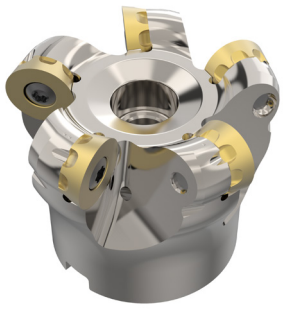
Spare Parts

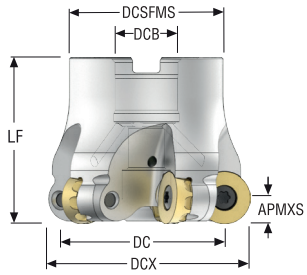
Accessories

For cutter	Arbor screw	Insert screw	Insert shim	Key	Shim screw	Stop screw	Lid	Lid Screw	Torque key	Torque value
										
R217.29I-1632-2040	–	C05010-T20P	–	T05P-2	–	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0050-0052	220.17-692M	C05013-T20P	–	T05P-2	–	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0063-0080	MC6S10X40	C05013-T20P	–	T05P-2	–	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0084	950E1645	C05013-T20P	–	T05P-2	–	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0100MA	950E1645	C05018-T20P	SRP1604IM0	T05P-2	CA5010	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0100	–	C05013-T20P	–	T05P-2	–	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0125MA	MC6S20X50	C05018-T20P	SRP1604IM0	T05P-2	CA5010	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-0125	950E1645	C05013-T20P	–	T05P-2	–	SX2035-T05P	–	–	T00-20P50	5.0NM
R220.29I-8160MA	–	C05018-T20P	SRP1604IM0	T05P-2	CA5010	SX2035-T05P	SC160-53	MF6S4X10	T00-20P50	5.0NM
R220.29I-8160	MC6S20X50	C05013-T20P	–	T05P-2	–	SX2035-T05P	SC160-53	MF6S4X10	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29I-08 – Inch





- For insert selection and cutting data recommendations, see page(s) 581-583
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R220.29I-02.00-08.4A	03278994	Arbor	1.379	2.000	4	0.315	0.750	1.614	2.000	2,7	3.388	3.921	9600	0.880	RP..1605
R220.29I-02.50-08.5A	03278995	Arbor	1.876	2.500	5	0.315	0.750	1.811	2.000	7,0	4.382	4.921	8700	0.220	RP..1605
R220.29I-03.00-08.6A	03278996	Arbor	2.376	3.000	6	0.315	1.000	2.402	2.000	5,3	5.381	5.921	7700	1.980	RP..1605
R220.29I-04.00-08.7A	03278997	Arbor	3.375	4.000	7	0.315	1.500	3.504	2.500	3,6	7.380	7.921	6800	5.070	RP..1605

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Key	Stop screw	Torque key	Torque value
R220.29I-02.00-02.50	UC6S3/8UNFX11/2	C05013-T20P	T05P-2	SX2035-T05P	T00-20P50	44.3IN.LBS
R220.29I-03.00	UC6S1/2UNFX1-1/2	C05013-T20P	T05P-2	SX2035-T05P	T00-20P50	44.3IN.LBS
R220.29I-04.00	UC6S3/4UNFX1-1/4	C05013-T20P	T05P-2	SX2035-T05P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-08I – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RPKT1605M0T-8-M12 MP2501	3,0 *0.12*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,60 *0.024*
P2	RPKT1605M0T-8-M12 MP2501	3,0 *0.12*	0,40 *0.016*	0,40 *0.016*	0,40 *0.016*	0,60 *0.024*
P3	RPKT1605M0T-8-M12 MP2501	3,0 *0.12*	0,38 *0.015*	0,38 *0.015*	0,36 *0.014*	0,55 *0.022*
P4	RPKT1605M0T-8-M12 MP2501	3,0 *0.12*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,55 *0.022*
P5	RPKT1605M0T-8-M12 MP2501	3,0 *0.12*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,55 *0.022*
P6	RPKT1605M0T-8-M18 MS2500	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,80 *0.032*
P7	RPKT1605M0T-6-M18 MS2500	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,80 *0.032*
P8	RPKT1605M0T-6-M18 MS2500	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*
P11	RPKT1605M0T-6-M18 MS2500	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,80 *0.032*
P12	RPKT1605M0T-6-M18 MS2500	2,5 *0.10*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,55 *0.022*
M1	RPHT1605M0T-8-M12 MS2050	3,0 *0.12*	0,40 *0.016*	0,40 *0.016*	0,40 *0.016*	0,60 *0.024*
M2	RPHT1605M0T-8-M12 MS2050	3,0 *0.12*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,55 *0.022*
M3	RPHT1605M0T-8-M12 MS2050	2,5 *0.10*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,44 *0.017*
M4	RPKT1605M0T-8-M12 T350M	1,9 *0.075*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*
M5	RPKT1605M0T-8-M12 T350M	1,9 *0.075*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*
K1	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,60 *0.024*	0,60 *0.024*	0,60 *0.024*	0,90 *0.036*
K2	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*
K3	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*
K4	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*
K5	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,48 *0.019*	0,48 *0.019*	0,48 *0.019*	0,75 *0.030*
K6	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,55 *0.022*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*
K7	RPKT1605M0T-8-M18 MK2050	3,0 *0.12*	0,48 *0.019*	0,48 *0.019*	0,48 *0.019*	0,75 *0.030*
N1	RPHT1605M0T-8-ME11 F40M	3,0 *0.12*	0,46 *0.018*	0,46 *0.018*	0,46 *0.018*	0,70 *0.028*
N2	RPHT1605M0T-8-ME11 F40M	3,0 *0.12*	0,46 *0.018*	0,46 *0.018*	0,46 *0.018*	0,70 *0.028*
N3	RPHT1605M0T-8-ME11 F40M	3,0 *0.12*	0,46 *0.018*	0,46 *0.018*	0,46 *0.018*	0,70 *0.028*
N11	RPHT1605M0T-8-ME11 F40M	3,0 *0.12*	0,46 *0.018*	0,46 *0.018*	0,46 *0.018*	0,70 *0.028*
S1	RPKT1605M0T-8-M12 MS2500	1,9 *0.075*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*
S2	RPKT1605M0T-8-M12 MS2500	1,9 *0.075*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*
S3	RPKT1605M0T-8-M12 MS2500	1,9 *0.075*	0,30 *0.012*	0,30 *0.012*	0,28 *0.011*	0,36 *0.014*
S11	RPHT1605M0T-8-M12 MS2050	2,5 *0.10*	0,32 *0.013*	0,32 *0.013*	0,32 *0.013*	0,44 *0.017*
S12	RPHT1605M0T-8-M12 MS2050	2,5 *0.10*	0,32 *0.013*	0,32 *0.013*	0,32 *0.013*	0,44 *0.017*
S13	RPHT1605M0T-8-M12 MS2050	1,9 *0.075*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,38 *0.015*
H5	RPKW1605M0T-8-MD20 F15M	2,5 *0.10*	0,44 *0.017*	0,44 *0.017*	0,42 *0.017*	0,60 *0.024*
H8	RPKW1605M0T-8-MD20 F15M	2,5 *0.10*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,48 *0.019*
H11	RPKW1605M0T-8-MD20 F15M	2,5 *0.10*	0,44 *0.017*	0,44 *0.017*	0,42 *0.017*	0,60 *0.024*
H12	RPKW1605M0T-8-MD20 F15M	2,5 *0.10*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,48 *0.019*
H21	RPKW1605M0T-8-MD20 F15M	2,5 *0.10*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,48 *0.019*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.29-08 – Cutting data v_c = (m/min)/*(sf/min)*

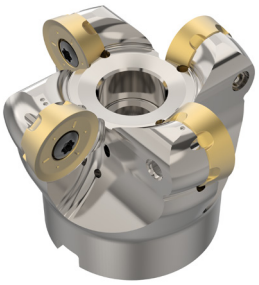
SMG	MP1501				MP2050				MP2501				T350M				F40M			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	290	340	410	480	295	340	410	475	260	300	360	425	260	305	365	420	225	265	315	365
	950	*1125*	*1350*	*1575*	*970*	*1125*	*1350*	*1550*	*850*	*980*	*1175*	*1400*	*850*	*1000*	*1200*	*1375*	*740*	*870*	*1025*	*1200*
P2	285	330	395	470	280	330	390	460	250	295	350	415	250	290	350	410	215	255	300	355
	940	*1075*	*1300*	*1550*	*920*	*1075*	*1275*	*1500*	*820*	*970*	*1150*	*1350*	*820*	*950*	*1150*	*1350*	*710*	*840*	*980*	*1175*
P3	250	295	350	410	245	285	350	405	225	260	310	365	220	255	310	360	190	220	270	315
	820	*970*	*1150*	*1350*	*800*	*940*	*1150*	*1325*	*740*	*850*	*1025*	*1200*	*720*	*840*	*1025*	*1175*	*620*	*720*	*890*	*1025*
P4	220	260	310	360	220	255	305	360	195	230	275	320	195	230	270	320	170	200	235	275
	720	*850*	*1025*	*1175*	*720*	*840*	*1000*	*1175*	*640*	*750*	*900*	*1050*	*640*	*750*	*890*	*1050*	*560*	*660*	*770*	*900*
P5	210	245	295	345	210	245	290	345	185	220	260	305	185	215	260	305	160	190	225	265
	690	*800*	*970*	*1125*	*690*	*800*	*950*	*1125*	*610*	*720*	*850*	*1000*	*610*	*710*	*850*	*1000*	*520*	*620*	*740*	*870*
P6	235	275	330	395	235	275	330	385	210	245	295	350	210	245	290	340	180	210	255	295
	770	*900*	*1075*	*1300*	*770*	*900*	*1075*	*1275*	*690*	*800*	*970*	*1150*	*690*	*800*	*950*	*1125*	*590*	*690*	*840*	*970*
P7	225	260	315	375	220	260	310	365	200	230	275	330	195	230	275	320	170	200	240	280
	740	*850*	*1025*	*1225*	*720*	*850*	*1025*	*1200*	*660*	*750*	*900*	*1075*	*640*	*750*	*900*	*1050*	*560*	*660*	*790*	*920*
P8	210	245	295	345	205	240	290	345	185	220	260	305	185	215	260	305	160	185	225	265
	690	*800*	*970*	*1125*	*670*	*790*	*950*	*1125*	*610*	*720*	*850*	*1000*	*610*	*710*	*850*	*1000*	*520*	*610*	*740*	*870*
P11	215	255	305	360	215	250	300	355	195	225	270	320	190	225	265	315	165	195	230	270
	710	*840*	*1000*	*1175*	*710*	*820*	*980*	*1175*	*640*	*740*	*890*	*1050*	*620*	*740*	*870*	*1025*	*540*	*640*	*750*	*890*
P12	145	170	205	240	145	165	200	235	130	150	180	210	125	150	175	205	110	130	155	180
	475	*560*	*670*	*790*	*475*	*540*	*660*	*770*	*425*	*490*	*590*	*690*	*410*	*490*	*570*	*670*	*360*	*425*	*510*	*590*
M1	—	—	—	—	200	235	280	330	180	210	255	300	190	225	270	315	175	205	245	285
	—	—	—	—	*660*	*770*	*920*	*1075*	*590*	*690*	*840*	*980*	*620*	*740*	*890*	*1025*	*570*	*670*	*800*	*940*
M2	—	—	—	—	170	195	235	275	150	175	210	245	160	185	225	260	145	170	205	240
	—	—	—	—	*560*	*640*	*770*	*900*	*490*	*570*	*690*	*800*	*520*	*610*	*740*	*850*	*475*	*560*	*670*	*790*
M3	—	—	—	—	135	160	190	220	125	145	170	205	130	150	180	210	120	135	165	195
	—	—	—	—	*445*	*520*	*620*	*720*	*410*	*475*	*560*	*670*	*425*	*490*	*590*	*690*	*395*	*445*	*540*	*640*
M4	—	—	—	—	105	120	145	175	95	110	135	160	100	115	140	165	90	105	130	150
	—	—	—	—	*345*	*395*	*475*	*570*	*310*	*360*	*445*	*520*	*330*	*375*	*460*	*540*	*295*	*345*	*425*	*490*
M5	—	—	—	—	90	100	125	145	80	95	110	135	85	95	115	140	75	90	105	125
	—	—	—	—	*295*	*330*	*410*	*475*	*260*	*310*	*360*	*445*	*280*	*310*	*375*	*460*	*245*	*295*	*345*	*410*
K1	225	260	315	370	225	260	310	365	200	230	280	330	200	230	275	325	170	200	240	280
	740	*850*	*1025*	*1225*	*740*	*850*	*1025*	*1200*	*660*	*750*	*920*	*1075*	*660*	*750*	*900*	*1075*	*560*	*660*	*790*	*920*
K2	200	235	280	330	200	235	275	325	180	205	250	290	175	205	245	290	155	180	215	250
	660	*770*	*920*	*1075*	*660*	*770*	*900*	*1075*	*590*	*670*	*820*	*950*	*570*	*670*	*800*	*950*	*510*	*590*	*710*	*820*
K3	170	200	235	275	170	195	235	275	150	175	210	245	150	175	210	245	130	150	180	210
	560	*660*	*770*	*900*	*560*	*640*	*770*	*900*	*490*	*570*	*690*	*800*	*490*	*570*	*690*	*800*	*425*	*490*	*590*	*690*
K4	160	190	225	265	160	190	225	265	145	165	200	235	145	165	200	235	125	145	175	205
	520	*620*	*740*	*870*	*520*	*620*	*740*	*870*	*475*	*540*	*660*	*770*	*475*	*540*	*660*	*770*	*410*	*475*	*570*	*670*
K5	100	120	140	165	100	115	140	160	90	105	125	145	90	105	120	145	75	90	105	125
	330	*395*	*460*	*540*	*330*	*375*	*460*	*520*	*295*	*345*	*410*	*475*	*295*	*345*	*395*	*475*	*245*	*295*	*345*	*410*
K6	145	165	200	235	140	165	195	230	125	145	175	205	125	145	175	205	110	130	150	180
	475	*540*	*660*	*770*	*460*	*540*	*640*	*750*	*410*	*475*	*570*	*670*	*410*	*475*	*570*	*670*	*360*	*425*	*490*	*590*
K7	130	150	180	210	125	150	175	210	115	135	160	185	115	130	155	185	100	115	135	160
	425	*490*	*590*	*690*	*410*	*490*	*570*	*690*	*375*	*445*	*520*	*610*	*375*	*425*	*510*	*610*	*330*	*375*	*445*	*520*
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1275	1475	1775	2100
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*4175*	*4850*	*5825*	*6900*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	510	600	720	840
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1675*	*1975*	*2350*	*2750*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	340	400	475	560
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1125*	*1300*	*1550*	*1825*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	390	455	540	640
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1275*	*1500*	*1775*	*2100*
S1	—	—	—	—	50	60	70	85	47	55	65	80	47	55	65	75	43	50	60	70
	—	—	—	—	*165*	*195*	*230*	*280*	*155*	*180*	*215*	*260*	*155*	*180*	*215*	*245*	*140*	*165*	*195*	*230*
S2	—	—	—	—	42	48	60	70	38	44	55	65	38	44	55	60	35	40	48	55
	—	—	—	—	*140*	*155*	*195*	*230*	*125*	*145*	*180*	*215*	*125*	*145*	*180*	*195*	*115*	*130*	*155*	*180*
S3	—	—	—	—	37	42	50	60	34	39	46	55	33	39	46	55	30	35	42	49
	—	—	—	—	*120*	*140*	*165*	*195*	*110*	*130*	*150*	*180*	*110*	*130*	*150*	*180*	*100*	*115*	*140*	*160*
S11	—	—	—	—	70	85	100	115	65	75	90	105	65	75	90	105	60	70	85	95
	—	—	—	—	*230*	*280*	*330*	*375*	*215*	*245*	*295*	*345*	*215*	*245*	*295*	*345*	*195*	*230*	*280*	*310*
S12	—	—	—	—	50	60	70	80	45	50	65	75	45	55	65	75	41	48	60	65
	—	—	—	—	*165*	*195*	*230*	*260*	*150*	*165*	*215*	*245*	*150*	*180*	*215*	*245*	*135*	*155*	*195*	*215*
S13	—	—	—	—	29	34	40	48	26	30	37	44	27	31	37	43	24	28	34	39
	—	—	—	—	*95*	*110*	*130*	*155*	*85*	*100*	*120*	*145*	*90*	*100*	*120*	*140*	*80*	*90*	*110*	*130*
H5	48	55	70	80	43	50	60	70	39	45	55	65	42	49	60	70	37	43	50	60
	155	*180*	*230*	*260*	*140*	*165*	*195*	*230*	*130*	*150*	*180*	*215*	*140*	*160*	*195*	*230*	*120*	*140*	*165*	*195*
H8	55	60	70	85	46	55	65	75	42	49	60	70	45	55	65	75	39	46	55	65
	180	*195*	*230*	*280*	*150*	*180*	*215*	*245*	*140*	*160*	*195*	*230*	*150*	*180*	*215*	*245*	*130*	*150*	*180*	*215*
H11	60	70	85	100	55	65	75	90	50	60	70	80	55	65	75	85	47	55	65	75
	195	*230*	*280*	*330*	*180*	*215*	*245*	*295*	*165*	*195*	*230*	*260*	*180*	*215*	*245*	*280*	*155*	*180*	*215*	*245*
H12	95	110	130	155	90	105	125	145	85	95	115	135	80	95	110	130	70	80	100	115
	310	*360*	*425*	*510*	*295*	*345*	*410*	*475*	*280*	*310*	*375*	*445*	*260*	*310*	*360*	*425*	*230*	*260*	*330*	*375*
H21	55	60	70	85	46	55	65	75	42	49	60	70	45	55	65	75	39	46	55	65
	180	*195*	*230*	*280*	*150*	*180*	*215*	*245*	*140*	*160*	*195*	*230*	*150*	*180*	*215*	*245*	*130*	*150*	*180*	*215*

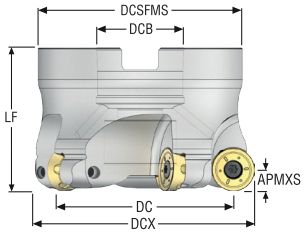
R217/220.29-08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050				MM4500				MS2050				MS2500			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	255 *840*	295 *970*	355 *1175*	420 *1375*	185 *610*	215 *710*	255 *840*	295 *970*	250 *820*	290 *950*	345 *1125*	405 *1325*	325 *1075*	380 *1250*	455 *1500*	530 *1750*
P2	245 *800*	290 *950*	345 *1125*	410 *1350*	175 *570*	205 *670*	245 *800*	290 *950*	240 *790*	280 *920*	335 *1100*	390 *1275*	310 *1025*	365 *1200*	435 *1425*	510 *1675*
P3	220 *720*	255 *840*	305 *1000*	360 *1175*	155 *510*	180 *590*	215 *710*	255 *840*	210 *690*	245 *800*	295 *970*	345 *1125*	275 *900*	320 *1050*	385 *1275*	455 *1500*
P4	195 *640*	225 *740*	270 *890*	315 *1025*	140 *460*	160 *520*	190 *620*	225 *740*	185 *610*	220 *720*	260 *850*	305 *1000*	245 *800*	285 *940*	340 *1125*	400 *1300*
P5	185 *610*	215 *710*	260 *850*	300 *980*	130 *425*	155 *510*	185 *610*	215 *710*	180 *590*	210 *690*	250 *820*	290 *950*	235 *770*	270 *890*	325 *1075*	380 *1250*
P6	205 *670*	240 *790*	290 *950*	345 *1125*	145 *475*	170 *560*	205 *670*	240 *790*	200 *660*	235 *770*	280 *920*	325 *1075*	260 *850*	305 *1000*	365 *1200*	425 *1400*
P7	195 *640*	230 *750*	275 *900*	325 *1075*	140 *460*	160 *520*	195 *640*	225 *740*	190 *620*	220 *720*	265 *870*	310 *1025*	245 *800*	290 *950*	345 *1125*	405 *1325*
P8	185 *610*	215 *710*	260 *850*	300 *980*	130 *425*	150 *490*	185 *610*	215 *710*	175 *570*	205 *670*	250 *820*	290 *950*	230 *750*	270 *890*	325 *1075*	380 *1250*
P11	190 *620*	220 *720*	265 *870*	315 *1025*	135 *445*	160 *520*	190 *620*	220 *720*	185 *610*	215 *710*	255 *840*	300 *980*	240 *790*	280 *920*	335 *1100*	390 *1275*
P12	125 *410*	150 *490*	180 *590*	210 *690*	90 *295*	105 *345*	125 *410*	145 *475*	120 *395*	140 *460*	170 *560*	200 *660*	160 *520*	185 *610*	220 *720*	260 *850*
M1	— —	— —	— —	— —	150 *490*	175 *570*	210 *690*	250 *820*	190 *620*	225 *740*	270 *890*	315 *1025*	225 *740*	260 *850*	310 *1025*	370 *1225*
M2	— —	— —	— —	— —	125 *410*	145 *475*	175 *570*	205 *670*	160 *520*	185 *610*	225 *740*	260 *850*	185 *610*	220 *720*	260 *850*	305 *1000*
M3	— —	— —	— —	— —	100 *330*	120 *395*	140 *460*	165 *540*	130 *425*	150 *490*	180 *590*	210 *690*	150 *490*	175 *570*	210 *690*	245 *800*
M4	— —	— —	— —	— —	80 *260*	90 *295*	110 *360*	130 *425*	100 *330*	115 *375*	140 *460*	165 *540*	120 *395*	135 *445*	165 *540*	190 *620*
M5	— —	— —	— —	— —	65 *215*	75 *245*	90 *295*	110 *360*	85 *280*	95 *310*	115 *375*	140 *460*	100 *330*	115 *375*	135 *445*	160 *520*
K1	265 *870*	310 *1025*	375 *1225*	440 *1450*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	240 *790*	280 *920*	335 *1100*	390 *1275*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	200 *660*	235 *770*	280 *920*	330 *1075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	190 *620*	225 *740*	270 *890*	315 *1025*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	120 *395*	140 *460*	165 *540*	195 *640*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	170 *560*	200 *660*	235 *770*	275 *900*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	155 *510*	180 *590*	215 *710*	250 *820*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	— —	24 *80*	28 *90*	34 *110*	40 *130*	47 *155*	55 *180*	65 *215*	75 *245*	60 *195*	65 *215*	80 *260*	95 *310*
S2	— —	— —	— —	— —	20 *65*	23 *75*	27 *90*	32 *105*	38 *125*	44 *145*	55 *180*	60 *195*	46 *150*	55 *180*	65 *215*	75 *245*
S3	— —	— —	— —	— —	17 *55*	20 *65*	24 *80*	28 *90*	33 *110*	39 *130*	46 *150*	55 *180*	41 *135*	47 *155*	55 *180*	65 *215*
S11	— —	— —	— —	— —	34 *110*	39 *130*	47 *155*	55 *180*	65 *215*	75 *245*	90 *295*	105 *345*	80 *260*	95 *310*	110 *360*	130 *425*
S12	— —	— —	— —	— —	31 *100*	36 *120*	43 *140*	50 *165*	45 *150*	55 *180*	65 *215*	75 *245*	55 *180*	65 *215*	75 *245*	90 *295*
S13	— —	— —	— —	— —	18 *60*	21 *70*	25 *80*	30 *100*	27 *90*	31 *100*	37 *120*	43 *140*	32 *105*	37 *120*	45 *150*	55 *180*
H5	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R220.29-38 – Inch





- For insert selection and cutting data recommendations, see page(s) 585-586
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R220.29I-02.50-38-04A	10005910	Arbor	1.756	2.500	4	0.374	0.750	1.789	2.000	10,39	4.256	4.921	5800	2.200	RPHT19
R220.29I-03.00-38-06A	10005911	Arbor	2.256	3.000	6	0.374	1.000	2.289	2.000	7,69	5.256	5.921	5100	2.650	RPHT19
R220.29I-04.00-38-05A	10005912	Arbor	3.256	4.000	5	0.374	1.500	3.539	2.500	5,06	7.256	7.921	4500	5.070	RPHT19
R220.29I-04.00-38-06A	10005913	Arbor	3.256	4.000	6	0.374	1.500	3.539	2.500	5,06	7.256	7.921	4500	5.510	RPHT19
R220.29I-05.00-38-07A	10005914	Arbor	4.256	5.000	7	0.374	1.500	3.539	2.500	3,76	9.256	9.921	4000	5.070	RPHT19
R220.29I-05.00-38-09A	10005915	Arbor	4.256	5.000	9	0.374	1.500	3.539	2.500	3,76	9.256	9.921	4000	4.410	RPHT19

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Coolant screw	Insert screw	Torque key	Torque value
R220.29I-02.50	UC6S3/8UNFX11/2	SX2035-T05P	C05013-T20P	T00-20P50	44.3IN.LBS
R220.29I-03.00	UC6S1/2UNFX1-1/2	SX2035-T05P	C05013-T20P	T00-20P50	44.3IN.LBS
R220.29I-04.00-05.00	UC6S3/4UNFX1-1/4	SX2035-T05P	C05013-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.29-38 – Insert selection – mm/*Inch*

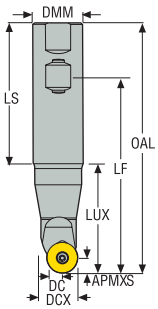
SMG		a_p	f_z			
			100%	30%	10%	5%
P1	RPHT190600T-6-M13 T350M	4,0 *0.16*	0,60 *0.024*	0,60 *0.024*	0,90 *0.036*	1,3 *0.050*
P2	RPHT190600T-6-M13 T350M	4,0 *0.16*	0,60 *0.024*	0,60 *0.024*	0,90 *0.036*	1,3 *0.050*
P3	RPHT190600T-6-M13 T350M	4,0 *0.16*	0,55 *0.022*	0,60 *0.024*	0,85 *0.034*	1,2 *0.048*
P4	RPHT190600T-6-M13 MS2500	4,0 *0.16*	0,55 *0.022*	0,60 *0.024*	0,85 *0.034*	1,2 *0.048*
P5	RPHT190600T-6-M13 MS2500	4,0 *0.16*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*	1,2 *0.048*
P6	RPHT190600T-6-M13 MS2500	4,0 *0.16*	0,55 *0.022*	0,55 *0.022*	0,80 *0.032*	1,2 *0.048*
P7	RPHT190600T-6-M13 MS2500	4,0 *0.16*	0,55 *0.022*	0,55 *0.022*	0,80 *0.032*	1,2 *0.048*
P8	RPHT190600T-6-M13 MS2500	4,0 *0.16*	0,55 *0.022*	0,60 *0.024*	0,85 *0.034*	1,2 *0.048*
P11	RPHT190600T-6-M13 MS2500	4,0 *0.16*	0,55 *0.022*	0,55 *0.022*	0,80 *0.032*	1,2 *0.048*
P12	RPHT190600T-6-M13 MS2500	3,0 *0.12*	0,42 *0.017*	0,40 *0.016*	0,55 *0.022*	0,80 *0.032*
M1	RPHT190600T-6-M13 F40M	4,0 *0.16*	0,60 *0.024*	0,60 *0.024*	0,90 *0.036*	1,3 *0.050*
M2	RPHT190600T-6-M13 F40M	4,0 *0.16*	0,55 *0.022*	0,55 *0.022*	0,85 *0.034*	1,2 *0.048*
M3	RPHT190600T-6-M13 F40M	3,0 *0.12*	0,50 *0.020*	0,48 *0.019*	0,65 *0.026*	0,95 *0.038*
M4	RPHT190600T-6-M13 F40M	2,5 *0.10*	0,48 *0.019*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*
M5	RPHT190600T-6-M13 F40M	2,5 *0.10*	0,48 *0.019*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*
S1	RPHT190600T-6-M13 MS2500	2,5 *0.10*	0,48 *0.019*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*
S2	RPHT190600T-6-M13 MS2500	2,5 *0.10*	0,48 *0.019*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*
S3	RPHT190600T-6-M13 MS2500	2,5 *0.10*	0,44 *0.017*	0,46 *0.018*	0,55 *0.022*	0,75 *0.030*
S11	RPHT190600T-6-M13 MS2050	2,5 *0.10*	0,55 *0.022*	0,50 *0.020*	0,65 *0.026*	0,95 *0.038*
S12	RPHT190600T-6-M13 MS2050	2,5 *0.10*	0,55 *0.022*	0,50 *0.020*	0,65 *0.026*	0,95 *0.038*
S13	RPHT190600T-6-M13 MS2050	2,5 *0.10*	0,48 *0.019*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.29-38 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	T350M				F40M				MS2050				MS2500			
	100%	30%	10%	5%	100%	30%	10%	5%	100%	30%	10%	5%	100%	30%	10%	5%
P1	215 *710*	305 *1000*	355 *1175*	370 *1225*	190 *620*	265 *870*	310 *1025*	320 *1050*	205 *670*	290 *950*	340 *1125*	355 *1175*	270 *890*	380 *1250*	445 *1450*	465 *1525*
P2	210 *690*	295 *970*	345 *1125*	360 *1175*	185 *610*	260 *850*	300 *980*	315 *1025*	200 *660*	285 *940*	330 *1075*	345 *1125*	265 *870*	370 *1225*	435 *1425*	450 *1475*
P3	185 *610*	255 *840*	305 *1000*	320 *1050*	160 *520*	220 *720*	265 *870*	275 *900*	180 *590*	245 *800*	290 *950*	305 *1000*	235 *770*	320 *1050*	380 *1250*	400 *1300*
P4	165 *540*	225 *740*	270 *890*	280 *920*	145 *475*	195 *640*	235 *770*	245 *800*	155 *510*	215 *710*	255 *840*	270 *890*	205 *670*	280 *920*	335 *1100*	350 *1150*
P5	155 *510*	220 *720*	255 *840*	265 *870*	135 *445*	190 *620*	220 *720*	230 *750*	150 *490*	210 *690*	245 *800*	255 *840*	195 *640*	275 *900*	320 *1050*	335 *1100*
P6	175 *570*	250 *820*	290 *950*	300 *980*	155 *510*	215 *710*	255 *840*	260 *850*	170 *560*	235 *770*	280 *920*	285 *940*	220 *720*	310 *1025*	365 *1200*	375 *1225*
P7	165 *540*	235 *770*	275 *900*	285 *940*	145 *475*	205 *670*	240 *790*	245 *800*	160 *520*	225 *740*	265 *870*	270 *890*	210 *690*	295 *970*	345 *1125*	355 *1175*
P8	155 *510*	215 *710*	255 *840*	265 *870*	135 *445*	185 *610*	220 *720*	230 *750*	150 *490*	205 *670*	245 *800*	255 *840*	195 *640*	270 *890*	320 *1050*	335 *1100*
P11	160 *520*	225 *740*	270 *890*	275 *900*	140 *460*	200 *660*	235 *770*	240 *790*	155 *510*	215 *710*	255 *840*	265 *870*	200 *660*	285 *940*	335 *1100*	345 *1125*
P12	110 *360*	150 *490*	175 *570*	185 *610*	95 *310*	130 *425*	155 *510*	160 *520*	105 *345*	145 *475*	170 *560*	175 *570*	135 *445*	190 *620*	220 *720*	230 *750*
M1	160 *520*	230 *750*	265 *870*	280 *920*	145 *475*	210 *690*	245 *800*	250 *820*	160 *520*	230 *750*	265 *870*	275 *900*	190 *620*	265 *870*	310 *1025*	325 *1075*
M2	135 *445*	190 *620*	220 *720*	230 *750*	120 *395*	175 *570*	200 *660*	210 *690*	135 *445*	190 *620*	220 *720*	230 *750*	155 *510*	220 *720*	255 *840*	270 *890*
M3	110 *360*	155 *510*	180 *590*	190 *620*	100 *330*	140 *460*	165 *540*	170 *560*	110 *360*	155 *510*	180 *590*	190 *620*	130 *425*	180 *590*	210 *690*	220 *720*
M4	150 *490*	210 *690*	245 *800*	260 *850*	80 *260*	110 *360*	125 *410*	135 *445*	85 *280*	120 *395*	140 *460*	150 *490*	100 *330*	140 *460*	165 *540*	175 *570*
M5	150 *490*	210 *690*	245 *800*	260 *850*	65 *215*	90 *295*	105 *345*	115 *375*	70 *230*	100 *330*	115 *375*	125 *410*	85 *280*	115 *375*	135 *445*	145 *475*
S1	41 *135*	55 *180*	65 *215*	70 *230*	37 *120*	50 *165*	60 *195*	65 *215*	41 *135*	55 *180*	65 *215*	70 *230*	49 *160*	70 *230*	80 *260*	85 *280*
S2	33 *110*	45 *150*	55 *180*	55 *180*	30 *100*	41 *135*	48 *155*	50 *165*	33 *110*	45 *150*	55 *180*	55 *180*	40 *130*	55 *180*	65 *215*	70 *230*
S3	29 *95*	40 *130*	47 *155*	49 *160*	26 *85*	36 *120*	42 *140*	45 *150*	29 *95*	40 *130*	47 *155*	49 *160*	35 *115*	48 *155*	55 *180*	60 *195*
S11	55 *180*	80 *260*	90 *295*	95 *310*	50 *165*	70 *230*	85 *280*	85 *280*	55 *180*	80 *260*	90 *295*	95 *310*	70 *230*	95 *310*	110 *360*	115 *375*
S12	39 *130*	55 *180*	65 *215*	65 *215*	35 *115*	49 *160*	60 *195*	60 *195*	39 *130*	55 *180*	65 *215*	65 *215*	47 *155*	65 *215*	80 *260*	80 *260*
S13	23 *75*	31 *100*	37 *120*	39 *130*	21 *70*	29 *95*	33 *110*	36 *120*	23 *75*	31 *100*	37 *120*	39 *130*	28 *90*	38 *125*	45 *150*	48 *155*

R217.29-10 – Metric



- For insert selection and cutting data recommendations, see page(s) 591-593
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.29-3250.3-10.3.080	02426255	Weldon	30,0	50,0	3	10,0	32,0	87,0	140,0	79,0	9,5	80,0	98,0	6500	1,0	RP..2006
R217.29-3225.3-10.1.100	02426250	Weldon	5,0	25,0	1	10,0	32,0	91,0	160,0	40,0	40,0	30,0	48,0	9200	0,8	RP..2006

Spare Parts

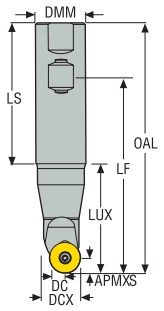
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.29-..	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217.29-10 – Inch



- For insert selection and cutting data recommendations, see page(s) 591-593
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.29-02.00-3-10.3	00087696	Weldon	1.213	2.000	3	0.315	1.250	3.400	5.512	3.400	9,8	3.213	3.921	6500	2.200	RP..2006

Spare Parts

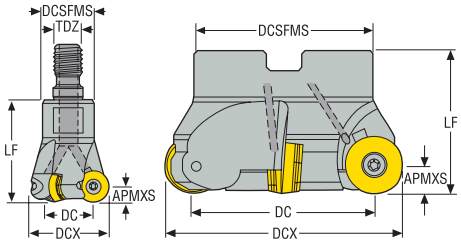
For cutter	Insert screw
R217.29-..	C05013-T20P

Accessories

Torque key	Torque value
T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.29-10 – Metric



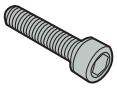
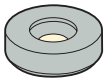
- For insert selection and cutting data recommendations, see page(s) 591-593
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.29-1640.RE-10.2A	02426282	Combimaster	20,0	40,0	2	10,0	–	M16	30,0	40,0	40,0	60,0	78,0	8400	0,3	RP..2006
R217.29-2040.RE-10.2A	02991175	Combimaster	20,0	40,0	2	10,0	–	M20	36,5	40,0	40,0	60,0	78,0	8400	0,3	RP..2006
R220.29-0063-10.4A	02427241	Arbor	43,0	63,0	4	10,0	22,0	–	47,0	50,0	6,0	106,0	124,0	5800	0,5	RP..2006
R220.29-0080-10.4MA	02497996	Arbor	60,0	80,0	4	10,0	27,0	–	62,0	50,0	6,5	140,0	158,0	2100	0,9	RP..2006
R220.29-0080-10.5A	02497999	Arbor	60,0	80,0	5	10,0	27,0	–	62,0	50,0	6,5	140,0	158,0	2100	0,9	RP..2006
R220.29-0083-10.4MA	02498001	Arbor	63,0	83,0	4	10,0	27,0	–	62,0	50,0	6,2	146,0	164,0	5000	0,9	RP..2006
R220.29-0100-10.5MA	02498002	Arbor	80,0	100,0	5	10,0	32,0	–	77,0	50,0	4,7	180,0	198,0	4500	1,4	RP..2006
R220.29-0100-10.6A	02468476	Arbor	80,0	100,0	6	10,0	32,0	–	77,0	50,0	4,7	180,0	198,0	4500	1,3	RP..2006
R220.29-0125-10.5MA	02498005	Arbor	105,0	125,0	5	10,0	40,0	–	90,0	63,0	3,47	230,0	248,0	4000	2,9	RP..2006
R220.29-0125-10.7A	02498006	Arbor	105,0	125,0	7	10,0	40,0	–	90,0	63,0	3,47	230,0	248,0	4000	2,7	RP..2006
R220.29-8160-10.6M	02498008	Arbor	140,0	160,0	6	10,0	40,0	–	90,0	63,0	2,2	300,0	318,0	3600	4,1	RP..2006
R220.29-8200-10.8M	02495666	Arbor	180,0	200,0	8	10,0	60,0	–	130,0	63,0	1,66	380,0	398,0	3200	6,0	RP..2006
R220.29-8250-10.9M	02495667	Arbor	230,0	250,0	9	10,0	60,0	–	130,0	63,0	1,3	480,0	498,0	2900	11,1	RP..2006

For Combimaster Shanks, see Machining Navigator Tooling System

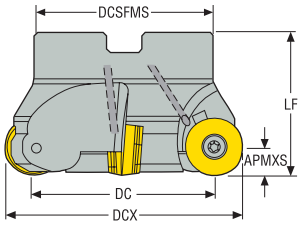
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert shim	Shim key	Shim screw	Torque key	Torque value
							
R217.29-..	–	C05013-T20P	–	–	–	T00-20P50	5.0NM
R217.29-2040-10	–	C05013-T20P	–	–	–	T00-20P50	5.0NM
R220.29-0063	220.17-692	C05013-T20P	–	–	–	T00-20P50	5.0NM
R220.29-0080M	MC6S12X35	C05018-T20P	SRP2004M0	H6B-H5.0L	CA5010	T00-20P50	5.0NM
R220.29-0080A	MC6S12X35	C05013-T20P	–	–	–	T00-20P50	5.0NM
R220.29-0083M	MC6S12X35	C05018-T20P	SRP2004M0	H6B-H5.0L	CA5010	T00-20P50	5.0NM
R220.29-0100M	MLC6S16X35	C05018-T20P	SRP2004M0	H6B-H5.0L	CA5010	T00-20P50	5.0NM
R220.29-0100	MLC6S16X35	C05013-T20P	–	–	–	T00-20P50	5.0NM
R220.29-0125M	MLC6S20X40	C05018-T20P	SRP2004M0	H6B-H5.0L	CA5010	T00-20P50	5.0NM
R220.29-0125A	MLC6S20X40	C05013-T20P	–	–	–	T00-20P50	5.0NM
R220.29-8160M	–	C05018-T20P	SRP2004M0	–	CA5010	T00-20P50	5.0NM
R220.29-8200-8250M	–	C05018-T20P	SRP2004M0	H6B-H5.0L	CA5010	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.29-10 – Inch



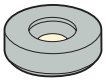
- For insert selection and cutting data recommendations, see page(s) 591-593
- For complete insert programme, see page(s) 750
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch		Inch	Inch		Inch	Inch		lbs	
R220.29-02.50-10.4A	00087697	Arbor	1.713	2.500	4	0.394	0.750	–	1.850	2.000	6,0	4.213	4.921	5800	1.320	RP..2006
R220.29-03.00-10.4A	00087698	Arbor	2.213	3.000	4	0.394	1.000	–	2.441	2.000	5,0	5.213	5.921	5100	2.200	RP..2006

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Insert shim	Shim key	Shim screw	Torque key	Torque value
							
R220.29-02.50	UC6S3/8UNFX11/2	C05013-T20P	–	–	–	T00-20P50	44.3IN.LBS
R220.29-03.00	UC6S1/2UNFX1-1/4	C05018-T20P	SRP2004M0	H6B-H5.0L	CA5010	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.29-10 – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RPHT2006M0T-ME12 MP2501	4,0 *0.16*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,55 *0.022*
P2	RPHT2006M0T-ME12 MP2501	4,0 *0.16*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,55 *0.022*
P3	RPHT2006M0T-ME12 MP2501	4,0 *0.16*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,55 *0.022*
P4	RPKT2006M0T-M15 MP2501	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,65 *0.026*
P5	RPKT2006M0T-M15 MP2501	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,65 *0.026*
P6	RPKT2006M0T-M20 MS2500	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,42 *0.017*	0,65 *0.026*
P7	RPKT2006M0T-M20 MS2500	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,42 *0.017*	0,65 *0.026*
P8	RPKT2006M0T-M20 MS2500	4,0 *0.16*	0,46 *0.018*	0,46 *0.018*	0,44 *0.017*	0,65 *0.026*
P11	RPKT2006M0T-M20 MS2500	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,42 *0.017*	0,65 *0.026*
P12	RPKT2006M0T-M20 MS2500	3,0 *0.12*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,44 *0.017*
M1	RPHT2006M0T-ME12 MS2050	4,0 *0.16*	0,38 *0.015*	0,38 *0.015*	0,38 *0.015*	0,55 *0.022*
M2	RPHT2006M0T-ME12 MS2050	4,0 *0.16*	0,34 *0.013*	0,34 *0.013*	0,34 *0.013*	0,50 *0.020*
M3	RPHT2006M0T-ME12 MS2050	3,0 *0.12*	0,32 *0.013*	0,32 *0.013*	0,32 *0.013*	0,42 *0.017*
M4	RPHT2006M0T-ME12 T350M	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*	0,36 *0.014*
M5	RPHT2006M0T-ME12 T350M	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*	0,36 *0.014*
K1	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,48 *0.019*	0,48 *0.019*	0,48 *0.019*	0,70 *0.028*
K2	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,65 *0.026*
K3	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,65 *0.026*
K4	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,65 *0.026*
K5	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,60 *0.024*
K6	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,44 *0.017*	0,44 *0.017*	0,44 *0.017*	0,65 *0.026*
K7	RPKT2006M0T-M20 MK2050	4,0 *0.16*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,60 *0.024*
S1	RPHT2006M0T-ME12 MS2500	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*	0,36 *0.014*
S2	RPHT2006M0T-ME12 MS2500	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*	0,36 *0.014*
S3	RPKT2006M0T-M15 MS2500	2,5 *0.10*	0,36 *0.014*	0,36 *0.014*	0,36 *0.014*	0,42 *0.017*
S11	RPHT2006M0T-ME12 MS2050	3,0 *0.12*	0,32 *0.013*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
S12	RPHT2006M0T-ME12 MS2050	3,0 *0.12*	0,32 *0.013*	0,32 *0.013*	0,34 *0.013*	0,42 *0.017*
S13	RPHT2006M0T-ME12 MS2050	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*	0,36 *0.014*
H5	RPKW2006M0T-MD22 F15M	3,0 *0.12*	0,50 *0.020*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
H8	RPKW2006M0T-MD22 F15M	3,0 *0.12*	0,38 *0.015*	0,38 *0.015*	0,40 *0.016*	0,50 *0.020*
H11	RPKW2006M0T-MD22 F15M	3,0 *0.12*	0,50 *0.020*	0,50 *0.020*	0,50 *0.020*	0,65 *0.026*
H12	RPKT2006M0T-M15 T350M	3,0 *0.12*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*	0,34 *0.013*
H21	RPKW2006M0T-MD22 F15M	3,0 *0.12*	0,38 *0.015*	0,38 *0.015*	0,40 *0.016*	0,50 *0.020*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.29-10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501				MP2050				MP2501				T350M				F15M				F30M			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	280	330	405	465	290	340	405	480	250	290	360	415	265	310	375	440	—	—	—	—	225	260	310	370
	920	*1075*	*1325*	*1525*	*950*	*1125*	*1325*	*1575*	*820*	*950*	*1175*	*1350*	*870*	*1025*	*1225*	*1450*	—	—	—	—	*740*	*850*	*1025*	*1225*
P2	275	320	385	455	285	330	395	470	240	285	340	400	260	305	365	430	—	—	—	—	215	255	305	355
	900	*1050*	*1275*	*1500*	*940*	*1075*	*1300*	*1550*	*790*	*940*	*1125*	*1300*	*850*	*1000*	*1200*	*1400*	—	—	—	—	*710*	*840*	*1000*	*1175*
P3	240	280	340	400	250	290	345	405	215	250	300	350	225	265	320	370	—	—	—	—	190	225	265	310
	790	*920*	*1125*	*1300*	*820*	*950*	*1125*	*1325*	*710*	*820*	*980*	*1150*	*740*	*870*	*1050*	*1225*	—	—	—	—	*620*	*740*	*870*	*1025*
P4	215	250	300	350	220	255	305	355	190	220	265	310	200	235	280	325	—	—	—	—	170	195	235	275
	710	*820*	*980*	*1150*	*720*	*840*	*1000*	*1175*	*620*	*720*	*870*	*1025*	*660*	*770*	*920*	*1075*	—	—	—	—	*560*	*640*	*770*	*900*
P5	205	235	285	340	210	250	295	350	180	210	255	300	195	225	270	320	—	—	—	—	160	185	225	265
	670	*770*	*940*	*1125*	*690*	*820*	*970*	*1150*	*590*	*690*	*840*	*980*	*640*	*740*	*890*	*1050*	—	—	—	—	*520*	*610*	*740*	*870*
P6	235	275	330	385	240	280	330	390	210	245	290	340	220	255	305	360	—	—	—	—	185	215	255	300
	770	*900*	*1075*	*1275*	*790*	*920*	*1075*	*1275*	*690*	*800*	*950*	*1125*	*720*	*840*	*1000*	*1175*	—	—	—	—	*610*	*710*	*840*	*980*
P7	220	260	310	360	225	265	315	370	195	230	275	320	205	240	290	340	—	—	—	—	175	200	240	280
	720	*850*	*1025*	*1175*	*740*	*870*	*1025*	*1225*	*640*	*750*	*900*	*1050*	*670*	*790*	*950*	*1125*	—	—	—	—	*570*	*660*	*790*	*920*
P8	205	235	285	335	210	245	290	340	180	210	255	295	190	225	265	310	—	—	—	—	160	185	225	260
	670	*770*	*940*	*1100*	*690*	*800*	*950*	*1125*	*590*	*690*	*840*	*970*	*620*	*740*	*870*	*1025*	—	—	—	—	*520*	*610*	*740*	*850*
P11	215	250	300	350	220	255	305	360	190	225	270	310	200	235	280	330	—	—	—	—	170	195	235	275
	710	*820*	*980*	*1150*	*720*	*840*	*1000*	*1175*	*620*	*740*	*890*	*1025*	*660*	*770*	*920*	*1075*	—	—	—	—	*560*	*640*	*770*	*900*
P12	140	165	200	230	140	165	200	235	125	145	175	205	130	150	185	215	—	—	—	—	110	130	150	175
	460	*540*	*660*	*750*	*460*	*540*	*660*	*770*	*410*	*475*	*570*	*670*	*425*	*490*	*610*	*710*	—	—	—	—	*360*	*425*	*490*	*570*
M1	—	—	—	—	205	235	285	335	175	205	245	290	200	235	280	330	—	—	—	—	175	205	245	285
	—	—	—	—	*670*	*770*	*940*	*1100*	*570*	*670*	*800*	*950*	*660*	*770*	*920*	*1075*	—	—	—	—	*570*	*670*	*800*	*940*
M2	—	—	—	—	170	200	235	280	145	170	205	245	165	195	235	275	—	—	—	—	145	170	205	240
	—	—	—	—	*560*	*660*	*770*	*920*	*475*	*560*	*670*	*800*	*540*	*640*	*770*	*900*	—	—	—	—	*475*	*560*	*670*	*790*
M3	—	—	—	—	135	160	190	220	120	140	165	195	135	155	185	220	—	—	—	—	120	140	165	190
	—	—	—	—	*445*	*520*	*620*	*720*	*395*	*460*	*540*	*640*	*445*	*510*	*610*	*720*	—	—	—	—	*395*	*460*	*540*	*620*
M4	—	—	—	—	105	125	145	175	95	110	130	155	105	120	145	170	—	—	—	—	90	105	125	150
	—	—	—	—	*345*	*410*	*475*	*570*	*310*	*360*	*425*	*510*	*345*	*395*	*475*	*560*	—	—	—	—	*295*	*345*	*410*	*490*
M5	—	—	—	—	90	105	120	145	80	90	110	130	90	100	120	145	—	—	—	—	75	90	105	125
	—	—	—	—	*295*	*345*	*395*	*475*	*260*	*295*	*360*	*425*	*295*	*330*	*395*	*475*	—	—	—	—	*245*	*295*	*345*	*410*
K1	215	255	305	360	225	260	315	370	190	225	270	320	—	—	—	—	150	180	215	250	170	200	240	280
	710	*840*	*1000*	*1175*	*740*	*850*	*1025*	*1225*	*620*	*740*	*890*	*1050*	—	—	—	—	*490*	*590*	*710*	*820*	*560*	*660*	*790*	*920*
K2	195	225	270	325	200	235	280	330	170	200	240	285	—	—	—	—	135	160	190	225	150	180	215	250
	640	*740*	*890*	*1075*	*660*	*770*	*920*	*1075*	*560*	*660*	*790*	*940*	—	—	—	—	*445*	*520*	*620*	*740*	*490*	*590*	*710*	*820*
K3	165	190	230	275	170	200	240	280	145	170	205	240	—	—	—	—	115	135	160	190	130	150	180	215
	540	*620*	*750*	*900*	*560*	*660*	*790*	*920*	*475*	*560*	*670*	*790*	—	—	—	—	*375*	*445*	*520*	*620*	*425*	*490*	*590*	*710*
K4	155	180	220	260	160	190	225	265	140	160	195	230	—	—	—	—	110	130	155	180	125	145	175	205
	510	*590*	*720*	*850*	*520*	*620*	*740*	*870*	*460*	*520*	*640*	*750*	—	—	—	—	*360*	*425*	*510*	*590*	*410*	*475*	*570*	*670*
K5	100	115	140	160	100	115	135	165	85	100	120	140	—	—	—	—	70	80	95	110	75	90	105	125
	330	*375*	*460*	*520*	*330*	*375*	*445*	*540*	*280*	*330*	*395*	*460*	—	—	—	—	*230*	*260*	*310*	*360*	*245*	*295*	*345*	*410*
K6	135	160	195	230	145	165	200	235	120	140	170	205	—	—	—	—	95	115	135	160	110	125	155	180
	445	*520*	*640*	*750*	*475*	*540*	*660*	*770*	*395*	*460*	*560*	*670*	—	—	—	—	*310*	*375*	*445*	*520*	*360*	*410*	*510*	*590*
K7	125	145	175	205	125	145	175	210	110	130	155	180	—	—	—	—	90	105	125	145	95	115	135	160
	410	*475*	*570*	*670*	*410*	*475*	*570*	*690*	*360*	*425*	*510*	*590*	—	—	—	—	*295*	*345*	*410*	*475*	*310*	*375*	*445*	*520*
S1	—	—	—	—	50	60	70	85	46	55	65	75	49	55	65	80	—	—	—	—	43	49	60	70
	—	—	—	—	*165*	*195*	*230*	*280*	*150*	*180*	*215*	*245*	*160*	*180*	*215*	*260*	—	—	—	—	*140*	*160*	*195*	*230*
S2	—	—	—	—	42	49	60	70	37	43	50	60	40	46	55	65	—	—	—	—	34	40	47	55
	—	—	—	—	*140*	*160*	*195*	*230*	*120*	*140*	*165*	*195*	*130*	*150*	*180*	*215*	—	—	—	—	*110*	*130*	*155*	*180*
S3	—	—	—	—	37	43	50	60	32	37	45	55	35	40	48	55	—	—	—	—	30	35	42	49
	—	—	—	—	*120*	*140*	*165*	*195*	*105*	*120*	*150*	*180*	*115*	*130*	*155*	*180*	—	—	—	—	*100*	*115*	*140*	*160*
S11	—	—	—	—	75	85	100	120	65	75	90	105	70	80	95	110	—	—	—	—	60	70	80	95
	—	—	—	—	*245*	*280*	*330*	*395*	*215*	*245*	*295*	*345*	*230*	*260*	*310*	*360*	—	—	—	—	*195*	*230*	*260*	*310*
S12	—	—	—	—	50	60	70	80	43	50	60	70	47	55	65	75	—	—	—	—	35	40	48	55
	—	—	—	—	*165*	*195*	*230*	*260*	*140*	*165*	*195*	*230*	*155*	*180*	*215*	*245*	—	—	—	—	*115*	*130*	*155*	*180*
S13	—	—	—	—	29	34	40	48	26	30	36	42	28	32	38	45	—	—	—	—	20	23	28	32
	—	—	—	—	*95*	*110*	*130*	*155*	*85*	*100*	*120*	*140*	*90*	*105*	*125*	*150*	—	—	—	—	*65*	*75*	*90*	*105*
H5	47	55	65	75	42	49	60	70	38	44	55	60	43	50	60	70	33	38	46	55	36	42	50	60
	155	*180*	*215*	*245*	*140*	*160*	*195*	*230*	*125*	*145*	*180*	*195*	*140*	*165*	*195*	*230*	*110*	*125*	*150*	*180*	*120*	*140*	*165*	*195*
H8	50	60	70	85	46	55	65	75	41	48	55	65	47	55	65	75	36	42	50	60	39	45	55	60
	165	*195*	*230*	*280*	*150*	*180*	*215*	*245*	*135*	*155*	*180*	*215*	*155*	*180*	*215*	*245*	*120*	*140*	*165*	*195*	*130*	*150*	*180*	*195*
H11	60	70	85	95	55	65	75	90	48	55	70	80	55	65	75	90	42	49	60	70	46	55	65	75
	195	*230*	*280*	*310*	*180*	*215*	*245*	*295*	*155*	*180*	*230*	*260*	*180*	*215*	*245*	*295*	*140*	*160*	*195*	*230*	*150*	*180*	*215*	*245*
H12	90	105	125	150	90	105	125	150	80	95	115	135	85	100	115	135	65	75	90	105	70	80	95	110
	295	*345*	*410*	*490*	*295*	*345*	*410*	*490*	*260*	*310*	*375*	*445*	*280*	*330*	*375*	*445*	*215*	*245*	*295*	*345*	*230*	*260*	*310*	*360*
H21	50	60	70	85	46	55	65	75	41	48	55	65	47	55	65	75	36	42	50	60	39	45	55	60
	165	*195*	*230*	*280*	*150*	*180*	*215*	*245*	*135*	*155*	*180*	*215*	*155*	*180*	*215*	*245*	*120*	*140*	*165*	*195*	*130*	*150*	*180*	*195*

R217/220.29-10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				MK2050				MM4500				MS2050				MS2500			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	230	270	325	385	270	315	385	450	190	220	265	310	255	300	355	420	335	390	465	550
	750	*890*	*1075*	*1275*	*890*	*1025*	*1275*	*1475*	*620*	*720*	*870*	*1025*	*840*	*980*	*1175*	*1375*	*1100*	*1275*	*1525*	*1800*
P2	225	265	315	375	265	310	370	435	185	215	255	305	250	290	345	410	325	380	455	540
	740	*870*	*1025*	*1225*	*870*	*1025*	*1225*	*1425*	*610*	*710*	*840*	*1000*	*820*	*950*	*1125*	*1350*	*1075*	*1250*	*1500*	*1775*
P3	200	230	275	320	230	270	325	385	160	185	225	260	215	255	305	355	285	335	400	465
	660	*750*	*900*	*1050*	*750*	*890*	*1075*	*1275*	*520*	*610*	*740*	*850*	*710*	*840*	*1000*	*1175*	*940*	*1100*	*1300*	*1525*
P4	175	205	245	285	205	240	290	340	140	165	195	230	190	225	265	310	250	295	350	410
	570	*670*	*800*	*940*	*670*	*790*	*950*	*1125*	*460*	*540*	*640*	*750*	*620*	*740*	*870*	*1025*	*820*	*970*	*1150*	*1350*
P5	170	200	235	280	195	230	275	325	135	160	190	225	185	220	260	305	245	285	340	400
	560	*660*	*770*	*920*	*640*	*750*	*900*	*1075*	*445*	*520*	*620*	*740*	*610*	*720*	*850*	*1000*	*800*	*940*	*1125*	*1300*
P6	190	220	265	310	220	260	315	365	155	180	215	255	210	245	290	345	275	320	380	450
	620	*720*	*870*	*1025*	*720*	*850*	*1025*	*1200*	*510*	*590*	*710*	*840*	*690*	*800*	*950*	*1125*	*900*	*1050*	*1250*	*1475*
P7	180	210	250	295	210	245	295	345	145	170	205	240	195	230	275	325	260	300	360	425
	590	*690*	*820*	*970*	*690*	*800*	*970*	*1125*	*475*	*560*	*670*	*790*	*640*	*750*	*900*	*1075*	*850*	*980*	*1175*	*1400*
P8	165	195	230	270	195	225	275	325	135	160	190	220	185	215	255	295	240	280	335	390
	540	*640*	*750*	*890*	*640*	*740*	*900*	*1075*	*445*	*520*	*620*	*720*	*610*	*710*	*840*	*970*	*790*	*920*	*1100*	*1275*
P11	175	205	245	285	200	235	285	335	140	165	195	230	190	225	265	315	250	295	350	410
	570	*670*	*800*	*940*	*660*	*770*	*940*	*1100*	*460*	*540*	*640*	*750*	*620*	*740*	*870*	*1025*	*820*	*970*	*1150*	*1350*
P12	115	130	160	185	135	155	185	220	90	105	130	150	125	145	175	205	165	190	230	270
	375	*425*	*520*	*610*	*445*	*510*	*610*	*720*	*295*	*345*	*425*	*490*	*410*	*475*	*570*	*670*	*540*	*620*	*750*	*890*
M1	180	215	255	300	—	—	—	—	155	185	220	260	200	235	280	330	235	275	325	385
	590	*710*	*840*	*980*	—	—	—	—	*510*	*610*	*720*	*850*	*660*	*770*	*920*	*1075*	*770*	*900*	*1075*	*1275*
M2	150	180	210	250	—	—	—	—	130	155	185	215	165	195	235	275	195	230	270	320
	490	*590*	*690*	*820*	—	—	—	—	*425*	*510*	*610*	*710*	*540*	*640*	*770*	*900*	*640*	*750*	*890*	*1050*
M3	125	145	170	200	—	—	—	—	105	125	145	170	135	155	185	220	155	185	220	255
	410	*475*	*560*	*660*	—	—	—	—	*345*	*410*	*475*	*560*	*445*	*510*	*610*	*720*	*510*	*610*	*720*	*840*
M4	95	110	130	155	—	—	—	—	85	95	115	135	105	120	145	170	125	140	170	200
	310	*360*	*425*	*510*	—	—	—	—	*280*	*310*	*375*	*445*	*345*	*395*	*475*	*560*	*410*	*460*	*560*	*660*
M5	80	95	110	130	—	—	—	—	70	80	95	110	90	100	120	145	105	120	140	165
	260	*310*	*360*	*425*	—	—	—	—	*230*	*260*	*310*	*360*	*295*	*330*	*395*	*475*	*345*	*395*	*460*	*540*
K1	180	210	250	295	285	335	400	470	—	—	—	—	—	—	—	—	—	—	—	—
	590	*690*	*820*	*970*	*940*	*1100*	*1300*	*1550*	—	—	—	—	—	—	—	—	—	—	—	—
K2	160	190	225	265	255	295	355	420	—	—	—	—	—	—	—	—	—	—	—	—
	520	*620*	*740*	*870*	*840*	*970*	*1175*	*1375*	—	—	—	—	—	—	—	—	—	—	—	—
K3	135	160	190	225	215	250	300	355	—	—	—	—	—	—	—	—	—	—	—	—
	445	*520*	*620*	*740*	*710*	*820*	*980*	*1175*	—	—	—	—	—	—	—	—	—	—	—	—
K4	130	150	180	215	205	240	285	340	—	—	—	—	—	—	—	—	—	—	—	—
	425	*490*	*590*	*710*	*670*	*790*	*940*	*1125*	—	—	—	—	—	—	—	—	—	—	—	—
K5	80	90	110	130	125	145	180	205	—	—	—	—	—	—	—	—	—	—	—	—
	260	*295*	*360*	*425*	*410*	*475*	*590*	*670*	—	—	—	—	—	—	—	—	—	—	—	—
K6	115	135	160	190	180	210	255	295	—	—	—	—	—	—	—	—	—	—	—	—
	375	*445*	*520*	*620*	*590*	*690*	*840*	*970*	—	—	—	—	—	—	—	—	—	—	—	—
K7	100	120	140	165	160	190	230	265	—	—	—	—	—	—	—	—	—	—	—	—
	330	*395*	*460*	*540*	*520*	*620*	*750*	*870*	—	—	—	—	—	—	—	—	—	—	—	—
S1	45	50	60	75	—	—	—	—	25	29	35	41	49	55	65	80	60	70	80	95
	150	*165*	*195*	*245*	—	—	—	—	*80*	*95*	*115*	*135*	*160*	*180*	*215*	*260*	*195*	*230*	*260*	*310*
S2	36	42	49	60	—	—	—	—	20	24	28	33	40	46	55	65	48	55	65	80
	120	*140*	*160*	*195*	—	—	—	—	*65*	*80*	*90*	*110*	*130*	*150*	*180*	*215*	*155*	*180*	*215*	*260*
S3	32	37	44	50	—	—	—	—	18	21	25	29	35	40	48	55	43	49	60	70
	105	*120*	*145*	*165*	—	—	—	—	*60*	*70*	*80*	*95*	*115*	*130*	*155*	*180*	*140*	*160*	*195*	*230*
S11	60	70	85	100	—	—	—	—	35	41	49	55	70	80	95	110	85	95	115	135
	195	*230*	*280*	*330*	—	—	—	—	*115*	*135*	*160*	*180*	*230*	*260*	*310*	*360*	*280*	*310*	*375*	*445*
S12	43	50	60	70	—	—	—	—	32	38	45	55	47	55	65	75	60	65	80	95
	140	*165*	*195*	*230*	—	—	—	—	*105*	*125*	*150*	*180*	*155*	*180*	*215*	*245*	*195*	*215*	*260*	*310*
S13	25	29	34	41	—	—	—	—	19	22	26	31	28	32	38	45	34	39	46	55
	80	*95*	*110*	*135*	—	—	—	—	*60*	*70*	*85*	*100*	*90*	*105*	*125*	*150*	*110*	*130*	*150*	*180*
H5	38	44	55	60	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	125	*145*	*180*	*195*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	41	48	55	65	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	135	*155*	*180*	*215*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	48	55	65	80	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	155	*180*	*215*	*260*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	75	85	100	120	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	245	*280*	*330*	*395*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	41	48	55	65	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	135	*155*	*180*	*215*	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

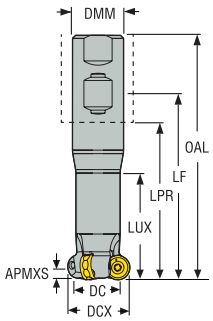
Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217/220.28 ROUND INSERT CUTTERS

Our range of double-sided round inserts in size 12 and cutters, R217/220.28, is ideal for light copy milling applications, face milling, slot milling and side milling in all workpiece materials.

- Cutter range 32-100 mm (1.25 - 4 inch)
- Max depth of cut 6 mm (.236 inch)
- Recommended slotting depth of cut 3 mm (.118 inch)
- Up to 16 cutting edges

R217.28-06 – Inch



- For insert selection and cutting data recommendations, see page(s) 598-599
- For complete insert programme, see page(s) 747
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.28-01.25-3-06-3A	03092089	Weldon	0.780	1.250	3	0.236	1.000	2.280	4.783	2.578	0,4	2.030	2.421	15600	0.880	RNMU12..

Spare Parts

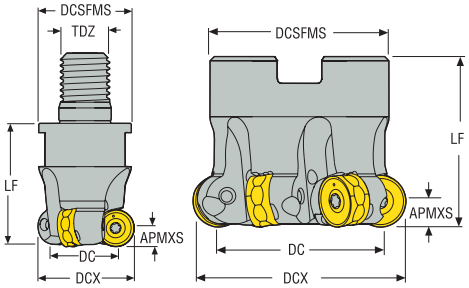
For cutter	Insert screw
R217.28-..	C04009-T15P

Accessories

Torque key	Torque value
T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.28-06 – Metric

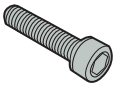


- For insert selection and cutting data recommendations, see page(s) 598-599
- For complete insert programme, see page(s) 747
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm	mm		mm	mm		mm	mm		mm	mm		kg	
R217.28-1632.RE-06.3A	03092078	Combimaster	20,1	32,0	3	6,0	–	M16	30,0	40,0	0,4	52,1	62,0	15600	0,2	RNMU12..
R217.28-2040.RE-06.4A	03092079	Combimaster	28,0	40,0	4	6,0	–	M20	36,5	45,0	0,54	68,0	78,0	14000	0,4	RNMU12..
R220.28-0040-06.4A	03092080	Arbor	28,0	40,0	4	6,0	16,0	–	35,0	40,0	0,54	68,0	78,0	14000	0,2	RNMU12..
R220.28-0050-06.5A	03092081	Arbor	38,0	50,0	5	6,0	22,0	–	42,0	40,0	0,62	88,0	98,0	12500	0,3	RNMU12..
R220.28-0050-06.6A	03092082	Arbor	38,0	50,0	6	6,0	22,0	–	42,0	40,0	0,62	88,0	98,0	12500	0,3	RNMU12..
R220.28-0052-06.5A	03092083	Arbor	40,0	52,0	5	6,0	22,0	–	47,0	40,0	0,6	92,0	102,0	12300	0,4	RNMU12..
R220.28-0063-06.6A	03092084	Arbor	51,0	63,0	6	6,0	22,0	–	47,0	40,0	0,47	114,0	124,0	11200	0,4	RNMU12..
R220.28-0063-06.8A	03092086	Arbor	51,0	63,0	8	6,0	22,0	–	47,0	40,0	0,47	114,0	124,0	10000	0,5	RNMU12..
R220.28-0066-06.7A	03092087	Arbor	54,0	66,0	7	6,0	27,0	–	62,0	50,0	0,45	120,0	130,0	10900	0,8	RNMU12..
R220.28-0080-06.8A	03092088	Arbor	67,9	80,0	8	6,0	27,0	–	62,0	50,0	0,53	147,9	158,0	10000	1,0	RNMU12..
R220.28-0100-06.10A	03137201	Arbor	88,0	100,0	10	6,0	32,0	–	77,0	50,0	0,11	188,0	198,0	8800	1,6	RNMU12..
R220.28-0100-06.12A	03137202	Arbor	88,0	100,0	12	6,0	32,0	–	77,0	50,0	0,11	188,0	198,0	8800	1,6	RNMU12..

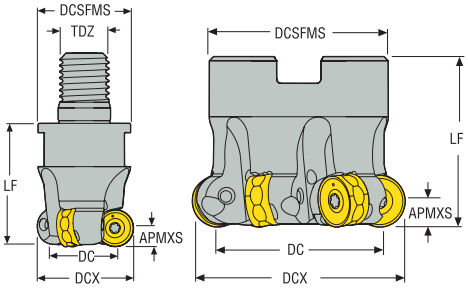
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.28-..	–	C04009-T15P	T00-15P35	3.5NM
R220.28-0040-0063	220.17-692	C04009-T15P	T00-15P35	3.5NM
R220.28-0066	MC6S12X40	C04009-T15P	T00-15P35	3.5NM
R220.28-0080	MC6S12X40	C04009-T15P	T00-15P35	3.5NM
R220.28-0100	950E1645	C04009-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.28-06 – Inch



- For insert selection and cutting data recommendations, see page(s) 598-599
- For complete insert programme, see page(s) 747
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	DCX	ZEFP	APMXS	DCB	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch	Inch		Inch	Inch		Inch	Inch		Inch	Inch		lbs	
R217.28-01.50-20RE-06-4A	03092090	Combimaster	1.028	1.500	4	0.236	–	M20	1.437	1.772	0,5	2.528	2.921	14000	0.660	RNMU12..
R220.28-01.50-06-4A	03092091	Arbor	1.028	1.500	4	0.236	0.500	–	1.260	1.500	0,5	2.528	2.921	14000	0.440	RNMU12..
R220.28-02.00-06-5A	03092092	Arbor	1.528	2.000	5	0.236	0.750	–	1.654	1.500	0,61	3.528	3.921	12500	0.660	RNMU12..
R220.28-02.00-06-6A	03092093	Arbor	1.528	2.000	6	0.236	0.750	–	1.654	1.500	0,61	3.528	3.921	12500	0.660	RNMU12..
R220.28-02.50-06-7A	03092094	Arbor	2.028	2.500	7	0.236	0.750	–	1.850	1.500	0,47	4.528	4.921	11200	1.100	RNMU12..
R220.28-03.00-06-8A	03092095	Arbor	2.524	3.000	8	0.236	1.000	–	2.441	2.000	0,56	5.524	5.921	10000	2.200	RNMU12..
R220.28-04.00-06-10A	03137203	Arbor	3.528	4.000	10	0.236	1.500	–	3.543	2.000	0,11	7.528	7.921	8800	3.970	RNMU12..
R220.28-04.00-06-12A	03137204	Arbor	3.528	4.000	12	0.236	1.500	–	3.543	2.000	0,11	7.528	7.921	8800	3.970	RNMU12..

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.28-..	–	C04009-T15P	T00-15P35	31.0IN.LBS
R220.28-01.50	UC6S1/4UNFX1	C04009-T15P	T00-15P35	31.0IN.LBS
R220.28-02.00-02.50	UC6S3/8UNFX1-1/4	C04009-T15P	T00-15P35	31.0IN.LBS
R220.28-03.00	UC6S1/2UNFX1-1/2	C04009-T15P	T00-15P35	31.0IN.LBS
R220.28-04.00	ULC6S3/4UNFX11/2	C04009-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.28 – Insert selection – mm/*Inch*

SMG		a_p	f_z			
			100%	70%	30%	10%
P1	RNMU1204M0-ME10 T350M	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,30 *0.012*	0,44 *0.017*
P2	RNMU1204M0-ME10 T350M	2,5 *0.10*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,44 *0.017*
P3	RNMU1204M0-ME10 T350M	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,28 *0.011*	0,42 *0.017*
P4	RNMU1204M0T-M10 MP2501	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,42 *0.017*
P5	RNMU1204M0T-M10 MP2501	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
P6	RNMU1204M0T-M10 MP2501	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
P7	RNMU1204M0T-M10 MP2501	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
P8	RNMU1204M0T-M10 MP2050	2,5 *0.10*	0,30 *0.012*	0,30 *0.012*	0,28 *0.011*	0,42 *0.017*
P11	RNMU1204M0T-M10 MP2050	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
P12	RNMU1204M0T-M10 MS2500	1,9 *0.075*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
M1	RNMU1204M0-ME10 T350M	2,5 *0.10*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,44 *0.017*
M2	RNMU1204M0-ME10 T350M	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
M3	RNMU1204M0-ME10 T350M	1,9 *0.075*	0,26 *0.010*	0,26 *0.010*	0,26 *0.010*	0,32 *0.013*
M4	RNMU1204M0T-M10 T350M	1,4 *0.055*	0,26 *0.010*	0,26 *0.010*	0,25 *0.010*	0,28 *0.011*
M5	RNMU1204M0T-M10 T350M	1,4 *0.055*	0,26 *0.010*	0,26 *0.010*	0,25 *0.010*	0,28 *0.011*
K1	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,32 *0.013*	0,32 *0.013*	0,30 *0.012*	0,44 *0.017*
K2	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
K3	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
K4	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
K5	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,25 *0.010*	0,25 *0.010*	0,25 *0.010*	0,36 *0.014*
K6	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,28 *0.011*	0,28 *0.011*	0,28 *0.011*	0,40 *0.016*
K7	RNMU1204M0T-M10 MK2050	2,5 *0.10*	0,25 *0.010*	0,25 *0.010*	0,25 *0.010*	0,36 *0.014*
N1	RNMU1204M0-ME10 F40M	2,5 *0.10*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,55 *0.022*
N2	RNMU1204M0-ME10 F40M	2,5 *0.10*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,55 *0.022*
N3	RNMU1204M0-ME10 F40M	2,5 *0.10*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,55 *0.022*
N11	RNMU1204M0-ME10 F40M	2,5 *0.10*	0,40 *0.016*	0,40 *0.016*	0,38 *0.015*	0,55 *0.022*
S1	RNMU1204M0T-M10 MS2500	1,4 *0.055*	0,26 *0.010*	0,26 *0.010*	0,25 *0.010*	0,28 *0.011*
S2	RNMU1204M0T-M10 MS2500	1,4 *0.055*	0,26 *0.010*	0,26 *0.010*	0,25 *0.010*	0,28 *0.011*
S3	RNMU1204M0T-M10 MS2500	1,4 *0.055*	0,24 *0.0095*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*
S11	RNMU1204M0T-M10 MS2050	1,7 *0.065*	0,28 *0.011*	0,28 *0.011*	0,26 *0.010*	0,32 *0.013*
S12	RNMU1204M0T-M10 MS2050	1,7 *0.065*	0,28 *0.011*	0,28 *0.011*	0,26 *0.010*	0,32 *0.013*
S13	RNMU1204M0T-M10 MS2050	1,4 *0.055*	0,26 *0.010*	0,26 *0.010*	0,25 *0.010*	0,28 *0.011*
H5	RNMU1204M0T-M10 MP2501	1,9 *0.075*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
H8	RNMU1204M0T-M10 MP2501	1,7 *0.065*	0,18 *0.0070*	0,18 *0.0070*	0,17 *0.0065*	0,22 *0.0085*
H11	RNMU1204M0T-M10 MP2501	1,9 *0.075*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*	0,28 *0.011*
H12	RNMU1204M0T-M10 MP2501	1,7 *0.065*	0,18 *0.0070*	0,18 *0.0070*	0,17 *0.0065*	0,22 *0.0085*
H21	RNMU1204M0T-M10 MP2501	1,7 *0.065*	0,18 *0.0070*	0,18 *0.0070*	0,17 *0.0065*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.28 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2050				MP2501				T350M				F40M				MK2050				MS2050				MS2500			
	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%	100%	70%	30%	10%
P1	285	325	390	455	290	330	395	465	255	290	345	405	230	260	315	370	285	325	390	460	245	275	330	390	320	360	430	510
	940	*1075*	*1275*	*1500*	*950*	*1075*	*1300*	*1525*	*840*	*950*	*1125*	*1325*	*750*	*850*	*1025*	*1225*	*940*	*1075*	*1275*	*1500*	*800*	*900*	*1075*	*1275*	*1050*	*1175*	*1400*	*1675*
P2	275	310	380	445	280	315	385	455	245	275	335	395	220	250	305	360	275	310	380	445	230	265	320	380	305	345	420	495
	900	*1025*	*1250*	*1450*	*920*	*1025*	*1275*	*1500*	*800*	*900*	*1100*	*1300*	*720*	*820*	*1000*	*1175*	*900*	*1025*	*1250*	*1450*	*750*	*870*	*1050*	*1250*	*1000*	*1125*	*1375*	*1625*
P3	240	270	330	390	245	275	335	395	215	240	295	345	195	220	270	315	240	270	330	390	205	230	280	330	265	300	370	430
	790	*890*	*1075*	*1275*	*800*	*900*	*1100*	*1300*	*710*	*790*	*970*	*1125*	*640*	*720*	*890*	*1025*	*790*	*890*	*1075*	*1275*	*670*	*750*	*920*	*1075*	*870*	*980*	*1225*	*1400*
P4	215	245	290	340	220	250	295	350	190	215	260	305	175	195	235	275	215	245	290	345	185	205	245	290	240	270	325	380
	710	*800*	*950*	*1125*	*720*	*820*	*970*	*1150*	*620*	*710*	*850*	*1000*	*570*	*640*	*770*	*900*	*710*	*800*	*950*	*1125*	*610*	*670*	*800*	*950*	*790*	*890*	*1075*	*1250*
P5	205	235	280	330	210	235	285	335	180	205	245	295	165	190	225	270	205	235	280	330	175	200	235	280	230	260	310	365
	670	*770*	*920*	*1075*	*690*	*770*	*940*	*1100*	*590*	*670*	*800*	*970*	*540*	*620*	*740*	*890*	*670*	*770*	*920*	*1075*	*570*	*660*	*770*	*920*	*750*	*850*	*1025*	*1200*
P6	230	260	310	370	235	265	320	380	205	230	275	330	185	210	255	300	230	260	315	370	195	220	265	315	255	290	345	410
	750	*850*	*1025*	*1225*	*770*	*870*	*1050*	*1250*	*670*	*750*	*900*	*1075*	*610*	*690*	*840*	*980*	*750*	*850*	*1025*	*1225*	*640*	*720*	*870*	*1025*	*840*	*950*	*1125*	*1350*
P7	220	245	295	350	220	250	300	355	195	220	260	310	175	200	240	285	220	245	295	350	185	210	250	295	240	275	330	390
	720	*800*	*970*	*1150*	*720*	*820*	*980*	*1175*	*640*	*720*	*850*	*1025*	*570*	*660*	*790*	*940*	*720*	*800*	*970*	*1150*	*610*	*690*	*820*	*970*	*790*	*900*	*1075*	*1275*
P8	200	230	280	325	205	230	285	330	180	200	245	290	165	185	225	265	200	230	280	325	170	195	235	275	225	255	310	360
	660	*750*	*920*	*1075*	*670*	*750*	*940*	*1075*	*590*	*660*	*800*	*950*	*540*	*610*	*740*	*870*	*660*	*750*	*920*	*1075*	*560*	*640*	*770*	*900*	*740*	*840*	*1025*	*1175*
P11	210	240	285	340	215	245	290	345	190	215	255	300	170	195	230	275	210	240	285	340	180	205	245	290	235	265	320	380
	690	*790*	*940*	*1125*	*710*	*800*	*950*	*1125*	*620*	*710*	*840*	*980*	*560*	*640*	*750*	*900*	*690*	*790*	*940*	*1125*	*590*	*670*	*800*	*950*	*770*	*870*	*1050*	*1250*
P12	140	155	185	220	140	160	190	225	125	140	165	195	110	125	150	180	140	155	190	220	115	135	160	185	155	175	210	245
	460	*510*	*610*	*720*	*460*	*520*	*620*	*740*	*410*	*460*	*540*	*640*	*360*	*410*	*490*	*590*	*460*	*510*	*620*	*720*	*375*	*445*	*520*	*610*	*510*	*570*	*690*	*800*
M1	195	220	270	320	200	225	275	325	185	210	260	305	180	200	245	290	—	—	—	—	185	210	260	305	220	245	300	355
	640	*720*	*890*	*1050*	*660*	*740*	*900*	*1075*	*610*	*690*	*850*	*1000*	*590*	*660*	*800*	*950*	—	—	—	—	*610*	*690*	*850*	*1000*	*720*	*800*	*980*	*1175*
M2	165	185	225	265	170	190	230	270	155	180	215	250	150	170	205	240	—	—	—	—	155	180	215	250	185	205	245	295
	540	*610*	*740*	*870*	*560*	*620*	*750*	*890*	*510*	*590*	*710*	*820*	*490*	*560*	*670*	*790*	—	—	—	—	*510*	*590*	*710*	*820*	*610*	*670*	*800*	*970*
M3	135	150	180	215	135	155	185	220	125	145	170	205	120	135	165	195	—	—	—	—	125	145	170	205	150	165	200	235
	445	*490*	*590*	*710*	*445*	*510*	*610*	*720*	*410*	*475*	*560*	*670*	*395*	*445*	*540*	*640*	—	—	—	—	*410*	*475*	*560*	*670*	*490*	*540*	*660*	*770*
M4	105	115	140	165	105	120	145	170	100	110	135	160	95	105	125	150	—	—	—	—	100	110	135	160	115	130	155	185
	345	*375*	*460*	*540*	*345*	*395*	*475*	*560*	*330*	*360*	*445*	*520*	*310*	*345*	*410*	*490*	—	—	—	—	*330*	*360*	*445*	*520*	*375*	*425*	*510*	*610*
M5	85	95	115	140	90	100	120	140	80	95	110	130	80	90	105	125	—	—	—	—	80	95	110	130	95	110	130	155
	280	*310*	*375*	*460*	*295*	*330*	*395*	*460*	*260*	*310*	*360*	*425*	*260*	*295*	*345*	*410*	—	—	—	—	*260*	*310*	*360*	*425*	*310*	*360*	*425*	*510*
K1	215	245	300	355	220	250	305	360	190	220	265	315	175	200	240	285	295	335	410	480	—	—	—	—	—	—	—	—
	710	*800*	*980*	*1175*	*720*	*820*	*1000*	*1175*	*620*	*720*	*870*	*1025*	*570*	*660*	*790*	*940*	*970*	*1100*	*1350*	*1575*	—	—	—	—	—	—	—	—
K2	195	220	265	315	200	225	270	320	175	195	235	280	160	180	215	255	265	300	360	430	—	—	—	—	—	—	—	—
	640	*720*	*870*	*1025*	*660*	*740*	*890*	*1050*	*570*	*640*	*770*	*920*	*520*	*590*	*710*	*840*	*870*	*980*	*1175*	*1400*	—	—	—	—	—	—	—	—
K3	165	185	225	265	170	190	230	270	145	165	200	235	135	150	180	215	225	255	305	365	—	—	—	—	—	—	—	—
	540	*610*	*740*	*870*	*560*	*620*	*750*	*890*	*475*	*540*	*660*	*770*	*445*	*490*	*590*	*710*	*740*	*840*	*1000*	*1200*	—	—	—	—	—	—	—	—
K4	155	180	215	255	160	180	215	260	140	160	190	225	130	145	175	205	215	245	290	345	—	—	—	—	—	—	—	—
	510	*590*	*710*	*840*	*520*	*590*	*710*	*850*	*460*	*520*	*620*	*740*	*425*	*475*	*570*	*670*	*710*	*800*	*950*	*1125*	—	—	—	—	—	—	—	—
K5	95	110	130	155	100	110	135	160	85	95	115	140	80	90	105	125	130	150	180	210	—	—	—	—	—	—	—	—
	310	*360*	*425*	*510*	*330*	*360*	*445*	*520*	*280*	*310*	*375*	*460*	*260*	*295*	*345*	*410*	*425*	*490*	*590*	*690*	—	—	—	—	—	—	—	—
K6	140	155	190	225	140	160	190	225	125	140	165	200	110	125	150	180	190	215	255	305	—	—	—	—	—	—	—	—
	460	*510*	*620*	*740*	*460*	*520*	*620*	*740*	*410*	*460*	*540*	*660*	*360*	*410*	*490*	*590*	*620*	*710*	*840*	*1000*	—	—	—	—	—	—	—	—
K7	125	140	170	200	125	145	170	200	110	125	150	175	100	115	135	160	170	190	230	270	—	—	—	—	—	—	—	—
	410	*460*	*560*	*660*	*410*	*475*	*560*	*660*	*360*	*410*	*490*	*570*	*330*	*375*	*445*	*520*	*560*	*620*	*750*	*890*	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	1300	1475	1800	2125	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*4275*	*4850*	*5900*	*6975*	—	—	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	—	—	520	590	720	860	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*1700*	*1925*	*2350*	*2825*	—	—	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	—	—	350	395	480	570	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*1150*	*1300*	*1575*	*1875*	—	—	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	—	—	400	450	550	650	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*1300*	*1475*	*1800*	*2125*	—	—	—	—	—	—	—	—	—	—	—	—
S1	50	55	70	80	50	60	70	80	46	50	60	75	44	50	60	70	—	—	—	—	46	50	60	75	55	65	75	90
	165	*180*	*230*	*260*	*165*	*195*	*230*	*260*	*150*	*165*	*195*	*245*	*145*	*165*	*195*	*230*	—	—	—	—	*150*	*165*	*195*	*245*	*180*	*215*	*245*	*295*
S2	41	46	55	65	42	47	55	65	37	42	50	60	36	40	48	55	—	—	—	—	37	42	50	60	45	50	60	70
	135	*150*	*180*	*215*	*140*	*155*	*180*	*215*	*120*	*140*	*165*	*195*	*120*	*130*	*155*	*180*	—	—	—	—	*120*	*140*	*165*	*195*	*150*	*165*	*195*	*230*
S3	36	40	48	55	37	41	49	60	33	37	44	50	31	35	42	50	—	—	—	—	33	37	44	50	40	45	55	65
	120	*130*	*155*	*180*	*120*	*135*	*160*	*195*	*110*	*120*	*145*	*165*	*100*	*115*	*140*	*165*	—	—	—	—	*110*	*120*	*145*	*165*	*130*	*150*	*180*	*215*
S11	70	80	95	115	70	80	95	115	65	70	85	105	60	70	85	100	—	—	—	—	65	70	85	105	80	90	105	125
	230	*260*	*310*	*375*	*230*	*260*	*310*	*375*	*215*	*230*	*280*	*345*	*195*	*230*	*280*	*330*	—	—	—	—	*215*	*230*	*280*	*345*	*260*	*295*	*345*	*410*
S12	48	55	65	80	49	55	65	80	44	50	60	70	42	48	55	70	—	—	—	—	44	50	60	70	55	60	75	85
	155	*180*	*215*	*260*	*160*	*180*	*215*	*260*	*145*	*165*	*195*	*230*	*140*	*155*	*180*	*230*	—	—	—	—	*145*	*165*	*195*	*230*	*180*	*195*	*245*	*280*
S13	28	32	38	45	29	33	39	46	26	29	35	41	25	28	33	40	—	—	—	—	26	29	35	41	32	36	43	50
	90	*105*	*125*	*150*	*95*	*110*	*130*	*150*	*85*	*95*	*115*	*135*	*80*	*90*	*110*	*130*	—	—	—	—	*85*	*95*	*115*	*135*	*105*	*120*	*140*	*165*
H5	41	47	55	65	42	48	60	65	41	46	55	65	37	42	50	60	—	—	—	—	—	—	—	—	—	—	—	—
	135	*155*	*180*	*215*	*140*	*155*	*195*	*215*	*135*	*150*	*180*	*215*	*120*	*140*	*165*	*195*	—	—	—	—	—	—	—	—	—	—	—	—
H8	44	50	60	70	45	50	60	70	43	49	60	70	40	45	55	60	—	—	—	—	—	—	—	—	—	—	—	—
	145	*165*	*195*	*230*	*150*	*165*	*195*	*230*	*140*	*160*	*195*	*230*	*130*	*150*	*180*	*195*	—	—	—	—	—	—	—	—	—	—	—	—
H11	55	60	70	85	55	60	75	85	50	60	70	80	47	55	65	75	—	—	—	—	—	—	—	—	—	—	—	—
	180	*195*	*230*	*280*	*180*	*195*	*245*	*280*	*165*	*195*	*230*	*260*	*155*	*180*	*215*	*245*	—	—	—	—	—	—	—	—	—	—	—	—
H12	90	100	120	140	90	100	120	140	80	90	105	120	70	80	95	110	—	—	—	—	—	—	—	—	—	—	—	—
	295	*330*	*395*	*460*	*295*	*330*	*395*	*460*	*260*	*295*	*345*	*395*	*230*	*260*	*310*	*360*	—	—	—	—	—	—	—	—	—	—	—	—
H21	44	50	60	70	45	50	60	70	43	49	60	70	40	45	55	60	—	—	—	—	—	—	—	—	—	—	—	—
	145	*165*	*195*	*230*	*150*	*165*	*195*	*230*	*140*	*160*	*195*	*230*	*130*	*150*	*180*	*195*	—	—	—	—	—	—	—	—	—	—	—	—

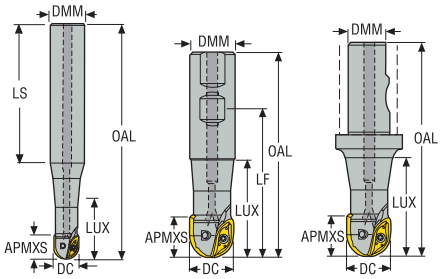
Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R218.20/19/24 BALLNOSE

We offer a variety of highly productive ballnose cutters for all materials and applications, ranging from general purpose to segment-oriented tools. The ballnose cutter is designed to deliver higher performance and better reliability in copy milling applications.

- Ballnose K=1, 3-cutting edge, cutter range 16-40 mm (.625 - 2 inch)
- Ballnose K=2, 2-cutting edge, cutter range 12-50 mm (.5 - 2 inch)
- Tapered Ballnose, 2-cutting edge, cutter range 12.7-25 mm (0.5 inch)

R218.20 – Metric



- For insert selection and cutting data recommendations, see page(s) 607-639
- For complete insert programme, see page(s) 770, 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	LF	OAL	LUX	RMPX°	RPMX	Weight	218.20	SPM.
			mm		mm	mm	mm	mm	mm	mm	mm			kg		
R218.20-1612.0-10.112A	02627903	Cylindrical	12,0	2	10,0	–	16,0	120,0	–	160,0	25,0	45,0	30000	0,3	-060(2)	–
R218.20-2016.0-14.070A	02722506	Cylindrical	16,0	2	14,0	8,0	20,0	70,0	–	120,0	36,0	45,0	28500	0,3	-080(2)	–
R218.20-1616.0-14.105E	00031596	Cylindrical	16,0	2	14,0	8,0	16,0	115,0	–	165,0	49,0	45,0	28500	0,5	-080(2)	–
R218.20-2520.0-18.120A	00031701	Cylindrical	20,0	2	18,0	10,0	25,0	104,0	–	176,0	54,0	45,0	20200	0,5	-100(2)	–
R218.20-3225.0-22.160A	00031940	Cylindrical	25,0	2	22,0	12,5	32,0	130,0	–	220,0	68,0	45,0	16900	1,1	-125(2)	–
R218.20-3230.0-26.160A	00032027	Cylindrical	30,0	2	27,0	15,0	32,0	130,0	–	220,0	73,0	45,0	12500	1,1	-150(2)	–
R218.20-3232.0-28.160A	00030730	Cylindrical	32,0	2	28,0	16,0	32,0	130,0	–	220,0	90,0	45,0	10900	1,2	-160(2)	–
R218.20-2520.3-18.070A	00031654	Weldon	20,0	2	18,0	10,0	25,0	56,0	93,94	126,0	54,0	45,0	20200	0,4	-100(2)	–
R218.20-2525.3-22.060A	00038464	Weldon	25,0	2	22,0	12,5	25,0	60,0	83,96	116,0	56,0	45,0	16900	0,4	-125(2)	–
R218.20-2525.3-22.080A	00031897	Weldon	25,0	2	22,0	12,5	25,0	60,0	103,96	136,0	75,5	45,0	16900	0,5	-125(2)	–
R218.20-3230.3-45.100A	00032046	Weldon	30,0	2	44,0	15,0	32,0	70,0	123,93	160,0	71,0	45,0	12500	0,8	-150(2)	SPMT10(2)
R218.20-3232.3-28.070A	00032245	Weldon	32,0	2	28,0	16,0	32,0	60,0	93,92	130,0	68,0	45,0	10900	0,7	-160(2)	–
R218.20-3232.3-28.100A	00030731	Weldon	32,0	2	28,0	16,0	32,0	70,0	123,92	160,0	89,0	45,0	10900	0,8	-160(2)	–
R218.20-3232.3-54.100A	00030733	Weldon	32,0	2	54,0	16,0	32,0	70,0	123,92	160,0	89,0	45,0	10900	0,8	-160(2)	SPMT10(3)

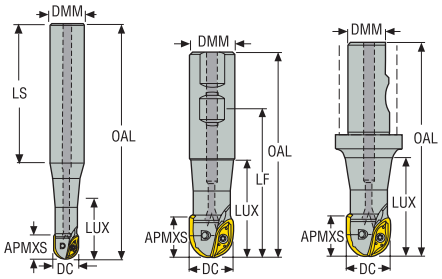
Spare Parts

Accessories

For cutter	Insert screw centre	Insert screw periph	Torque key	Torque value
R218.20-1612	C01805-T06P	–	T00-06P05	0.5NM
R218.20.. Ø16	C02506-T08P	–	T00-08P12	1.2NM
R218.20.. Ø20	C03007-T09P	–	T00-09P20	2.0NM
R218.20.. Ø25-30	C04009-T15P	–	T00-15P35	3.5NM
R218.20.. Ø32	C04011-T15P	–	T00-15P35	3.5NM
R218.20.. Ø30-100A	C04009-T15P	C03508-T15P	T00-15P35	3.0NM
R218.20.. Ø32-100A	C04011-T15P	C03508-T15P	T00-15P35	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.20 – Metric



- For insert selection and cutting data recommendations, see page(s) 607-639
- For complete insert programme, see page(s) 751, 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	LF	OAL	LUX	RMPX°	RPMX	Weight	218.20	SCET
			mm		mm	mm	mm	mm	mm	mm	mm			kg		
R218.20-5050.3-70.150	00032677	Weldon	50,0	2	70,0	25,0	50,0	80,0	184,87	229,87	149,0	45,0	3700	2,9	-250(2)	SC..12 (3)
R218.20-3240.3S-60.100	00032440	Seco-Weldon	40,0	2	60,0	20,0	32,0	59,5	–	159,4	89,0	45,0	7200	1,0	-200(2)	SC..12 (3)
R218.20-3250.3S-70.100	00032627	Seco-Weldon	50,0	2	70,0	25,0	32,0	59,5	–	159,37	91,0	45,0	3700	1,2	-250(2)	SC..12 (3)

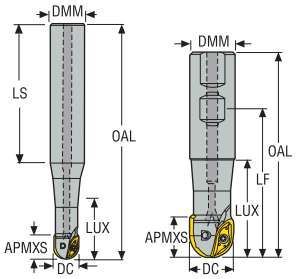
Spare Parts

Accessories

For cutter	Insert screw centre	Insert screw periph	Torque key	Torque value
R218.20.. Ø50	C06018-T25P	C45011-T20P	T00T-25P80	5.0NM
R218.20.. Ø40	C05013-T20P	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.20 – Inch



- For insert selection and cutting data recommendations, see page(s) 607-639
- For complete insert programme, see page(s) 770, 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	LF	OAL	LUX	RMPX°	RPMX	Weight	218.20	SPM.
			Inch		Inch	Inch	Inch	Inch	Inch	Inch	Inch			lbs		
R218.20-0.500.0-11-111A	02687512	Cylindrical	0.500	2	0.433	0.250	0.625	4.724	–	6.298	1.142	45,0	30000	0.660	-0.250.R (2)	–
R218.20-0.625.0-14-070A	02740370	Cylindrical	0.625	2	0.551	0.313	0.750	2.819	–	4.785	1.398	45,0	28500	0.660	-080.R (2)	–
R218.20-0.750.0-17-120A	00040031	Cylindrical	0.750	2	0.669	0.375	1.000	4.248	–	7.002	2.087	45,0	20200	1.320	-0.375.R (2)	–
R218.20-01.00.0-22-160A	00040032	Cylindrical	1.000	2	0.866	0.500	1.250	4.996	–	8.577	2.795	45,0	16900	2.430	-125.R (2)	–
R218.20-0.500.3-11-060A	02687514	Weldon	0.500	2	0.433	0.250	0.750	2.362	3.313	4.331	0.827	45,0	30000	0.440	-0.250.R (2)	–
R218.20-0.625.3-14-050A	02740373	Weldon	0.625	2	0.551	0.313	0.625	2.299	2.919	3.874	1.500	45,0	28500	0.440	-080 (2)	–
R218.20-0.750.3-17-070A	00040022	Weldon	0.750	2	0.669	0.375	1.000	2.280	3.895	5.035	2.000	45,0	20200	1.100	-0.375.R (2)	–
R218.20-01.00.3-22-070A	00040024	Weldon	1.000	2	0.866	0.500	1.000	2.362	3.896	5.039	2.000	45,0	16900	1.100	-125.R (2)	–
R218.20-01.00.3-45-080A	02428546	Weldon	1.000	2	1.772	0.500	1.000	2.362	4.290	5.429	3.000	45,0	16900	0.880	-125.R (2)	SPMX09 (3)
R218.20-01.25.3-28-100A	00040025	Weldon	1.250	2	1.102	0.625	1.250	2.673	5.073	6.213	3.500	45,0	10900	1.760	-160.R (2)	–
R218.20-01.25.3-54-100A	00040026	Weldon	1.250	2	2.126	0.625	1.250	2.673	5.073	6.213	3.500	45,0	10900	1.760	-160.R (2)	SPMT10 (3)
R218.20-01.50.3-34-100A	00040027	Weldon	1.500	2	1.339	0.750	1.500	3.083	5.435	6.626	3.500	45,0	7200	2.650	-0.750.R (2)	–

Spare Parts

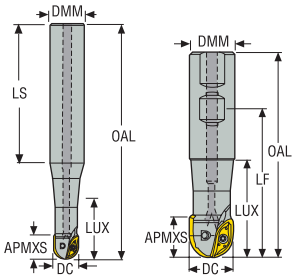
Accessories

For cutter	Insert screw	Insert screw centre	Insert screw periph	Torque key	Torque value
Ø 00.500	C02052-T06P	–	–	T00-06P05	4.4IN.LBS
Ø 00.625	C02506-T08P	–	–	T00-08P12	10.6IN.LBS
Ø 00.750	C03006-T09P	–	–	T00-09P20	17.7IN.LBS
Ø 01.00	C04009-T15P	–	–	T00-15P35	31.0IN.LBS
Ø 01.00 SPM.	–	C04009-T15P	C03007-T09P	T00-15P35	31.0IN.LBS
Ø 01.25	C04011-T15P	–	–	T00-15P35	31.0IN.LBS
Ø 01.25 SPM.	–	C04011-T15P	C03508-T15P	T00-15P35	31.0IN.LBS
Ø 01.50	C05013-T20P	–	–	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R218.20 – Inch



- For insert selection and cutting data recommendations, see page(s) 607-639
- For complete insert programme, see page(s) 751, 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DMM	LS	LF	OAL	LUX	RMPX°	RPMX	Weight	218.20	SCET
			Inch		Inch	Inch	Inch	Inch	Inch	Inch	Inch			lbs		
R218.20-01.50.3-60-110A	00040028	Weldon	1.500	2	2.362	0.750	1.500	3.083	5.829	7.020	3.917	45,0	7200	2.650	-0.750.R (2)	SC..12 (3)
R218.20-01.50.3-60-152A	02723631	Weldon	1.500	2	2.362	0.750	1.500	3.083	7.482	8.673	5.571	45,0	7200	3.310	-0.750.R (2)	SC..12 (3)
R218.20-02.00.3-70-120A	02740375	Weldon	2.000	2	2.756	1.000	2.000	3.243	6.124	7.967	4.705	45,0	3700	5.730	-250.R (2)	SC..12 (3)
R218.20-02.00.3-70-152A	02723632	Weldon	2.000	2	2.756	1.000	2.000	3.243	7.383	9.227	5.965	45,0	3700	6.170	-250.R (2)	SC..12 (3)
R218.20-02.00.3-70-203A	02723633	Weldon	2.000	2	2.756	1.000	2.000	3.243	9.391	11.235	7.972	45,0	3700	7.940	-250.R (2)	SC..12 (3)

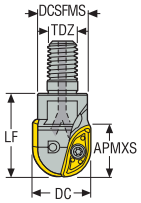
Spare Parts

Accessories

For cutter	Insert screw centre	Insert screw periph	Torque key	Torque value
Dia 01.50	C05013-T20P	C45011-T20P	T00-20P50	44.3IN.LBS
Dia 02.00	C06018-T25P	C45011-T20P	T00T-25P80	70.8IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.20 – Metric



- For insert selection and cutting data recommendations, see page(s) 607-639
- For complete insert programme, see page(s) 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCSFMS	TDZ	LF	RMPX°	RPMX	Weight	218.20
			mm		mm	mm	mm		mm			kg	
R218.20-0612.RE-10A	02731891	Combimaster	12,0	2	10,0	6,0	11,0	M6	20,0	45,0	30000	0,1	-060(2)
R218.20-0812.RE-10A	02627909	Combimaster	12,0	2	10,0	6,0	13,5	M8	23,0	45,0	30000	0,1	-060(2)
R218.20-0816.RE-14A	02742691	Combimaster	16,0	2	14,0	8,0	13,5	M8	23,0	45,0	28500	0,1	-080(2)
R218.20-1016.RE-14A	00031585	Combimaster	16,0	2	14,0	8,0	18,0	M10	28,0	45,0	28500	0,1	-080(2)
R218.20-1020.RE-18A	00039896	Combimaster	20,0	2	18,0	10,0	18,0	M10	28,0	45,0	20200	0,1	-100(2)
R218.20-1220.RE-18A	00031619	Combimaster	20,0	2	18,0	10,0	21,5	M12	35,0	45,0	20200	0,2	-100(2)
R218.20-1225.RE-22A	00031777	Combimaster	25,0	2	22,0	12,5	21,5	M12	35,0	45,0	16900	0,1	-125(2)
R218.20-1630.RE-26A	00032025	Combimaster	30,0	2	27,0	15,0	28,5	M16	40,0	45,0	12500	0,2	-150(2)
R218.20-1632.RE-28A	00030728	Combimaster	32,0	2	28,0	16,0	28,5	M16	40,0	45,0	10900	0,3	-160(2)
R218.20-1640.RE-35A	00032409	Combimaster	40,0	2	35,0	20,0	34,0	M16	50,0	45,0	7200	0,3	-200(2)
R218.20-2040.RE-35A	02928081	Combimaster	40,0	2	35,0	20,0	36,5	M20	54,9	45,0	7200	0,3	-200(2)
R218.20-2050.RE-44A	02928082	Combimaster	50,0	2	44,0	25,0	36,5	M20	64,87	45,0	5000	0,4	-250(2)

For Combimaster Shanks, see Machining Navigator Tooling System

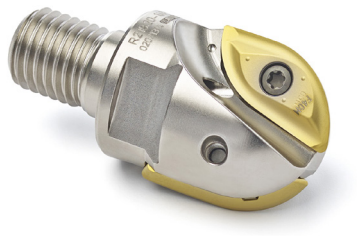
Spare Parts

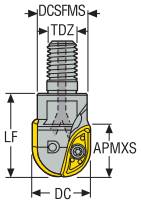
Accessories

For cutter	Insert screw	Torque key	Torque value
R218.20-.. Ø 12	C01805-T06P	T00-06P05	0.5NM
R218.20-.. Ø 16	C02506-T08P	T00-08P12	1.2NM
R218.20-.. Ø 20	C03007-T09P	T00-09P20	2.0NM
R218.20-.. Ø 25-30	C04009-T15P	T00-15P35	3.5NM
R218.20-.. Ø 32	C04011-T15P	T00-15P35	3.5NM
R218.20-..1640	C05013-T20P	T00-20P50	5.0NM
R218.20-..2040	C05013-T20P	T00-20P50	5.0NM
R218.20-.. Ø 50	C06018-T25P	T00T-25P80	8.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.20 – Inch





- For insert selection and cutting data recommendations, see page(s) 607-639
- For complete insert programme, see page(s) 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	APMXE	DCSFMS	TDZ	LF	RMPX°	RPMX	Weight	218.20
			Inch		Inch	Inch	Inch		Inch			lbs	
R218.20-0.500-06RE-11A	02687515	Combimaster	0.500	2	0.433	0.250	0.433	M6	0.787	45,0	30000	0.020	-0.250.R (2)
R218.20-0.500-08RE-11A	02687516	Combimaster	0.500	2	0.433	0.250	0.531	M8	0.906	45,0	28500	0.020	-0.250.R (2)
R218.20-0.625-08RE-14A	02742688	Combimaster	0.625	2	0.551	0.313	0.531	M8	0.906	45,0	28500	0.020	-080.R (2)
R218.20-0.750-10RE-17A	02428548	Combimaster	0.750	2	0.669	0.375	0.728	M10	1.102	45,0	20200	0.220	-0.375.R (2)
R218.20-01.00-12RE-22A	00040018	Combimaster	1.000	2	0.866	0.500	0.846	M12	1.378	45,0	16900	0.220	-125.R (2)
R218.20-01.25-16RE-28A	00040019	Combimaster	1.250	2	1.102	0.625	1.122	M16	1.575	45,0	10900	0.220	-160.R (2)
R218.20-01.50-16RE-34A	00040020	Combimaster	1.500	2	1.339	0.750	1.339	M16	1.969	45,0	7200	0.220	-0.750.R (2)
R218.20-01.50-20RE-34A	02928065	Combimaster	1.500	2	1.339	0.750	1.437	M20	2.165	45,0	7200	0.660	-0.750.R (2)
R218.20-02.00-20RE-44A	02928066	Combimaster	2.000	2	1.732	1.000	1.437	M20	2.559	45,0	5000	1.100	-250(2)

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R218.20-0.500	C02052-T06P	T00-06P05	4.4IN.LBS
R218.20-0.625	C02506-T08P	T00-08P12	10.6IN.LBS
R218.20-0.750	C03006-T09P	T00-09P20	17.7IN.LBS
R218.20-01.00	C04009-T15P	T00-15P35	31.0IN.LBS
R218.20-01.25	C04011-T15P	T00-15P35	31.0IN.LBS
R218.20-01.50	C05013-T20P	T00-20P50	44.3IN.LBS
R218.20-02.00	C06018-T25P	T00T-25P80	70.8IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.20-0.250 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*
P2	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*
P3	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,042 *0.0017*	0,042 *0.0017*	0,046 *0.0018*
P4	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,042 *0.0017*	0,042 *0.0017*	0,046 *0.0018*
P5	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
P6	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
P7	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
P8	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,042 *0.0017*	0,042 *0.0017*	0,046 *0.0018*
P11	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
M1	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*
M2	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
M3	218.20-0.250ER-ME03 F40M	5,0 *0.20*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*
M4	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,032 *0.0013*	0,032 *0.0013*	0,032 *0.0013*
M5	218.20-0.250ER-M03 F40M	4,0 *0.16*	0,032 *0.0013*	0,032 *0.0013*	0,032 *0.0013*
K1	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*
K2	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
K3	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
K4	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
K5	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*
K6	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*
K7	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*
N1	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*
N2	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*
N3	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*
N11	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*
S1	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,032 *0.0013*	0,032 *0.0013*	0,032 *0.0013*
S2	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,032 *0.0013*	0,032 *0.0013*	0,032 *0.0013*
S3	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,030 *0.0012*	0,030 *0.0012*	0,030 *0.0012*
S11	218.20-0.250ER-ME03 F40M	4,5 *0.18*	0,036 *0.0014*	0,036 *0.0014*	0,038 *0.0015*
S12	218.20-0.250ER-ME03 F40M	4,5 *0.18*	0,036 *0.0014*	0,036 *0.0014*	0,038 *0.0015*
S13	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,032 *0.0013*	0,032 *0.0013*	0,032 *0.0013*
H5	218.20-0.250ER-M03 F40M	5,0 *0.20*	0,030 *0.0012*	0,030 *0.0012*	0,032 *0.0013*
H8	218.20-0.250ER-M03 F40M	4,5 *0.18*	0,024 *0.00095*	0,024 *0.00095*	0,024 *0.00095*
H11	218.20-0.250ER-M03 F40M	5,0 *0.20*	0,030 *0.0012*	0,030 *0.0012*	0,032 *0.0013*
H12	218.20-0.250ER-M03 F40M	4,5 *0.18*	0,024 *0.00095*	0,024 *0.00095*	0,024 *0.00095*
H21	218.20-0.250ER-M03 F40M	4,5 *0.18*	0,024 *0.00095*	0,024 *0.00095*	0,024 *0.00095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-0.250 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			15%	10%	5%
P1	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
P2	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
P3	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P4	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P5	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P6	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P7	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
P8	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P11	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*
M1	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
M2	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
M3	218.20-0.250ER-ME03 F40M	5,0 *0.20*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
M4	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
M5	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
K1	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
K2	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
K3	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
K4	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
K5	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*
K6	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
K7	218.20-0.250ER-M03 F40M	7,0 *0.28*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*
N1	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
N2	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
N3	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
N11	218.20-0.250ER-ME03 F40M	7,0 *0.28*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
S1	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
S2	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
S3	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*
S11	218.20-0.250ER-ME03 F40M	4,5 *0.18*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S12	218.20-0.250ER-ME03 F40M	4,5 *0.18*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S13	218.20-0.250ER-ME03 F40M	4,0 *0.16*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
H5	218.20-0.250ER-M03 F40M	5,0 *0.20*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*
H8	218.20-0.250ER-M03 F40M	4,5 *0.18*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*
H11	218.20-0.250ER-M03 F40M	5,0 *0.20*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*
H12	218.20-0.250ER-M03 F40M	4,5 *0.18*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*
H21	218.20-0.250ER-M03 F40M	4,5 *0.18*	0,030 *0.0012*	0,034 *0.0013*	0,048 *0.0019*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-0.250 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M				
	100%	70%	30%	10%	5%
P1	295 *970*	325 *1075*	385 *1275*	450 *1475*	490 *1600*
P2	290 *950*	315 *1025*	375 *1225*	435 *1425*	480 *1575*
P3	250 *820*	275 *900*	325 *1075*	380 *1250*	415 *1350*
P4	220 *720*	240 *790*	285 *940*	335 *1100*	365 *1200*
P5	210 *690*	230 *750*	275 *900*	325 *1075*	350 *1150*
P6	235 *770*	260 *850*	310 *1025*	360 *1175*	395 *1300*
P7	225 *740*	245 *800*	290 *950*	340 *1125*	370 *1225*
P8	210 *690*	230 *750*	270 *890*	320 *1050*	350 *1150*
P11	220 *720*	240 *790*	280 *920*	330 *1075*	360 *1175*
M1	230 *750*	255 *840*	300 *980*	350 *1150*	385 *1275*
M2	190 *620*	210 *690*	245 *800*	290 *950*	315 *1025*
M3	160 *520*	175 *570*	205 *670*	225 *740*	245 *800*
M4	125 *410*	135 *445*	160 *520*	170 *560*	190 *620*
M5	105 *345*	110 *360*	135 *445*	145 *475*	155 *510*
K1	230 *750*	250 *820*	295 *970*	345 *1125*	380 *1250*
K2	200 *660*	220 *720*	260 *850*	305 *1000*	330 *1075*
K3	170 *560*	185 *610*	220 *720*	260 *850*	280 *920*
K4	160 *520*	180 *590*	210 *690*	245 *800*	265 *870*
K5	100 *330*	105 *345*	125 *410*	150 *490*	160 *520*
K6	145 *475*	155 *510*	185 *610*	220 *720*	235 *770*
K7	125 *410*	140 *460*	160 *520*	190 *620*	205 *670*
N1	1750 *5750*	1900 *6225*	2250 *7375*	2650 *8700*	2875 *9425*
N2	700 *2300*	770 *2525*	910 *2975*	1075 *3525*	1175 *3850*
N3	470 *1550*	510 *1675*	610 *2000*	710 *2325*	780 *2550*
N11	530 *1750*	580 *1900*	700 *2300*	810 *2650*	890 *2925*
S1	60 *195*	65 *215*	75 *245*	80 *260*	90 *295*
S2	48 *155*	50 *165*	60 *195*	65 *215*	70 *230*
S3	41 *135*	44 *145*	50 *165*	55 *180*	60 *195*
S11	85 *280*	90 *295*	105 *345*	115 *375*	125 *410*
S12	55 *180*	60 *195*	75 *245*	80 *260*	85 *280*
S13	33 *110*	35 *115*	42 *140*	45 *150*	49 *160*
H5	48 *155*	50 *165*	60 *195*	70 *230*	75 *245*
H8	50 *165*	55 *180*	65 *215*	70 *230*	75 *245*
H11	60 *195*	65 *215*	80 *260*	85 *280*	95 *310*
H12	90 *295*	95 *310*	115 *375*	125 *410*	135 *445*
H21	50 *165*	55 *180*	65 *215*	70 *230*	75 *245*

R218.20-0.375 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
P2	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
P3	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
P4	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
P5	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
P6	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
P7	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
P8	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
P11	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
M1	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
M2	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
M3	218.20-0.375ER-ME05 F40M	8,0 *0.32*	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*
M4	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
M5	218.20-0.375ER-M05 F40M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
K1	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
K2	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
K3	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
K4	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
K5	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*
K6	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
K7	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*
N1	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
N2	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
N3	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
N11	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S1	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
S2	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
S3	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,050 *0.0020*	0,050 *0.0020*	0,050 *0.0020*
S11	218.20-0.375ER-ME05 F40M	7,0 *0.28*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
S12	218.20-0.375ER-ME05 F40M	7,0 *0.28*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
S13	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H5	218.20-0.375ER-M05 F25M	8,0 *0.32*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*
H8	218.20-0.375ER-M05 F25M	7,0 *0.28*	0,038 *0.0015*	0,038 *0.0015*	0,040 *0.0016*
H11	218.20-0.375ER-M05 F25M	8,0 *0.32*	0,048 *0.0019*	0,048 *0.0019*	0,050 *0.0020*
H12	218.20-0.375ER-M05 F25M	7,0 *0.28*	0,038 *0.0015*	0,038 *0.0015*	0,040 *0.0016*
H21	218.20-0.375ER-M05 F25M	7,0 *0.28*	0,038 *0.0015*	0,038 *0.0015*	0,040 *0.0016*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-0.375 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			15%	10%	5%
P1	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
P2	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
P3	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P4	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,12 *0.0048*	0,16 *0.0065*
P5	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
P6	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
P7	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
P8	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*
P11	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
M1	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
M2	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
M3	218.20-0.375ER-ME05 F40M	8,0 *0.32*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
M4	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
M5	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
K1	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
K2	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
K3	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
K4	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
K5	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
K6	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
K7	218.20-0.375ER-M05 F25M	10,0 *0.40*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
N1	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
N2	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
N3	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
N11	218.20-0.375ER-ME05 F40M	10,0 *0.40*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
S1	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
S2	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
S3	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
S11	218.20-0.375ER-ME05 F40M	7,0 *0.28*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
S12	218.20-0.375ER-ME05 F40M	7,0 *0.28*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
S13	218.20-0.375ER-ME05 F40M	6,0 *0.24*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
H5	218.20-0.375ER-M05 F25M	8,0 *0.32*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
H8	218.20-0.375ER-M05 F25M	7,0 *0.28*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
H11	218.20-0.375ER-M05 F25M	8,0 *0.32*	0,065 *0.0026*	0,075 *0.0030*	0,11 *0.0044*
H12	218.20-0.375ER-M05 F25M	7,0 *0.28*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*
H21	218.20-0.375ER-M05 F25M	7,0 *0.28*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-0.375 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F25M					F40M				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	280 *920*	305 *1000*	370 *1225*	435 *1425*	475 *1550*	270 *890*	295 *970*	355 *1175*	420 *1375*	455 *1500*
P2	275 *900*	300 *980*	360 *1175*	425 *1400*	460 *1500*	265 *870*	285 *940*	345 *1125*	410 *1350*	445 *1450*
P3	240 *790*	260 *850*	315 *1025*	365 *1200*	400 *1300*	230 *750*	250 *820*	300 *980*	350 *1150*	385 *1275*
P4	210 *690*	230 *750*	275 *900*	320 *1050*	355 *1175*	205 *670*	220 *720*	265 *870*	310 *1025*	340 *1125*
P5	200 *660*	220 *720*	265 *870*	310 *1025*	335 *1100*	195 *640*	210 *690*	255 *840*	300 *980*	325 *1075*
P6	225 *740*	245 *800*	295 *970*	350 *1150*	385 *1275*	220 *720*	235 *770*	285 *940*	335 *1100*	370 *1225*
P7	215 *710*	230 *750*	280 *920*	330 *1075*	360 *1175*	205 *670*	225 *740*	270 *890*	320 *1050*	350 *1150*
P8	200 *660*	220 *720*	265 *870*	305 *1000*	335 *1100*	195 *640*	210 *690*	255 *840*	295 *970*	325 *1075*
P11	205 *670*	225 *740*	270 *890*	320 *1050*	350 *1150*	200 *660*	215 *710*	260 *850*	310 *1025*	340 *1125*
M1	— —	— —	— —	— —	— —	215 *710*	230 *750*	280 *920*	330 *1075*	360 *1175*
M2	— —	— —	— —	— —	— —	175 *570*	190 *620*	230 *750*	270 *890*	290 *950*
M3	— —	— —	— —	— —	— —	150 *490*	160 *520*	190 *620*	215 *710*	235 *770*
M4	— —	— —	— —	— —	— —	120 *395*	125 *410*	150 *490*	165 *540*	180 *590*
M5	— —	— —	— —	— —	— —	100 *330*	105 *345*	125 *410*	135 *445*	150 *490*
K1	220 *720*	235 *770*	285 *940*	335 *1100*	365 *1200*	210 *690*	230 *750*	275 *900*	325 *1075*	350 *1150*
K2	190 *620*	210 *690*	250 *820*	295 *970*	320 *1050*	185 *610*	200 *660*	240 *790*	285 *940*	310 *1025*
K3	160 *520*	175 *570*	210 *690*	250 *820*	270 *890*	155 *510*	170 *560*	205 *670*	240 *790*	260 *850*
K4	155 *510*	170 *560*	200 *660*	240 *790*	260 *850*	150 *490*	160 *520*	195 *640*	230 *750*	250 *820*
K5	95 *310*	105 *345*	125 *410*	145 *475*	155 *510*	90 *295*	100 *330*	120 *395*	140 *460*	150 *490*
K6	135 *445*	150 *490*	180 *590*	210 *690*	230 *750*	130 *425*	140 *460*	170 *560*	205 *670*	220 *720*
K7	120 *395*	130 *425*	160 *520*	185 *610*	200 *660*	115 *375*	125 *410*	150 *490*	180 *590*	195 *640*
N1	— —	— —	— —	— —	— —	1575 *5175*	1700 *5575*	2075 *6800*	2425 *7950*	2650 *8700*
N2	— —	— —	— —	— —	— —	640 *2100*	690 *2275*	840 *2750*	980 *3225*	1075 *3525*
N3	— —	— —	— —	— —	— —	425 *1400*	460 *1500*	560 *1825*	650 *2125*	710 *2325*
N11	— —	— —	— —	— —	— —	485 *1600*	530 *1750*	640 *2100*	740 *2425*	810 *2650*
S1	55 *180*	60 *195*	70 *230*	80 *260*	85 *280*	55 *180*	60 *195*	70 *230*	75 *245*	85 *280*
S2	46 *150*	48 *155*	60 *195*	65 *215*	70 *230*	44 *145*	46 *150*	55 *180*	60 *195*	65 *215*
S3	40 *130*	42 *140*	50 *165*	55 *180*	60 *195*	39 *130*	41 *135*	49 *160*	55 *180*	60 *195*
S11	80 *260*	85 *280*	100 *330*	110 *360*	125 *410*	75 *245*	80 *260*	100 *330*	110 *360*	120 *395*
S12	55 *180*	60 *195*	70 *230*	75 *245*	85 *280*	55 *180*	55 *180*	70 *230*	75 *245*	80 *260*
S13	32 *105*	34 *110*	41 *135*	44 *145*	48 *155*	31 *100*	32 *105*	39 *130*	43 *140*	47 *155*
H5	46 *150*	50 *165*	60 *195*	65 *215*	70 *230*	45 *150*	48 *155*	55 *180*	65 *215*	70 *230*
H8	49 *160*	55 *180*	65 *215*	70 *230*	75 *245*	47 *155*	50 *165*	60 *195*	65 *215*	75 *245*
H11	60 *195*	65 *215*	75 *245*	85 *280*	90 *295*	55 *180*	60 *195*	75 *245*	80 *260*	90 *295*
H12	90 *295*	95 *310*	110 *360*	125 *410*	135 *445*	85 *280*	90 *295*	110 *360*	120 *395*	130 *425*
H21	49 *160*	55 *180*	65 *215*	70 *230*	75 *245*	47 *155*	50 *165*	60 *195*	65 *215*	75 *245*

R218.20-0.750 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
P3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P4	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P5	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P6	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P7	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P8	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P11	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
M2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	29,0 *1.1*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
M4	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M5	218.20-0.750ER-M10 MM4500	SCET120612T-M14 T350M	22,0 *0.85*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
N1	218.20-0.750ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N2	218.20-0.750ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N3	218.20-0.750ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N11	218.20-0.750ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
S1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
S11	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	25,0 *1.0*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
S12	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	25,0 *1.0*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
S13	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	22,0 *0.85*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-0.750 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
P2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P4	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P5	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P6	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P7	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P8	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P11	218.20-0.750ER-M10 MM4500	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
M1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
M2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
M3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	29,0 *1.1*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
M4	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
M5	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
N1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
N2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
N3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
N11	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
S1	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
S2	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
S3	218.20-0.750ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
S11	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	25,0 *1.0*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
S12	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	25,0 *1.0*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
S13	218.20-0.750ER-ME10 F40M	SCET120612T-M14 F40M	22,0 *0.85*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-0.750 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M					MM4500				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	200 *660*	220 *720*	265 *870*	315 *1025*	345 *1125*	155 *510*	165 *540*	205 *670*	240 *790*	260 *850*
P2	195 *640*	215 *710*	255 *840*	305 *1000*	330 *1075*	150 *490*	165 *540*	195 *640*	235 *770*	250 *820*
P3	170 *560*	185 *610*	225 *740*	270 *890*	285 *940*	130 *425*	140 *460*	170 *560*	205 *670*	220 *720*
P4	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	115 *375*	125 *410*	155 *510*	180 *590*	195 *640*
P5	145 *475*	155 *510*	190 *620*	225 *740*	245 *800*	110 *360*	120 *395*	145 *475*	170 *560*	185 *610*
P6	160 *520*	175 *570*	215 *710*	255 *840*	275 *900*	125 *410*	135 *445*	165 *540*	195 *640*	210 *690*
P7	155 *510*	165 *540*	205 *670*	240 *790*	260 *850*	115 *375*	125 *410*	155 *510*	180 *590*	200 *660*
P8	140 *460*	155 *510*	190 *620*	225 *740*	240 *790*	110 *360*	120 *395*	145 *475*	170 *560*	185 *610*
P11	150 *490*	160 *520*	195 *640*	230 *750*	255 *840*	115 *375*	125 *410*	150 *490*	175 *570*	195 *640*
M1	160 *520*	170 *560*	205 *670*	245 *800*	265 *870*	130 *425*	140 *460*	165 *540*	200 *660*	215 *710*
M2	130 *425*	140 *460*	170 *560*	205 *670*	220 *720*	105 *345*	115 *375*	140 *460*	165 *540*	180 *590*
M3	105 *345*	115 *375*	140 *460*	165 *540*	175 *570*	85 *280*	95 *310*	115 *375*	135 *445*	145 *475*
M4	85 *280*	95 *310*	115 *375*	125 *410*	135 *445*	70 *230*	75 *245*	90 *295*	105 *345*	110 *360*
M5	70 *230*	75 *245*	95 *310*	105 *345*	115 *375*	60 *195*	65 *215*	75 *245*	85 *280*	90 *295*
N1	1150 *3775*	1250 *4100*	1500 *4925*	1800 *5900*	1950 *6400*	— —	— —	— —	— —	— —
N2	460 *1500*	500 *1650*	610 *2000*	730 *2400*	790 *2600*	— —	— —	— —	— —	— —
N3	305 *1000*	335 *1100*	405 *1325*	485 *1600*	520 *1700*	— —	— —	— —	— —	— —
N11	350 *1150*	380 *1250*	465 *1525*	550 *1800*	600 *1975*	— —	— —	— —	— —	— —
S1	40 *130*	43 *140*	55 *180*	60 *195*	65 *215*	21 *70*	23 *75*	28 *90*	32 *105*	34 *110*
S2	32 *105*	35 *115*	42 *140*	48 *155*	50 *165*	17 *55*	19 *60*	23 *75*	25 *80*	27 *90*
S3	28 *90*	30 *100*	37 *120*	42 *140*	45 *150*	15 *49*	16 *50*	20 *65*	22 *70*	24 *80*
S11	55 *180*	60 *195*	70 *230*	85 *280*	90 *295*	29 *95*	31 *100*	38 *125*	44 *145*	48 *155*
S12	37 *120*	41 *135*	49 *160*	60 *195*	60 *195*	27 *90*	29 *95*	35 *115*	41 *135*	44 *145*
S13	22 *70*	24 *80*	30 *100*	33 *110*	36 *120*	16 *50*	17 *55*	21 *70*	24 *80*	25 *80*

R218.20-060 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,044 *0.0017*	0,044 *0.0017*	0,048 *0.0019*
P2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,046 *0.0018*	0,046 *0.0018*	0,050 *0.0020*
P3	218.20-060ER-ME03 F40M	6,0 *0.24*	0,044 *0.0017*	0,044 *0.0017*	0,046 *0.0018*
P4	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,046 *0.0018*
P5	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
P6	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
P7	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
P8	218.20-060ER-ME03 F40M	6,0 *0.24*	0,044 *0.0017*	0,044 *0.0017*	0,046 *0.0018*
P11	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
P12	218.20-060ER-ME03 F40M	5,0 *0.20*	0,030 *0.0012*	0,030 *0.0012*	0,030 *0.0012*
M1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,046 *0.0018*	0,046 *0.0018*	0,050 *0.0020*
M2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
M3	218.20-060ER-ME03 F40M	5,0 *0.20*	0,034 *0.0013*	0,034 *0.0013*	0,036 *0.0014*
M4	218.20-060ER-ME03 F40M	3,5 *0.14*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*
M5	218.20-060ER-ME03 F40M	3,5 *0.14*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*
K1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,046 *0.0018*	0,046 *0.0018*	0,050 *0.0020*
K2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
K3	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
K4	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
K5	218.20-060ER-ME03 F40M	6,0 *0.24*	0,038 *0.0015*	0,038 *0.0015*	0,040 *0.0016*
K6	218.20-060ER-ME03 F40M	6,0 *0.24*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
K7	218.20-060ER-ME03 F40M	6,0 *0.24*	0,038 *0.0015*	0,038 *0.0015*	0,040 *0.0016*
N1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
N2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
N3	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
N11	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
S1	218.20-060ER-ME03 F40M	3,5 *0.14*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*
S2	218.20-060ER-ME03 F40M	3,5 *0.14*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*
S3	218.20-060ER-ME03 F40M	3,5 *0.14*	0,030 *0.0012*	0,030 *0.0012*	0,030 *0.0012*
S11	218.20-060ER-ME03 MS2050	4,0 *0.16*	0,036 *0.0014*	0,036 *0.0014*	0,038 *0.0015*
S12	218.20-060ER-ME03 MS2050	4,0 *0.16*	0,036 *0.0014*	0,036 *0.0014*	0,038 *0.0015*
S13	218.20-060ER-ME03 MS2050	3,5 *0.14*	0,032 *0.0013*	0,032 *0.0013*	0,034 *0.0013*
H5	218.20-060ER-ME03 F40M	5,0 *0.20*	0,030 *0.0012*	0,030 *0.0012*	0,030 *0.0012*
H8	218.20-060ER-ME03 F40M	4,0 *0.16*	0,024 *0.00095*	0,024 *0.00095*	0,024 *0.00095*
H11	218.20-060ER-ME03 F40M	5,0 *0.20*	0,030 *0.0012*	0,030 *0.0012*	0,030 *0.0012*
H12	218.20-060ER-ME03 F40M	4,0 *0.16*	0,024 *0.00095*	0,024 *0.00095*	0,024 *0.00095*
H21	218.20-060ER-ME03 F40M	4,0 *0.16*	0,024 *0.00095*	0,024 *0.00095*	0,024 *0.00095*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-060 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			15%	10%	5%
P1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,075 *0.0030*	0,10 *0.0040*
P2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
P3	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
P4	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*
P5	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*
P6	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P7	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P8	218.20-060ER-ME03 F40M	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
P11	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,065 *0.0026*	0,095 *0.0038*
P12	218.20-060ER-ME03 F40M	5,0 *0.20*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*
M1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
M2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*
M3	218.20-060ER-ME03 F40M	5,0 *0.20*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
M4	218.20-060ER-ME03 F40M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
M5	218.20-060ER-ME03 F40M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
K1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*
K2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*
K3	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*
K4	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*
K5	218.20-060ER-ME03 F40M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*
K6	218.20-060ER-ME03 F40M	6,0 *0.24*	0,055 *0.0022*	0,070 *0.0028*	0,095 *0.0038*
K7	218.20-060ER-ME03 F40M	6,0 *0.24*	0,050 *0.0020*	0,060 *0.0024*	0,085 *0.0034*
N1	218.20-060ER-ME03 F40M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
N2	218.20-060ER-ME03 F40M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
N3	218.20-060ER-ME03 F40M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
N11	218.20-060ER-ME03 F40M	6,0 *0.24*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*
S1	218.20-060ER-ME03 F40M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
S2	218.20-060ER-ME03 F40M	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
S3	218.20-060ER-ME03 F40M	3,5 *0.14*	0,036 *0.0014*	0,044 *0.0017*	0,060 *0.0024*
S11	218.20-060ER-ME03 MS2050	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S12	218.20-060ER-ME03 MS2050	4,0 *0.16*	0,046 *0.0018*	0,055 *0.0022*	0,075 *0.0030*
S13	218.20-060ER-ME03 MS2050	3,5 *0.14*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*
H5	218.20-060ER-ME03 F40M	5,0 *0.20*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*
H8	218.20-060ER-ME03 F40M	4,0 *0.16*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
H11	218.20-060ER-ME03 F40M	5,0 *0.20*	0,038 *0.0015*	0,046 *0.0018*	0,065 *0.0026*
H12	218.20-060ER-ME03 F40M	4,0 *0.16*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*
H21	218.20-060ER-ME03 F40M	4,0 *0.16*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-060 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	305 *1000*	335 *1100*	395 *1300*	465 *1525*	510 *1675*	335 *1100*	365 *1200*	435 *1425*	510 *1675*	560 *1825*
P2	295 *970*	320 *1050*	385 *1275*	450 *1475*	495 *1625*	325 *1075*	355 *1175*	420 *1375*	495 *1625*	540 *1775*
P3	255 *840*	280 *920*	335 *1100*	390 *1275*	425 *1400*	280 *920*	305 *1000*	365 *1200*	430 *1400*	470 *1550*
P4	230 *750*	250 *820*	295 *970*	345 *1125*	375 *1225*	250 *820*	275 *900*	325 *1075*	380 *1250*	415 *1350*
P5	215 *710*	235 *770*	280 *920*	330 *1075*	360 *1175*	240 *790*	260 *850*	310 *1025*	360 *1175*	395 *1300*
P6	245 *800*	265 *870*	315 *1025*	375 *1225*	405 *1325*	270 *890*	290 *950*	350 *1150*	410 *1350*	445 *1450*
P7	230 *750*	250 *820*	300 *980*	350 *1150*	380 *1250*	255 *840*	275 *900*	330 *1075*	390 *1275*	420 *1375*
P8	215 *710*	235 *770*	280 *920*	330 *1075*	360 *1175*	235 *770*	260 *850*	310 *1025*	360 *1175*	395 *1300*
P11	225 *740*	245 *800*	290 *950*	340 *1125*	370 *1225*	245 *800*	270 *890*	320 *1050*	375 *1225*	410 *1350*
P12	145 *475*	155 *510*	185 *610*	210 *690*	230 *750*	160 *520*	170 *560*	205 *670*	230 *750*	250 *820*
M1	240 *790*	260 *850*	310 *1025*	365 *1200*	400 *1300*	265 *870*	285 *940*	340 *1125*	400 *1300*	440 *1450*
M2	195 *640*	215 *710*	255 *840*	295 *970*	325 *1075*	215 *710*	235 *770*	280 *920*	325 *1075*	355 *1175*
M3	160 *520*	175 *570*	205 *670*	235 *770*	255 *840*	175 *570*	190 *620*	225 *740*	255 *840*	280 *920*
M4	130 *425*	135 *445*	160 *520*	175 *570*	195 *640*	140 *460*	150 *490*	175 *570*	195 *640*	215 *710*
M5	110 *360*	115 *375*	135 *445*	150 *490*	160 *520*	120 *395*	125 *410*	150 *490*	165 *540*	180 *590*
K1	235 *770*	255 *840*	305 *1000*	355 *1175*	390 *1275*	— —	— —	— —	— —	— —
K2	205 *670*	225 *740*	270 *890*	310 *1025*	340 *1125*	— —	— —	— —	— —	— —
K3	175 *570*	190 *620*	225 *740*	265 *870*	290 *950*	— —	— —	— —	— —	— —
K4	165 *540*	180 *590*	215 *710*	250 *820*	275 *900*	— —	— —	— —	— —	— —
K5	100 *330*	110 *360*	130 *425*	155 *510*	165 *540*	— —	— —	— —	— —	— —
K6	145 *475*	160 *520*	190 *620*	220 *720*	245 *800*	— —	— —	— —	— —	— —
K7	130 *425*	140 *460*	165 *540*	195 *640*	215 *710*	— —	— —	— —	— —	— —
N1	1775 *5825*	1925 *6325*	2325 *7625*	2725 *8950*	2975 *9750*	— —	— —	— —	— —	— —
N2	720 *2350*	780 *2550*	940 *3075*	1100 *3600*	1200 *3925*	— —	— —	— —	— —	— —
N3	475 *1550*	520 *1700*	630 *2075*	730 *2400*	800 *2625*	— —	— —	— —	— —	— —
N11	550 *1800*	590 *1925*	720 *2350*	840 *2750*	920 *3025*	— —	— —	— —	— —	— —
S1	60 *195*	65 *215*	75 *245*	85 *280*	90 *295*	65 *215*	70 *230*	85 *280*	90 *295*	100 *330*
S2	49 *160*	50 *165*	60 *195*	65 *215*	75 *245*	55 *180*	55 *180*	65 *215*	75 *245*	80 *260*
S3	42 *140*	44 *145*	55 *180*	60 *195*	65 *215*	46 *150*	49 *160*	60 *195*	65 *215*	70 *230*
S11	85 *280*	90 *295*	105 *345*	120 *395*	130 *425*	95 *310*	100 *330*	115 *375*	130 *425*	140 *460*
S12	60 *195*	60 *195*	75 *245*	80 *260*	90 *295*	65 *215*	70 *230*	80 *260*	90 *295*	100 *330*
S13	34 *110*	36 *120*	42 *140*	47 *155*	50 *165*	37 *120*	39 *130*	47 *155*	50 *165*	55 *180*
H5	48 *155*	50 *165*	60 *195*	70 *230*	75 *245*	— —	— —	— —	— —	— —
H8	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	— —	— —	— —	— —	— —
H11	60 *195*	65 *215*	80 *260*	90 *295*	95 *310*	— —	— —	— —	— —	— —
H12	90 *295*	100 *330*	115 *375*	130 *425*	140 *460*	— —	— —	— —	— —	— —
H21	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	— —	— —	— —	— —	— —

R218.20-080 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.20-080ER-ME04 F40M	8,0 *0.32*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P2	218.20-080ER-ME04 F40M	8,0 *0.32*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
P3	218.20-080ER-ME04 F40M	8,0 *0.32*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P4	218.20-080ER-M04 F25M	8,0 *0.32*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P5	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P6	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P7	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P8	218.20-080ER-M04 F25M	8,0 *0.32*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P11	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P12	218.20-080ER-M04 F25M	7,0 *0.28*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*
M1	218.20-080ER-ME04 F40M	8,0 *0.32*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
M2	218.20-080ER-ME04 F40M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M3	218.20-080ER-ME04 F40M	7,0 *0.28*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*
M4	218.20-080ER-ME04 F40M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
M5	218.20-080ER-M04 F40M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
K1	218.20-080ER-M04 F25M	8,0 *0.32*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
K2	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K3	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K4	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K5	218.20-080ER-M04 F25M	8,0 *0.32*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*
K6	218.20-080ER-M04 F25M	8,0 *0.32*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K7	218.20-080ER-M04 F25M	8,0 *0.32*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*
N1	218.20-080ER-ME04 F40M	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
N2	218.20-080ER-ME04 F40M	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
N3	218.20-080ER-ME04 F40M	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
N11	218.20-080ER-ME04 F40M	8,0 *0.32*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
S1	218.20-080ER-ME04 T350M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
S2	218.20-080ER-ME04 T350M	5,0 *0.20*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
S3	218.20-080ER-ME04 T350M	5,0 *0.20*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*
S11	218.20-080ER-ME04 MS2050	6,0 *0.24*	0,046 *0.0018*	0,046 *0.0018*	0,050 *0.0020*
S12	218.20-080ER-ME04 MS2050	6,0 *0.24*	0,046 *0.0018*	0,046 *0.0018*	0,050 *0.0020*
S13	218.20-080ER-ME04 MS2050	5,0 *0.20*	0,042 *0.0017*	0,042 *0.0017*	0,044 *0.0017*
H5	218.20-080ER-M04 F25M	7,0 *0.28*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*
H8	218.20-080ER-M04 F25M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H11	218.20-080ER-M04 F25M	7,0 *0.28*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*
H12	218.20-080ER-M04 F25M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H21	218.20-080ER-M04 F25M	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-080 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			15%	10%	5%
P1	218.20-080ER-ME04 F40M	8,0 *0.32*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
P2	218.20-080ER-ME04 F40M	8,0 *0.32*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
P3	218.20-080ER-ME04 F40M	8,0 *0.32*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
P4	218.20-080ER-M04 F25M	8,0 *0.32*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P5	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P6	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P7	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P8	218.20-080ER-M04 F25M	8,0 *0.32*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
P11	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P12	218.20-080ER-M04 F25M	7,0 *0.28*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
M1	218.20-080ER-ME04 F40M	8,0 *0.32*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
M2	218.20-080ER-ME04 F40M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
M3	218.20-080ER-ME04 F40M	7,0 *0.28*	0,11 *0.0044*	0,13 *0.0050*	0,18 *0.0070*
M4	218.20-080ER-ME04 F40M	5,0 *0.20*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
M5	218.20-080ER-ME04 F40M	5,0 *0.20*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
K1	218.20-080ER-M04 F25M	8,0 *0.32*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
K2	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K3	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K4	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K5	218.20-080ER-M04 F25M	8,0 *0.32*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
K6	218.20-080ER-M04 F25M	8,0 *0.32*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K7	218.20-080ER-M04 F25M	8,0 *0.32*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
N1	218.20-080ER-ME04 F40M	8,0 *0.32*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
N2	218.20-080ER-ME04 F40M	8,0 *0.32*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
N3	218.20-080ER-ME04 F40M	8,0 *0.32*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
N11	218.20-080ER-ME04 F40M	8,0 *0.32*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
S1	218.20-080ER-ME04 T350M	5,0 *0.20*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
S2	218.20-080ER-ME04 T350M	5,0 *0.20*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
S3	218.20-080ER-ME04 T350M	5,0 *0.20*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
S11	218.20-080ER-ME04 MS2050	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
S12	218.20-080ER-ME04 MS2050	6,0 *0.24*	0,060 *0.0024*	0,070 *0.0028*	0,10 *0.0040*
S13	218.20-080ER-ME04 MS2050	5,0 *0.20*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*
H5	218.20-080ER-M04 F25M	7,0 *0.28*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H8	218.20-080ER-M04 F25M	6,0 *0.24*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
H11	218.20-080ER-M04 F25M	7,0 *0.28*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H12	218.20-080ER-M04 F25M	6,0 *0.24*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
H21	218.20-080ER-M04 F25M	6,0 *0.24*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-080 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	T350M					F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	285	310	370	435	475	265	285	345	405	440	250	270	320	380	415	195	210	255	300	325	305	330	395	465	500
	940	*1025*	*1225*	*1425*	*1550*	*870*	*940*	*1125*	*1325*	*1450*	*820*	*890*	*1050*	*1250*	*1350*	*640*	*690*	*840*	*980*	*1075*	*1000*	*1075*	*1300*	*1525*	*1650*
P2	270	295	360	420	460	250	270	335	390	425	235	255	315	365	400	185	200	245	285	315	295	320	385	450	490
	890	*970*	*1175*	*1375*	*1500*	*820*	*890*	*1100*	*1275*	*1400*	*770*	*840*	*1025*	*1200*	*1300*	*610*	*660*	*800*	*940*	*1025*	*970*	*1050*	*1275*	*1475*	*1600*
P3	240	260	310	365	400	220	240	290	340	370	210	225	270	320	345	165	175	210	250	270	255	275	335	390	425
	790	*850*	*1025*	*1200*	*1300*	*720*	*790*	*950*	*1125*	*1225*	*690*	*740*	*890*	*1050*	*1125*	*540*	*570*	*690*	*820*	*890*	*840*	*900*	*1100*	*1275*	*1400*
P4	210	225	275	325	355	195	210	255	305	330	185	200	240	285	310	145	155	185	225	245	230	245	295	345	375
	690	*740*	*900*	*1075*	*1175*	*640*	*690*	*840*	*1000*	*1075*	*610*	*660*	*790*	*940*	*1025*	*475*	*510*	*610*	*740*	*800*	*750*	*800*	*970*	*1125*	*1225*
P5	205	220	265	310	340	190	205	245	290	315	175	190	230	270	295	140	150	180	215	235	215	235	280	330	360
	670	*720*	*870*	*1025*	*1125*	*620*	*670*	*800*	*950*	*1025*	*570*	*620*	*750*	*890*	*970*	*460*	*490*	*590*	*710*	*770*	*710*	*770*	*920*	*1075*	*1175*
P6	230	245	300	350	380	210	230	280	325	355	200	215	260	305	330	155	170	205	240	260	245	265	315	370	410
	750	*800*	*980*	*1150*	*1250*	*690*	*750*	*920*	*1075*	*1175*	*660*	*710*	*850*	*1000*	*1075*	*510*	*560*	*670*	*790*	*850*	*800*	*870*	*1025*	*1225*	*1350*
P7	215	235	280	330	360	200	215	260	305	335	190	205	245	285	315	145	160	195	225	245	230	250	300	350	385
	710	*770*	*920*	*1075*	*1175*	*660*	*710*	*850*	*1000*	*1100*	*620*	*670*	*800*	*940*	*1025*	*475*	*520*	*640*	*740*	*800*	*750*	*820*	*980*	*1150*	*1275*
P8	200	215	260	305	335	185	200	240	285	310	175	190	225	265	290	140	150	180	210	230	215	230	280	330	360
	660	*710*	*850*	*1000*	*1100*	*610*	*660*	*790*	*940*	*1025*	*570*	*620*	*740*	*870*	*950*	*460*	*490*	*590*	*690*	*750*	*710*	*750*	*920*	*1075*	*1175*
P11	210	225	275	320	350	195	210	255	300	325	180	195	240	280	305	145	155	190	220	240	225	245	290	340	375
	690	*740*	*900*	*1050*	*1150*	*640*	*690*	*840*	*980*	*1075*	*590*	*640*	*790*	*920*	*1000*	*475*	*510*	*620*	*720*	*790*	*740*	*800*	*950*	*1125*	*1225*
P12	135	145	180	205	225	125	135	165	190	205	120	130	155	175	195	95	100	120	140	150	145	155	185	215	230
	445	*475*	*590*	*670*	*740*	*410*	*445*	*540*	*620*	*670*	*395*	*425*	*510*	*570*	*640*	*310*	*330*	*395*	*460*	*490*	*475*	*510*	*610*	*710*	*750*
M1	210	225	280	325	355	—	—	—	—	—	190	205	255	295	320	160	170	210	245	270	240	260	310	365	395
	690	*740*	*920*	*1075*	*1175*	—	—	—	—	—	*620*	*670*	*840*	*970*	*1050*	*520*	*560*	*690*	*800*	*890*	*790*	*850*	*1025*	*1200*	*1300*
M2	175	190	230	270	295	—	—	—	—	—	160	170	210	245	265	135	145	175	205	225	195	210	255	300	325
	570	*620*	*750*	*890*	*970*	—	—	—	—	—	*520*	*560*	*690*	*800*	*870*	*445*	*475*	*570*	*670*	*740*	*640*	*690*	*840*	*980*	*1075*
M3	145	155	185	215	235	—	—	—	—	—	130	140	170	195	210	110	120	140	160	175	160	170	205	235	255
	475	*510*	*610*	*710*	*770*	—	—	—	—	—	*425*	*460*	*560*	*640*	*690*	*360*	*395*	*460*	*520*	*570*	*520*	*560*	*670*	*770*	*840*
M4	120	125	150	165	180	—	—	—	—	—	105	110	135	150	165	90	95	115	125	135	130	135	165	180	195
	395	*410*	*490*	*540*	*590*	—	—	—	—	—	*345*	*360*	*445*	*490*	*540*	*295*	*310*	*375*	*410*	*445*	*425*	*445*	*540*	*590*	*640*
M5	100	105	125	135	150	—	—	—	—	—	90	95	115	125	135	75	80	95	105	115	110	115	135	150	165
	330	*345*	*410*	*445*	*490*	—	—	—	—	—	*295*	*310*	*375*	*410*	*445*	*245*	*260*	*310*	*345*	*375*	*360*	*375*	*445*	*490*	*540*
K1	—	—	—	—	—	200	215	265	310	335	185	200	250	290	315	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*660*	*710*	*870*	*1025*	*1100*	*610*	*660*	*820*	*950*	*1025*	—	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	180	195	235	275	300	170	180	220	255	280	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*590*	*640*	*770*	*900*	*980*	*560*	*590*	*720*	*840*	*920*	—	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	150	165	200	230	255	140	155	185	220	240	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*490*	*540*	*660*	*750*	*840*	*460*	*510*	*610*	*720*	*790*	—	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	145	155	190	220	240	135	145	180	210	225	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*475*	*510*	*620*	*720*	*790*	*445*	*475*	*590*	*690*	*740*	—	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	90	95	115	135	145	85	90	105	125	140	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*295*	*310*	*375*	*445*	*475*	*280*	*295*	*345*	*410*	*460*	—	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	130	140	165	195	215	120	130	155	185	200	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*425*	*460*	*540*	*640*	*710*	*395*	*425*	*510*	*610*	*660*	—	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	115	120	145	175	190	105	115	135	165	175	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*375*	*395*	*475*	*570*	*620*	*345*	*375*	*445*	*540*	*570*	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	1400	1500	1825	2175	2350	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*4600*	*4925*	*6000*	*7125*	*7700*	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	560	610	740	880	950	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1825*	*2000*	*2425*	*2875*	*3125*	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	375	405	490	590	640	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1225*	*1325*	*1600*	*1925*	*2100*	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	430	460	560	670	730	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1400*	*1500*	*1825*	*2200*	*2400*	—	—	—	—	—	—	—	—	—	—
S1	55	55	70	75	85	55	55	70	75	80	50	50	65	70	75	27	29	35	38	42	60	65	75	85	90
	180	*180*	*230*	*245*	*280*	*180*	*180*	*230*	*245*	*260*	*165*	*165*	*215*	*230*	*245*	*90*	*95*	*115*	*125*	*140*	*195*	*215*	*245*	*280*	*295*
S2	44	46	55	60	70	43	45	55	60	65	40	42	50	55	60	22	23	28	31	34	49	50	60	65	75
	145	*150*	*180*	*195*	*230*	*140*	*150*	*180*	*195*	*215*	*130*	*140*	*165*	*180*	*195*	*70*	*75*	*90*	*100*	*110*	*160*	*165*	*195*	*215*	*245*
S3	39	40	49	55	60	37	39	48	55	55	35	37	45	49	55	19	20	24	27	30	42	44	55	60	65
	130	*130*	*160*	*180*	*195*	*120*	*130*	*155*	*180*	*180*	*115*	*120*	*150*	*160*	*180*	*60*	*65*	*80*	*90*	*100*	*140*	*145*	*180*	*195*	*215*
S11	75	80	95	110	120	75	80	95	105	115	70	75	90	100	105	38	40	48	55	60	85	90	105	120	130
	245	*260*	*310*	*360*	*395*	*245*	*260*	*310*	*345*	*375*	*230*	*245*	*295*	*330*	*345*	*125*	*130*	*155*	*180*	*195*	*280*	*295*	*345*	*395*	*425*
S12	50	55	65	75	80	50	55	65	70	80	48	50	60	70	75	35	37	44	50	55	60	60	75	85	90
	165	*180*	*215*	*245*	*260*	*165*	*180*	*215*	*230*	*260*	*155*	*165*	*195*	*230*	*245*	*115*	*120*	*145*	*165*	*180*	*195*	*195*	*245*	*280*	*295*
S13	31	32	39	43	47	30	31	38	42	46	28	29	36	39	43	21	21	26	29	31	34	36	43	47	50
	100	*105*	*130*	*140*	*155*	*100*	*100*	*125*	*140*	*150*	*90*	*95*	*120*	*130*	*140*	*70*	*70*	*85*	*95*	*100*	*110*	*120*	*140*	*155*	*165*
H5	45	49	60	70	75	42	45	55	65	70	40	43	50	60	65	—	—	—	—	—	—	—	—	—	—
	150	*160*	*195*	*230*	*245*	*140*	*150*	*180*	*215*	*230*	*130*	*140*	*165*	*195*	*215*	—	—	—	—	—	—	—	—	—	—
H8	49	50	65	70	80	46	49	60	65	70	43	46	55	60	70	—	—	—	—	—	—	—	—	—	—
	160	*165*	*215*	*230*	*260*	*150*	*160*	*195*	*215*	*230*	*140*	*150*	*180*	*195*	*230*	—	—	—	—	—	—	—	—	—	—
H11	60	60	75	85	95	55	60	70	80	85	50	55	65	75	80	—	—	—	—	—	—	—	—	—	—
	195	*195*	*245*	*280*	*310*	*180*	*195*	*230*	*260*	*280*	*165*	*180*	*215*	*245*	*260*	—	—	—	—	—	—	—	—	—	—
H12	90	95	115	130	140	80	85	105	120	130	75	80	100	110	120	—	—	—	—	—	—	—	—	—	—
	295	*310*	*375*	*425*	*460*	*260*	*280*	*345*	*395*	*425*	*245*	*260*	*330*	*360*	*395*	—	—	—	—	—	—	—	—	—	—
H21	49	50	65	70	80	46	49	60	65	70	43	46	55	60	70	—	—	—	—	—	—	—	—	—	—
	160	*165*	*215*	*230*	*260*	*150*	*160*	*195*	*215*	*230*	*140*	*150*	*180*	*195*	*230*	—	—	—	—	—	—	—	—	—	—

R218.20-100 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.20-100ER-ME05 F40M	11,0 *0.44*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P2	218.20-100ER-ME05 F40M	11,0 *0.44*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P3	218.20-100ER-ME05 F40M	11,0 *0.44*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P4	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*
P5	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P6	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P7	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P8	218.20-100ER-M05 F25M	11,0 *0.44*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P11	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P12	218.20-100ER-M05 F25M	9,0 *0.36*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*
M1	218.20-100ER-ME05 F40M	11,0 *0.44*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
M2	218.20-100ER-ME05 F40M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M3	218.20-100ER-ME05 F40M	9,0 *0.36*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*
M4	218.20-100ER-ME05 F40M	6,0 *0.24*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
M5	218.20-100ER-M05 F40M	6,0 *0.24*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
K1	218.20-100ER-M05 F25M	11,0 *0.44*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
K2	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K3	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K4	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K5	218.20-100ER-M05 F25M	11,0 *0.44*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*
K6	218.20-100ER-M05 F25M	11,0 *0.44*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K7	218.20-100ER-M05 F25M	11,0 *0.44*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*
N1	218.20-100ER-ME05 F40M	11,0 *0.44*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
N2	218.20-100ER-ME05 F40M	11,0 *0.44*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
N3	218.20-100ER-ME05 F40M	11,0 *0.44*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
N11	218.20-100ER-ME05 F40M	11,0 *0.44*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
S1	218.20-100ER-ME05 F40M	6,0 *0.24*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
S2	218.20-100ER-ME05 F40M	6,0 *0.24*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
S3	218.20-100ER-ME05 F40M	6,0 *0.24*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*
S11	218.20-100ER-ME05 MS2050	8,0 *0.32*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
S12	218.20-100ER-ME05 MS2050	8,0 *0.32*	0,060 *0.0024*	0,060 *0.0024*	0,060 *0.0024*
S13	218.20-100ER-ME05 MS2050	6,0 *0.24*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H5	218.20-100ER-M05 F25M	9,0 *0.36*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*
H8	218.20-100ER-M05 F25M	8,0 *0.32*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H11	218.20-100ER-M05 F25M	9,0 *0.36*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*
H12	218.20-100ER-M05 F25M	8,0 *0.32*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H21	218.20-100ER-M05 F25M	8,0 *0.32*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-100 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			15%	10%	5%
P1	218.20-100ER-ME05 F40M	11,0 *0.44*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
P2	218.20-100ER-ME05 F40M	11,0 *0.44*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
P3	218.20-100ER-ME05 F40M	11,0 *0.44*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P4	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P5	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P6	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P7	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P8	218.20-100ER-M05 F25M	11,0 *0.44*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P11	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P12	218.20-100ER-M05 F25M	9,0 *0.36*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
M1	218.20-100ER-ME05 F40M	11,0 *0.44*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
M2	218.20-100ER-ME05 F40M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
M3	218.20-100ER-ME05 F40M	9,0 *0.36*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M4	218.20-100ER-ME05 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
M5	218.20-100ER-ME05 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
K1	218.20-100ER-M05 F25M	11,0 *0.44*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
K2	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K3	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K4	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K5	218.20-100ER-M05 F25M	11,0 *0.44*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
K6	218.20-100ER-M05 F25M	11,0 *0.44*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K7	218.20-100ER-M05 F25M	11,0 *0.44*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
N1	218.20-100ER-ME05 F40M	11,0 *0.44*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
N2	218.20-100ER-ME05 F40M	11,0 *0.44*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
N3	218.20-100ER-ME05 F40M	11,0 *0.44*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
N11	218.20-100ER-ME05 F40M	11,0 *0.44*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
S1	218.20-100ER-ME05 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
S2	218.20-100ER-ME05 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
S3	218.20-100ER-ME05 F40M	6,0 *0.24*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
S11	218.20-100ER-ME05 MS2050	8,0 *0.32*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
S12	218.20-100ER-ME05 MS2050	8,0 *0.32*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*
S13	218.20-100ER-ME05 MS2050	6,0 *0.24*	0,065 *0.0026*	0,080 *0.0032*	0,11 *0.0044*
H5	218.20-100ER-M05 F25M	9,0 *0.36*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H8	218.20-100ER-M05 F25M	8,0 *0.32*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
H11	218.20-100ER-M05 F25M	9,0 *0.36*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H12	218.20-100ER-M05 F25M	8,0 *0.32*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
H21	218.20-100ER-M05 F25M	8,0 *0.32*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-100 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	260 *850*	280 *920*	340 *1125*	400 *1300*	430 *1400*	240 *790*	260 *850*	310 *1025*	365 *1200*	395 *1300*	195 *640*	210 *690*	250 *820*	295 *970*	320 *1050*	280 *920*	305 *1000*	365 *1200*	430 *1400*	465 *1525*
P2	255 *840*	275 *900*	330 *1075*	390 *1275*	420 *1375*	230 *750*	250 *820*	300 *980*	355 *1175*	385 *1275*	185 *610*	205 *670*	245 *800*	290 *950*	310 *1025*	270 *890*	295 *970*	355 *1175*	420 *1375*	455 *1500*
P3	215 *710*	235 *770*	285 *940*	340 *1125*	370 *1225*	200 *660*	215 *710*	260 *850*	310 *1025*	340 *1125*	160 *520*	175 *570*	210 *690*	250 *820*	275 *900*	235 *770*	260 *850*	310 *1025*	360 *1175*	395 *1300*
P4	195 *640*	210 *690*	250 *820*	300 *980*	325 *1075*	175 *570*	190 *620*	230 *750*	275 *900*	300 *980*	145 *475*	155 *510*	185 *610*	220 *720*	240 *790*	210 *690*	225 *740*	270 *890*	325 *1075*	350 *1150*
P5	185 *610*	200 *660*	245 *800*	285 *940*	310 *1025*	170 *560*	185 *610*	225 *740*	260 *850*	285 *940*	135 *445*	150 *490*	180 *590*	210 *690*	230 *750*	200 *660*	215 *710*	260 *850*	310 *1025*	335 *1100*
P6	205 *670*	225 *740*	275 *900*	320 *1050*	350 *1150*	190 *620*	205 *670*	250 *820*	290 *950*	320 *1050*	155 *510*	165 *540*	205 *670*	235 *770*	260 *850*	225 *740*	245 *800*	290 *950*	345 *1125*	380 *1250*
P7	195 *640*	215 *710*	260 *850*	300 *980*	330 *1075*	180 *590*	195 *640*	235 *770*	275 *900*	300 *980*	145 *475*	160 *520*	190 *620*	225 *740*	245 *800*	215 *710*	235 *770*	275 *900*	325 *1075*	355 *1175*
P8	185 *610*	200 *660*	240 *790*	285 *940*	310 *1025*	165 *540*	180 *590*	220 *720*	260 *850*	285 *940*	135 *445*	145 *475*	175 *570*	210 *690*	230 *750*	200 *660*	215 *710*	260 *850*	305 *1000*	335 *1100*
P11	190 *620*	205 *670*	250 *820*	295 *970*	320 *1050*	175 *570*	190 *620*	230 *750*	270 *890*	290 *950*	140 *460*	155 *510*	185 *610*	215 *710*	235 *770*	210 *690*	225 *740*	270 *890*	320 *1050*	345 *1125*
P12	130 *425*	140 *460*	165 *540*	185 *610*	205 *670*	120 *395*	125 *410*	150 *490*	170 *560*	185 *610*	95 *310*	105 *345*	125 *410*	140 *460*	150 *490*	135 *445*	150 *490*	175 *570*	200 *660*	215 *710*
M1	— —	— —	— —	— —	— —	185 *610*	200 *660*	245 *800*	285 *940*	310 *1025*	160 *520*	175 *570*	210 *690*	245 *800*	270 *890*	220 *720*	240 *790*	285 *940*	340 *1125*	365 *1200*
M2	— —	— —	— —	— —	— —	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	130 *425*	145 *475*	175 *570*	200 *660*	220 *720*	180 *590*	195 *640*	235 *770*	280 *920*	300 *980*
M3	— —	— —	— —	— —	— —	130 *425*	140 *460*	165 *540*	185 *610*	205 *670*	110 *360*	120 *395*	145 *475*	160 *520*	175 *570*	150 *490*	165 *540*	195 *640*	220 *720*	240 *790*
M4	— —	— —	— —	— —	— —	105 *345*	110 *360*	135 *445*	145 *475*	155 *510*	90 *295*	95 *310*	115 *375*	125 *410*	135 *445*	125 *410*	130 *425*	155 *510*	165 *540*	180 *590*
M5	— —	— —	— —	— —	— —	90 *295*	90 *295*	110 *360*	120 *395*	130 *425*	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*	105 *345*	105 *345*	130 *425*	140 *460*	150 *490*
K1	200 *660*	215 *710*	260 *850*	305 *1000*	335 *1100*	185 *610*	200 *660*	240 *790*	280 *920*	305 *1000*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	175 *570*	190 *620*	230 *750*	270 *890*	295 *970*	160 *520*	175 *570*	210 *690*	245 *800*	270 *890*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	150 *490*	160 *520*	195 *640*	230 *750*	250 *820*	135 *445*	150 *490*	180 *590*	210 *690*	230 *750*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	140 *460*	155 *510*	185 *610*	220 *720*	240 *790*	130 *425*	140 *460*	170 *560*	200 *660*	220 *720*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	85 *280*	95 *310*	110 *360*	135 *445*	145 *475*	80 *260*	85 *280*	105 *345*	120 *395*	130 *425*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	125 *410*	135 *445*	165 *540*	190 *620*	210 *690*	115 *375*	125 *410*	150 *490*	175 *570*	190 *620*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	110 *360*	120 *395*	145 *475*	170 *560*	185 *610*	100 *330*	110 *360*	130 *425*	155 *510*	170 *560*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	1350 *4425*	1475 *4850*	1800 *5900*	2100 *6900*	2250 *7375*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	550 *1800*	590 *1925*	720 *2350*	850 *2800*	910 *2975*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	365 *1200*	395 *1300*	480 *1575*	570 *1875*	610 *2000*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	420 *1375*	455 *1500*	550 *1800*	650 *2125*	700 *2300*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	55 *180*	55 *180*	70 *230*	75 *245*	80 *260*	50 *165*	50 *165*	65 *215*	65 *215*	75 *245*	28 *90*	29 *95*	36 *120*	38 *125*	42 *140*	55 *180*	60 *195*	75 *245*	80 *260*	85 *280*
S2	44 *145*	45 *150*	55 *180*	60 *195*	65 *215*	40 *130*	42 *140*	50 *165*	55 *180*	60 *195*	23 *75*	23 *75*	29 *95*	31 *100*	33 *110*	46 *150*	48 *155*	60 *195*	65 *215*	70 *230*
S3	38 *125*	40 *130*	48 *155*	50 *165*	55 *180*	35 *115*	36 *120*	44 *145*	48 *155*	50 *165*	20 *65*	21 *70*	25 *80*	27 *90*	29 *95*	40 *130*	42 *140*	50 *165*	55 *180*	60 *195*
S11	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*	65 *215*	70 *230*	85 *280*	95 *310*	105 *345*	38 *125*	40 *130*	48 *155*	55 *180*	60 *195*	75 *245*	85 *280*	100 *330*	110 *360*	120 *395*
S12	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	46 *150*	49 *160*	60 *195*	65 *215*	70 *230*	35 *115*	37 *120*	45 *150*	49 *160*	55 *180*	55 *180*	55 *180*	70 *230*	75 *245*	85 *280*
S13	30 *100*	32 *105*	39 *130*	41 *135*	45 *150*	28 *90*	29 *95*	35 *115*	38 *125*	41 *135*	21 *70*	22 *70*	27 *90*	29 *95*	31 *100*	32 *105*	34 *110*	41 *135*	44 *145*	48 *155*
H5	43 *140*	46 *150*	55 *180*	60 *195*	65 *215*	39 *130*	42 *140*	50 *165*	55 *180*	60 *195*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	45 *150*	49 *160*	60 *195*	65 *215*	70 *230*	42 *140*	45 *150*	55 *180*	60 *195*	65 *215*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	55 *180*	60 *195*	70 *230*	80 *260*	85 *280*	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	80 *260*	85 *280*	105 *345*	115 *375*	125 *410*	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	45 *150*	49 *160*	60 *195*	65 *215*	70 *230*	42 *140*	45 *150*	55 *180*	60 *195*	65 *215*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

R218.20-125 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.20-125ER-ME07 F40M	13,0 *0.50*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P2	218.20-125ER-ME07 F40M	13,0 *0.50*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
P3	218.20-125ER-ME07 F40M	13,0 *0.50*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P4	218.20-125ER-M07 F25M	13,0 *0.50*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P5	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P6	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P7	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P8	218.20-125ER-M07 F25M	13,0 *0.50*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
P11	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
P12	218.20-125ER-M07 F25M	11,0 *0.44*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*
M1	218.20-125ER-ME07 F40M	13,0 *0.50*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
M2	218.20-125ER-ME07 F40M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M3	218.20-125ER-ME07 F40M	11,0 *0.44*	0,080 *0.0032*	0,080 *0.0032*	0,085 *0.0034*
M4	218.20-125ER-ME07 F40M	8,0 *0.32*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
M5	218.20-125ER-M07 F40M	8,0 *0.32*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
K1	218.20-125ER-M07 F25M	13,0 *0.50*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
K2	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K3	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K4	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K5	218.20-125ER-M07 F25M	13,0 *0.50*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*
K6	218.20-125ER-M07 F25M	13,0 *0.50*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K7	218.20-125ER-M07 F25M	13,0 *0.50*	0,085 *0.0034*	0,085 *0.0034*	0,095 *0.0038*
N1	218.20-125ER-ME07 F40M	13,0 *0.50*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*
N2	218.20-125ER-ME07 F40M	13,0 *0.50*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*
N3	218.20-125ER-ME07 F40M	13,0 *0.50*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*
N11	218.20-125ER-ME07 F40M	13,0 *0.50*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*
S1	218.20-125ER-ME07 F40M	8,0 *0.32*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
S2	218.20-125ER-ME07 F40M	8,0 *0.32*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
S3	218.20-125ER-ME07 F40M	8,0 *0.32*	0,070 *0.0028*	0,070 *0.0028*	0,070 *0.0028*
S11	218.20-125ER-ME07 MS2050	9,0 *0.36*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*
S12	218.20-125ER-ME07 MS2050	9,0 *0.36*	0,085 *0.0034*	0,085 *0.0034*	0,085 *0.0034*
S13	218.20-125ER-ME07 MS2050	8,0 *0.32*	0,075 *0.0030*	0,075 *0.0030*	0,075 *0.0030*
H5	218.20-125ER-M07 F25M	11,0 *0.44*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*
H8	218.20-125ER-M07 F25M	9,0 *0.36*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H11	218.20-125ER-M07 F25M	11,0 *0.44*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*
H12	218.20-125ER-M07 F25M	9,0 *0.36*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*
H21	218.20-125ER-M07 F25M	9,0 *0.36*	0,055 *0.0022*	0,055 *0.0022*	0,055 *0.0022*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-125 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			15%	10%	5%
P1	218.20-125ER-ME07 F40M	13,0 *0.50*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
P2	218.20-125ER-ME07 F40M	13,0 *0.50*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
P3	218.20-125ER-ME07 F40M	13,0 *0.50*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P4	218.20-125ER-M07 F25M	13,0 *0.50*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P5	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P6	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P7	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P8	218.20-125ER-M07 F25M	13,0 *0.50*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
P11	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
P12	218.20-125ER-M07 F25M	11,0 *0.44*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
M1	218.20-125ER-ME07 F40M	13,0 *0.50*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
M2	218.20-125ER-ME07 F40M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
M3	218.20-125ER-ME07 F40M	11,0 *0.44*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
M4	218.20-125ER-ME07 F40M	8,0 *0.32*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
M5	218.20-125ER-ME07 F40M	8,0 *0.32*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
K1	218.20-125ER-M07 F25M	13,0 *0.50*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
K2	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K3	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K4	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K5	218.20-125ER-M07 F25M	13,0 *0.50*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
K6	218.20-125ER-M07 F25M	13,0 *0.50*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
K7	218.20-125ER-M07 F25M	13,0 *0.50*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
N1	218.20-125ER-ME07 F40M	13,0 *0.50*	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
N2	218.20-125ER-ME07 F40M	13,0 *0.50*	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
N3	218.20-125ER-ME07 F40M	13,0 *0.50*	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
N11	218.20-125ER-ME07 F40M	13,0 *0.50*	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
S1	218.20-125ER-ME07 F40M	8,0 *0.32*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
S2	218.20-125ER-ME07 F40M	8,0 *0.32*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
S3	218.20-125ER-ME07 F40M	8,0 *0.32*	0,085 *0.0034*	0,10 *0.0040*	0,14 *0.0055*
S11	218.20-125ER-ME07 MS2050	9,0 *0.36*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
S12	218.20-125ER-ME07 MS2050	9,0 *0.36*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*
S13	218.20-125ER-ME07 MS2050	8,0 *0.32*	0,095 *0.0038*	0,11 *0.0044*	0,15 *0.0060*
H5	218.20-125ER-M07 F25M	11,0 *0.44*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H8	218.20-125ER-M07 F25M	9,0 *0.36*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
H11	218.20-125ER-M07 F25M	11,0 *0.44*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H12	218.20-125ER-M07 F25M	9,0 *0.36*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*
H21	218.20-125ER-M07 F25M	9,0 *0.36*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-125 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	260 *850*	285 *940*	340 *1125*	400 *1300*	435 *1425*	255 *840*	275 *900*	335 *1100*	390 *1275*	425 *1400*	205 *670*	225 *740*	270 *890*	320 *1050*	345 *1125*	280 *920*	305 *1000*	365 *1200*	430 *1400*	470 *1550*
P2	250 *820*	270 *890*	330 *1075*	390 *1275*	425 *1400*	245 *800*	265 *870*	325 *1075*	380 *1250*	415 *1350*	200 *660*	215 *710*	265 *870*	310 *1025*	335 *1100*	270 *890*	290 *950*	355 *1175*	420 *1375*	455 *1500*
P3	220 *720*	235 *770*	285 *940*	340 *1125*	370 *1225*	215 *710*	230 *750*	280 *920*	335 *1100*	365 *1200*	175 *570*	190 *620*	225 *740*	270 *890*	295 *970*	235 *770*	255 *840*	305 *1000*	365 *1200*	400 *1300*
P4	195 *640*	210 *690*	250 *820*	300 *980*	325 *1075*	190 *620*	205 *670*	245 *800*	295 *970*	320 *1050*	155 *510*	165 *540*	200 *660*	240 *790*	260 *850*	210 *690*	225 *740*	270 *890*	320 *1050*	350 *1150*
P5	185 *610*	200 *660*	245 *800*	285 *940*	315 *1025*	180 *590*	195 *640*	240 *790*	280 *920*	305 *1000*	150 *490*	160 *520*	195 *640*	225 *740*	250 *820*	200 *660*	215 *710*	265 *870*	310 *1025*	335 *1100*
P6	210 *690*	225 *740*	275 *900*	320 *1050*	350 *1150*	205 *670*	220 *720*	270 *890*	315 *1025*	345 *1125*	165 *540*	180 *590*	220 *720*	255 *840*	280 *920*	225 *740*	245 *800*	295 *970*	345 *1125*	375 *1225*
P7	200 *660*	215 *710*	260 *850*	305 *1000*	330 *1075*	195 *640*	210 *690*	255 *840*	295 *970*	325 *1075*	155 *510*	170 *560*	205 *670*	240 *790*	260 *850*	215 *710*	230 *750*	280 *920*	325 *1075*	355 *1175*
P8	185 *610*	200 *660*	240 *790*	285 *940*	315 *1025*	180 *590*	195 *640*	235 *770*	280 *920*	305 *1000*	145 *475*	160 *520*	190 *620*	225 *740*	250 *820*	200 *660*	215 *710*	260 *850*	310 *1025*	335 *1100*
P11	190 *620*	210 *690*	250 *820*	295 *970*	320 *1050*	190 *620*	205 *670*	245 *800*	290 *950*	315 *1025*	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	205 *670*	225 *740*	270 *890*	315 *1025*	345 *1125*
P12	130 *425*	140 *460*	165 *540*	185 *610*	205 *670*	125 *410*	135 *445*	160 *520*	185 *610*	200 *660*	100 *330*	110 *360*	130 *425*	150 *490*	160 *520*	140 *460*	150 *490*	180 *590*	200 *660*	220 *720*
M1	— —	— —	— —	— —	— —	195 *640*	210 *690*	260 *850*	310 *1025*	335 *1100*	170 *560*	185 *610*	225 *740*	265 *870*	290 *950*	215 *710*	235 *770*	285 *940*	340 *1125*	370 *1225*
M2	— —	— —	— —	— —	— —	165 *540*	180 *590*	215 *710*	250 *820*	275 *900*	140 *460*	155 *510*	185 *610*	215 *710*	235 *770*	180 *590*	195 *640*	235 *770*	275 *900*	305 *1000*
M3	— —	— —	— —	— —	— —	135 *445*	145 *475*	175 *570*	200 *660*	220 *720*	120 *395*	125 *410*	150 *490*	175 *570*	190 *620*	150 *490*	160 *520*	195 *640*	220 *720*	245 *800*
M4	— —	— —	— —	— —	— —	110 *360*	115 *375*	140 *460*	155 *510*	170 *560*	95 *310*	100 *330*	120 *395*	135 *445*	145 *475*	120 *395*	130 *425*	155 *510*	170 *560*	185 *610*
M5	— —	— —	— —	— —	— —	95 *310*	95 *310*	120 *395*	130 *425*	140 *460*	80 *260*	85 *280*	100 *330*	110 *360*	120 *395*	100 *330*	105 *345*	130 *425*	140 *460*	155 *510*
K1	195 *640*	215 *710*	265 *870*	310 *1025*	335 *1100*	195 *640*	210 *690*	255 *840*	305 *1000*	330 *1075*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	175 *570*	190 *620*	230 *750*	270 *890*	295 *970*	175 *570*	185 *610*	225 *740*	265 *870*	290 *950*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	150 *490*	160 *520*	195 *640*	230 *750*	250 *820*	145 *475*	160 *520*	190 *620*	225 *740*	245 *800*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	145 *475*	155 *510*	190 *620*	220 *720*	240 *790*	140 *460*	150 *490*	185 *610*	215 *710*	235 *770*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	85 *280*	95 *310*	115 *375*	135 *445*	145 *475*	85 *280*	90 *295*	110 *360*	130 *425*	140 *460*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	125 *410*	135 *445*	165 *540*	195 *640*	210 *690*	125 *410*	135 *445*	160 *520*	190 *620*	205 *670*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	110 *360*	120 *395*	145 *475*	170 *560*	185 *610*	110 *360*	120 *395*	140 *460*	170 *560*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	1475 *4850*	1575 *5175*	1900 *6225*	2250 *7375*	2475 *8125*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	590 *1925*	640 *2100*	760 *2500*	910 *2975*	1000 *3275*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	395 *1300*	425 *1400*	510 *1675*	610 *2000*	670 *2200*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	450 *1475*	485 *1600*	580 *1900*	690 *2275*	760 *2500*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	55 *180*	55 *180*	70 *230*	75 *245*	80 *260*	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	29 *95*	31 *100*	37 *120*	41 *135*	45 *150*	55 *180*	60 *195*	75 *245*	80 *260*	85 *280*
S2	43 *140*	45 *150*	55 *180*	60 *195*	65 *215*	42 *140*	44 *145*	55 *180*	60 *195*	65 *215*	24 *80*	25 *80*	30 *100*	33 *110*	36 *120*	46 *150*	48 *155*	60 *195*	65 *215*	70 *230*
S3	37 *120*	39 *130*	48 *155*	50 *165*	55 *180*	36 *120*	38 *125*	47 *155*	50 *165*	55 *180*	21 *70*	22 *70*	26 *85*	29 *95*	31 *100*	40 *130*	42 *140*	50 *165*	55 *180*	60 *195*
S11	75 *245*	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	75 *245*	90 *295*	100 *330*	110 *360*	40 *130*	43 *140*	50 *165*	55 *180*	65 *215*	80 *260*	85 *280*	100 *330*	110 *360*	125 *410*
S12	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	49 *160*	50 *165*	65 *215*	70 *230*	75 *245*	37 *120*	39 *130*	48 *155*	55 *180*	60 *195*	55 *180*	60 *195*	70 *230*	75 *245*	85 *280*
S13	30 *100*	31 *100*	38 *125*	42 *140*	45 *150*	29 *95*	31 *100*	37 *120*	41 *135*	44 *145*	22 *70*	23 *75*	28 *90*	31 *100*	34 *110*	32 *105*	34 *110*	41 *135*	45 *150*	49 *160*
H5	43 *140*	46 *150*	55 *180*	60 *195*	70 *230*	42 *140*	45 *150*	55 *180*	60 *195*	65 *215*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	46 *150*	49 *160*	60 *195*	65 *215*	70 *230*	45 *150*	48 *155*	60 *195*	65 *215*	70 *230*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	55 *180*	60 *195*	70 *230*	80 *260*	85 *280*	55 *180*	55 *180*	70 *230*	75 *245*	85 *280*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	85 *280*	90 *295*	105 *345*	120 *395*	130 *425*	80 *260*	85 *280*	105 *345*	115 *375*	125 *410*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	46 *150*	49 *160*	60 *195*	65 *215*	70 *230*	45 *150*	48 *155*	60 *195*	65 *215*	70 *230*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

R218.20-150 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
P3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P4	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*
P5	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P6	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P7	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P8	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P11	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P12	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*
M1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
M2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
M4	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M5	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K1	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
K2	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K3	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K4	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K5	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
K6	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K7	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
N1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N11	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
S1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
S11	218.20-150ER-ME07 MS2050	SPMT100408T-M08 F40M	18,0 *0.70*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
S12	218.20-150ER-ME07 MS2050	SPMT100408T-M08 F40M	18,0 *0.70*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
S13	218.20-150ER-ME07 MS2050	SPMT100408T-M08 F40M	16,0 *0.65*	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-150 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P4	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P5	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P6	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P7	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P8	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P11	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P12	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*
M1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
M2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
M3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,15 *0.0060*	0,18 *0.0070*	0,24 *0.0095*
M4	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
M5	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
K1	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
K2	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K3	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K4	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K5	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*
K6	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K7	218.20-150ER-M08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*
N1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,26 *0.010*	0,30 *0.012*	0,44 *0.017*
N2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,26 *0.010*	0,30 *0.012*	0,44 *0.017*
N3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,26 *0.010*	0,30 *0.012*	0,44 *0.017*
N11	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,26 *0.010*	0,30 *0.012*	0,44 *0.017*
S1	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
S2	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
S3	218.20-150ER-ME07 F40M	SPMT100408T-M08 F40M	16,0 *0.65*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
S11	218.20-150ER-ME07 MS2050	SPMT100408T-M08 F40M	18,0 *0.70*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
S12	218.20-150ER-ME07 MS2050	SPMT100408T-M08 F40M	18,0 *0.70*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
S13	218.20-150ER-ME07 MS2050	SPMT100408T-M08 F40M	16,0 *0.65*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-150 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	220 *720*	240 *790*	290 *950*	345 *1125*	375 *1225*	170 *560*	180 *590*	225 *740*	265 *870*	285 *940*	270 *890*	290 *950*	350 *1150*	415 *1350*	450 *1475*
P2	215 *710*	235 *770*	285 *940*	335 *1100*	365 *1200*	165 *540*	180 *590*	215 *710*	255 *840*	280 *920*	255 *840*	280 *920*	340 *1125*	405 *1325*	435 *1425*
P3	190 *620*	205 *670*	250 *820*	290 *950*	320 *1050*	145 *475*	155 *510*	190 *620*	220 *720*	245 *800*	225 *740*	245 *800*	295 *970*	350 *1150*	385 *1275*
P4	165 *540*	180 *590*	220 *720*	255 *840*	280 *920*	125 *410*	135 *445*	165 *540*	195 *640*	215 *710*	200 *660*	215 *710*	260 *850*	310 *1025*	335 *1100*
P5	160 *520*	170 *560*	210 *690*	250 *820*	270 *890*	120 *395*	130 *425*	160 *520*	190 *620*	205 *670*	190 *620*	210 *690*	255 *840*	295 *970*	320 *1050*
P6	180 *590*	195 *640*	235 *770*	280 *920*	300 *980*	135 *445*	145 *475*	180 *590*	215 *710*	230 *750*	215 *710*	235 *770*	285 *940*	330 *1075*	360 *1175*
P7	170 *560*	180 *590*	220 *720*	265 *870*	285 *940*	130 *425*	140 *460*	170 *560*	200 *660*	215 *710*	205 *670*	220 *720*	270 *890*	315 *1025*	340 *1125*
P8	160 *520*	170 *560*	210 *690*	245 *800*	270 *890*	120 *395*	130 *425*	160 *520*	185 *610*	205 *670*	190 *620*	205 *670*	245 *800*	295 *970*	320 *1050*
P11	165 *540*	175 *570*	215 *710*	255 *840*	275 *900*	125 *410*	135 *445*	165 *540*	195 *640*	210 *690*	200 *660*	215 *710*	260 *850*	305 *1000*	330 *1075*
P12	115 *375*	120 *395*	145 *475*	165 *540*	180 *590*	85 *280*	90 *295*	110 *360*	125 *410*	135 *445*	130 *425*	140 *460*	175 *570*	195 *640*	210 *690*
M1	175 *570*	190 *620*	230 *750*	270 *890*	295 *970*	140 *460*	150 *490*	185 *610*	220 *720*	240 *790*	205 *670*	225 *740*	275 *900*	325 *1075*	350 *1150*
M2	145 *475*	155 *510*	190 *620*	225 *740*	240 *790*	115 *375*	125 *410*	155 *510*	185 *610*	195 *640*	175 *570*	185 *610*	225 *740*	265 *870*	290 *950*
M3	125 *410*	130 *425*	160 *520*	180 *590*	195 *640*	100 *330*	105 *345*	130 *425*	145 *475*	160 *520*	145 *475*	155 *510*	190 *620*	210 *690*	235 *770*
M4	100 *330*	105 *345*	125 *410*	140 *460*	150 *490*	80 *260*	85 *280*	105 *345*	110 *360*	120 *395*	115 *375*	125 *410*	150 *490*	165 *540*	180 *590*
M5	85 *280*	90 *295*	105 *345*	115 *375*	125 *410*	70 *230*	70 *230*	85 *280*	95 *310*	100 *330*	100 *330*	105 *345*	125 *410*	135 *445*	150 *490*
K1	170 *560*	185 *610*	225 *740*	265 *870*	290 *950*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	130 *425*	140 *460*	170 *560*	200 *660*	215 *710*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	120 *395*	130 *425*	160 *520*	190 *620*	205 *670*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	75 *245*	80 *260*	100 *330*	115 *375*	125 *410*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	105 *345*	115 *375*	140 *460*	170 *560*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	95 *310*	105 *345*	125 *410*	150 *490*	160 *520*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	1275 *4175*	1375 *4500*	1675 *5500*	1975 *6475*	2150 *7050*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	510 *1675*	550 *1800*	680 *2225*	790 *2600*	870 *2850*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	340 *1125*	365 *1200*	450 *1475*	530 *1750*	580 *1900*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	390 *1275*	420 *1375*	520 *1700*	600 *1975*	660 *2175*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	47 *155*	49 *160*	60 *195*	65 *215*	70 *230*	25 *80*	26 *85*	31 *100*	34 *110*	37 *120*	55 *180*	55 *180*	70 *230*	75 *245*	85 *280*
S2	38 *125*	40 *130*	47 *155*	50 *165*	55 *180*	20 *65*	21 *70*	25 *80*	28 *90*	30 *100*	44 *145*	46 *150*	55 *180*	60 *195*	65 *215*
S3	33 *110*	34 *110*	42 *140*	45 *150*	50 *165*	18 *60*	18 *60*	22 *70*	24 *80*	26 *85*	38 *125*	40 *130*	49 *160*	55 *180*	60 *195*
S11	65 *215*	65 *215*	85 *280*	90 *295*	100 *330*	34 *110*	36 *120*	44 *145*	48 *155*	55 *180*	75 *245*	80 *260*	100 *330*	105 *345*	120 *395*
S12	44 *145*	46 *150*	55 *180*	65 *215*	70 *230*	31 *100*	33 *110*	41 *135*	45 *150*	49 *160*	55 *180*	55 *180*	70 *230*	75 *245*	80 *260*
S13	26 *85*	28 *90*	33 *110*	36 *120*	40 *130*	19 *60*	20 *65*	24 *80*	26 *85*	28 *90*	31 *100*	32 *105*	39 *130*	43 *140*	47 *155*

R218.20-160 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
P3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P4	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P5	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P6	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P7	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P8	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P11	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
P12	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	26,0 *1.0*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
M1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
M2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*
M4	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M5	218.20-160ER-M08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
K1	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
K2	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K3	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K4	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K5	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
K6	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
K7	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	32,0 *1.3*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
N1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F25M	32,0 *1.3*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F25M	32,0 *1.3*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F25M	32,0 *1.3*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
N11	218.20-160ER-ME08 F40M	SPMT100408T-M08 F25M	32,0 *1.3*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
S1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
S3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
S11	218.20-160ER-ME08 MS2050	SPMT100408T-M08 F40M	23,0 *0.90*	0,085 *0.0034*	0,085 *0.0034*	0,090 *0.0036*
S12	218.20-160ER-ME08 MS2050	SPMT100408T-M08 F40M	23,0 *0.90*	0,085 *0.0034*	0,085 *0.0034*	0,090 *0.0036*
S13	218.20-160ER-ME08 MS2050	SPMT100408T-M08 F40M	19,0 *0.75*	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*
H5	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	26,0 *1.0*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
H8	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	23,0 *0.90*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
H11	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	26,0 *1.0*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
H12	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	23,0 *0.90*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
H21	218.20-160ER-M08 F25M	SPMT100408T-M08 F25M	23,0 *0.90*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-160 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
P2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P4	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,19 *0.0075*	0,22 *0.0085*	0,30 *0.012*
P5	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P6	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P7	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P8	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
P11	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
P12	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	26,0 *1.0*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*
M1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
M2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
M3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	26,0 *1.0*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
M4	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
M5	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
K1	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
K2	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K3	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K4	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K5	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,16 *0.0065*	0,20 *0.0080*	0,28 *0.011*
K6	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K7	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	32,0 *1.3*	0,16 *0.0065*	0,20 *0.0080*	0,28 *0.011*
N1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
N2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
N3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
N11	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	32,0 *1.3*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
S1	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
S2	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*
S3	218.20-160ER-ME08 F40M	SPMT100408T-M08 F40M	19,0 *0.75*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
S11	218.20-160ER-ME08 MS2050	SPMT100408T-M08 F40M	23,0 *0.90*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
S12	218.20-160ER-ME08 MS2050	SPMT100408T-M08 F40M	23,0 *0.90*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*
S13	218.20-160ER-ME08 MS2050	SPMT100408T-M08 F40M	19,0 *0.75*	0,10 *0.0040*	0,12 *0.0048*	0,17 *0.0065*
H5	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	26,0 *1.0*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*
H8	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	23,0 *0.90*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
H11	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	26,0 *1.0*	0,12 *0.0048*	0,15 *0.0060*	0,20 *0.0080*
H12	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	23,0 *0.90*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*
H21	218.20-160ER-M08 F25M	SPMT100408T-M08 F40M	23,0 *0.90*	0,095 *0.0038*	0,11 *0.0044*	0,16 *0.0065*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-160 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	230 *750*	250 *820*	300 *980*	360 *1175*	390 *1275*	220 *720*	240 *790*	290 *950*	345 *1125*	375 *1225*	180 *590*	195 *640*	235 *770*	280 *920*	305 *1000*	260 *850*	280 *920*	340 *1125*	405 *1325*	435 *1425*
P2	225 *740*	240 *790*	295 *970*	345 *1125*	380 *1250*	215 *710*	235 *770*	285 *940*	335 *1100*	365 *1200*	175 *570*	190 *620*	230 *750*	270 *890*	295 *970*	250 *820*	270 *890*	330 *1075*	390 *1275*	425 *1400*
P3	195 *640*	210 *690*	260 *850*	300 *980*	330 *1075*	190 *620*	205 *670*	250 *820*	290 *950*	320 *1050*	155 *510*	165 *540*	200 *660*	235 *770*	260 *850*	220 *720*	240 *790*	290 *950*	340 *1125*	370 *1225*
P4	170 *560*	185 *610*	225 *740*	265 *870*	290 *950*	165 *540*	180 *590*	220 *720*	255 *840*	280 *920*	135 *445*	145 *475*	175 *570*	210 *690*	230 *750*	195 *640*	210 *690*	255 *840*	300 *980*	330 *1075*
P5	165 *540*	180 *590*	215 *710*	260 *850*	280 *920*	160 *520*	170 *560*	210 *690*	250 *820*	270 *890*	130 *425*	140 *460*	170 *560*	205 *670*	220 *720*	185 *610*	200 *660*	245 *800*	290 *950*	315 *1025*
P6	185 *610*	200 *660*	245 *800*	290 *950*	315 *1025*	180 *590*	195 *640*	235 *770*	280 *920*	300 *980*	145 *475*	155 *510*	190 *620*	225 *740*	245 *800*	210 *690*	225 *740*	270 *890*	325 *1075*	350 *1150*
P7	175 *570*	190 *620*	230 *750*	275 *900*	295 *970*	170 *560*	180 *590*	220 *720*	265 *870*	285 *940*	135 *445*	145 *475*	180 *590*	215 *710*	230 *750*	195 *640*	215 *710*	255 *840*	305 *1000*	330 *1075*
P8	165 *540*	180 *590*	215 *710*	255 *840*	280 *920*	160 *520*	170 *560*	210 *690*	245 *800*	270 *890*	130 *425*	140 *460*	170 *560*	200 *660*	220 *720*	185 *610*	200 *660*	245 *800*	285 *940*	310 *1025*
P11	170 *560*	185 *610*	225 *740*	265 *870*	285 *940*	165 *540*	175 *570*	215 *710*	255 *840*	275 *900*	135 *445*	145 *475*	175 *570*	210 *690*	225 *740*	190 *620*	205 *670*	250 *820*	295 *970*	325 *1075*
P12	120 *395*	125 *410*	155 *510*	170 *560*	185 *610*	115 *375*	120 *395*	150 *490*	165 *540*	180 *590*	90 *295*	100 *330*	120 *395*	135 *445*	145 *475*	130 *425*	140 *460*	170 *560*	190 *620*	205 *670*
M1	— —	— —	— —	— —	— —	175 *570*	190 *620*	230 *750*	270 *890*	295 *970*	150 *490*	160 *520*	200 *660*	235 *770*	255 *840*	205 *670*	220 *720*	265 *870*	315 *1025*	340 *1125*
M2	— —	— —	— —	— —	— —	145 *475*	155 *510*	190 *620*	225 *740*	240 *790*	125 *410*	135 *445*	160 *520*	195 *640*	210 *690*	165 *540*	180 *590*	220 *720*	260 *850*	280 *920*
M3	— —	— —	— —	— —	— —	125 *410*	130 *425*	160 *520*	180 *590*	195 *640*	105 *345*	115 *375*	140 *460*	155 *510*	170 *560*	145 *475*	155 *510*	185 *610*	210 *690*	225 *740*
M4	— —	— —	— —	— —	— —	100 *330*	105 *345*	125 *410*	140 *460*	150 *490*	85 *280*	90 *295*	110 *360*	120 *395*	130 *425*	115 *375*	120 *395*	145 *475*	160 *520*	175 *570*
M5	— —	— —	— —	— —	— —	85 *280*	85 *280*	105 *345*	115 *375*	125 *410*	70 *230*	75 *245*	90 *295*	100 *330*	110 *360*	95 *310*	100 *330*	120 *395*	130 *425*	145 *475*
K1	175 *570*	190 *620*	235 *770*	275 *900*	300 *980*	170 *560*	185 *610*	225 *740*	265 *870*	290 *950*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K2	155 *510*	170 *560*	205 *670*	245 *800*	265 *870*	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K3	130 *425*	145 *475*	175 *570*	210 *690*	225 *740*	130 *425*	140 *460*	170 *560*	200 *660*	215 *710*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K4	125 *410*	135 *445*	165 *540*	200 *660*	215 *710*	120 *395*	130 *425*	160 *520*	190 *620*	205 *670*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K5	80 *260*	85 *280*	100 *330*	120 *395*	130 *425*	75 *245*	80 *260*	100 *330*	115 *375*	125 *410*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K6	110 *360*	120 *395*	145 *475*	175 *570*	190 *620*	105 *345*	115 *375*	140 *460*	170 *560*	180 *590*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
K7	100 *330*	110 *360*	130 *425*	155 *510*	170 *560*	95 *310*	105 *345*	125 *410*	150 *490*	160 *520*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N1	— —	— —	— —	— —	— —	1275 *4175*	1375 *4500*	1675 *5500*	1975 *6475*	2150 *7050*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	510 *1675*	550 *1800*	680 *2225*	790 *2600*	870 *2850*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	340 *1125*	365 *1200*	450 *1475*	530 *1750*	580 *1900*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	390 *1275*	420 *1375*	520 *1700*	610 *2000*	660 *2175*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	48 *155*	50 *165*	60 *195*	65 *215*	75 *245*	46 *150*	48 *155*	60 *195*	65 *215*	70 *230*	26 *85*	27 *90*	34 *110*	36 *120*	40 *130*	55 *180*	55 *180*	70 *230*	75 *245*	80 *260*
S2	39 *130*	40 *130*	50 *165*	55 *180*	60 *195*	37 *120*	39 *130*	48 *155*	50 *165*	55 *180*	21 *70*	22 *70*	27 *90*	29 *95*	32 *105*	43 *140*	45 *150*	55 *180*	60 *195*	65 *215*
S3	34 *110*	36 *120*	44 *145*	47 *155*	50 *165*	33 *110*	34 *110*	42 *140*	45 *150*	50 *165*	19 *60*	19 *60*	24 *80*	26 *85*	28 *90*	38 *125*	40 *130*	48 *155*	50 *165*	55 *180*
S11	65 *215*	70 *230*	85 *280*	95 *310*	100 *330*	65 *215*	65 *215*	80 *260*	90 *295*	100 *330*	36 *120*	38 *125*	47 *155*	50 *165*	55 *180*	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*
S12	45 *150*	48 *155*	60 *195*	65 *215*	70 *230*	44 *145*	46 *150*	55 *180*	65 *215*	70 *230*	33 *110*	35 *115*	43 *140*	47 *155*	50 *165*	50 *165*	55 *180*	65 *215*	75 *245*	80 *260*
S13	27 *90*	28 *90*	35 *115*	38 *125*	41 *135*	26 *85*	27 *90*	33 *110*	36 *120*	40 *130*	20 *65*	21 *70*	25 *80*	27 *90*	30 *100*	30 *100*	32 *105*	38 *125*	42 *140*	46 *150*
H5	39 *130*	42 *140*	50 *165*	55 *180*	60 *195*	38 *125*	40 *130*	49 *160*	55 *180*	60 *195*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H8	42 *140*	45 *150*	55 *180*	60 *195*	65 *215*	41 *135*	43 *140*	50 *165*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H11	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*	48 *155*	50 *165*	65 *215*	70 *230*	75 *245*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H12	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
H21	42 *140*	45 *150*	55 *180*	60 *195*	65 *215*	41 *135*	43 *140*	50 *165*	55 *180*	65 *215*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —

R218.20-200 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
P2	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
P3	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,19 *0.0075*	0,19 *0.0075*	0,20 *0.0080*
P4	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,19 *0.0075*	0,19 *0.0075*	0,20 *0.0080*
P5	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P6	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P7	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P8	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,19 *0.0075*	0,19 *0.0075*	0,20 *0.0080*
P11	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P12	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	29,0 *1.1*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M1	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
M2	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
M3	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	29,0 *1.1*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
M4	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M5	218.20-200ER-M10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
N1	218.20-200ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N2	218.20-200ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N3	218.20-200ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N11	218.20-200ER-ME10 F40M	SCET120612T-M11 F40M	36,0 *1.4*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
S1	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
S2	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
S3	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
S11	218.20-200ER-ME10 MS2050	SCET120612T-M14 MS2050	25,0 *1.0*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
S12	218.20-200ER-ME10 MS2050	SCET120612T-M14 MS2050	25,0 *1.0*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
S13	218.20-200ER-ME10 MS2050	SCET120612T-M14 MS2050	22,0 *0.85*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-200 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,28 *0.011*	0,34 *0.013*	0,46 *0.018*
P2	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,28 *0.011*	0,34 *0.013*	0,48 *0.019*
P3	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,26 *0.010*	0,32 *0.013*	0,44 *0.017*
P4	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,26 *0.010*	0,32 *0.013*	0,44 *0.017*
P5	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
P6	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
P7	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
P8	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,26 *0.010*	0,32 *0.013*	0,44 *0.017*
P11	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	36,0 *1.4*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
P12	218.20-200ER-M10 F40M	SCET120612T-M11 MP2501	29,0 *1.1*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*
M1	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,28 *0.011*	0,34 *0.013*	0,48 *0.019*
M2	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	36,0 *1.4*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
M3	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	29,0 *1.1*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
M4	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
M5	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
N1	218.20-200ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
N2	218.20-200ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
N3	218.20-200ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
N11	218.20-200ER-ME10 F40M	SCET120612T-M14 F40M	36,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
S1	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
S2	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
S3	218.20-200ER-ME10 F40M	SCET120612T-M14 T350M	22,0 *0.85*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*
S11	218.20-200ER-ME10 MS2050	SCET120612T-M14 MS2050	25,0 *1.0*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
S12	218.20-200ER-ME10 MS2050	SCET120612T-M14 MS2050	25,0 *1.0*	0,15 *0.0060*	0,17 *0.0065*	0,24 *0.0095*
S13	218.20-200ER-ME10 MS2050	SCET120612T-M14 MS2050	22,0 *0.85*	0,13 *0.0050*	0,15 *0.0060*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-200 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	205 *670*	220 *720*	270 *890*	320 *1050*	345 *1125*	165 *540*	180 *590*	220 *720*	260 *850*	280 *920*	245 *800*	265 *870*	320 *1050*	385 *1275*	415 *1350*
P2	195 *640*	210 *690*	260 *850*	310 *1025*	335 *1100*	160 *520*	170 *560*	210 *690*	250 *820*	270 *890*	240 *790*	255 *840*	315 *1025*	370 *1225*	405 *1325*
P3	170 *560*	185 *610*	225 *740*	270 *890*	290 *950*	140 *460*	150 *490*	180 *590*	220 *720*	235 *770*	210 *690*	225 *740*	275 *900*	320 *1050*	355 *1175*
P4	150 *490*	165 *540*	200 *660*	240 *790*	260 *850*	125 *410*	130 *425*	160 *520*	195 *640*	210 *690*	185 *610*	200 *660*	240 *790*	290 *950*	310 *1025*
P5	145 *475*	160 *520*	195 *640*	230 *750*	250 *820*	120 *395*	130 *425*	160 *520*	185 *610*	200 *660*	175 *570*	190 *620*	230 *750*	275 *900*	295 *970*
P6	165 *540*	175 *570*	220 *720*	255 *840*	280 *920*	135 *445*	145 *475*	175 *570*	205 *670*	225 *740*	195 *640*	215 *710*	260 *850*	310 *1025*	340 *1125*
P7	155 *510*	165 *540*	205 *670*	240 *790*	265 *870*	125 *410*	135 *445*	165 *540*	195 *640*	215 *710*	185 *610*	200 *660*	245 *800*	290 *950*	320 *1050*
P8	145 *475*	155 *510*	190 *620*	230 *750*	245 *800*	115 *375*	125 *410*	155 *510*	185 *610*	200 *660*	175 *570*	190 *620*	230 *750*	270 *890*	295 *970*
P11	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	120 *395*	130 *425*	160 *520*	190 *620*	210 *690*	180 *590*	195 *640*	235 *770*	285 *940*	310 *1025*
P12	105 *345*	110 *360*	135 *445*	150 *490*	165 *540*	85 *280*	90 *295*	110 *360*	125 *410*	135 *445*	125 *410*	135 *445*	160 *520*	180 *590*	195 *640*
M1	155 *510*	170 *560*	210 *690*	250 *820*	270 *890*	135 *445*	145 *475*	180 *590*	215 *710*	235 *770*	190 *620*	205 *670*	255 *840*	300 *980*	325 *1075*
M2	130 *425*	140 *460*	175 *570*	205 *670*	225 *740*	115 *375*	125 *410*	150 *490*	175 *570*	195 *640*	160 *520*	170 *560*	210 *690*	250 *820*	265 *870*
M3	115 *375*	120 *395*	145 *475*	165 *540*	180 *590*	95 *310*	105 *345*	125 *410*	145 *475*	155 *510*	135 *445*	145 *475*	175 *570*	200 *660*	215 *710*
M4	90 *295*	95 *310*	120 *395*	130 *425*	140 *460*	80 *260*	80 *260*	100 *330*	110 *360*	120 *395*	110 *360*	115 *375*	140 *460*	150 *490*	165 *540*
M5	75 *245*	80 *260*	100 *330*	105 *345*	120 *395*	65 *215*	70 *230*	85 *280*	95 *310*	100 *330*	90 *295*	95 *310*	115 *375*	125 *410*	140 *460*
N1	1150 *3775*	1250 *4100*	1525 *5000*	1800 *5900*	1975 *6475*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	470 *1550*	500 *1650*	620 *2025*	730 *2400*	800 *2625*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	310 *1025*	335 *1100*	410 *1350*	485 *1600*	530 *1750*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	355 *1175*	380 *1250*	470 *1550*	550 *1800*	610 *2000*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	43 *140*	45 *150*	55 *180*	60 *195*	65 *215*	24 *80*	25 *80*	31 *100*	34 *110*	37 *120*	50 *165*	55 *180*	65 *215*	70 *230*	80 *260*
S2	35 *115*	36 *120*	44 *145*	48 *155*	55 *180*	20 *65*	20 *65*	25 *80*	27 *90*	30 *100*	41 *135*	43 *140*	50 *165*	55 *180*	65 *215*
S3	30 *100*	32 *105*	39 *130*	43 *140*	46 *150*	17 *55*	18 *60*	22 *70*	24 *80*	26 *85*	36 *120*	38 *125*	46 *150*	50 *165*	55 *180*
S11	60 *195*	60 *195*	75 *245*	85 *280*	90 *295*	33 *110*	35 *115*	43 *140*	48 *155*	50 *165*	70 *230*	75 *245*	90 *295*	100 *330*	110 *360*
S12	41 *135*	43 *140*	50 *165*	60 *195*	65 *215*	31 *100*	32 *105*	40 *130*	44 *145*	47 *155*	48 *155*	50 *165*	65 *215*	70 *230*	75 *245*
S13	24 *80*	25 *80*	31 *100*	34 *110*	37 *120*	18 *60*	19 *60*	23 *75*	26 *85*	28 *90*	29 *95*	30 *100*	37 *120*	40 *130*	44 *145*

R218.20-250 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*
P2	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
P3	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,16 *0.0065*	0,16 *0.0065*	0,18 *0.0070*
P4	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,19 *0.0075*	0,19 *0.0075*	0,20 *0.0080*
P5	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P6	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P7	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P8	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,19 *0.0075*	0,19 *0.0075*	0,20 *0.0080*
P11	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
P12	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	34,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M1	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
M2	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
M3	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	34,0 *1.3*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
M4	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*
M5	218.20-250TR-M14 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
N1	218.20-250ER-ME12 F40M	SCET120612T-M11 F40M	42,0 *1.7*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
N2	218.20-250ER-ME12 F40M	SCET120612T-M11 F40M	42,0 *1.7*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
N3	218.20-250ER-ME12 F40M	SCET120612T-M11 F40M	42,0 *1.7*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
N11	218.20-250ER-ME12 F40M	SCET120612T-M11 F40M	42,0 *1.7*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
S1	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*
S2	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*
S3	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
S11	218.20-250ER-ME12 MS2050	SCET120612T-M14 MS2050	29,0 *1.1*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
S12	218.20-250ER-ME12 MS2050	SCET120612T-M14 MS2050	29,0 *1.1*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
S13	218.20-250ER-ME12 MS2050	SCET120612T-M14 MS2050	25,0 *1.0*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-250 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
P2	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
P3	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,22 *0.0085*	0,28 *0.011*	0,38 *0.015*
P4	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,26 *0.010*	0,32 *0.013*	0,44 *0.017*
P5	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,26 *0.010*	0,30 *0.012*	0,42 *0.017*
P6	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
P7	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
P8	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,26 *0.010*	0,32 *0.013*	0,44 *0.017*
P11	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	42,0 *1.7*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
P12	218.20-250TR-M14 F40M	SCET120612T-M11 MP2501	34,0 *1.3*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*
M1	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
M2	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	42,0 *1.7*	0,22 *0.0085*	0,26 *0.010*	0,36 *0.014*
M3	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	34,0 *1.3*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
M4	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
M5	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
N1	218.20-250ER-ME12 F40M	SCET120612T-M14 F40M	42,0 *1.7*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
N2	218.20-250ER-ME12 F40M	SCET120612T-M14 F40M	42,0 *1.7*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
N3	218.20-250ER-ME12 F40M	SCET120612T-M14 F40M	42,0 *1.7*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
N11	218.20-250ER-ME12 F40M	SCET120612T-M14 F40M	42,0 *1.7*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
S1	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
S2	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*
S3	218.20-250ER-ME12 F40M	SCET120612T-M14 T350M	25,0 *1.0*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
S11	218.20-250ER-ME12 MS2050	SCET120612T-M14 MS2050	29,0 *1.1*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
S12	218.20-250ER-ME12 MS2050	SCET120612T-M14 MS2050	29,0 *1.1*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
S13	218.20-250ER-ME12 MS2050	SCET120612T-M14 MS2050	25,0 *1.0*	0,15 *0.0060*	0,18 *0.0070*	0,25 *0.010*

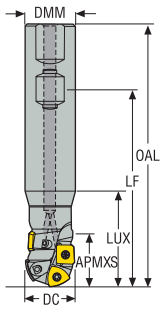
SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.20-250 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	190 *620*	210 *690*	255 *840*	305 *1000*	325 *1075*	155 *510*	170 *560*	210 *690*	245 *800*	265 *870*	210 *690*	230 *750*	280 *920*	335 *1100*	360 *1175*
P2	185 *610*	205 *670*	245 *800*	295 *970*	315 *1025*	150 *490*	165 *540*	200 *660*	240 *790*	255 *840*	205 *670*	225 *740*	270 *890*	325 *1075*	350 *1150*
P3	165 *540*	180 *590*	215 *710*	255 *840*	275 *900*	130 *425*	145 *475*	175 *570*	205 *670*	225 *740*	180 *590*	195 *640*	235 *770*	280 *920*	305 *1000*
P4	145 *475*	155 *510*	190 *620*	230 *750*	245 *800*	115 *375*	125 *410*	155 *510*	185 *610*	195 *640*	160 *520*	170 *560*	210 *690*	250 *820*	270 *890*
P5	135 *445*	150 *490*	185 *610*	215 *710*	235 *770*	110 *360*	120 *395*	150 *490*	175 *570*	190 *620*	150 *490*	165 *540*	200 *660*	240 *790*	260 *850*
P6	155 *510*	170 *560*	205 *670*	245 *800*	265 *870*	125 *410*	135 *445*	165 *540*	200 *660*	215 *710*	170 *560*	185 *610*	225 *740*	270 *890*	290 *950*
P7	145 *475*	160 *520*	195 *640*	230 *750*	250 *820*	120 *395*	130 *425*	160 *520*	185 *610*	200 *660*	160 *520*	175 *570*	215 *710*	255 *840*	275 *900*
P8	135 *445*	150 *490*	180 *590*	215 *710*	230 *750*	110 *360*	120 *395*	145 *475*	175 *570*	190 *620*	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*
P11	140 *460*	155 *510*	190 *620*	225 *740*	245 *800*	115 *375*	125 *410*	155 *510*	180 *590*	195 *640*	155 *510*	170 *560*	210 *690*	245 *800*	265 *870*
P12	95 *310*	105 *345*	125 *410*	145 *475*	155 *510*	75 *245*	85 *280*	100 *330*	115 *375*	125 *410*	105 *345*	115 *375*	135 *445*	160 *520*	170 *560*
M1	150 *490*	165 *540*	200 *660*	235 *770*	255 *840*	130 *425*	140 *460*	170 *560*	205 *670*	220 *720*	165 *540*	180 *590*	220 *720*	260 *850*	280 *920*
M2	125 *410*	135 *445*	165 *540*	195 *640*	210 *690*	105 *345*	115 *375*	140 *460*	170 *560*	185 *610*	135 *445*	150 *490*	180 *590*	215 *710*	235 *770*
M3	100 *330*	110 *360*	135 *445*	155 *510*	170 *560*	90 *295*	95 *310*	115 *375*	135 *445*	145 *475*	110 *360*	120 *395*	150 *490*	170 *560*	185 *610*
M4	85 *280*	90 *295*	110 *360*	125 *410*	135 *445*	75 *245*	80 *260*	95 *310*	105 *345*	115 *375*	95 *310*	100 *330*	125 *410*	135 *445*	145 *475*
M5	70 *230*	75 *245*	95 *310*	100 *330*	110 *360*	60 *195*	65 *215*	80 *260*	90 *295*	95 *310*	75 *245*	85 *280*	105 *345*	110 *360*	120 *395*
N1	1075 *3525*	1175 *3850*	1450 *4750*	1725 *5650*	1875 *6150*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N2	435 *1425*	475 *1550*	580 *1900*	690 *2275*	750 *2450*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N3	290 *950*	315 *1025*	390 *1275*	465 *1525*	500 *1650*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
N11	335 *1100*	360 *1175*	445 *1450*	530 *1750*	570 *1875*	— —	— —	— —	— —	— —	— —	— —	— —	— —	— —
S1	39 *130*	42 *140*	50 *165*	55 *180*	60 *195*	22 *70*	24 *80*	30 *100*	32 *105*	35 *115*	43 *140*	47 *155*	55 *180*	65 *215*	70 *230*
S2	32 *105*	34 *110*	42 *140*	46 *150*	50 *165*	18 *60*	19 *60*	24 *80*	26 *85*	28 *90*	35 *115*	38 *125*	46 *150*	50 *165*	55 *180*
S3	28 *90*	30 *100*	36 *120*	40 *130*	43 *140*	16 *50*	17 *55*	21 *70*	23 *75*	25 *80*	31 *100*	33 *110*	40 *130*	44 *145*	48 *155*
S11	55 *180*	60 *195*	70 *230*	80 *260*	85 *280*	30 *100*	33 *110*	40 *130*	44 *145*	48 *155*	60 *195*	65 *215*	75 *245*	85 *280*	95 *310*
S12	37 *120*	40 *130*	49 *160*	55 *180*	60 *195*	28 *90*	30 *100*	37 *120*	41 *135*	45 *150*	40 *130*	44 *145*	55 *180*	60 *195*	65 *215*
S13	22 *70*	24 *80*	29 *95*	32 *105*	35 *115*	17 *55*	18 *60*	22 *70*	24 *80*	26 *85*	24 *80*	26 *85*	32 *105*	35 *115*	38 *125*

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R218.19 – Metric



- For insert selection and cutting data recommendations, see page(s) 643-659
- For complete insert programme, see page(s) 770, 787
- For ISO attribute explanation, see page 16

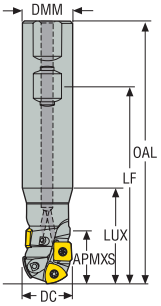
Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	LUX	RPMX	Weight	218.19	SPMT
			mm		mm	mm	mm	mm	mm		kg		
R218.19-2016.3-17.050A	75069117	Weldon	16,0	1	17,5	20,0	60,0	100,0	31,0	41600	0,2	-080(2)	-0602(2)
R218.19-2520.3-21.069A	75069118	Weldon	20,0	1	21,6	25,0	82,5	125,0	31,0	26200	0,4	-100(2)	-0703(2)
R218.19-2525.3-26.074HA	75069119	Weldon	25,0	1	26,6	25,0	82,5	130,0	46,0	21700	0,4	-125(2)	-0903(2)
R218.19-3232.3-30.070HA	75069120	Weldon	32,0	1	31,2	32,0	82,5	130,0	46,0	14800	0,7	-160(2)	–

Spare Parts / Accessories

For cutter	Insert screw	Torque key	Torque value
R218.19-.. Ø16	C02205-T07P	T00-07P09	0.9NM
R218.19-.. Ø20	C02506-T07P	T00-07P09	0.9NM
R218.19-.. Ø25	C03006-T09P	T00-09P20	2.0NM
R218.19-.. Ø32	C03508-T15P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.19 – Inch



- For insert selection and cutting data recommendations, see page(s) 643-659
- For complete insert programme, see page(s) 770, 787
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	LUX	RPMX	Weight	218.19	SPMX
			Inch		Inch	Inch	Inch	Inch	Inch		lbs		
R218.19-00.75-3-21M	00087573	Weldon	0.750	1	0.835	0.750	2.583	4.031	1.425	26200	0.660	100 (2)	0703 (2)
R218.19-01.00-3-26H	00087575	Weldon	1.000	1	1.063	1.000	2.835	5.031	2.173	21700	1.100	125 (2)	0903 (2)

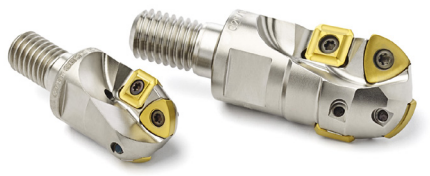
Spare Parts

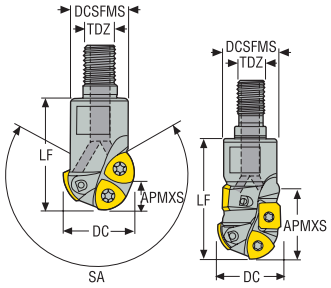
Accessories

For cutter	Insert screw	Torque key	Torque value
R218.19-00.75	C02506-T07P	T00-07P09	8.0IN.LBS
R218.19-01.00	C03006-T09P	T00-09P20	17.7IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.19 – Metric





- For insert selection and cutting data recommendations, see page(s) 643-659
- For complete insert programme, see page(s) 770, 787
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DCSFMS	TDZ	LF	RPMX	Weight	218.19	SPMX	SPMT
			mm		mm	mm		mm		kg			
R218.19-0816.RE-12A	02644033	Combimaster	16,0	1	12,0	13,5	M8	23,0	41600	0,1	-080(2)	-0602	–
R218.19-1020.RE-16A	02644034	Combimaster	20,0	1	16,0	18,0	M10	28,0	26200	0,1	-100(2)	-0703	–
R218.19-1220.RE-21A	75077649	Combimaster	20,0	1	21,6	21,0	M12	45,0	26200	0,1	-100(2)	-0703(2)	–
R218.19-1225.RE-26HA	75094632	Combimaster	25,0	1	26,6	21,0	M12	45,0	21700	0,1	-125(2)	-0903(2)	–
R218.19-1632.RE-36HA	75077650	Combimaster	32,0	1	38,6	28,0	M16	55,0	14800	0,2	-160(2)	–	-1004(3)
R218.19-1225.RE-14HFA	75094633	Combimaster	25,0	1	12,5	21,0	M12	40,0	21700	0,1	-125(3)	–	–
R218.19-1632.RE-18HFA	75094580	Combimaster	32,0	1	16,0	28,0	M16	40,0	14800	0,2	-160(3)	–	–
R218.19-1640.RE-25HFA	00089918	Combimaster	40,0	1	20,0	28,0	M16	50,0	10400	0,2	-200(3)	–	–

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

For cutter	Insert screw
R218.19-.. Ø16	C02205-T07P
R218.19-.. Ø20	C02506-T07P
R218.19-.. Ø25	C03006-T09P
R218.19-.. Ø32	C03508-T15P
R218.19-.. Ø40	C45011-T20P

Accessories

Torque key	Torque value
T00-07P09	0.9NM
T00-07P09	0.9NM
T00-09P20	2.0NM
T00-15P30	3.0NM
T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.19-080 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
P2	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,15 *0.0060*	0,15 *0.0060*	0,17 *0.0065*
P3	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
P4	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P5	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P6	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P7	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P8	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,16 *0.0065*
P11	218.19-080T-MD04 MS2500	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
P12	218.19-080T-MD04 MS2500	SPMX060204-75 F40M	9,0 *0.36*	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*
M1	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,15 *0.0060*	0,15 *0.0060*	0,17 *0.0065*
M2	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
M3	218.19-080T-M04 F40M	SPMX060204-75 F40M	9,0 *0.36*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
M4	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
M5	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
K1	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,15 *0.0060*	0,15 *0.0060*	0,17 *0.0065*
K2	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
K3	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
K4	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
K5	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*
K6	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
K7	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*
S1	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
S2	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
S3	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,10 *0.0040*	0,10 *0.0040*	0,10 *0.0040*
S11	218.19-080T-M04 F40M	SPMX060204-75 F40M	8,0 *0.32*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*
S12	218.19-080T-M04 F40M	SPMX060204-75 F40M	8,0 *0.32*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*
S13	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,11 *0.0044*	0,11 *0.0044*	0,11 *0.0044*
H5	218.19-080T-MD04 F15M	SPMX060204-75 F40M	7,0 *0.28*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
H8	218.19-080T-MD04 F15M	SPMX060204-75 F40M	6,0 *0.24*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
H11	218.19-080T-MD04 F15M	SPMX060204-75 F40M	7,0 *0.28*	0,090 *0.0036*	0,090 *0.0036*	0,095 *0.0038*
H12	218.19-080T-M04 F30M	SPMX060204-75 F40M	6,0 *0.24*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*
H21	218.19-080T-MD04 F15M	SPMX060204-75 F40M	6,0 *0.24*	0,070 *0.0028*	0,070 *0.0028*	0,075 *0.0030*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-080 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
P2	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,22 *0.0085*	0,26 *0.010*	0,36 *0.014*
P3	218.19-080T-M04 F40M	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P4	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P5	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P6	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,19 *0.0075*	0,24 *0.0095*	0,32 *0.013*
P7	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,19 *0.0075*	0,24 *0.0095*	0,32 *0.013*
P8	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
P11	218.19-080T-M04 MP2501	SPMX060204-75 F40M	11,0 *0.44*	0,19 *0.0075*	0,24 *0.0095*	0,32 *0.013*
P12	218.19-080T-M04 MP2501	SPMX060204-75 F40M	9,0 *0.36*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
M1	218.19-080T-M04 F30M	SPMX060204-75 F40M	11,0 *0.44*	0,22 *0.0085*	0,26 *0.010*	0,36 *0.014*
M2	218.19-080T-M04 F30M	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
M3	218.19-080T-M04 F30M	SPMX060204-75 F40M	9,0 *0.36*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*
M4	218.19-080T-M04 F30M	SPMX060204-75 F40M	6,0 *0.24*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
M5	218.19-080T-M04 F30M	SPMX060204-75 F40M	6,0 *0.24*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
K1	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,22 *0.0085*	0,26 *0.010*	0,36 *0.014*
K2	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
K3	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
K4	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
K5	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
K6	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
K7	218.19-080T-MD04 F15M	SPMX060204-75 F40M	11,0 *0.44*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
S1	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
S2	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
S3	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,13 *0.0050*	0,16 *0.0065*	0,22 *0.0085*
S11	218.19-080T-M04 F40M	SPMX060204-75 F40M	8,0 *0.32*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*
S12	218.19-080T-M04 F40M	SPMX060204-75 F40M	8,0 *0.32*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*
S13	218.19-080T-M04 F40M	SPMX060204-75 F40M	6,0 *0.24*	0,14 *0.0055*	0,17 *0.0065*	0,24 *0.0095*
H5	218.19-080T-MD04 F15M	SPMX060204-75 F40M	7,0 *0.28*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
H8	218.19-080T-MD04 F15M	SPMX060204-75 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H11	218.19-080T-MD04 F15M	SPMX060204-75 F40M	7,0 *0.28*	0,12 *0.0048*	0,14 *0.0055*	0,20 *0.0080*
H12	218.19-080T-M04 F30M	SPMX060204-75 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*
H21	218.19-080T-MD04 F15M	SPMX060204-75 F40M	6,0 *0.24*	0,090 *0.0036*	0,11 *0.0044*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-080 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501					F15M					F40M					MS2500				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	275	300	365	430	460	—	—	—	—	—	210	225	275	325	350	285	310	380	445	480
	900	*980*	*1200*	*1400*	*1500*	—	—	—	—	—	*690*	*740*	*900*	*1075*	*1150*	*940*	*1025*	*1250*	*1450*	*1575*
P2	265	290	350	415	450	—	—	—	—	—	200	220	265	315	340	275	300	360	430	465
	870	*950*	*1150*	*1350*	*1475*	—	—	—	—	—	*660*	*720*	*870*	*1025*	*1125*	*900*	*980*	*1175*	*1400*	*1525*
P3	235	255	305	365	395	—	—	—	—	—	175	195	230	275	300	240	265	315	375	405
	770	*840*	*1000*	*1200*	*1300*	—	—	—	—	—	*570*	*640*	*750*	*900*	*980*	*790*	*870*	*1025*	*1225*	*1325*
P4	205	225	275	320	345	—	—	—	—	—	155	170	210	245	260	215	235	285	330	360
	670	*740*	*900*	*1050*	*1125*	—	—	—	—	—	*510*	*560*	*690*	*800*	*850*	*710*	*770*	*940*	*1075*	*1175*
P5	195	215	260	305	330	—	—	—	—	—	150	165	200	230	250	205	220	270	315	340
	640	*710*	*850*	*1000*	*1075*	—	—	—	—	—	*490*	*540*	*660*	*750*	*820*	*670*	*720*	*890*	*1025*	*1125*
P6	220	240	295	345	375	—	—	—	—	—	165	180	225	260	285	230	250	305	355	390
	720	*790*	*970*	*1125*	*1225*	—	—	—	—	—	*540*	*590*	*740*	*850*	*940*	*750*	*820*	*1000*	*1175*	*1275*
P7	210	225	275	325	355	—	—	—	—	—	160	170	210	245	270	215	235	285	335	370
	690	*740*	*900*	*1075*	*1175*	—	—	—	—	—	*520*	*560*	*690*	*800*	*890*	*710*	*770*	*940*	*1100*	*1225*
P8	195	215	255	305	330	—	—	—	—	—	150	165	195	230	250	205	220	265	315	340
	640	*710*	*840*	*1000*	*1075*	—	—	—	—	—	*490*	*540*	*640*	*750*	*820*	*670*	*720*	*870*	*1025*	*1125*
P11	205	220	270	315	345	—	—	—	—	—	155	165	205	240	260	210	230	280	325	355
	670	*720*	*890*	*1025*	*1125*	—	—	—	—	—	*510*	*540*	*670*	*790*	*850*	*690*	*750*	*920*	*1075*	*1175*
P12	140	150	180	210	230	—	—	—	—	—	105	115	135	160	175	140	155	190	220	240
	460	*490*	*590*	*690*	*750*	—	—	—	—	—	*345*	*375*	*445*	*520*	*570*	*460*	*510*	*620*	*720*	*790*
M1	190	210	250	300	325	—	—	—	—	—	165	180	215	255	275	200	215	260	310	335
	620	*690*	*820*	*980*	*1075*	—	—	—	—	—	*540*	*590*	*710*	*840*	*900*	*660*	*710*	*850*	*1025*	*1100*
M2	160	175	210	245	265	—	—	—	—	—	135	145	180	210	225	165	180	215	255	275
	520	*570*	*690*	*800*	*870*	—	—	—	—	—	*445*	*475*	*590*	*690*	*740*	*540*	*590*	*710*	*840*	*900*
M3	135	145	175	205	225	—	—	—	—	—	115	125	150	175	190	140	150	180	210	230
	445	*475*	*570*	*670*	*740*	—	—	—	—	—	*375*	*410*	*490*	*570*	*620*	*460*	*490*	*590*	*690*	*750*
M4	115	120	145	175	190	—	—	—	—	—	95	100	125	145	160	115	125	150	180	195
	375	*395*	*475*	*570*	*620*	—	—	—	—	—	*310*	*330*	*410*	*475*	*520*	*375*	*410*	*490*	*590*	*640*
M5	95	100	120	145	155	—	—	—	—	—	80	85	105	120	135	95	100	125	150	160
	310	*330*	*395*	*475*	*510*	—	—	—	—	—	*260*	*280*	*345*	*395*	*445*	*310*	*330*	*410*	*490*	*520*
K1	210	230	275	330	355	185	200	240	285	310	160	175	210	250	270	—	—	—	—	—
	690	*750*	*900*	*1075*	*1175*	*610*	*660*	*790*	*940*	*1025*	*520*	*570*	*690*	*820*	*890*	—	—	—	—	—
K2	185	205	250	290	315	160	175	215	250	270	140	155	190	220	235	—	—	—	—	—
	610	*670*	*820*	*950*	*1025*	*520*	*570*	*710*	*820*	*890*	*460*	*510*	*620*	*720*	*770*	—	—	—	—	—
K3	160	170	210	245	265	135	150	180	210	230	120	130	160	185	200	—	—	—	—	—
	520	*560*	*690*	*800*	*870*	*445*	*490*	*590*	*690*	*750*	*395*	*425*	*520*	*610*	*660*	—	—	—	—	—
K4	150	165	200	235	255	130	140	175	205	220	115	125	150	180	190	—	—	—	—	—
	490	*540*	*660*	*770*	*840*	*425*	*460*	*570*	*670*	*720*	*375*	*410*	*490*	*590*	*620*	—	—	—	—	—
K5	95	100	120	145	155	80	90	105	125	135	70	75	90	110	120	—	—	—	—	—
	310	*330*	*395*	*475*	*510*	*260*	*295*	*345*	*410*	*445*	*230*	*245*	*295*	*360*	*395*	—	—	—	—	—
K6	135	145	175	205	225	115	125	150	180	190	100	110	135	155	170	—	—	—	—	—
	445	*475*	*570*	*670*	*740*	*375*	*410*	*490*	*590*	*620*	*330*	*360*	*445*	*510*	*560*	—	—	—	—	—
K7	120	130	155	185	200	105	115	135	160	170	90	100	120	140	150	—	—	—	—	—
	395	*425*	*510*	*610*	*660*	*345*	*375*	*445*	*520*	*560*	*295*	*330*	*395*	*460*	*490*	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	1175	1300	1550	1825	1975	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*3850*	*4275*	*5075*	*6000*	*6475*	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	480	520	620	740	800	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1575*	*1700*	*2025*	*2425*	*2625*	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	320	345	415	495	530	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1050*	*1125*	*1350*	*1625*	*1750*	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	365	395	475	560	610	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1200*	*1300*	*1550*	*1825*	*2000*	—	—	—	—	—
S1	55	60	70	85	90	—	—	—	—	—	45	47	60	70	75	55	60	75	85	95
	180	*195*	*230*	*280*	*295*	—	—	—	—	—	*150*	*155*	*195*	*230*	*245*	*180*	*195*	*245*	*280*	*310*
S2	44	47	55	70	75	—	—	—	—	—	36	38	47	55	60	46	48	60	70	75
	145	*155*	*180*	*230*	*245*	—	—	—	—	—	*120*	*125*	*155*	*180*	*195*	*150*	*155*	*195*	*230*	*245*
S3	39	41	50	60	65	—	—	—	—	—	32	34	41	48	55	40	43	50	60	65
	130	*135*	*165*	*195*	*215*	—	—	—	—	—	*105*	*110*	*135*	*155*	*180*	*130*	*140*	*165*	*195*	*215*
S11	70	75	95	110	120	—	—	—	—	—	60	65	80	90	100	75	80	100	115	125
	230	*245*	*310*	*360*	*395*	—	—	—	—	—	*195*	*215*	*260*	*295*	*330*	*245*	*260*	*330*	*375*	*410*
S12	50	55	65	75	85	—	—	—	—	—	40	44	55	65	70	50	55	70	80	90
	165	*180*	*215*	*245*	*280*	—	—	—	—	—	*130*	*145*	*180*	*215*	*230*	*165*	*180*	*230*	*260*	*295*
S13	31	33	40	47	50	—	—	—	—	—	25	27	33	38	42	32	34	41	49	55
	100	*110*	*130*	*155*	*165*	—	—	—	—	—	*80*	*90*	*110*	*125*	*140*	*105*	*110*	*135*	*160*	*180*
H5	45	49	60	70	75	43	46	55	65	70	38	40	49	60	65	—	—	—	—	—
	150	*160*	*195*	*230*	*245*	*140*	*150*	*180*	*215*	*230*	*125*	*130*	*160*	*195*	*215*	—	—	—	—	—
H8	49	55	65	75	80	47	50	60	70	80	41	44	55	60	70	—	—	—	—	—
	160	*180*	*215*	*245*	*260*	*155*	*165*	*195*	*230*	*260*	*135*	*145*	*180*	*195*	*230*	—	—	—	—	—
H11	60	60	75	90	95	55	60	70	85	90	48	50	60	75	80	—	—	—	—	—
	195	*195*	*245*	*295*	*310*	*180*	*195*	*230*	*280*	*295*	*155*	*165*	*195*	*245*	*260*	—	—	—	—	—
H12	100	105	125	150	160	85	90	105	125	140	75	80	95	110	125	—	—	—	—	—
	330	*345*	*410*	*490*	*520*	*280*	*295*	*345*	*410*	*460*	*245*	*260*	*310*	*360*	*410*	—	—	—	—	—
H21	49	55	65	75	80	47	50	60	70	80	41	44	55	60	70	—	—	—	—	—
	160	*180*	*215*	*245*	*260*	*155*	*165*	*195*	*230*	*260*	*135*	*145*	*180*	*195*	*230*	—	—	—	—	—

R218.19-100 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
P2	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
P3	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
P4	218.19-100T-MD08 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
P5	218.19-100T-MD08 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
P6	218.19-100T-MD08 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,25 *0.010*	0,25 *0.010*	0,28 *0.011*
P7	218.19-100T-MD08 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,25 *0.010*	0,25 *0.010*	0,28 *0.011*
P8	218.19-100T-MD08 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,30 *0.012*
P11	218.19-100T-MD08 MS2500	SPMX070304-75 F40M	19,0 *0.75*	0,25 *0.010*	0,25 *0.010*	0,28 *0.011*
P12	218.19-100T-MD08 MS2500	SPMX070304-75 F40M	16,0 *0.65*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*
M1	218.19-100T-M06 T350M	SPMX070304-75 F40M	19,0 *0.75*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
M2	218.19-100T-M06 T350M	SPMX070304-75 F40M	19,0 *0.75*	0,19 *0.0075*	0,19 *0.0075*	0,22 *0.0085*
M3	218.19-100T-M06 T350M	SPMX070304-75 F40M	16,0 *0.65*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
M4	218.19-100T-M06 T350M	SPMX070304-75 F40M	12,0 *0.48*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
M5	218.19-100T-M06 T350M	SPMX070304-75 F40M	12,0 *0.48*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
K1	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*
K2	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
K3	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
K4	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
K5	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,24 *0.0095*	0,24 *0.0095*	0,25 *0.010*
K6	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
K7	218.19-100T-MD08 F15M	SPMX070304-75 F40M	19,0 *0.75*	0,24 *0.0095*	0,24 *0.0095*	0,25 *0.010*
S1	218.19-100T-M06 MS2500	SPMX070304-75 F40M	12,0 *0.48*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
S2	218.19-100T-M06 MS2500	SPMX070304-75 F40M	12,0 *0.48*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
S3	218.19-100T-M06 MS2500	SPMX070304-75 F40M	12,0 *0.48*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*
S11	218.19-100T-M06 MS2050	SPMX070304-75 F40M	14,0 *0.55*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
S12	218.19-100T-M06 MS2050	SPMX070304-75 F40M	14,0 *0.55*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
S13	218.19-100T-M06 MS2050	SPMX070304-75 F40M	12,0 *0.48*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
H5	218.19-100T-MD08 F15M	SPMX070304-75 F40M	12,0 *0.48*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
H8	218.19-100T-MD08 F15M	SPMX070304-75 F40M	11,0 *0.44*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*
H11	218.19-100T-MD08 F15M	SPMX070304-75 F40M	12,0 *0.48*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
H12	218.19-100T-M06 MP3000	SPMX070304-75 F40M	11,0 *0.44*	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*
H21	218.19-100T-MD08 F15M	SPMX070304-75 F40M	11,0 *0.44*	0,12 *0.0048*	0,12 *0.0048*	0,13 *0.0050*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-100 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
P2	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
P3	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,34 *0.013*	0,48 *0.019*
P4	218.19-100T-M06 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,34 *0.013*	0,48 *0.019*
P5	218.19-100T-M06 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,32 *0.013*	0,46 *0.018*
P6	218.19-100T-M06 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,32 *0.013*	0,46 *0.018*
P7	218.19-100T-M06 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,32 *0.013*	0,46 *0.018*
P8	218.19-100T-M06 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,34 *0.013*	0,48 *0.019*
P11	218.19-100T-M06 MP2501	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,32 *0.013*	0,46 *0.018*
P12	218.19-100T-M06 MP2501	SPMX070304-75 F40M	16,0 *0.65*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
M1	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
M2	218.19-100T-M06 F40M	SPMX070304-75 F40M	19,0 *0.75*	0,28 *0.011*	0,32 *0.013*	0,46 *0.018*
M3	218.19-100T-M06 F40M	SPMX070304-75 F40M	16,0 *0.65*	0,22 *0.0085*	0,26 *0.010*	0,38 *0.015*
M4	218.19-100T-M06 F40M	SPMX070304-75 F40M	12,0 *0.48*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
M5	218.19-100T-M06 F40M	SPMX070304-75 F40M	12,0 *0.48*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
K1	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,40 *0.016*	0,48 *0.019*	0,70 *0.028*
K2	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,36 *0.014*	0,44 *0.017*	0,65 *0.026*
K3	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,36 *0.014*	0,44 *0.017*	0,65 *0.026*
K4	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,36 *0.014*	0,44 *0.017*	0,65 *0.026*
K5	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,32 *0.013*	0,40 *0.016*	0,55 *0.022*
K6	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,36 *0.014*	0,44 *0.017*	0,65 *0.026*
K7	218.19-100T-MD08 F25M	SPMX070304-75 F40M	19,0 *0.75*	0,32 *0.013*	0,40 *0.016*	0,55 *0.022*
S1	218.19-100T-M06 F40M	SPMX070304-75 F40M	12,0 *0.48*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
S2	218.19-100T-M06 F40M	SPMX070304-75 F40M	12,0 *0.48*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
S3	218.19-100T-M06 F40M	SPMX070304-75 F40M	12,0 *0.48*	0,18 *0.0070*	0,22 *0.0085*	0,30 *0.012*
S11	218.19-100T-M06 MS2050	SPMX070304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,26 *0.010*	0,38 *0.015*
S12	218.19-100T-M06 MS2050	SPMX070304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,26 *0.010*	0,38 *0.015*
S13	218.19-100T-M06 MS2050	SPMX070304-75 F40M	12,0 *0.48*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
H5	218.19-100T-MD08 F15M	SPMX070304-75 F40M	12,0 *0.48*	0,22 *0.0085*	0,26 *0.010*	0,36 *0.014*
H8	218.19-100T-MD08 F15M	SPMX070304-75 F40M	11,0 *0.44*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*
H11	218.19-100T-MD08 F15M	SPMX070304-75 F40M	12,0 *0.48*	0,22 *0.0085*	0,26 *0.010*	0,36 *0.014*
H12	218.19-100T-M06 MP3000	SPMX070304-75 F40M	11,0 *0.44*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*
H21	218.19-100T-MD08 F15M	SPMX070304-75 F40M	11,0 *0.44*	0,17 *0.0065*	0,20 *0.0080*	0,28 *0.011*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-100 – Cutting data v_c = (m/min)/(*sf/min*)

SMG	MP2501					T350M					F15M					F40M					MS2050					MS2500					MP3000				
		70%	30%	10%	5%		70%	30%	10%	5%		70%	30%	10%	5%		70%	30%	10%	5%		70%	30%	10%	5%		70%	30%	10%	5%		70%	30%	10%	5%
P1	215	235	290	340	360	215	230	285	340	365	—	—	—	—	—	185	200	245	295	320	205	220	270	325	350	265	290	355	425	460	230	250	310	370	400
	710	*770*	*950*	*1125*	*1175*	*710*	*750*	*940*	*1125*	*1200*	—	—	—	—	—	*610*	*660*	*800*	*970*	*1050*	*670*	*720*	*890*	*1075*	*1150*	*870*	*950*	*1175*	*1400*	*1500*	*750*	*820*	*1025*	*1225*	*1300*
P2	210	225	275	325	350	210	225	275	330	355	—	—	—	—	—	180	195	240	285	310	200	215	265	315	340	260	280	345	415	450	225	245	300	360	390
	690	*740*	*900*	*1075*	*1150*	*690*	*740*	*900*	*1075*	*1175*	—	—	—	—	—	*590*	*640*	*790*	*940*	*1025*	*660*	*710*	*870*	*1025*	*1125*	*850*	*920*	*1125*	*1350*	*1475*	*740*	*800*	*980*	*1175*	*1275*
P3	180	195	240	285	310	185	200	245	290	310	—	—	—	—	—	160	175	210	250	265	175	190	235	275	295	230	250	305	360	385	200	215	265	315	335
	590	*640*	*790*	*940*	*1025*	*610*	*660*	*800*	*950*	*1025*	—	—	—	—	—	*520*	*570*	*690*	*820*	*870*	*570*	*620*	*770*	*900*	*970*	*750*	*820*	*1000*	*1175*	*1275*	*660*	*710*	*870*	*1025*	*1100*
P4	165	175	215	255	275	160	175	215	255	275	—	—	—	—	—	140	155	185	220	240	155	170	205	245	260	205	220	270	320	345	175	190	235	275	300
	540	*570*	*710*	*840*	*900*	*520*	*570*	*710*	*840*	*900*	—	—	—	—	—	*460*	*510*	*610*	*720*	*790*	*510*	*560*	*670*	*800*	*850*	*670*	*720*	*890*	*1050*	*1125*	*570*	*620*	*770*	*900*	*980*
P5	155	170	210	245	260	155	170	205	240	260	—	—	—	—	—	135	145	180	210	225	150	160	195	230	250	195	210	255	305	330	170	185	225	265	285
	510	*560*	*690*	*800*	*850*	*510*	*560*	*670*	*790*	*850*	—	—	—	—	—	*445*	*475*	*590*	*690*	*740*	*490*	*520*	*640*	*750*	*820*	*640*	*690*	*840*	*1000*	*1075*	*560*	*610*	*740*	*870*	*940*
P6	175	190	235	275	290	175	190	230	275	295	—	—	—	—	—	155	165	200	240	260	170	185	220	265	285	220	240	290	345	370	190	210	250	300	325
	570	*620*	*770*	*900*	*950*	*570*	*620*	*750*	*900*	*970*	—	—	—	—	—	*510*	*540*	*660*	*790*	*850*	*560*	*610*	*720*	*870*	*940*	*720*	*790*	*950*	*1125*	*1225*	*620*	*690*	*820*	*980*	*1075*
P7	165	180	220	260	275	165	180	215	260	280	—	—	—	—	—	145	155	190	225	245	160	175	210	250	270	210	225	270	325	350	180	195	235	285	305
	540	*590*	*720*	*850*	*900*	*540*	*590*	*710*	*850*	*920*	—	—	—	—	—	*475*	*510*	*620*	*740*	*800*	*520*	*570*	*690*	*820*	*890*	*690*	*740*	*890*	*1075*	*1150*	*590*	*640*	*770*	*940*	*1000*
P8	150	165	205	240	260	155	170	205	240	260	—	—	—	—	—	135	145	180	210	225	150	160	195	230	245	195	210	255	305	325	170	185	225	265	280
	490	*540*	*670*	*790*	*850*	*510*	*560*	*670*	*790*	*850*	—	—	—	—	—	*445*	*475*	*590*	*690*	*740*	*490*	*520*	*640*	*750*	*800*	*640*	*690*	*840*	*1000*	*1075*	*560*	*610*	*740*	*870*	*920*
P11	160	175	215	250	270	160	175	210	255	275	—	—	—	—	—	140	155	185	220	235	155	170	200	245	260	200	220	265	320	340	175	190	230	275	295
	520	*570*	*710*	*820*	*890*	*520*	*570*	*690*	*840*	*900*	—	—	—	—	—	*460*	*510*	*610*	*720*	*770*	*510*	*560*	*660*	*800*	*850*	*660*	*720*	*870*	*1050*	*1125*	*570*	*620*	*750*	*900*	*970*
P12	110	120	145	170	185	105	115	140	170	180	—	—	—	—	—	95	100	125	145	160	100	110	135	160	175	135	145	175	210	230	115	125	155	185	200
	360	*395*	*475*	*560*	*610*	*345*	*375*	*460*	*560*	*590*	—	—	—	—	—	*310*	*330*	*410*	*475*	*520*	*330*	*360*	*445*	*520*	*570*	*445*	*475*	*570*	*690*	*750*	*375*	*410*	*510*	*610*	*660*
M1	150	165	200	235	255	160	175	215	255	275	—	—	—	—	—	145	160	195	230	250	160	175	215	255	275	185	200	250	295	320	170	185	225	270	290
	490	*540*	*660*	*770*	*840*	*520*	*570*	*710*	*840*	*900*	—	—	—	—	—	*475*	*520*	*640*	*750*	*820*	*520*	*570*	*710*	*840*	*900*	*610*	*660*	*820*	*970*	*1050*	*560*	*610*	*740*	*890*	*950*
M2	125	135	165	195	210	135	145	175	210	225	—	—	—	—	—	120	130	160	190	205	135	145	175	210	225	155	170	205	245	260	140	150	185	220	235
	410	*445*	*540*	*640*	*690*	*445*	*475*	*570*	*690*	*740*	—	—	—	—	—	*395*	*425*	*520*	*620*	*670*	*445*	*475*	*570*	*690*	*740*	*510*	*560*	*670*	*800*	*850*	*460*	*490*	*610*	*720*	*770*
M3	105	110	135	165	180	110	120	150	175	190	—	—	—	—	—	100	110	135	160	170	110	120	150	175	190	130	140	170	205	220	120	130	155	185	200
	345	*360*	*445*	*540*	*590*	*360*	*395*	*490*	*570*	*620*	—	—	—	—	—	*330*	*360*	*445*	*520*	*560*	*360*	*395*	*490*	*570*	*620*	*425*	*460*	*560*	*670*	*720*	*395*	*425*	*510*	*610*	*660*
M4	90	95	115	135	150	95	100	120	145	155	—	—	—	—	—	85	90	110	130	145	95	100	120	145	155	110	115	140	170	185	100	105	130	150	165
	295	*310*	*375*	*445*	*490*	*310*	*330*	*395*	*475*	*510*	—	—	—	—	—	*280*	*295*	*360*	*425*	*475*	*310*	*330*	*395*	*475*	*510*	*360*	*375*	*460*	*560*	*610*	*330*	*345*	*425*	*490*	*540*
M5	75	80	95	115	125	80	85	100	120	130	—	—	—	—	—	70	75	90	110	120	75	85	100	120	130	90	95	115	140	150	80	85	105	125	140
	245	*260*	*310*	*375*	*410*	*260*	*280*	*330*	*395*	*425*	—	—	—	—	—	*230*	*245*	*295*	*360*	*395*	*245*	*280*	*330*	*395*	*425*	*295*	*310*	*375*	*460*	*490*	*260*	*280*	*345*	*410*	*460*
K1	165	180	220	260	280	165	180	220	260	285	150	165	200	235	255	145	155	190	225	245	—	—	—	—	—	—	—	—	—	—	180	195	240	285	310
	540	*590*	*720*	*850*	*920*	*540*	*590*	*720*	*850*	*940*	*490*	*540*	*660*	*770*	*840*	*475*	*510*	*620*	*740*	*800*	—	—	—	—	—	—	—	—	—	—	*590*	*640*	*790*	*940*	*1025*
K2	145	160	195	230	245	145	160	195	230	250	135	145	180	210	225	130	140	170	200	215	—	—	—	—	—	—	—	—	—	—	160	175	210	250	270
	475	*520*	*640*	*750*	*800*	*475*	*520*	*640*	*750*	*820*	*445*	*475*	*590*	*690*	*740*	*425*	*460*	*560*	*660*	*710*	—	—	—	—	—	—	—	—	—	—	*520*	*570*	*690*	*820*	*890*
K3	125	135	165	195	210	125	135	165	195	210	115	125	150	180	190	110	115	145	170	185	—	—	—	—	—	—	—	—	—	—	135	145	180	210	230
	410	*445*	*540*	*640*	*690*	*410*	*445*	*540*	*640*	*690*	*375*	*410*	*490*	*590*	*620*	*360*	*375*	*475*	*560*	*610*	—	—	—	—	—	—	—	—	—	—	*445*	*475*	*590*	*690*	*750*
K4	120	130	160	190	200	120	130	155	185	200	110	115	145	170	180	105	110	135	160	175	—	—	—	—	—	—	—	—	—	—	130	140	170	200	220
	395	*425*	*520*	*620*	*660*	*395*	*425*	*510*	*610*	*660*	*360*	*375*	*475*	*560*	*590*	*345*	*360*	*445*	*520*	*570*	—	—	—	—	—	—	—	—	—	—	*425*	*460*	*560*	*660*	*720*
K5	75	80	95	115	125	75	80	95	115	125	65	70	90	105	115	65	70	85	100	110	—	—	—	—	—	—	—	—	—	—	80	85	105	125	135
	245	*260*	*310*	*375*	*410*	*245*	*260*	*310*	*375*	*410*	*215*	*230*	*295*	*345*	*375*	*215*	*230*	*280*	*330*	*360*	—	—	—	—	—	—	—	—	—	—	*260*	*280*	*345*	*410*	*445*
K6	105	115	140	165	175	105	115	140	165	175	95	105	125	150	160	90	100	120	140	155	—	—	—	—	—	—	—	—	—	—	115	125	150	180	190
	345	*375*	*460*	*540*	*570*	*345*	*375*	*460*	*540*	*570*	*310*	*345*	*410*	*490*	*520*	*295*	*330*	*395*	*460*	*510*	—	—	—	—	—	—	—	—	—	—	*375*	*410*	*490*	*590*	*620*
K7	95	100	125	145	160	95	100	125	145	160	85	90	115	135	145	80	90	110	125	140	—	—	—	—	—	—	—	—	—	—	100	110	135	160	170
	310	*330*	*410*	*475*	*520*	*310*	*330*	*410*	*475*	*520*	*280*	*295*	*375*	*445*	*475*	*260*	*295*	*360*	*410*	*460*	—	—	—	—	—	—	—	—	—	—	*330*	*360*	*445*	*520*	*560*
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1050	1125	1400	1650	1800	—	—	—	—	—	—	—	—	—	—	1300	1425	1750	2050	2250
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*3450*	*3700*	*4600*	*5425*	*5900*	—	—	—	—	—	—	—	—	—	—	*4275*	*4675*	*5750*	*6725*	*7375*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	425	460	570	670	730	—	—	—	—	—	—	—	—	—	—	530	570	710	830	910
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1400*	*1500*	*1875*	*2200*	*2400*	—	—	—	—	—	—	—	—	—	—	*1750*	*1875*	*2325*	*2725*	*2975*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	280	305	380	445	485	—	—	—	—	—	—	—	—	—	—	355	380	475	550	610
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*920*	*1000*	*1250*	*1450*	*1600*	—	—	—	—	—	—	—	—	—	—	*1175*	*1250*	*1550*	*1800*	*2000*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	320	350	430	510	550	—	—	—	—	—	—	—	—	—	—	405	435	540	630	690
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1050*	*1150*	*1400*	*1675*	*1800*	—	—	—	—	—	—	—	—	—	—	*1325*	*1425*	*1775*	*2075*	*2275*
S1	—	—	—	—	—	43	46	55	65	75	—	—	—	—	—	39	42	50	60	65	43	46	55	65	75	55	55	70	80	90	46	49	60	70	75
	—	—	—	—	—	*140*	*150*	*180*	*215*	*245*	—	—	—	—	—	*130*	*140*	*165*	*195*	*215*	*140*	*150*	*180*	*215*	*245*	*180*	*180*	*230*	*260*	*295*	*150*	*160*	*195*	*230*	*245*
S2	—	—	—	—	—	35	37	46	55	60	—	—	—	—	—	32	34	41	49	55	35	37	46	55	60	43	45	55	65	70	37	39	48	55	60
	—	—	—	—	—	*115*	*120*	*150*	*180*	*195*	—	—	—	—	—	*105*	*110*	*135*	*160*	*180*	*115*	*120*	*150*	*180*	*195*	*140*	*150*	*180*	*215*	*230*	*120*	*130*	*155*	*180*	*195*
S3	—	—	—	—	—	31	33	40	48	50	—	—	—	—	—	28	30	36	43	48	31	33	40	48	50	37	40	49	60	65	32	35	42	50	55
	—	—	—	—	—	*100*	*110*	*130*	*155*	*165*	—	—	—	—	—	*90*	*100*	*120*	*140*	*155*	*100*	*110*	*130*	*155*	*165*	*120*	*130*	*160*	*195*	*215*	*105*	*115*	*140*	*165*	*180*
S11	—	—	—	—	—	60	65	75	90	100	—	—	—	—	—	55	60	70	85	90	60	65	75	90	100	75	80	95	110	120	65	70	80	95	105
	—	—	—	—	—	*195*	*215*	*245*	*295*	*330*	—	—	—	—	—	*180*	*195*	*230*	*280*	*295*	*195*	*215*	*245*	*295*	*330*	*245*	*260*	*310*	*360*	*395*	*215*	*230*	*260*	*310*	*345*
S12	—	—	—	—	—	41	44	55	65	70	—	—	—	—	—	38	40	49	55	65	41	44	55	65	70	50	55	65	75	85	44	47	55	65	75
	—	—	—	—	—	*135*	*145*	*180*	*215*	*230*	—	—	—	—	—	*125*	*130*	*160*	*180*	*215*	*135*	*145*	*180*	*215*	*230*	*165*	*180*	*215*	*245*	*280*	*145*	*155*	*180*	*215*	*245*
S13	—	—	—	—	—	24	26	32	38	41	—	—	—	—	—	22	24	29	34	37	24	26	32	38	41	30	32	39	46	50	26	27	34	40	43
	—	—	—	—	—	*80*	*85*	*105*	*125*	*135*	—	—	—	—	—	*70*	*80*	*95*	*110*	*120*	*80*	*85*	*105*	*125*	*135*	*100*	*105*	*130*	*150*	*165*	*85*	*90*	*110*	*130*	*140*
H5	—	—	—	—	—	40	43	50	60	65	37	40	48	55	60	35	38	45	55	60	—	—	—	—	—	—	—	—	—	—	41	44	55	65	70
	—	—	—	—	—	*130*	*140*	*165*	*195*	*215*	*120*	*130*	*155*	*180*	*195*	*115*	*125*	*150*	*180*	*195*	—	—	—	—	—	—	—	—	—	—	*135*	*145*	*180*	*215*	*230*
H8	—	—	—	—	—	44	47	55	65	75	40	43	50	60	70	38	41	49	60	65	—	—	—	—	—	—	—	—	—	—	45	48	60	70	75
	—	—	—	—	—	*145*	*155*	*180*	*215*	*245*	*130*	*140*	*165*	*195*	*230*	*125*	*135*	*160*	*195*	*215*	—	—	—	—	—	—	—	—	—	—	*150*	*155*	*195*	*230*	*245*
H11	—	—	—	—	—	50	55	65	80	85	47	50	60	75	80	45	48	60	70	75	—	—	—	—	—	—	—	—	—	—	50	55	70	80	85
	—	—	—	—	—	*165*	*180*	*215*	*260*	*280*	*155*	*165*	*195*	*245*	*260*	*150*	*155*	*195*	*230*	*245*	—	—	—	—	—	—	—	—	—	—	*165*	*180*	*230*	*260*	*280*
H12	—	—	—	—	—	80	85	100	120	130	75	75	95	110	120	70	75	90	105	115	—	—	—	—	—	—	—	—	—	—	85	90	110	130	140
	—	—	—	—	—	*260*	*280*	*330*	*395*	*425*	*245*	*245*	*310*	*360*	*395*	*230*	*245*	*295*	*345*	*375*	—	—	—	—	—	—	—	—	—	—	*280*	*295*	*360*	*425*	*460*
H21	—	—	—	—	—	44	47	55	65	75	40	43	50	60	70	38	41	49	60	65	—	—	—	—	—	—	—	—	—	—	45	48	60	70	75
	—	—	—	—	—	*145*	*155*	*180*	*215*	*245*	*130*	*140*	*165*	*195*	*230*	*125*	*135*	*160*	*195*	*215*	—	—	—	—	—	—	—	—	—	—	*150*	*155*	*195*	*230*	*245*

R218.19-125 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	24,0 *0.95*	0,22 *0.0085*	0,22 *0.0085*	0,25 *0.010*
P2	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	24,0 *0.95*	0,22 *0.0085*	0,22 *0.0085*	0,25 *0.010*
P3	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	24,0 *0.95*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
P4	218.19-125T-T3-MD10 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,34 *0.013*
P5	218.19-125T-T3-MD10 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
P6	218.19-125T-T3-MD10 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
P7	218.19-125T-T3-MD10 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
P8	218.19-125T-T3-MD10 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,34 *0.013*
P11	218.19-125T-T3-MD10 MS2500	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
P12	218.19-125T-T3-MD10 MS2500	SPMX090304-75 F40M	19,0 *0.75*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
M1	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	24,0 *0.95*	0,22 *0.0085*	0,22 *0.0085*	0,25 *0.010*
M2	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	24,0 *0.95*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
M3	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	19,0 *0.75*	0,17 *0.0065*	0,17 *0.0065*	0,18 *0.0070*
M4	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	14,0 *0.55*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
M5	218.19-125T-T3-M07 T350M	SPMX090304-75 F40M	14,0 *0.55*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
K1	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,32 *0.013*	0,32 *0.013*	0,36 *0.014*
K2	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K3	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K4	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K5	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,26 *0.010*	0,26 *0.010*	0,30 *0.012*
K6	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K7	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	24,0 *0.95*	0,26 *0.010*	0,26 *0.010*	0,30 *0.012*
S1	218.19-125T-T3-M07 MS2500	SPMX090304-75 F40M	14,0 *0.55*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
S2	218.19-125T-T3-M07 MS2500	SPMX090304-75 F40M	14,0 *0.55*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
S3	218.19-125T-T3-M07 MS2500	SPMX090304-75 F40M	14,0 *0.55*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
S11	218.19-125T-T3-M07 MS2050	SPMX090304-75 F40M	17,0 *0.65*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
S12	218.19-125T-T3-M07 MS2050	SPMX090304-75 F40M	17,0 *0.65*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
S13	218.19-125T-T3-M07 MS2050	SPMX090304-75 F40M	14,0 *0.55*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
H5	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	15,0 *0.60*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
H8	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	13,0 *0.50*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
H11	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	15,0 *0.60*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*
H12	218.19-125T-T3-MD08 MP3000	SPMX090304-75 F40M	13,0 *0.50*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*
H21	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	13,0 *0.50*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-125 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.19-125T-T3-M07 F40M	SPMX090304-75 F40M	24,0 *0.95*	0,32 *0.013*	0,38 *0.015*	0,55 *0.022*
P2	218.19-125T-T3-M07 F40M	SPMX090304-75 F40M	24,0 *0.95*	0,32 *0.013*	0,38 *0.015*	0,55 *0.022*
P3	218.19-125T-T3-M07 F40M	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
P4	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
P5	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
P6	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,34 *0.013*	0,50 *0.020*
P7	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,34 *0.013*	0,50 *0.020*
P8	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
P11	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,34 *0.013*	0,50 *0.020*
P12	218.19-125T-T3-M07 MP2501	SPMX090304-75 F40M	19,0 *0.75*	0,20 *0.0080*	0,24 *0.0095*	0,34 *0.013*
M1	218.19-125T-T3-M07 MP3000	SPMX090304-75 F40M	24,0 *0.95*	0,32 *0.013*	0,38 *0.015*	0,55 *0.022*
M2	218.19-125T-T3-M07 MP3000	SPMX090304-75 F40M	24,0 *0.95*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
M3	218.19-125T-T3-M07 MP3000	SPMX090304-75 F40M	19,0 *0.75*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
M4	218.19-125T-T3-M07 MP3000	SPMX090304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
M5	218.19-125T-T3-M07 MP3000	SPMX090304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
K1	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,46 *0.018*	0,55 *0.022*	0,80 *0.032*
K2	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K3	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K4	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K5	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,38 *0.015*	0,46 *0.018*	0,65 *0.026*
K6	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K7	218.19-125T-T3-MD10 F25M	SPMX090304-75 F40M	24,0 *0.95*	0,38 *0.015*	0,46 *0.018*	0,65 *0.026*
S1	218.19-125T-T3-M07 F40M	SPMX090304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
S2	218.19-125T-T3-M07 F40M	SPMX090304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
S3	218.19-125T-T3-M07 F40M	SPMX090304-75 F40M	14,0 *0.55*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
S11	218.19-125T-T3-M07 MS2050	SPMX090304-75 F40M	17,0 *0.65*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
S12	218.19-125T-T3-M07 MS2050	SPMX090304-75 F40M	17,0 *0.65*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
S13	218.19-125T-T3-M07 MS2050	SPMX090304-75 F40M	14,0 *0.55*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
H5	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	15,0 *0.60*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
H8	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	13,0 *0.50*	0,19 *0.0075*	0,24 *0.0095*	0,32 *0.013*
H11	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	15,0 *0.60*	0,25 *0.010*	0,30 *0.012*	0,42 *0.017*
H12	218.19-125T-T3-M07 MP3000	SPMX090304-75 F40M	13,0 *0.50*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
H21	218.19-125T-T3-MD10 F15M	SPMX090304-75 F40M	13,0 *0.50*	0,19 *0.0075*	0,24 *0.0095*	0,32 *0.013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-125 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501					T350M					F15M					F40M				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	200	215	260	310	335	210	230	275	330	350	—	—	—	—	—	180	200	240	285	305
	660	*710*	*850*	*1025*	*1100*	*690*	*750*	*900*	*1075*	*1150*	—	—	—	—	—	*590*	*660*	*790*	*940*	*1000*
P2	190	210	255	305	325	205	220	270	320	345	—	—	—	—	—	180	195	235	280	300
	620	*690*	*840*	*1000*	*1075*	*670*	*720*	*890*	*1050*	*1125*	—	—	—	—	—	*590*	*640*	*770*	*920*	*980*
P3	170	185	225	260	285	175	190	235	280	305	—	—	—	—	—	155	165	205	245	265
	560	*610*	*740*	*850*	*940*	*570*	*620*	*770*	*920*	*1000*	—	—	—	—	—	*510*	*540*	*670*	*800*	*870*
P4	150	160	195	235	250	155	170	205	245	265	—	—	—	—	—	135	145	180	215	230
	490	*520*	*640*	*770*	*820*	*510*	*560*	*670*	*800*	*870*	—	—	—	—	—	*445*	*475*	*590*	*710*	*750*
P5	140	155	190	225	245	150	165	200	235	255	—	—	—	—	—	130	145	175	205	220
	460	*510*	*620*	*740*	*800*	*490*	*540*	*660*	*770*	*840*	—	—	—	—	—	*425*	*475*	*570*	*670*	*720*
P6	160	175	215	255	275	170	185	225	270	285	—	—	—	—	—	150	160	195	235	250
	520	*570*	*710*	*840*	*900*	*560*	*610*	*740*	*890*	*940*	—	—	—	—	—	*490*	*520*	*640*	*770*	*820*
P7	150	165	205	240	260	160	175	215	255	270	—	—	—	—	—	140	150	185	220	235
	490	*540*	*670*	*790*	*850*	*520*	*570*	*710*	*840*	*890*	—	—	—	—	—	*460*	*490*	*610*	*720*	*770*
P8	140	155	190	220	240	150	160	195	235	255	—	—	—	—	—	130	140	170	205	220
	460	*510*	*620*	*720*	*790*	*490*	*520*	*640*	*770*	*840*	—	—	—	—	—	*425*	*460*	*560*	*670*	*720*
P11	145	160	195	235	250	155	170	210	245	260	—	—	—	—	—	135	150	180	215	230
	475	*520*	*640*	*770*	*820*	*510*	*560*	*690*	*800*	*850*	—	—	—	—	—	*445*	*490*	*590*	*710*	*750*
P12	100	110	135	160	170	105	115	135	160	175	—	—	—	—	—	90	100	120	140	150
	330	*360*	*445*	*520*	*560*	*345*	*375*	*445*	*520*	*570*	—	—	—	—	—	*295*	*330*	*395*	*460*	*490*
M1	140	150	185	220	235	155	170	205	245	265	—	—	—	—	—	145	155	190	225	240
	460	*490*	*610*	*720*	*770*	*510*	*560*	*670*	*800*	*870*	—	—	—	—	—	*475*	*510*	*620*	*740*	*790*
M2	115	125	155	180	195	130	140	175	200	220	—	—	—	—	—	120	130	160	185	200
	375	*410*	*510*	*590*	*640*	*425*	*460*	*570*	*660*	*720*	—	—	—	—	—	*395*	*425*	*520*	*610*	*660*
M3	95	105	130	150	165	105	115	145	170	180	—	—	—	—	—	95	105	130	155	165
	310	*345*	*425*	*490*	*540*	*345*	*375*	*475*	*560*	*590*	—	—	—	—	—	*310*	*345*	*425*	*510*	*540*
M4	80	85	105	125	135	90	95	115	135	145	—	—	—	—	—	80	85	105	125	135
	260	*280*	*345*	*410*	*445*	*295*	*310*	*375*	*445*	*475*	—	—	—	—	—	*260*	*280*	*345*	*410*	*445*
M5	65	70	85	105	110	75	80	95	115	125	—	—	—	—	—	65	70	90	105	110
	215	*230*	*280*	*345*	*360*	*245*	*260*	*310*	*375*	*410*	—	—	—	—	—	*215*	*230*	*295*	*345*	*360*
K1	150	165	200	240	255	160	175	215	255	270	140	150	185	220	235	140	155	185	220	235
	490	*540*	*660*	*790*	*840*	*520*	*570*	*710*	*840*	*890*	*460*	*490*	*610*	*720*	*770*	*460*	*510*	*610*	*720*	*770*
K2	135	145	180	215	235	145	155	190	225	240	125	135	165	195	210	125	135	165	195	210
	445	*475*	*590*	*710*	*770*	*475*	*510*	*620*	*740*	*790*	*410*	*445*	*540*	*640*	*690*	*410*	*445*	*540*	*640*	*690*
K3	115	125	155	180	195	120	135	160	190	205	105	110	140	165	180	105	115	140	165	180
	375	*410*	*510*	*590*	*640*	*395*	*445*	*520*	*620*	*670*	*345*	*360*	*460*	*540*	*590*	*345*	*375*	*460*	*540*	*590*
K4	110	120	145	175	190	115	125	155	180	195	100	105	135	160	170	100	110	135	155	170
	360	*395*	*475*	*570*	*620*	*375*	*410*	*510*	*590*	*640*	*330*	*345*	*445*	*520*	*560*	*330*	*360*	*445*	*510*	*560*
K5	70	75	90	105	115	70	75	95	110	120	60	65	80	95	105	60	65	80	95	105
	230	*245*	*295*	*345*	*375*	*230*	*245*	*310*	*360*	*395*	*195*	*215*	*260*	*310*	*345*	*195*	*215*	*260*	*310*	*345*
K6	95	105	130	155	165	105	110	135	160	170	85	95	120	140	150	90	95	120	140	150
	310	*345*	*425*	*510*	*540*	*345*	*360*	*445*	*520*	*560*	*280*	*310*	*395*	*460*	*490*	*295*	*310*	*395*	*460*	*490*
K7	85	95	115	135	145	90	100	120	140	155	80	85	105	125	135	80	85	105	125	135
	280	*310*	*375*	*445*	*475*	*295*	*330*	*395*	*460*	*510*	*260*	*280*	*345*	*410*	*445*	*260*	*280*	*345*	*410*	*445*
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1000	1100	1350	1600	1725
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*3275*	*3600*	*4425*	*5250*	*5650*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	405	440	550	650	700
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1325*	*1450*	*1800*	*2125*	*2300*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	270	295	365	430	465
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*890*	*970*	*1200*	*1400*	*1525*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	310	335	415	495	530
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1025*	*1100*	*1350*	*1625*	*1750*
S1	—	—	—	—	—	41	44	55	65	70	—	—	—	—	—	37	40	49	60	60
	—	—	—	—	—	*135*	*145*	*180*	*215*	*230*	—	—	—	—	—	*120*	*130*	*160*	*195*	*195*
S2	—	—	—	—	—	33	36	44	50	55	—	—	—	—	—	30	32	40	47	50
	—	—	—	—	—	*110*	*120*	*145*	*165*	*180*	—	—	—	—	—	*100*	*105*	*130*	*155*	*165*
S3	—	—	—	—	—	29	31	38	45	49	—	—	—	—	—	26	28	35	41	45
	—	—	—	—	—	*95*	*100*	*125*	*150*	*160*	—	—	—	—	—	*85*	*90*	*115*	*135*	*150*
S11	—	—	—	—	—	55	60	70	85	95	—	—	—	—	—	50	55	65	80	85
	—	—	—	—	—	*180*	*195*	*230*	*280*	*310*	—	—	—	—	—	*165*	*180*	*215*	*260*	*280*
S12	—	—	—	—	—	38	41	50	60	65	—	—	—	—	—	34	37	45	55	60
	—	—	—	—	—	*125*	*135*	*165*	*195*	*215*	—	—	—	—	—	*110*	*120*	*150*	*180*	*195*
S13	—	—	—	—	—	23	25	30	36	39	—	—	—	—	—	21	23	28	33	35
	—	—	—	—	—	*75*	*80*	*100*	*120*	*130*	—	—	—	—	—	*70*	*75*	*90*	*110*	*115*
H5	—	—	—	—	—	37	40	48	55	60	33	35	43	50	55	32	35	42	49	55
	—	—	—	—	—	*120*	*130*	*155*	*180*	*195*	*110*	*115*	*140*	*165*	*180*	*105*	*115*	*140*	*160*	*180*
H8	—	—	—	—	—	41	44	55	65	70	36	39	48	55	60	35	38	46	55	60
	—	—	—	—	—	*135*	*145*	*180*	*215*	*230*	*120*	*130*	*155*	*180*	*195*	*115*	*125*	*150*	*180*	*195*
H11	—	—	—	—	—	47	50	60	70	80	41	45	55	65	70	41	44	55	65	70
	—	—	—	—	—	*155*	*165*	*195*	*230*	*260*	*135*	*150*	*180*	*215*	*230*	*135*	*145*	*180*	*215*	*230*
H12	—	—	—	—	—	75	80	95	115	125	65	70	85	100	110	65	70	85	100	110
	—	—	—	—	—	*245*	*260*	*310*	*375*	*410*	*215*	*230*	*280*	*330*	*360*	*215*	*230*	*280*	*330*	*360*
H21	—	—	—	—	—	41	44	55	65	70	36	39	48	55	60	35	38	46	55	60
	—	—	—	—	—	*135*	*145*	*180*	*215*	*230*	*120*	*130*	*155*	*180*	*195*	*115*	*125*	*150*	*180*	*195*

R218.19-125 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MS2050					MS2500					MP3000					F25M				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	200	220	265	315	335	265	285	345	410	440	230	250	300	355	380	165	180	220	260	275
	660	*720*	*870*	*1025*	*1100*	*870*	*940*	*1125*	*1350*	*1450*	*750*	*820*	*980*	*1175*	*1250*	*540*	*590*	*720*	*850*	*900*
P2	195	210	255	305	330	255	280	335	400	430	220	240	290	350	370	160	175	210	255	270
	640	*690*	*840*	*1000*	*1075*	*840*	*920*	*1100*	*1300*	*1400*	*720*	*790*	*950*	*1150*	*1225*	*520*	*570*	*690*	*840*	*890*
P3	170	180	225	270	290	220	240	295	350	380	190	205	255	305	330	140	155	185	220	235
	560	*590*	*740*	*890*	*950*	*720*	*790*	*970*	*1150*	*1250*	*620*	*670*	*840*	*1000*	*1075*	*460*	*510*	*610*	*720*	*770*
P4	150	160	195	235	255	195	210	260	310	335	170	185	225	270	290	125	135	165	200	210
	490	*520*	*640*	*770*	*840*	*640*	*690*	*850*	*1025*	*1100*	*560*	*610*	*740*	*890*	*950*	*410*	*445*	*540*	*660*	*690*
P5	145	160	195	225	245	190	205	255	295	320	165	180	220	255	275	120	130	160	190	205
	475	*520*	*640*	*740*	*800*	*620*	*670*	*840*	*970*	*1050*	*540*	*590*	*720*	*840*	*900*	*395*	*425*	*520*	*620*	*670*
P6	165	180	215	255	275	215	230	285	335	360	185	200	245	290	310	135	145	180	210	230
	540	*590*	*710*	*840*	*900*	*710*	*750*	*940*	*1100*	*1175*	*610*	*660*	*800*	*950*	*1025*	*445*	*475*	*590*	*690*	*750*
P7	155	170	205	240	260	200	220	270	315	340	175	190	235	275	295	125	135	170	200	215
	510	*560*	*670*	*790*	*850*	*660*	*720*	*890*	*1025*	*1125*	*570*	*620*	*770*	*900*	*970*	*410*	*445*	*560*	*660*	*710*
P8	140	155	190	225	245	185	200	245	295	320	160	175	215	255	275	120	130	155	185	200
	460	*510*	*620*	*740*	*800*	*610*	*660*	*800*	*970*	*1050*	*520*	*570*	*710*	*840*	*900*	*395*	*425*	*510*	*610*	*660*
P11	150	165	200	235	250	195	215	260	310	330	170	185	225	270	285	120	130	165	195	210
	490	*540*	*660*	*770*	*820*	*640*	*710*	*850*	*1025*	*1075*	*560*	*610*	*740*	*890*	*940*	*395*	*425*	*540*	*640*	*690*
P12	100	110	130	155	165	130	140	170	205	220	115	125	150	175	190	85	90	110	130	140
	330	*360*	*425*	*510*	*540*	*425*	*460*	*560*	*670*	*720*	*375*	*410*	*490*	*570*	*620*	*280*	*295*	*360*	*425*	*460*
M1	155	170	205	245	265	185	200	240	285	305	165	180	220	260	280	—	—	—	—	—
	510	*560*	*670*	*800*	*870*	*610*	*660*	*790*	*940*	*1000*	*540*	*590*	*720*	*850*	*920*	—	—	—	—	—
M2	130	140	175	200	220	150	165	200	235	255	140	150	185	215	230	—	—	—	—	—
	425	*460*	*570*	*660*	*720*	*490*	*540*	*660*	*770*	*840*	*460*	*490*	*610*	*710*	*750*	—	—	—	—	—
M3	105	115	145	170	180	125	135	165	195	210	110	120	150	180	190	—	—	—	—	—
	345	*375*	*475*	*560*	*590*	*410*	*445*	*540*	*640*	*690*	*360*	*395*	*490*	*590*	*620*	—	—	—	—	—
M4	90	95	115	135	145	100	110	135	160	170	95	100	120	145	155	—	—	—	—	—
	295	*310*	*375*	*445*	*475*	*330*	*360*	*445*	*520*	*560*	*310*	*330*	*395*	*475*	*510*	—	—	—	—	—
M5	75	80	95	115	125	85	90	110	130	145	75	85	100	120	130	—	—	—	—	—
	245	*260*	*310*	*375*	*410*	*280*	*295*	*360*	*425*	*475*	*245*	*280*	*330*	*395*	*425*	—	—	—	—	—
K1	—	—	—	—	—	—	—	—	—	—	175	190	230	275	295	125	135	170	200	215
	—	—	—	—	—	—	—	—	—	—	*570*	*620*	*750*	*900*	*970*	*410*	*445*	*560*	*660*	*710*
K2	—	—	—	—	—	—	—	—	—	—	155	170	210	245	265	115	120	150	180	195
	—	—	—	—	—	—	—	—	—	—	*510*	*560*	*690*	*800*	*870*	*375*	*395*	*490*	*590*	*640*
K3	—	—	—	—	—	—	—	—	—	—	135	145	175	205	225	95	105	130	150	165
	—	—	—	—	—	—	—	—	—	—	*445*	*475*	*570*	*670*	*740*	*310*	*345*	*425*	*490*	*540*
K4	—	—	—	—	—	—	—	—	—	—	125	140	170	195	210	90	100	120	145	155
	—	—	—	—	—	—	—	—	—	—	*410*	*460*	*560*	*640*	*690*	*295*	*330*	*395*	*475*	*510*
K5	—	—	—	—	—	—	—	—	—	—	75	85	105	120	130	55	60	75	90	95
	—	—	—	—	—	—	—	—	—	—	*245*	*280*	*345*	*395*	*425*	*180*	*195*	*245*	*295*	*310*
K6	—	—	—	—	—	—	—	—	—	—	110	120	150	175	185	80	85	110	125	140
	—	—	—	—	—	—	—	—	—	—	*360*	*395*	*490*	*570*	*610*	*260*	*280*	*360*	*410*	*460*
K7	—	—	—	—	—	—	—	—	—	—	100	105	130	155	170	75	80	95	115	120
	—	—	—	—	—	—	—	—	—	—	*330*	*345*	*425*	*510*	*560*	*245*	*260*	*310*	*375*	*395*
N1	—	—	—	—	—	—	—	—	—	—	1250	1350	1700	2000	2175	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*4100*	*4425*	*5575*	*6550*	*7125*	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	510	550	680	810	870	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1675*	*1800*	*2225*	*2650*	*2850*	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	340	365	455	540	580	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1125*	*1200*	*1500*	*1775*	*1900*	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	385	420	520	620	670	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1275*	*1375*	*1700*	*2025*	*2200*	—	—	—	—	—
S1	41	44	55	65	70	50	55	65	80	85	43	47	55	65	70	—	—	—	—	—
	135	*145*	*180*	*215*	*230*	*165*	*180*	*215*	*260*	*280*	*140*	*155*	*180*	*215*	*230*	—	—	—	—	—
S2	33	36	44	50	55	40	43	55	65	65	35	38	46	55	60	—	—	—	—	—
	110	*120*	*145*	*165*	*180*	*130*	*140*	*180*	*215*	*215*	*115*	*125*	*150*	*180*	*195*	—	—	—	—	—
S3	29	31	38	45	49	35	38	47	55	60	31	33	40	47	50	—	—	—	—	—
	95	*100*	*125*	*150*	*160*	*115*	*125*	*155*	*180*	*195*	*100*	*110*	*130*	*155*	*165*	—	—	—	—	—
S11	55	60	70	85	95	65	70	90	105	115	60	65	75	90	100	—	—	—	—	—
	180	*195*	*230*	*280*	*310*	*215*	*230*	*295*	*345*	*375*	*195*	*215*	*245*	*295*	*330*	—	—	—	—	—
S12	38	41	50	60	65	46	50	60	75	80	40	43	50	65	70	—	—	—	—	—
	125	*135*	*165*	*195*	*215*	*150*	*165*	*195*	*245*	*260*	*130*	*140*	*165*	*215*	*230*	—	—	—	—	—
S13	23	25	30	36	39	28	30	37	44	47	24	26	32	38	41	—	—	—	—	—
	75	*80*	*100*	*120*	*130*	*90*	*100*	*120*	*145*	*155*	*80*	*85*	*105*	*125*	*135*	—	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	37	41	49	60	65	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*120*	*135*	*160*	*195*	*215*	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	41	45	55	65	70	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*135*	*150*	*180*	*215*	*230*	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	47	50	65	75	80	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*155*	*165*	*215*	*245*	*260*	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	80	85	105	125	135	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*260*	*280*	*345*	*410*	*445*	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	41	45	55	65	70	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*135*	*150*	*180*	*215*	*230*	—	—	—	—	—

R218.19-160 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				100%	70%	30%
P1	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	28,0 *1.1*	0,22 *0.0085*	0,22 *0.0085*	0,25 *0.010*
P2	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	28,0 *1.1*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*
P3	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	28,0 *1.1*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
P4	218.19-160T-04-MD11 MP2501	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
P5	218.19-160T-04-MD11 MP2501	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
P6	218.19-160T-04-MD11 MP2501	SPMT100408T-M08 F40M	28,0 *1.1*	0,28 *0.011*	0,28 *0.011*	0,32 *0.013*
P7	218.19-160T-04-MD11 MP2501	SPMT100408T-M08 F40M	28,0 *1.1*	0,28 *0.011*	0,28 *0.011*	0,32 *0.013*
P8	218.19-160T-04-MD11 MP2501	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,34 *0.013*
P11	218.19-160T-04-MD11 MS2500	SPMT100408T-M08 F40M	28,0 *1.1*	0,28 *0.011*	0,28 *0.011*	0,32 *0.013*
P12	218.19-160T-04-MD11 MS2500	SPMT100408T-M08 F40M	22,0 *0.85*	0,20 *0.0080*	0,20 *0.0080*	0,22 *0.0085*
M1	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	28,0 *1.1*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*
M2	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	28,0 *1.1*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
M3	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	22,0 *0.85*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
M4	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	17,0 *0.65*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
M5	218.19-160T-04-M08 T350M	SPMT100408T-M08 F40M	17,0 *0.65*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
K1	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,32 *0.013*	0,32 *0.013*	0,36 *0.014*
K2	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K3	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K4	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K5	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
K6	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,30 *0.012*	0,30 *0.012*	0,32 *0.013*
K7	218.19-160T-04-MD11 MK2050	SPMT100408T-M08 F40M	28,0 *1.1*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N1	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	28,0 *1.1*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N2	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	28,0 *1.1*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N3	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	28,0 *1.1*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
N11	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	28,0 *1.1*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
S1	218.19-160T-04-M08 MS2500	SPMT100408T-M08 F40M	17,0 *0.65*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
S2	218.19-160T-04-M08 MS2500	SPMT100408T-M08 F40M	17,0 *0.65*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
S3	218.19-160T-04-M08 MS2500	SPMT100408T-M08 F40M	17,0 *0.65*	0,15 *0.0060*	0,15 *0.0060*	0,16 *0.0065*
S11	218.19-160T-04-M08 MS2050	SPMT100408T-M08 F40M	20,0 *0.80*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
S12	218.19-160T-04-M08 MS2050	SPMT100408T-M08 F40M	20,0 *0.80*	0,17 *0.0065*	0,17 *0.0065*	0,19 *0.0075*
S13	218.19-160T-04-M08 MS2050	SPMT100408T-M08 F40M	17,0 *0.65*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
H5	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	18,0 *0.70*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*
H8	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	15,0 *0.60*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*
H11	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	18,0 *0.70*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*
H12	218.19-160T-04-MD09 MP3000	SPMT100408T-M08 F40M	15,0 *0.60*	0,12 *0.0048*	0,12 *0.0048*	0,12 *0.0048*
H21	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	15,0 *0.60*	0,14 *0.0055*	0,14 *0.0055*	0,15 *0.0060*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-160 – Insert selection – mm/*Inch*

SMG			a_p	f_z		
				15%	10%	5%
P1	218.19-160T-04-M08 F40M	SPMT100408T-M08 F40M	35,0 *1.4*	0,32 *0.013*	0,38 *0.015*	0,55 *0.022*
P2	218.19-160T-04-M08 F40M	SPMT100408T-M08 F40M	35,0 *1.4*	0,32 *0.013*	0,40 *0.016*	0,55 *0.022*
P3	218.19-160T-04-M08 F40M	SPMT100408T-M08 F40M	35,0 *1.4*	0,32 *0.013*	0,38 *0.015*	0,50 *0.020*
P4	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
P5	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
P6	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	35,0 *1.4*	0,40 *0.016*	0,48 *0.019*	0,70 *0.028*
P7	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	35,0 *1.4*	0,40 *0.016*	0,48 *0.019*	0,70 *0.028*
P8	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,75 *0.030*
P11	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	35,0 *1.4*	0,40 *0.016*	0,48 *0.019*	0,70 *0.028*
P12	218.19-160T-04-MD11 MP1501	SPMT100408T-M08 F40M	28,0 *1.1*	0,28 *0.011*	0,34 *0.013*	0,46 *0.018*
M1	218.19-160T-04-M08 MP3000	SPMT100408T-M08 F40M	35,0 *1.4*	0,32 *0.013*	0,40 *0.016*	0,55 *0.022*
M2	218.19-160T-04-M08 MP3000	SPMT100408T-M08 F40M	35,0 *1.4*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
M3	218.19-160T-04-M08 MP3000	SPMT100408T-M08 F40M	28,0 *1.1*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
M4	218.19-160T-04-M08 MP3000	SPMT100408T-M08 F40M	21,0 *0.85*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
M5	218.19-160T-04-M08 MP3000	SPMT100408T-M08 F40M	21,0 *0.85*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
K1	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,46 *0.018*	0,55 *0.022*	0,75 *0.030*
K2	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K3	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K4	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K5	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,38 *0.015*	0,44 *0.017*	0,60 *0.024*
K6	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,42 *0.017*	0,50 *0.020*	0,70 *0.028*
K7	218.19-160T-04-MD11 F25M	SPMT100408T-M08 F40M	35,0 *1.4*	0,38 *0.015*	0,44 *0.017*	0,60 *0.024*
N1	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	35,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
N2	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	35,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
N3	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	35,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
N11	218.19-160-04-E07 H25	SPMT100408T-M08 F40M	35,0 *1.4*	0,36 *0.014*	0,44 *0.017*	0,60 *0.024*
S1	218.19-160T-04-M08 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
S2	218.19-160T-04-M08 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
S3	218.19-160T-04-M08 F40M	SPMT100408T-M08 F40M	21,0 *0.85*	0,20 *0.0080*	0,24 *0.0095*	0,32 *0.013*
S11	218.19-160T-04-M08 MS2050	SPMT100408T-M08 F40M	24,0 *0.95*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
S12	218.19-160T-04-M08 MS2050	SPMT100408T-M08 F40M	24,0 *0.95*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
S13	218.19-160T-04-M08 MS2050	SPMT100408T-M08 F40M	21,0 *0.85*	0,22 *0.0085*	0,25 *0.010*	0,36 *0.014*
H5	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	22,0 *0.85*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
H8	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	19,0 *0.75*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*
H11	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	22,0 *0.85*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
H12	218.19-160T-04-M08 MP3000	SPMT100408T-M08 F40M	19,0 *0.75*	0,14 *0.0055*	0,16 *0.0065*	0,22 *0.0085*
H21	218.19-160T-04-MD11 F15M	SPMT100408T-M08 F40M	19,0 *0.75*	0,19 *0.0075*	0,22 *0.0085*	0,32 *0.013*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-160 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501					MP2050					MP2501					MP3000					F15M					F40M				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	220	235	295	345	375	230	250	305	365	390	195	210	260	305	335	225	245	295	350	375	—	—	—	—	—	180	195	235	280	300
	720	*770*	*970*	*1125*	*1225*	*750*	*820*	*1000*	*1200*	*1275*	*640*	*690*	*850*	*1000*	*1100*	*740*	*800*	*970*	*1150*	*1225*	—	—	—	—	—	*590*	*640*	*770*	*920*	*980*
P2	215	230	280	335	365	220	240	295	350	380	190	205	250	300	325	210	230	285	335	365	—	—	—	—	—	170	185	230	270	290
	710	*750*	*920*	*1100*	*1200*	*720*	*790*	*970*	*1150*	*1250*	*620*	*670*	*820*	*980*	*1075*	*690*	*750*	*940*	*1100*	*1200*	—	—	—	—	—	*560*	*610*	*750*	*890*	*950*
P3	185	205	245	300	315	195	210	260	305	335	165	180	220	265	280	185	205	250	295	325	—	—	—	—	—	150	165	200	235	260
	610	*670*	*800*	*980*	*1025*	*640*	*690*	*850*	*1000*	*1100*	*540*	*590*	*720*	*870*	*920*	*610*	*670*	*820*	*970*	*1075*	—	—	—	—	—	*490*	*540*	*660*	*770*	*850*
P4	165	180	220	265	285	170	185	230	270	295	145	160	195	235	250	165	180	220	265	285	—	—	—	—	—	130	145	175	210	230
	540	*590*	*720*	*870*	*940*	*560*	*610*	*750*	*890*	*970*	*475*	*520*	*640*	*770*	*820*	*540*	*590*	*720*	*870*	*940*	—	—	—	—	—	*425*	*475*	*570*	*690*	*750*
P5	155	170	210	250	270	165	175	220	260	280	140	150	190	220	240	160	170	210	250	270	—	—	—	—	—	125	135	170	200	220
	510	*560*	*690*	*820*	*890*	*540*	*570*	*720*	*850*	*920*	*460*	*490*	*620*	*720*	*790*	*520*	*560*	*690*	*820*	*890*	—	—	—	—	—	*410*	*445*	*560*	*660*	*720*
P6	180	195	240	285	305	185	200	250	290	315	160	175	210	255	270	175	190	240	280	305	—	—	—	—	—	140	155	195	225	245
	590	*640*	*790*	*940*	*1000*	*610*	*660*	*820*	*950*	*1025*	*520*	*570*	*690*	*840*	*890*	*570*	*620*	*790*	*920*	*1000*	—	—	—	—	—	*460*	*510*	*640*	*740*	*800*
P7	170	185	225	270	285	175	190	235	275	300	150	165	200	240	255	165	180	230	265	290	—	—	—	—	—	135	145	185	215	230
	560	*610*	*740*	*890*	*940*	*570*	*620*	*770*	*900*	*980*	*490*	*540*	*660*	*790*	*840*	*540*	*590*	*750*	*870*	*950*	—	—	—	—	—	*445*	*475*	*610*	*710*	*750*
P8	155	170	210	250	265	165	175	220	255	280	140	150	185	220	235	160	170	210	245	270	—	—	—	—	—	125	135	170	200	220
	510	*560*	*690*	*820*	*870*	*540*	*570*	*720*	*840*	*920*	*460*	*490*	*610*	*720*	*770*	*520*	*560*	*690*	*800*	*890*	—	—	—	—	—	*410*	*445*	*560*	*660*	*720*
P11	165	180	220	260	280	170	180	230	270	290	145	160	195	230	245	160	175	220	260	280	—	—	—	—	—	130	140	175	205	225
	540	*590*	*720*	*850*	*920*	*560*	*590*	*750*	*890*	*950*	*475*	*520*	*640*	*750*	*800*	*520*	*570*	*720*	*850*	*920*	—	—	—	—	—	*425*	*460*	*570*	*670*	*740*
P12	110	120	145	175	190	115	125	150	180	195	100	105	130	155	170	110	120	145	175	185	—	—	—	—	—	90	95	115	140	150
	360	*395*	*475*	*570*	*620*	*375*	*410*	*490*	*590*	*640*	*330*	*345*	*425*	*510*	*560*	*360*	*395*	*475*	*570*	*610*	—	—	—	—	—	*295*	*310*	*375*	*460*	*490*
M1	—	—	—	—	—	155	170	215	250	270	135	145	180	215	235	160	170	215	250	275	—	—	—	—	—	135	150	185	215	235
	—	—	—	—	—	*510*	*560*	*710*	*820*	*890*	*445*	*475*	*590*	*710*	*770*	*520*	*560*	*710*	*820*	*900*	—	—	—	—	—	*445*	*490*	*610*	*710*	*770*
M2	—	—	—	—	—	130	140	175	210	225	110	120	150	180	195	130	145	175	210	225	—	—	—	—	—	115	125	150	180	195
	—	—	—	—	—	*425*	*460*	*570*	*690*	*740*	*360*	*395*	*490*	*590*	*640*	*425*	*475*	*570*	*690*	*740*	—	—	—	—	—	*375*	*410*	*490*	*590*	*640*
M3	—	—	—	—	—	110	120	145	175	185	95	100	125	150	160	110	120	145	175	185	—	—	—	—	—	95	105	125	150	160
	—	—	—	—	—	*360*	*395*	*475*	*570*	*610*	*310*	*330*	*410*	*490*	*520*	*360*	*395*	*475*	*570*	*610*	—	—	—	—	—	*310*	*345*	*410*	*490*	*520*
M4	—	—	—	—	—	90	95	115	135	145	75	85	100	120	130	90	95	115	140	150	—	—	—	—	—	75	85	100	120	130
	—	—	—	—	—	*295*	*310*	*375*	*445*	*475*	*245*	*280*	*330*	*395*	*425*	*295*	*310*	*375*	*460*	*490*	—	—	—	—	—	*245*	*280*	*330*	*395*	*425*
M5	—	—	—	—	—	75	80	95	115	125	65	70	85	100	105	75	80	95	115	125	—	—	—	—	—	65	70	85	100	105
	—	—	—	—	—	*245*	*260*	*310*	*375*	*410*	*215*	*230*	*280*	*330*	*345*	*245*	*260*	*310*	*375*	*410*	—	—	—	—	—	*215*	*230*	*280*	*330*	*345*
K1	170	180	225	265	290	175	190	235	275	300	150	160	200	235	255	170	180	225	265	290	135	145	180	215	235	135	145	180	215	230
	560	*590*	*740*	*870*	*950*	*570*	*620*	*770*	*900*	*980*	*490*	*520*	*660*	*770*	*840*	*560*	*590*	*740*	*870*	*950*	*445*	*475*	*590*	*710*	*770*	*445*	*475*	*590*	*710*	*750*
K2	150	160	200	240	255	155	170	205	245	270	130	145	180	210	230	150	160	200	240	260	120	130	160	190	205	120	130	160	190	205
	490	*520*	*660*	*790*	*840*	*510*	*560*	*670*	*800*	*890*	*425*	*475*	*590*	*690*	*750*	*490*	*520*	*660*	*790*	*850*	*395*	*425*	*520*	*620*	*670*	*395*	*425*	*520*	*620*	*670*
K3	125	135	170	200	220	130	140	175	210	225	110	120	150	180	195	125	135	170	200	220	100	110	135	160	175	100	110	135	160	175
	410	*445*	*560*	*660*	*720*	*425*	*460*	*570*	*690*	*740*	*360*	*395*	*490*	*590*	*640*	*410*	*445*	*560*	*660*	*720*	*330*	*360*	*445*	*520*	*570*	*330*	*360*	*445*	*520*	*570*
K4	120	130	165	190	210	125	135	165	200	215	105	115	145	170	185	120	130	160	190	210	95	105	130	155	165	95	105	130	155	165
	395	*425*	*540*	*620*	*690*	*410*	*445*	*540*	*660*	*710*	*345*	*375*	*475*	*560*	*610*	*395*	*425*	*520*	*620*	*690*	*310*	*345*	*425*	*510*	*540*	*310*	*345*	*425*	*510*	*540*
K5	75	80	100	120	130	80	85	105	125	135	65	70	90	105	115	75	80	100	120	130	60	65	80	95	105	60	65	80	95	105
	245	*260*	*330*	*395*	*425*	*260*	*280*	*345*	*410*	*445*	*215*	*230*	*295*	*345*	*375*	*245*	*260*	*330*	*395*	*425*	*195*	*215*	*260*	*310*	*345*	*195*	*215*	*260*	*310*	*345*
K6	105	115	145	170	185	110	120	145	175	190	95	100	125	150	160	105	115	140	170	185	85	95	115	135	150	85	90	115	135	145
	345	*375*	*475*	*560*	*610*	*360*	*395*	*475*	*570*	*620*	*310*	*330*	*410*	*490*	*520*	*345*	*375*	*460*	*560*	*610*	*280*	*310*	*375*	*445*	*490*	*280*	*295*	*375*	*445*	*475*
K7	95	105	130	155	165	100	110	135	155	170	85	95	115	135	145	95	105	130	150	165	80	85	105	125	135	75	85	105	120	130
	310	*345*	*425*	*510*	*540*	*330*	*360*	*445*	*510*	*560*	*280*	*310*	*375*	*445*	*475*	*310*	*345*	*425*	*490*	*540*	*260*	*280*	*345*	*410*	*445*	*245*	*280*	*345*	*395*	*425*
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1225	1325	1650	1975	2125	—	—	—	—	—	990	1075	1325	1575	1700
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*4025*	*4350*	*5425*	*6475*	*6975*	—	—	—	—	—	*3250*	*3525*	*4350*	*5175*	*5575*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	500	540	670	790	860	—	—	—	—	—	400	430	540	630	690
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1650*	*1775*	*2200*	*2600*	*2825*	—	—	—	—	—	*1300*	*1400*	*1775*	*2075*	*2275*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	330	360	445	530	570	—	—	—	—	—	265	285	355	425	455
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1075*	*1175*	*1450*	*1750*	*1875*	—	—	—	—	—	*870*	*940*	*1175*	*1400*	*1500*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	380	410	510	600	650	—	—	—	—	—	305	330	410	485	520
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1250*	*1350*	*1675*	*1975*	*2125*	—	—	—	—	—	*1000*	*1075*	*1350*	*1600*	*1700*
S1	—	—	—	—	—	43	47	55	65	70	—	—	—	—	—	41	45	55	65	70	—	—	—	—	—	35	39	46	55	60
	—	—	—	—	—	*140*	*155*	*180*	*215*	*230*	—	—	—	—	—	*135*	*150*	*180*	*215*	*230*	—	—	—	—	—	*115*	*130*	*150*	*180*	*195*
S2	—	—	—	—	—	34	37	45	55	60	—	—	—	—	—	33	36	43	50	55	—	—	—	—	—	29	31	37	45	48
	—	—	—	—	—	*110*	*120*	*150*	*180*	*195*	—	—	—	—	—	*110*	*120*	*140*	*165*	*180*	—	—	—	—	—	*95*	*100*	*120*	*150*	*155*
S3	—	—	—	—	—	30	33	40	47	50	—	—	—	—	—	29	32	39	45	50	—	—	—	—	—	25	27	33	39	43
	—	—	—	—	—	*100*	*110*	*130*	*155*	*165*	—	—	—	—	—	*95*	*105*	*130*	*150*	*165*	—	—	—	—	—	*80*	*90*	*110*	*130*	*140*
S11	—	—	—	—	—	60	65	75	90	100	—	—	—	—	—	55	60	75	90	95	—	—	—	—	—	49	55	65	75	80
	—	—	—	—	—	*195*	*215*	*245*	*295*	*330*	—	—	—	—	—	*180*	*195*	*245*	*295*	*310*	—	—	—	—	—	*160*	*180*	*215*	*245*	*260*
S12	—	—	—	—	—	41	44	55	65	70	—	—	—	—	—	39	42	50	60	65	—	—	—	—	—	34	37	44	55	55
	—	—	—	—	—	*135*	*145*	*180*	*215*	*230*	—	—	—	—	—	*130*	*140*	*165*	*195*	*215*	—	—	—	—	—	*110*	*120*	*145*	*180*	*180*
S13	—	—	—	—	—	24	26	31	38	40	—	—	—	—	—	23	25	30	36	39	—	—	—	—	—	20	22	26	31	34
	—	—	—	—	—	*80*	*85*	*100*	*125*	*130*	—	—	—	—	—	*75*	*80*	*100*	*120*	*130*	—	—	—	—	—	*65*	*70*	*85*	*100*	*110*
H5	39	43	50	60	65	36	39	48	55	60	—	—	—	—	—	36	39	48	55	60	32	35	42	49	55	31	33	41	48	50
	130	*140*	*165*	*195*	*215*	*120*	*130*	*155*	*180*	*195*	—	—	—	—	—	*120*	*130*	*155*	*180*	*195*	*105*	*115*	*140*	*160*	*180*	*100*	*110*	*135*	*155*	*165*
H8	43	47	55	70	75	39	43	50	60	65	—	—	—	—	—	39	43	50	60	65	35	38	46	55	60	34	37	44	55	55
	140	*155*	*180*	*230*	*245*	*130*	*140*	*165*	*195*	*215*	—	—	—	—	—	*130*	*140*	*165*	*195*	*215*	*115*	*125*	*150*	*180*	*195*	*110*	*120*	*145*	*180*	*180*
H11	50	55	65	80	85	46	50	60	70	80	—	—	—	—	—	46	50	60	70	80	41	44	55	65	70	39	43	50	60	65
	165	*180*	*215*	*260*	*280*	*150*	*165*	*195*	*230*	*260*	—	—	—	—	—	*150*	*165*	*195*	*230*	*260*	*135*	*145*	*180*	*215*	*230*	*130*	*140*	*165*	*195*	*215*
H12	75	85	100	120	130	80	85	105	125	135	—	—	—	—	—	75	80	100	120	130	60	65	80	100	105	60	65	80	95	105
	245	*280*	*330*	*395*	*425*	*260*	*280*	*345*	*410*	*445*	—	—	—	—	—	*245*	*260*	*330*	*395*	*425*	*195*	*215*	*260*	*330*	*345*	*195*	*215*	*260*	*310*	*345*
H21	43	47	55	70	75	39	43	50	60	65	—	—	—	—	—	39	43	50	60	65	35	38	46	55	60	34	37	44	55	55
	140	*155*	*180*	*230*	*245*	*130*	*140*	*165*	*195*	*215*	—	—	—	—	—	*130*	*140*	*165*	*195*	*215*	*115*	*125*	*150*	*180*	*195*	*110*	*120*	*145*	*180*	*180*

R218.19-160 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK2050					MS2050					MS2500					MH1000					H25				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	190	205	255	300	330	195	215	260	310	330	260	280	340	405	430	—	—	—	—	—	—	—	—	—	—
	620	*670*	*840*	*980*	*1075*	*640*	*710*	*850*	*1025*	*1075*	*850*	*920*	*1125*	*1325*	*1400*	—	—	—	—	—	—	—	—	—	—
P2	185	200	245	295	320	185	200	250	295	320	245	265	330	385	420	—	—	—	—	—	—	—	—	—	—
	610	*660*	*800*	*970*	*1050*	*610*	*660*	*820*	*970*	*1050*	*800*	*870*	*1075*	*1275*	*1375*	—	—	—	—	—	—	—	—	—	—
P3	165	175	215	260	275	165	180	220	260	285	215	235	290	340	375	—	—	—	—	—	—	—	—	—	—
	540	*570*	*710*	*850*	*900*	*540*	*590*	*720*	*850*	*940*	*710*	*770*	*950*	*1125*	*1225*	—	—	—	—	—	—	—	—	—	—
P4	145	155	195	230	250	145	160	195	230	250	190	205	255	305	330	—	—	—	—	—	—	—	—	—	—
	475	*510*	*640*	*750*	*820*	*475*	*520*	*640*	*750*	*820*	*620*	*670*	*840*	*1000*	*1075*	—	—	—	—	—	—	—	—	—	—
P5	135	150	185	220	235	140	150	185	220	240	180	195	240	290	315	—	—	—	—	—	—	—	—	—	—
	445	*490*	*610*	*720*	*770*	*460*	*490*	*610*	*720*	*790*	*590*	*640*	*790*	*950*	*1025*	—	—	—	—	—	—	—	—	—	—
P6	160	170	210	250	265	155	170	215	250	270	205	220	280	325	350	—	—	—	—	—	—	—	—	—	—
	520	*560*	*690*	*820*	*870*	*510*	*560*	*710*	*820*	*890*	*670*	*720*	*920*	*1075*	*1150*	—	—	—	—	—	—	—	—	—	—
P7	150	160	195	235	250	145	160	200	235	255	190	210	265	305	330	—	—	—	—	—	—	—	—	—	—
	490	*520*	*640*	*770*	*820*	*475*	*520*	*660*	*770*	*840*	*620*	*690*	*870*	*1000*	*1075*	—	—	—	—	—	—	—	—	—	—
P8	135	150	180	220	230	140	150	185	215	240	180	195	240	285	315	—	—	—	—	—	—	—	—	—	—
	445	*490*	*590*	*720*	*750*	*460*	*490*	*610*	*710*	*790*	*590*	*640*	*790*	*940*	*1025*	—	—	—	—	—	—	—	—	—	—
P11	145	155	190	230	245	145	155	195	225	245	185	205	255	300	325	—	—	—	—	—	—	—	—	—	—
	475	*510*	*620*	*750*	*800*	*475*	*510*	*640*	*740*	*800*	*610*	*670*	*840*	*980*	*1075*	—	—	—	—	—	—	—	—	—	—
P12	95	105	130	150	165	100	105	130	150	165	130	140	165	200	215	—	—	—	—	—	—	—	—	—	—
	310	*345*	*425*	*490*	*540*	*330*	*345*	*425*	*490*	*540*	*425*	*460*	*540*	*660*	*710*	—	—	—	—	—	—	—	—	—	—
M1	—	—	—	—	—	150	165	205	240	260	175	190	235	275	300	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*490*	*540*	*670*	*790*	*850*	*570*	*620*	*770*	*900*	*980*	—	—	—	—	—	—	—	—	—	—
M2	—	—	—	—	—	125	135	165	200	215	145	160	195	230	250	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*410*	*445*	*540*	*660*	*710*	*475*	*520*	*640*	*750*	*820*	—	—	—	—	—	—	—	—	—	—
M3	—	—	—	—	—	105	115	140	165	175	120	130	160	190	205	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*345*	*375*	*460*	*540*	*570*	*395*	*425*	*520*	*620*	*670*	—	—	—	—	—	—	—	—	—	—
M4	—	—	—	—	—	85	90	110	130	140	95	105	125	150	165	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*280*	*295*	*360*	*425*	*460*	*310*	*345*	*410*	*490*	*540*	—	—	—	—	—	—	—	—	—	—
M5	—	—	—	—	—	70	75	90	110	115	80	90	105	125	135	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*230*	*245*	*295*	*360*	*375*	*260*	*295*	*345*	*410*	*445*	—	—	—	—	—	—	—	—	—	—
K1	200	215	265	315	345	—	—	—	—	—	—	—	—	—	—	165	175	215	260	285	—	—	—	—	—
	660	*710*	*870*	*1025*	*1125*	—	—	—	—	—	—	—	—	—	—	*540*	*570*	*710*	*850*	*940*	—	—	—	—	—
K2	180	190	240	285	305	—	—	—	—	—	—	—	—	—	—	145	155	195	230	250	—	—	—	—	—
	590	*620*	*790*	*940*	*1000*	—	—	—	—	—	—	—	—	—	—	*475*	*510*	*640*	*750*	*820*	—	—	—	—	—
K3	150	165	200	240	260	—	—	—	—	—	—	—	—	—	—	125	135	165	195	210	—	—	—	—	—
	490	*540*	*660*	*790*	*850*	—	—	—	—	—	—	—	—	—	—	*410*	*445*	*540*	*640*	*690*	—	—	—	—	—
K4	145	155	195	230	245	—	—	—	—	—	—	—	—	—	—	115	125	160	185	200	—	—	—	—	—
	475	*510*	*640*	*750*	*800*	—	—	—	—	—	—	—	—	—	—	*375*	*410*	*520*	*610*	*660*	—	—	—	—	—
K5	90	95	120	140	155	—	—	—	—	—	—	—	—	—	—	75	80	100	115	125	—	—	—	—	—
	295	*310*	*395*	*460*	*510*	—	—	—	—	—	—	—	—	—	—	*245*	*260*	*330*	*375*	*410*	—	—	—	—	—
K6	125	135	170	200	220	—	—	—	—	—	—	—	—	—	—	105	110	140	165	180	—	—	—	—	—
	410	*445*	*560*	*660*	*720*	—	—	—	—	—	—	—	—	—	—	*345*	*360*	*460*	*540*	*590*	—	—	—	—	—
K7	115	125	155	180	200	—	—	—	—	—	—	—	—	—	—	95	100	125	150	160	—	—	—	—	—
	375	*410*	*510*	*590*	*660*	—	—	—	—	—	—	—	—	—	—	*310*	*330*	*410*	*490*	*520*	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1050	1150	1400	1675	1825
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*3450*	*3775*	*4600*	*5500*	*6000*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	425	460	570	670	730
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1400*	*1500*	*1875*	*2200*	*2400*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	285	305	380	450	490
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*940*	*1000*	*1250*	*1475*	*1600*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	325	350	435	510	560
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1075*	*1150*	*1425*	*1675*	*1825*
S1	—	—	—	—	—	39	42	50	60	65	48	50	60	75	80	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*130*	*140*	*165*	*195*	*215*	*155*	*165*	*195*	*245*	*260*	—	—	—	—	—	—	—	—	—	—
S2	—	—	—	—	—	31	34	41	49	55	38	42	50	60	65	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*100*	*110*	*135*	*160*	*180*	*125*	*140*	*165*	*195*	*215*	—	—	—	—	—	—	—	—	—	—
S3	—	—	—	—	—	28	30	37	43	47	34	37	45	50	55	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*90*	*100*	*120*	*140*	*155*	*110*	*120*	*150*	*165*	*180*	—	—	—	—	—	—	—	—	—	—
S11	—	—	—	—	—	55	60	70	85	90	65	70	85	105	110	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*180*	*195*	*230*	*280*	*295*	*215*	*230*	*280*	*345*	*360*	—	—	—	—	—	—	—	—	—	—
S12	—	—	—	—	—	37	40	49	60	65	45	49	60	70	75	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*120*	*130*	*160*	*195*	*215*	*150*	*160*	*195*	*230*	*245*	—	—	—	—	—	—	—	—	—	—
S13	—	—	—	—	—	22	24	29	34	37	27	29	35	42	45	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*70*	*80*	*95*	*110*	*120*	*90*	*95*	*115*	*140*	*150*	—	—	—	—	—	—	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	38	42	50	60	65	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*125*	*140*	*165*	*195*	*215*	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	42	45	55	65	70	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*140*	*150*	*180*	*215*	*230*	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	49	55	65	75	85	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*160*	*180*	*215*	*245*	*280*	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	75	80	100	120	125	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*245*	*260*	*330*	*395*	*410*	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	42	45	55	65	70	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*140*	*150*	*180*	*215*	*230*	—	—	—	—	—

R218.19-200 – Insert selection – mm/*Inch*

SMG		a_p	f_z		
			100%	70%	30%
P1	218.19-200T-05-M10 F40M	18,0 *0.70*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*
P2	218.19-200T-05-M10 F40M	18,0 *0.70*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*
P3	218.19-200T-05-M10 F40M	18,0 *0.70*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
P4	218.19-200T-05-M10 F25M	18,0 *0.70*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
P5	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
P6	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
P7	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
P8	218.19-200T-05-M10 F25M	18,0 *0.70*	0,26 *0.010*	0,26 *0.010*	0,28 *0.011*
P11	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
P12	218.19-200T-05-M10 F25M	14,0 *0.55*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*
M1	218.19-200T-05-M10 F40M	18,0 *0.70*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*
M2	218.19-200T-05-M10 F40M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
M3	218.19-200T-05-M10 F40M	14,0 *0.55*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*
M4	218.19-200T-05-M10 F40M	11,0 *0.44*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*
M5	218.19-200T-05-M10 F40M	11,0 *0.44*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*
K1	218.19-200T-05-M10 F25M	18,0 *0.70*	0,28 *0.011*	0,28 *0.011*	0,30 *0.012*
K2	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
K3	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
K4	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
K5	218.19-200T-05-M10 F25M	18,0 *0.70*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
K6	218.19-200T-05-M10 F25M	18,0 *0.70*	0,25 *0.010*	0,25 *0.010*	0,26 *0.010*
K7	218.19-200T-05-M10 F25M	18,0 *0.70*	0,22 *0.0085*	0,22 *0.0085*	0,24 *0.0095*
N1	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,36 *0.014*	0,36 *0.014*	0,38 *0.015*
N2	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,36 *0.014*	0,36 *0.014*	0,38 *0.015*
N3	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,36 *0.014*	0,36 *0.014*	0,38 *0.015*
N11	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,36 *0.014*	0,36 *0.014*	0,38 *0.015*
S1	218.19-200T-05-M10 F40M	11,0 *0.44*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*
S2	218.19-200T-05-M10 F40M	11,0 *0.44*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*
S3	218.19-200T-05-M10 F40M	11,0 *0.44*	0,18 *0.0070*	0,18 *0.0070*	0,19 *0.0075*
S11	218.19-200T-05-M10 F40M	13,0 *0.50*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*
S12	218.19-200T-05-M10 F40M	13,0 *0.50*	0,22 *0.0085*	0,22 *0.0085*	0,22 *0.0085*
S13	218.19-200T-05-M10 F40M	11,0 *0.44*	0,20 *0.0080*	0,20 *0.0080*	0,20 *0.0080*
H5	218.19-200T-05-M10 F25M	11,0 *0.44*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
H8	218.19-200T-05-M10 F25M	10,0 *0.40*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*
H11	218.19-200T-05-M10 F25M	11,0 *0.44*	0,16 *0.0065*	0,16 *0.0065*	0,17 *0.0065*
H12	218.19-200T-05-M10 F25M	10,0 *0.40*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*
H21	218.19-200T-05-M10 F25M	10,0 *0.40*	0,13 *0.0050*	0,13 *0.0050*	0,13 *0.0050*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-200 – Insert selection – mm/*Inch*

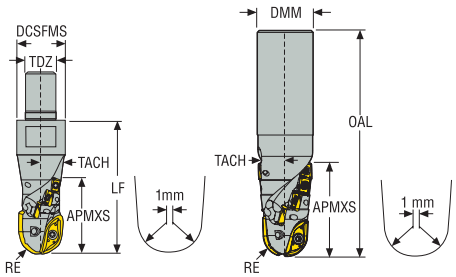
SMG		a_p	f_z		
			15%	10%	5%
P1	218.19-200T-05-M10 F40M	18,0 *0.70*	0,38 *0.015*	0,44 *0.017*	0,60 *0.024*
P2	218.19-200T-05-M10 F40M	18,0 *0.70*	0,38 *0.015*	0,46 *0.018*	0,65 *0.026*
P3	218.19-200T-05-M10 F40M	18,0 *0.70*	0,36 *0.014*	0,42 *0.017*	0,60 *0.024*
P4	218.19-200T-05-M10 F25M	18,0 *0.70*	0,36 *0.014*	0,42 *0.017*	0,60 *0.024*
P5	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,42 *0.017*	0,55 *0.022*
P6	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,40 *0.016*	0,55 *0.022*
P7	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,40 *0.016*	0,55 *0.022*
P8	218.19-200T-05-M10 F25M	18,0 *0.70*	0,36 *0.014*	0,42 *0.017*	0,60 *0.024*
P11	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,40 *0.016*	0,55 *0.022*
P12	218.19-200T-05-M10 F25M	14,0 *0.55*	0,24 *0.0095*	0,28 *0.011*	0,40 *0.016*
M1	218.19-200T-05-M10 F40M	18,0 *0.70*	0,38 *0.015*	0,46 *0.018*	0,65 *0.026*
M2	218.19-200T-05-M10 F40M	18,0 *0.70*	0,34 *0.013*	0,42 *0.017*	0,55 *0.022*
M3	218.19-200T-05-M10 F40M	14,0 *0.55*	0,28 *0.011*	0,34 *0.013*	0,46 *0.018*
M4	218.19-200T-05-M10 F40M	11,0 *0.44*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
M5	218.19-200T-05-M10 F40M	11,0 *0.44*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
K1	218.19-200T-05-M10 F25M	18,0 *0.70*	0,38 *0.015*	0,46 *0.018*	0,65 *0.026*
K2	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,42 *0.017*	0,55 *0.022*
K3	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,42 *0.017*	0,55 *0.022*
K4	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,42 *0.017*	0,55 *0.022*
K5	218.19-200T-05-M10 F25M	18,0 *0.70*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
K6	218.19-200T-05-M10 F25M	18,0 *0.70*	0,34 *0.013*	0,42 *0.017*	0,55 *0.022*
K7	218.19-200T-05-M10 F25M	18,0 *0.70*	0,30 *0.012*	0,36 *0.014*	0,50 *0.020*
N1	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,48 *0.019*	0,60 *0.024*	0,80 *0.032*
N2	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,48 *0.019*	0,60 *0.024*	0,80 *0.032*
N3	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,48 *0.019*	0,60 *0.024*	0,80 *0.032*
N11	218.19-200T-05-ME10 F40M	18,0 *0.70*	0,48 *0.019*	0,60 *0.024*	0,80 *0.032*
S1	218.19-200T-05-M10 F40M	11,0 *0.44*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
S2	218.19-200T-05-M10 F40M	11,0 *0.44*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
S3	218.19-200T-05-M10 F40M	11,0 *0.44*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*
S11	218.19-200T-05-M10 F40M	13,0 *0.50*	0,28 *0.011*	0,34 *0.013*	0,46 *0.018*
S12	218.19-200T-05-M10 F40M	13,0 *0.50*	0,28 *0.011*	0,34 *0.013*	0,46 *0.018*
S13	218.19-200T-05-M10 F40M	11,0 *0.44*	0,25 *0.010*	0,30 *0.012*	0,40 *0.016*
H5	218.19-200T-05-M10 F25M	11,0 *0.44*	0,20 *0.0080*	0,25 *0.010*	0,34 *0.013*
H8	218.19-200T-05-M10 F25M	10,0 *0.40*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*
H11	218.19-200T-05-M10 F25M	11,0 *0.44*	0,20 *0.0080*	0,25 *0.010*	0,34 *0.013*
H12	218.19-200T-05-M10 F25M	10,0 *0.40*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*
H21	218.19-200T-05-M10 F25M	10,0 *0.40*	0,16 *0.0065*	0,19 *0.0075*	0,26 *0.010*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.19-200 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F25M					F40M				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	220 *720*	230 *750*	285 *940*	345 *1125*	380 *1250*	200 *660*	210 *690*	260 *850*	315 *1025*	345 *1125*
P2	215 *710*	225 *740*	280 *920*	330 *1075*	360 *1175*	195 *640*	205 *670*	255 *840*	300 *980*	330 *1075*
P3	190 *620*	200 *660*	245 *800*	295 *970*	320 *1050*	170 *560*	180 *590*	225 *740*	265 *870*	290 *950*
P4	165 *540*	175 *570*	215 *710*	260 *850*	280 *920*	150 *490*	160 *520*	195 *640*	235 *770*	255 *840*
P5	160 *520*	170 *560*	210 *690*	245 *800*	275 *900*	145 *475*	155 *510*	190 *620*	225 *740*	250 *820*
P6	180 *590*	190 *620*	235 *770*	280 *920*	310 *1025*	165 *540*	175 *570*	215 *710*	255 *840*	280 *920*
P7	170 *560*	180 *590*	225 *740*	265 *870*	290 *950*	155 *510*	165 *540*	205 *670*	240 *790*	265 *870*
P8	160 *520*	170 *560*	205 *670*	245 *800*	265 *870*	145 *475*	150 *490*	185 *610*	225 *740*	245 *800*
P11	165 *540*	175 *570*	215 *710*	255 *840*	280 *920*	150 *490*	160 *520*	195 *640*	235 *770*	255 *840*
P12	115 *375*	120 *395*	145 *475*	175 *570*	190 *620*	105 *345*	110 *360*	135 *445*	160 *520*	175 *570*
M1	— —	— —	— —	— —	— —	155 *510*	165 *540*	205 *670*	245 *800*	265 *870*
M2	— —	— —	— —	— —	— —	130 *425*	140 *460*	170 *560*	200 *660*	225 *740*
M3	— —	— —	— —	— —	— —	110 *360*	115 *375*	145 *475*	170 *560*	190 *620*
M4	— —	— —	— —	— —	— —	90 *295*	90 *295*	115 *375*	135 *445*	150 *490*
M5	— —	— —	— —	— —	— —	75 *245*	75 *245*	95 *310*	115 *375*	125 *410*
K1	170 *560*	180 *590*	220 *720*	260 *850*	285 *940*	155 *510*	165 *540*	200 *660*	240 *790*	260 *850*
K2	150 *490*	160 *520*	200 *660*	235 *770*	260 *850*	140 *460*	145 *475*	180 *590*	210 *690*	235 *770*
K3	130 *425*	135 *445*	170 *560*	200 *660*	220 *720*	115 *375*	125 *410*	155 *510*	180 *590*	200 *660*
K4	120 *395*	130 *425*	160 *520*	190 *620*	210 *690*	110 *360*	120 *395*	145 *475*	170 *560*	190 *620*
K5	75 *245*	80 *260*	100 *330*	115 *375*	130 *425*	70 *230*	75 *245*	90 *295*	105 *345*	115 *375*
K6	110 *360*	115 *375*	140 *460*	165 *540*	185 *610*	100 *330*	105 *345*	130 *425*	150 *490*	170 *560*
K7	95 *310*	105 *345*	125 *410*	150 *490*	165 *540*	90 *295*	95 *310*	115 *375*	135 *445*	150 *490*
N1	— —	— —	— —	— —	— —	1125 *3700*	1175 *3850*	1475 *4850*	1750 *5750*	1925 *6325*
N2	— —	— —	— —	— —	— —	450 *1475*	480 *1575*	600 *1975*	700 *2300*	780 *2550*
N3	— —	— —	— —	— —	— —	300 *980*	320 *1050*	395 *1300*	470 *1550*	520 *1700*
N11	— —	— —	— —	— —	— —	345 *1125*	365 *1200*	455 *1500*	530 *1750*	590 *1925*
S1	46 *150*	47 *155*	60 *195*	70 *230*	75 *245*	42 *140*	43 *140*	55 *180*	65 *215*	70 *230*
S2	37 *120*	38 *125*	47 *155*	55 *180*	60 *195*	34 *110*	35 *115*	43 *140*	50 *165*	55 *180*
S3	33 *110*	34 *110*	41 *135*	49 *160*	55 *180*	30 *100*	31 *100*	37 *120*	45 *150*	49 *160*
S11	65 *215*	65 *215*	80 *260*	95 *310*	105 *345*	55 *180*	60 *195*	75 *245*	85 *280*	95 *310*
S12	43 *140*	45 *150*	55 *180*	65 *215*	75 *245*	39 *130*	41 *135*	50 *165*	60 *195*	65 *215*
S13	26 *85*	27 *90*	33 *110*	39 *130*	43 *140*	24 *80*	24 *80*	30 *100*	36 *120*	39 *130*
H5	41 *135*	42 *140*	50 *165*	60 *195*	65 *215*	37 *120*	38 *125*	47 *155*	55 *180*	60 *195*
H8	44 *145*	45 *150*	55 *180*	65 *215*	70 *230*	40 *130*	41 *135*	50 *165*	60 *195*	65 *215*
H11	50 *165*	55 *180*	65 *215*	80 *260*	85 *280*	47 *155*	49 *160*	60 *195*	70 *230*	80 *260*
H12	80 *260*	80 *260*	100 *330*	120 *395*	130 *425*	70 *230*	75 *245*	90 *295*	105 *345*	120 *395*
H21	44 *145*	45 *150*	55 *180*	65 *215*	70 *230*	40 *130*	41 *135*	50 *165*	60 *195*	65 *215*

R218.24 – Metric



- For insert selection and cutting data recommendations, see page(s) 661-668
- For complete insert programme, see page(s) 775-776, 777, 788
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DCSFMS	DMM	TDZ	LF	RPMX	Weight	218.20	XO.X
			mm		mm	mm	mm		mm		kg		
R218.24-20R063.0-025-06.2A	02756721	Cylindrical	12,86	2	24,0	–	20,0	–	–	20000	0,2	0.250 (2)	06 (6)
R218.24-25R080.0-038-06.2A	02735933	Cylindrical	15,92	2	38,0	–	25,0	–	–	18000	0,3	R080 (2)	06 (12)
R218.24-25R100.0-048-10.2A	02926941	Cylindrical	19,66	2	48,0	–	25,0	–	–	16000	0,4	R100 (2)	10 (10)
R218.24-12R080.RE-028-06.2A	02735924	Combimaster	15,92	2	28,0	23,0	–	M12	50,0	18000	0,1	R080 (2)	06 (8)
R218.24-16R100.RE-032-10.2A	02926942	Combimaster	19,67	2	32,6	30,0	–	M16	55,0	16000	0,2	R100 (2)	10 (6)

Spare Parts

Accessories

For cutter	Insert screw centre	Insert screw periph	Key center	Key periphery	Torque key	Torque value
R218.24-63	C02053-T06P	C01804-T06P	H4B-T06P	–	T00-06P05	0.5NM
R218.24-080	C02506-T08P	C01804-T06P	H4B-T08P	H4B-T06P	T00-08P12	0.5NM
R218.24-100	C03007-T09P	C02506-T07P	H4B-T09P	H4B-T07P	T00-09P20	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R218.24-063 – Insert selection – mm/*Inch*

SMG			f_z				
			100%	70%	30%	10%	5%
P1	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,042 *0.0017*	0,042 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 0.0040
P2	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,042 *0.0017*	0,042 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 0.0040
P3	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,070 *0.0028*	0,10 0.0040
P4	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
P5	218.20-0.250ER-M03 F40M	XOMX060204R-M05 F40M	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
P6	218.20-0.250ER-M03 F40M	XOMX060204R-M05 F40M	0,038 *0.0015*	0,038 *0.0015*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
P7	218.20-0.250ER-M03 F40M	XOMX060204R-M05 F40M	0,038 *0.0015*	0,038 *0.0015*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
P8	218.20-0.250ER-M03 F40M	XOMX060204R-M05 F40M	0,040 *0.0016*	0,040 *0.0016*	0,046 *0.0018*	0,070 *0.0028*	0,10 0.0040
P11	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,038 *0.0015*	0,038 *0.0015*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
P12	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,046 *0.0018*	0,065 0.0026
M1	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,042 *0.0017*	0,042 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 0.0040
M2	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
M3	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,055 *0.0022*	0,075 0.0030
M4	218.20-0.250ER-M03 F40M	XOMX060204R-M05 F40M	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,048 *0.0019*	0,065 0.0026
M5	218.20-0.250ER-M03 F40M	XOMX060204R-M05 F40M	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,048 *0.0019*	0,065 0.0026
K1	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,042 *0.0017*	0,042 *0.0017*	0,048 *0.0019*	0,075 *0.0030*	0,10 0.0040
K2	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
K3	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
K4	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
K5	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 0.0034
K6	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,040 *0.0016*	0,040 *0.0016*	0,044 *0.0017*	0,070 *0.0028*	0,095 0.0038
K7	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*	0,060 *0.0024*	0,085 0.0034
N1	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*	0,13 0.0050
N2	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 MP3000	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*	0,13 0.0050
N3	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 MP3000	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*	0,13 0.0050
N11	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,055 *0.0022*	0,055 *0.0022*	0,060 *0.0024*	0,095 *0.0038*	0,13 0.0050
S1	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,048 *0.0019*	0,065 0.0026
S2	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,048 *0.0019*	0,065 0.0026
S3	218.20-0.250ER-ME03 F40M	XOMX060204R-M05 F40M	0,026 *0.0010*	0,026 *0.0010*	0,028 *0.0011*	0,044 *0.0017*	0,060 0.0024
S11	218.20-0.250ER-ME03 MS2050	XOMX060204R-M05 F40M	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,055 *0.0022*	0,075 0.0030
S12	218.20-0.250ER-ME03 MS2050	XOMX060204R-M05 F40M	0,032 *0.0013*	0,032 *0.0013*	0,036 *0.0014*	0,055 *0.0022*	0,075 0.0030
S13	218.20-0.250ER-ME03 MS2050	XOMX060204R-M05 F40M	0,028 *0.0011*	0,028 *0.0011*	0,032 *0.0013*	0,048 *0.0019*	0,065 0.0026
H11	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,026 *0.0010*	0,026 *0.0010*	0,030 *0.0012*	0,046 *0.0018*	0,065 0.0026
H12	218.20-0.250ER-M03 F40M	XOMX060204R-M05 MP3000	0,020 *0.00080*	0,020 *0.00080*	0,022 *0.00085*	0,036 *0.0014*	0,050 0.0020

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.24-063 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	275 *900*	310 *1025*	365 *1200*	425 *1400*	460 *1500*	300 *980*	340 *1125*	400 *1300*	470 *1550*	500 *1650*
P2	265 *870*	300 *980*	355 *1175*	415 *1350*	445 *1450*	295 *970*	330 *1075*	390 *1275*	455 *1500*	490 *1600*
P3	230 *750*	260 *850*	305 *1000*	360 *1175*	385 *1275*	255 *840*	290 *950*	340 *1125*	395 *1300*	425 *1400*
P4	205 *670*	230 *750*	275 *900*	320 *1050*	340 *1125*	225 *740*	255 *840*	300 *980*	350 *1150*	375 *1225*
P5	195 *640*	220 *720*	260 *850*	305 *1000*	325 *1075*	215 *710*	240 *790*	285 *940*	335 *1100*	360 *1175*
P6	220 *720*	250 *820*	290 *950*	340 *1125*	365 *1200*	245 *800*	275 *900*	320 *1050*	375 *1225*	400 *1300*
P7	210 *690*	235 *770*	275 *900*	320 *1050*	345 *1125*	230 *750*	260 *850*	305 *1000*	355 *1175*	380 *1250*
P8	195 *640*	220 *720*	260 *850*	305 *1000*	325 *1075*	215 *710*	240 *790*	285 *940*	335 *1100*	355 *1175*
P11	205 *670*	230 *750*	270 *890*	310 *1025*	335 *1100*	225 *740*	250 *820*	295 *970*	345 *1125*	370 *1225*
P12	125 *410*	140 *460*	165 *540*	195 *640*	210 *690*	140 *460*	155 *510*	185 *610*	215 *710*	230 *750*
M1	215 *710*	245 *800*	285 *940*	335 *1100*	360 *1175*	235 *770*	265 *870*	315 *1025*	370 *1225*	395 *1300*
M2	175 *570*	200 *660*	235 *770*	275 *900*	295 *970*	195 *640*	220 *720*	260 *850*	300 *980*	320 *1050*
M3	140 *460*	155 *510*	185 *610*	215 *710*	230 *750*	150 *490*	170 *560*	200 *660*	235 *770*	255 *840*
M4	105 *345*	120 *395*	140 *460*	165 *540*	175 *570*	115 *375*	130 *425*	155 *510*	180 *590*	195 *640*
M5	90 *295*	100 *330*	115 *375*	135 *445*	145 *475*	95 *310*	110 *360*	125 *410*	150 *490*	160 *520*
K1	210 *690*	240 *790*	280 *920*	330 *1075*	355 *1175*	— —	— —	— —	— —	— —
K2	185 *610*	210 *690*	245 *800*	290 *950*	310 *1025*	— —	— —	— —	— —	— —
K3	155 *510*	175 *570*	210 *690*	245 *800*	260 *850*	— —	— —	— —	— —	— —
K4	150 *490*	170 *560*	200 *660*	235 *770*	250 *820*	— —	— —	— —	— —	— —
K5	90 *295*	100 *330*	120 *395*	140 *460*	150 *490*	— —	— —	— —	— —	— —
K6	130 *425*	150 *490*	175 *570*	205 *670*	220 *720*	— —	— —	— —	— —	— —
K7	115 *375*	130 *425*	155 *510*	180 *590*	195 *640*	— —	— —	— —	— —	— —
N1	1600 *5250*	1800 *5900*	2150 *7050*	2500 *8200*	2675 *8775*	— —	— —	— —	— —	— —
N2	640 *2100*	720 *2350*	860 *2825*	1000 *3275*	1075 *3525*	— —	— —	— —	— —	— —
N3	430 *1400*	485 *1600*	580 *1900*	670 *2200*	720 *2350*	— —	— —	— —	— —	— —
N11	490 *1600*	550 *1800*	660 *2175*	770 *2525*	820 *2700*	— —	— —	— —	— —	— —
S1	49 *160*	55 *180*	65 *215*	75 *245*	80 *260*	55 *180*	60 *195*	70 *230*	85 *280*	90 *295*
S2	40 *130*	45 *150*	50 *165*	60 *195*	65 *215*	44 *145*	49 *160*	55 *180*	70 *230*	75 *245*
S3	35 *115*	39 *130*	46 *150*	55 *180*	60 *195*	38 *125*	43 *140*	50 *165*	60 *195*	65 *215*
S11	70 *230*	80 *260*	90 *295*	110 *360*	115 *375*	75 *245*	85 *280*	100 *330*	120 *395*	130 *425*
S12	49 *160*	55 *180*	65 *215*	75 *245*	80 *260*	55 *180*	60 *195*	70 *230*	85 *280*	90 *295*
S13	28 *90*	31 *100*	36 *120*	43 *140*	46 *150*	31 *100*	34 *110*	40 *130*	47 *155*	50 *165*
H11	55 *180*	60 *195*	70 *230*	80 *260*	90 *295*	— —	— —	— —	— —	— —
H12	80 *260*	85 *280*	100 *330*	120 *395*	125 *410*	— —	— —	— —	— —	— —

R218.24-080 – Insert selection – mm/*Inch*

SMG			f_z				
			100%	70%	30%	10%	5%
P1	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
P2	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
P3	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P4	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P5	218.20-080ER-M04 F25M	XOMX060204R-M05 F40M	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P6	218.20-080ER-M04 F25M	XOMX060204R-M05 F40M	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P7	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P8	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P11	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P12	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,11 *0.0044*	0,15 0.0060
M1	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
M2	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
M3	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*	0,18 0.0070
M4	218.20-080ER-M04 F40M	XOMX060204R-M05 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
M5	218.20-080ER-M04 F40M	XOMX060204R-M05 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
K1	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
K2	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K3	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K4	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K5	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,15 *0.0060*	0,20 0.0080
K6	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K7	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,15 *0.0060*	0,20 0.0080
N1	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N2	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N3	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N11	218.20-080ER-ME04 F40M	XOMX060204R-M05 F40M	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
S1	218.20-080ER-ME04 T350M	XOMX060204R-M05 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
S2	218.20-080ER-ME04 T350M	XOMX060204R-M05 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
S3	218.20-080ER-ME04 T350M	XOMX060204R-M05 F40M	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,11 *0.0044*	0,15 0.0060
S11	218.20-080ER-ME04 MS2050	XOMX060204R-M05 MS2050	0,042 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,075 *0.0030*	0,10 0.0040
S12	218.20-080ER-ME04 MS2050	XOMX060204R-M05 MS2050	0,042 *0.0017*	0,042 *0.0017*	0,046 *0.0018*	0,075 *0.0030*	0,10 0.0040
S13	218.20-080ER-ME04 MS2050	XOMX060204R-M05 MS2050	0,036 *0.0014*	0,036 *0.0014*	0,040 *0.0016*	0,065 *0.0026*	0,090 0.0036
H11	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,11 *0.0044*	0,15 0.0060
H12	218.20-080ER-M04 F25M	XOMX060204R-M05 MP3000	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,085 *0.0034*	0,12 0.0048

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.24-080 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	T350M					F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	240	270	330	380	410	225	255	305	355	380	205	230	275	325	345	165	185	225	260	280	265	300	350	415	440
	790	*890*	*1075*	*1250*	*1350*	*740*	*840*	*1000*	*1175*	*1250*	*670*	*750*	*900*	*1075*	*1125*	*540*	*610*	*740*	*850*	*920*	*870*	*980*	*1150*	*1350*	*1450*
P2	235	265	320	370	395	220	245	295	345	370	200	225	270	315	335	160	180	220	255	270	260	290	345	405	430
	770	*870*	*1050*	*1225*	*1300*	*720*	*800*	*970*	*1125*	*1225*	*660*	*740*	*890*	*1025*	*1100*	*520*	*590*	*720*	*840*	*890*	*850*	*950*	*1125*	*1325*	*1400*
P3	205	230	275	325	345	190	215	255	300	320	175	195	230	275	290	140	160	190	220	235	220	250	300	350	375
	670	*750*	*900*	*1075*	*1125*	*620*	*710*	*840*	*980*	*1050*	*570*	*640*	*750*	*900*	*950*	*460*	*520*	*620*	*720*	*770*	*720*	*820*	*980*	*1150*	*1225*
P4	180	205	240	285	305	165	190	225	265	280	150	170	205	240	255	125	140	165	195	210	195	220	265	310	330
	590	*670*	*790*	*940*	*1000*	*540*	*620*	*740*	*870*	*920*	*490*	*560*	*670*	*790*	*840*	*410*	*460*	*540*	*640*	*690*	*640*	*720*	*870*	*1025*	*1075*
P5	175	195	235	275	295	160	185	220	255	275	145	165	200	235	250	120	135	160	190	200	190	215	250	295	315
	570	*640*	*770*	*900*	*970*	*520*	*610*	*720*	*840*	*900*	*475*	*540*	*660*	*770*	*820*	*395*	*445*	*520*	*620*	*660*	*620*	*710*	*820*	*970*	*1025*
P6	195	220	265	310	330	180	205	245	290	310	165	185	225	260	280	135	150	180	210	225	215	240	285	335	355
	640	*720*	*870*	*1025*	*1075*	*590*	*670*	*800*	*950*	*1025*	*540*	*610*	*740*	*850*	*920*	*445*	*490*	*590*	*690*	*740*	*710*	*790*	*940*	*1100*	*1175*
P7	185	210	250	295	315	170	195	235	270	290	155	175	210	245	265	125	145	170	200	215	200	230	265	315	335
	610	*690*	*820*	*970*	*1025*	*560*	*640*	*770*	*890*	*950*	*510*	*570*	*690*	*800*	*870*	*410*	*475*	*560*	*660*	*710*	*660*	*750*	*870*	*1025*	*1100*
P8	170	195	230	275	290	160	180	215	255	270	145	165	195	230	245	120	135	160	185	200	185	210	250	295	315
	560	*640*	*750*	*900*	*950*	*520*	*590*	*710*	*840*	*890*	*475*	*540*	*640*	*750*	*800*	*395*	*445*	*520*	*610*	*660*	*610*	*690*	*820*	*970*	*1025*
P11	180	205	245	285	305	165	190	225	265	280	150	170	205	240	255	125	140	165	195	210	195	220	260	305	325
	590	*670*	*800*	*940*	*1000*	*540*	*620*	*740*	*870*	*920*	*490*	*560*	*670*	*790*	*840*	*410*	*460*	*540*	*640*	*690*	*640*	*720*	*850*	*1000*	*1075*
P12	115	130	155	180	195	110	120	145	170	180	100	110	130	155	165	80	90	105	125	135	120	140	160	190	205
	375	*425*	*510*	*590*	*640*	*360*	*395*	*475*	*560*	*590*	*330*	*360*	*425*	*510*	*540*	*260*	*295*	*345*	*410*	*445*	*395*	*460*	*520*	*620*	*670*
M1	180	205	245	285	305	—	—	—	—	—	160	180	220	255	270	140	155	190	220	235	210	235	275	325	345
	590	*670*	*800*	*940*	*1000*	—	—	—	—	—	*520*	*590*	*720*	*840*	*890*	*460*	*510*	*620*	*720*	*770*	*690*	*770*	*900*	*1075*	*1125*
M2	150	170	205	240	255	—	—	—	—	—	135	150	180	210	225	115	130	155	180	195	170	195	225	265	285
	490	*560*	*670*	*790*	*840*	—	—	—	—	—	*445*	*490*	*590*	*690*	*740*	*375*	*425*	*510*	*590*	*640*	*560*	*640*	*740*	*870*	*940*
M3	120	135	160	190	200	—	—	—	—	—	105	120	145	165	180	90	100	125	145	155	135	150	180	210	225
	395	*445*	*520*	*620*	*660*	—	—	—	—	—	*345*	*395*	*475*	*540*	*590*	*295*	*330*	*410*	*475*	*510*	*445*	*490*	*590*	*690*	*740*
M4	95	105	125	145	155	—	—	—	—	—	80	90	110	130	135	70	80	95	110	120	105	115	135	160	170
	310	*345*	*410*	*475*	*510*	—	—	—	—	—	*260*	*295*	*360*	*425*	*445*	*230*	*260*	*310*	*360*	*395*	*345*	*375*	*445*	*520*	*560*
M5	75	85	105	125	130	—	—	—	—	—	70	75	90	110	115	60	65	80	95	100	85	95	115	135	145
	245	*280*	*345*	*410*	*425*	—	—	—	—	—	*230*	*245*	*295*	*360*	*375*	*195*	*215*	*260*	*310*	*330*	*280*	*310*	*375*	*445*	*475*
K1	—	—	—	—	—	175	195	235	275	290	155	175	215	250	265	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*570*	*640*	*770*	*900*	*950*	*510*	*570*	*710*	*820*	*870*	—	—	—	—	—	—	—	—	—	—
K2	—	—	—	—	—	155	175	210	245	260	140	160	190	220	235	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*510*	*570*	*690*	*800*	*850*	*460*	*520*	*620*	*720*	*770*	—	—	—	—	—	—	—	—	—	—
K3	—	—	—	—	—	130	145	175	205	220	120	135	160	190	200	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*425*	*475*	*570*	*670*	*720*	*395*	*445*	*520*	*620*	*660*	—	—	—	—	—	—	—	—	—	—
K4	—	—	—	—	—	125	140	170	195	210	115	125	155	180	190	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*410*	*460*	*560*	*640*	*690*	*375*	*410*	*510*	*590*	*620*	—	—	—	—	—	—	—	—	—	—
K5	—	—	—	—	—	75	85	100	120	130	70	80	90	110	115	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*245*	*280*	*330*	*395*	*425*	*230*	*260*	*295*	*360*	*375*	—	—	—	—	—	—	—	—	—	—
K6	—	—	—	—	—	110	125	150	175	185	100	110	135	160	170	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*360*	*410*	*490*	*570*	*610*	*330*	*360*	*445*	*520*	*560*	—	—	—	—	—	—	—	—	—	—
K7	—	—	—	—	—	95	110	130	150	165	90	100	120	140	150	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*310*	*360*	*425*	*490*	*540*	*295*	*330*	*395*	*460*	*490*	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	1150	1300	1600	1875	1975	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*3775*	*4275*	*5250*	*6150*	*6475*	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	470	530	640	760	800	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1550*	*1750*	*2100*	*2500*	*2625*	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	310	350	430	500	530	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1025*	*1150*	*1400*	*1650*	*1750*	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	355	400	490	580	610	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	*1175*	*1300*	*1600*	*1900*	*2000*	—	—	—	—	—	—	—	—	—	—
S1	43	48	60	70	75	42	47	55	65	70	38	43	50	60	65	22	24	29	34	36	48	55	65	75	80
	140	*155*	*195*	*230*	*245*	*140*	*155*	*180*	*215*	*230*	*125*	*140*	*165*	*195*	*215*	*70*	*80*	*95*	*110*	*120*	*155*	*180*	*215*	*245*	*260*
S2	35	39	47	55	60	34	38	45	55	55	31	34	41	49	50	17	19	23	28	29	39	44	50	60	65
	115	*130*	*155*	*180*	*195*	*110*	*125*	*150*	*180*	*180*	*100*	*110*	*135*	*160*	*165*	*55*	*60*	*75*	*90*	*95*	*130*	*145*	*165*	*195*	*215*
S3	31	34	41	48	50	30	33	40	46	50	27	30	36	42	45	15	17	20	24	25	34	38	45	55	55
	100	*110*	*135*	*155*	*165*	*100*	*110*	*130*	*150*	*165*	*90*	*100*	*120*	*140*	*150*	*49*	*55*	*65*	*80*	*80*	*110*	*125*	*150*	*180*	*180*
S11	60	70	80	95	100	60	65	80	95	100	55	60	70	85	90	30	34	41	48	50	70	75	90	105	115
	195	*230*	*260*	*310*	*330*	*195*	*215*	*260*	*310*	*330*	*180*	*195*	*230*	*280*	*295*	*100*	*110*	*135*	*155*	*165*	*230*	*245*	*295*	*345*	*375*
S12	42	47	55	65	70	41	45	55	65	70	37	41	50	60	65	28	31	38	44	47	47	55	65	75	80
	140	*155*	*180*	*215*	*230*	*135*	*150*	*180*	*215*	*230*	*120*	*135*	*165*	*195*	*215*	*90*	*100*	*125*	*145*	*155*	*155*	*180*	*215*	*245*	*260*
S13	24	27	33	39	41	24	26	32	38	40	21	24	29	34	36	16	18	22	26	27	27	30	36	42	45
	80	*90*	*110*	*130*	*135*	*80*	*85*	*105*	*125*	*130*	*70*	*80*	*95*	*110*	*120*	*50*	*60*	*70*	*85*	*90*	*90*	*100*	*120*	*140*	*150*
H11	49	55	65	75	80	46	50	60	70	75	41	47	55	65	70	—	—	—	—	—	—	—	—	—	—
	160	*180*	*215*	*245*	*260*	*150*	*165*	*195*	*230*	*245*	*135*	*155*	*180*	*215*	*230*	—	—	—	—	—	—	—	—	—	—
H12	70	80	95	115	120	65	75	90	105	110	60	70	80	95	100	—	—	—	—	—	—	—	—	—	—
	230	*260*	*310*	*375*	*395*	*215*	*245*	*295*	*345*	*360*	*195*	*230*	*260*	*310*	*330*	—	—	—	—	—	—	—	—	—	—

R218.24-100 – Insert selection – mm/*Inch*

SMG			f_z				
			100%	70%	30%	10%	5%
P1	218.20-100ER-ME05 F40M	XOMX10T308TR-ME07 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
P2	218.20-100ER-ME05 F40M	XOMX10T308TR-ME07 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
P3	218.20-100ER-ME05 F40M	XOMX10T308TR-ME07 MP2501	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P4	218.20-100ER-ME05 F40M	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P5	218.20-100ER-M05 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P6	218.20-100ER-M05 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P7	218.20-100ER-M05 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P8	218.20-100ER-M05 F40M	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P11	218.20-100ER-M05 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P12	218.20-100ER-M05 F40M	XOMX10T308TR-M09 MP2501	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,11 *0.0044*	0,15 0.0060
M1	218.20-100ER-ME05 F40M	XOEX10T308R-M06 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
M2	218.20-100ER-ME05 F40M	XOEX10T308R-M06 F40M	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
M3	218.20-100ER-ME05 F40M	XOEX10T308R-M06 F40M	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*	0,18 0.0070
M4	218.20-100ER-M05 F40M	XOEX10T308R-M06 T350M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
M5	218.20-100ER-M05 F40M	XOEX10T308R-M06 T350M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
K1	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
K2	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K3	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K4	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K5	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,15 *0.0060*	0,20 0.0080
K6	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K7	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MK2050	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,15 *0.0060*	0,20 0.0080
N1	218.20-100ER-ME05 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N2	218.20-100ER-ME05 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N3	218.20-100ER-ME05 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N11	218.20-100ER-ME05 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
S1	218.20-100ER-ME05 F40M	XOEX10T308R-M06 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
S2	218.20-100ER-ME05 F40M	XOEX10T308R-M06 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
S3	218.20-100ER-ME05 F40M	XOEX10T308R-M06 F40M	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,11 *0.0044*	0,15 0.0060
S11	218.20-100ER-ME05 MS2050	XOEX10T308R-M06 MS2050	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,090 *0.0036*	0,13 0.0050
S12	218.20-100ER-ME05 MS2050	XOEX10T308R-M06 MS2050	0,050 *0.0020*	0,050 *0.0020*	0,060 *0.0024*	0,090 *0.0036*	0,13 0.0050
S13	218.20-100ER-ME05 MS2050	XOEX10T308R-M06 MS2050	0,046 *0.0018*	0,046 *0.0018*	0,050 *0.0020*	0,080 *0.0032*	0,11 0.0044
H11	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MP1501	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,11 *0.0044*	0,15 0.0060
H12	218.20-100ER-M05 F25M	XOMX10T308TR-M09 MP1501	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,085 *0.0034*	0,12 0.0048

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.24-100 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	230	260	315	365	390	210	235	285	330	355	170	190	230	270	285	255	285	340	405	425
	750	*850*	*1025*	*1200*	*1275*	*690*	*770*	*940*	*1075*	*1175*	*560*	*620*	*750*	*890*	*940*	*840*	*940*	*1125*	*1325*	*1400*
P2	225	255	305	355	380	205	230	280	325	345	165	185	225	260	280	245	280	330	385	410
	740	*840*	*1000*	*1175*	*1250*	*670*	*750*	*920*	*1075*	*1125*	*540*	*610*	*740*	*850*	*920*	*800*	*920*	*1075*	*1275*	*1350*
P3	195	220	265	310	330	180	200	240	280	300	145	165	195	230	245	210	240	290	335	360
	640	*720*	*870*	*1025*	*1075*	*590*	*660*	*790*	*920*	*980*	*475*	*540*	*640*	*750*	*800*	*690*	*790*	*950*	*1100*	*1175*
P4	170	195	230	275	290	155	175	210	250	265	125	145	170	200	215	190	215	255	295	320
	560	*640*	*750*	*900*	*950*	*510*	*570*	*690*	*820*	*870*	*410*	*475*	*560*	*660*	*710*	*620*	*710*	*840*	*970*	*1050*
P5	165	190	225	265	285	150	170	205	240	255	125	140	165	195	210	180	205	245	285	305
	540	*620*	*740*	*870*	*940*	*490*	*560*	*670*	*790*	*840*	*410*	*460*	*540*	*640*	*690*	*590*	*670*	*800*	*940*	*1000*
P6	185	210	255	295	315	170	190	230	270	290	140	155	185	220	235	205	230	275	325	340
	610	*690*	*840*	*970*	*1025*	*560*	*620*	*750*	*890*	*950*	*460*	*510*	*610*	*720*	*770*	*670*	*750*	*900*	*1075*	*1125*
P7	175	200	240	280	300	160	180	220	255	270	130	145	175	205	220	190	215	255	305	325
	570	*660*	*790*	*920*	*980*	*520*	*590*	*720*	*840*	*890*	*425*	*475*	*570*	*670*	*720*	*620*	*710*	*840*	*1000*	*1075*
P8	165	185	220	260	275	150	170	200	235	250	120	135	165	190	205	180	200	245	285	300
	540	*610*	*720*	*850*	*900*	*490*	*560*	*660*	*770*	*820*	*395*	*445*	*540*	*620*	*670*	*590*	*660*	*800*	*940*	*980*
P11	170	195	235	270	290	155	175	210	250	265	125	145	170	200	215	185	210	250	295	315
	560	*640*	*770*	*890*	*950*	*510*	*570*	*690*	*820*	*870*	*410*	*475*	*560*	*660*	*710*	*610*	*690*	*820*	*970*	*1025*
P12	110	125	145	175	185	100	115	135	160	170	80	90	110	130	135	120	135	160	185	200
	360	*410*	*475*	*570*	*610*	*330*	*375*	*445*	*520*	*560*	*260*	*295*	*360*	*425*	*445*	*395*	*445*	*520*	*610*	*660*
M1	—	—	—	—	—	165	185	225	260	280	140	160	195	225	240	200	225	265	310	330
	—	—	—	—	—	*540*	*610*	*740*	*850*	*920*	*460*	*520*	*640*	*740*	*790*	*660*	*740*	*870*	*1025*	*1075*
M2	—	—	—	—	—	135	155	185	215	230	120	135	160	185	200	165	185	220	255	275
	—	—	—	—	—	*445*	*510*	*610*	*710*	*750*	*395*	*445*	*520*	*610*	*660*	*540*	*610*	*720*	*840*	*900*
M3	—	—	—	—	—	110	120	145	175	185	95	105	125	150	160	130	145	175	205	215
	—	—	—	—	—	*360*	*395*	*475*	*570*	*610*	*310*	*345*	*410*	*490*	*520*	*425*	*475*	*570*	*670*	*710*
M4	—	—	—	—	—	85	95	115	135	140	75	80	95	115	120	100	110	135	155	170
	—	—	—	—	—	*280*	*310*	*375*	*445*	*460*	*245*	*260*	*310*	*375*	*395*	*330*	*360*	*445*	*510*	*560*
M5	—	—	—	—	—	70	80	95	110	120	60	70	80	95	100	85	95	110	130	140
	—	—	—	—	—	*230*	*260*	*310*	*360*	*395*	*195*	*230*	*260*	*310*	*330*	*280*	*310*	*360*	*425*	*460*
K1	180	200	240	280	300	160	185	220	255	275	—	—	—	—	—	—	—	—	—	—
	590	*660*	*790*	*920*	*980*	*520*	*610*	*720*	*840*	*900*	—	—	—	—	—	—	—	—	—	—
K2	160	180	215	250	270	145	165	195	230	245	—	—	—	—	—	—	—	—	—	—
	520	*590*	*710*	*820*	*890*	*475*	*540*	*640*	*750*	*800*	—	—	—	—	—	—	—	—	—	—
K3	135	150	180	215	225	120	140	165	195	205	—	—	—	—	—	—	—	—	—	—
	445	*490*	*590*	*710*	*740*	*395*	*460*	*540*	*640*	*670*	—	—	—	—	—	—	—	—	—	—
K4	130	145	175	205	215	115	130	160	185	195	—	—	—	—	—	—	—	—	—	—
	425	*475*	*570*	*670*	*710*	*375*	*425*	*520*	*610*	*640*	—	—	—	—	—	—	—	—	—	—
K5	80	90	105	125	130	70	80	95	110	120	—	—	—	—	—	—	—	—	—	—
	260	*295*	*345*	*410*	*425*	*230*	*260*	*310*	*360*	*395*	—	—	—	—	—	—	—	—	—	—
K6	115	125	155	180	190	100	115	140	165	175	—	—	—	—	—	—	—	—	—	—
	375	*410*	*510*	*590*	*620*	*330*	*375*	*460*	*540*	*570*	—	—	—	—	—	—	—	—	—	—
K7	100	115	135	155	170	90	105	120	145	155	—	—	—	—	—	—	—	—	—	—
	330	*375*	*445*	*510*	*560*	*295*	*345*	*395*	*475*	*510*	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	1200	1350	1650	1925	2025	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*3925*	*4425*	*5425*	*6325*	*6650*	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	480	540	660	780	820	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*1575*	*1775*	*2175*	*2550*	*2700*	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	320	360	440	520	550	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*1050*	*1175*	*1450*	*1700*	*1800*	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	370	415	510	590	630	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*1225*	*1350*	*1675*	*1925*	*2075*	—	—	—	—	—	—	—	—	—	—
S1	43	48	60	70	75	39	44	55	60	65	22	25	30	35	37	47	50	60	75	80
	140	*155*	*195*	*230*	*245*	*130*	*145*	*180*	*195*	*215*	*70*	*80*	*100*	*115*	*120*	*155*	*165*	*195*	*245*	*260*
S2	35	39	47	55	60	32	35	42	50	55	18	20	24	28	30	37	42	50	60	65
	115	*130*	*155*	*180*	*195*	*105*	*115*	*140*	*165*	*180*	*60*	*65*	*80*	*90*	*100*	*120*	*140*	*165*	*195*	*215*
S3	31	34	41	48	50	28	31	37	43	46	16	18	21	25	26	33	37	43	50	55
	100	*110*	*135*	*155*	*165*	*90*	*100*	*120*	*140*	*150*	*50*	*60*	*70*	*80*	*85*	*110*	*120*	*140*	*165*	*180*
S11	60	70	80	95	100	55	60	75	85	95	31	35	42	49	55	65	75	85	105	110
	195	*230*	*260*	*310*	*330*	*180*	*195*	*245*	*280*	*310*	*100*	*115*	*140*	*160*	*180*	*215*	*245*	*280*	*345*	*360*
S12	42	47	55	65	70	38	43	50	60	65	29	32	39	46	49	46	50	60	70	75
	140	*155*	*180*	*215*	*230*	*125*	*140*	*165*	*195*	*215*	*95*	*105*	*130*	*150*	*160*	*150*	*165*	*195*	*230*	*245*
S13	24	27	33	39	41	22	25	30	35	37	17	19	22	26	28	26	29	35	41	44
	80	*90*	*110*	*130*	*135*	*70*	*80*	*100*	*115*	*120*	*55*	*60*	*70*	*85*	*90*	*85*	*95*	*115*	*135*	*145*
H11	47	55	60	75	80	43	48	55	65	70	—	—	—	—	—	—	—	—	—	—
	155	*180*	*195*	*245*	*260*	*140*	*155*	*180*	*215*	*230*	—	—	—	—	—	—	—	—	—	—
H12	70	80	90	110	115	65	70	85	100	105	—	—	—	—	—	—	—	—	—	—
	230	*260*	*295*	*360*	*375*	*215*	*230*	*280*	*330*	*345*	—	—	—	—	—	—	—	—	—	—

R218.24-125 – Insert selection – mm/*Inch*

SMG			f_z				
			100%	70%	30%	10%	5%
P1	218.20-125ER-ME07 F40M	XOMX10T308TR-ME07 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P2	218.20-125ER-ME07 F40M	XOMX10T308TR-ME07 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
P3	218.20-125ER-ME07 F40M	XOMX10T308TR-ME07 MP2501	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P4	218.20-125ER-ME07 F40M	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,095 *0.0038*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P5	218.20-125ER-M07 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P6	218.20-125ER-M07 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P7	218.20-125ER-M07 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P8	218.20-125ER-M07 F40M	XOMX10T308TR-M09 MP2501	0,095 *0.0038*	0,095 *0.0038*	0,11 *0.0044*	0,17 *0.0065*	0,24 0.0095
P11	218.20-125ER-M07 F40M	XOMX10T308TR-M09 MP2501	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
P12	218.20-125ER-M07 F40M	XOMX10T308TR-M09 MP2501	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,11 *0.0044*	0,15 0.0060
M1	218.20-125ER-ME07 F40M	XOEX10T308R-M06 F40M	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
M2	218.20-125ER-ME07 F40M	XOEX10T308R-M06 F40M	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
M3	218.20-125ER-ME07 F40M	XOEX10T308R-M06 F40M	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*	0,18 0.0070
M4	218.20-125ER-M07 F40M	XOEX10T308R-M06 T350M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
M5	218.20-125ER-M07 F40M	XOEX10T308R-M06 T350M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
K1	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,10 *0.0040*	0,10 *0.0040*	0,11 *0.0044*	0,18 *0.0070*	0,25 0.010
K2	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K3	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K4	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K5	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,14 *0.0055*	0,20 0.0080
K6	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,090 *0.0036*	0,090 *0.0036*	0,10 *0.0040*	0,16 *0.0065*	0,22 0.0085
K7	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MK2050	0,080 *0.0032*	0,080 *0.0032*	0,095 *0.0038*	0,14 *0.0055*	0,20 0.0080
N1	218.20-125ER-ME07 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N2	218.20-125ER-ME07 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N3	218.20-125ER-ME07 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
N11	218.20-125ER-ME07 F40M	XOEX10T308FR-E05 H15	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,32 0.013
S1	218.20-125ER-ME07 F40M	XOEX10T308R-M06 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
S2	218.20-125ER-ME07 F40M	XOEX10T308R-M06 F40M	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
S3	218.20-125ER-ME07 F40M	XOEX10T308R-M06 F40M	0,060 *0.0024*	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*	0,14 0.0055
S11	218.20-125ER-ME07 MS2050	XOEX10T308R-M06 MS2050	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*	0,18 0.0070
S12	218.20-125ER-ME07 MS2050	XOEX10T308R-M06 MS2050	0,075 *0.0030*	0,075 *0.0030*	0,080 *0.0032*	0,13 *0.0050*	0,18 0.0070
S13	218.20-125ER-ME07 MS2050	XOEX10T308R-M06 MS2050	0,065 *0.0026*	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*	0,16 0.0065
H11	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MP1501	0,060 *0.0024*	0,060 *0.0024*	0,070 *0.0028*	0,11 *0.0044*	0,15 0.0060
H12	218.20-125ER-M07 F25M	XOMX10T308TR-M09 MP1501	0,048 *0.0019*	0,048 *0.0019*	0,055 *0.0022*	0,085 *0.0034*	0,12 0.0048

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R218.24-125 – Cutting data v_c = (m/min)/*(sf/min)*

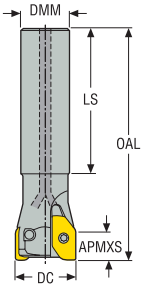
SMG	F25M					F40M					MM4500					MS2050				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
P1	230	260	310	365	390	225	250	305	360	380	180	205	245	290	310	245	275	335	395	420
	750	*850*	*1025*	*1200*	*1275*	*740*	*820*	*1000*	*1175*	*1250*	*590*	*670*	*800*	*950*	*1025*	*800*	*900*	*1100*	*1300*	*1375*
P2	225	250	300	350	375	220	245	295	345	365	175	200	240	280	300	240	270	325	380	405
	740	*820*	*980*	*1150*	*1225*	*720*	*800*	*970*	*1125*	*1200*	*570*	*660*	*790*	*920*	*980*	*790*	*890*	*1075*	*1250*	*1325*
P3	195	220	260	305	325	190	215	255	300	320	155	175	205	245	260	210	235	280	330	350
	640	*720*	*850*	*1000*	*1075*	*620*	*710*	*840*	*980*	*1050*	*510*	*570*	*670*	*800*	*850*	*690*	*770*	*920*	*1075*	*1150*
P4	170	190	235	275	295	165	190	230	270	285	135	155	185	215	230	185	205	250	295	315
	560	*620*	*770*	*900*	*970*	*540*	*620*	*750*	*890*	*940*	*445*	*510*	*610*	*710*	*750*	*610*	*670*	*820*	*970*	*1025*
P5	165	185	225	260	280	160	180	220	255	275	130	150	175	205	220	180	200	240	280	300
	540	*610*	*740*	*850*	*920*	*520*	*590*	*720*	*840*	*900*	*425*	*490*	*570*	*670*	*720*	*590*	*660*	*790*	*920*	*980*
P6	185	210	250	295	315	180	205	245	285	305	145	165	200	235	250	200	225	270	315	340
	610	*690*	*820*	*970*	*1025*	*590*	*670*	*800*	*940*	*1000*	*475*	*540*	*660*	*770*	*820*	*660*	*740*	*890*	*1025*	*1125*
P7	175	195	235	275	295	170	195	230	270	290	140	155	190	220	235	190	210	255	300	320
	570	*640*	*770*	*900*	*970*	*560*	*640*	*750*	*890*	*950*	*460*	*510*	*620*	*720*	*770*	*620*	*690*	*840*	*980*	*1050*
P8	165	185	220	260	275	160	180	215	250	270	130	145	175	205	215	175	200	235	275	295
	540	*610*	*720*	*850*	*900*	*520*	*590*	*710*	*820*	*890*	*425*	*475*	*570*	*670*	*710*	*570*	*660*	*770*	*900*	*970*
P11	170	190	230	270	290	165	190	225	265	280	135	150	180	215	230	185	205	250	290	310
	560	*620*	*750*	*890*	*950*	*540*	*620*	*740*	*870*	*920*	*445*	*490*	*590*	*710*	*750*	*610*	*670*	*820*	*950*	*1025*
P12	110	125	145	170	185	110	120	145	170	180	85	100	115	135	145	120	135	155	185	200
	360	*410*	*475*	*560*	*610*	*360*	*395*	*475*	*560*	*590*	*280*	*330*	*375*	*445*	*475*	*395*	*445*	*510*	*610*	*660*
M1	—	—	—	—	—	175	200	240	275	295	150	170	205	240	255	195	215	260	305	325
	—	—	—	—	—	*570*	*660*	*790*	*900*	*970*	*490*	*560*	*670*	*790*	*840*	*640*	*710*	*850*	*1000*	*1075*
M2	—	—	—	—	—	145	165	195	230	245	125	140	170	200	210	160	180	215	255	270
	—	—	—	—	—	*475*	*540*	*640*	*750*	*800*	*410*	*460*	*560*	*660*	*690*	*520*	*590*	*710*	*840*	*890*
M3	—	—	—	—	—	115	130	155	185	195	100	110	135	160	170	130	145	170	200	215
	—	—	—	—	—	*375*	*425*	*510*	*610*	*640*	*330*	*360*	*445*	*520*	*560*	*425*	*475*	*560*	*660*	*710*
M4	—	—	—	—	—	90	100	120	140	150	80	85	105	125	130	100	110	135	155	165
	—	—	—	—	—	*295*	*330*	*395*	*460*	*490*	*260*	*280*	*345*	*410*	*425*	*330*	*360*	*445*	*510*	*540*
M5	—	—	—	—	—	75	85	100	120	125	65	70	85	100	110	85	90	110	130	140
	—	—	—	—	—	*245*	*280*	*330*	*395*	*410*	*215*	*230*	*280*	*330*	*360*	*280*	*295*	*360*	*425*	*460*
K1	175	200	240	280	300	175	195	235	275	290	—	—	—	—	—	—	—	—	—	—
	570	*660*	*790*	*920*	*980*	*570*	*640*	*770*	*900*	*950*	—	—	—	—	—	—	—	—	—	—
K2	155	175	210	250	265	155	175	210	245	260	—	—	—	—	—	—	—	—	—	—
	510	*570*	*690*	*820*	*870*	*510*	*570*	*690*	*800*	*850*	—	—	—	—	—	—	—	—	—	—
K3	135	150	180	210	225	130	145	175	205	220	—	—	—	—	—	—	—	—	—	—
	445	*490*	*590*	*690*	*740*	*425*	*475*	*570*	*670*	*720*	—	—	—	—	—	—	—	—	—	—
K4	125	145	170	200	215	125	140	170	195	210	—	—	—	—	—	—	—	—	—	—
	410	*475*	*560*	*660*	*710*	*410*	*460*	*560*	*640*	*690*	—	—	—	—	—	—	—	—	—	—
K5	80	85	105	125	130	75	85	100	120	130	—	—	—	—	—	—	—	—	—	—
	260	*280*	*345*	*410*	*425*	*245*	*280*	*330*	*395*	*425*	—	—	—	—	—	—	—	—	—	—
K6	110	125	150	175	190	110	125	150	175	185	—	—	—	—	—	—	—	—	—	—
	360	*410*	*490*	*570*	*620*	*360*	*410*	*490*	*570*	*610*	—	—	—	—	—	—	—	—	—	—
K7	100	110	130	155	165	95	110	130	155	165	—	—	—	—	—	—	—	—	—	—
	330	*360*	*425*	*510*	*540*	*310*	*360*	*425*	*510*	*540*	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	1275	1425	1750	2050	2175	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*4175*	*4675*	*5750*	*6725*	*7125*	—	—	—	—	—	—	—	—	—	—
N2	—	—	—	—	—	520	580	710	830	880	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*1700*	*1900*	*2325*	*2725*	*2875*	—	—	—	—	—	—	—	—	—	—
N3	—	—	—	—	—	345	385	470	550	580	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*1125*	*1275*	*1550*	*1800*	*1900*	—	—	—	—	—	—	—	—	—	—
N11	—	—	—	—	—	395	440	540	630	670	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	*1300*	*1450*	*1775*	*2075*	*2200*	—	—	—	—	—	—	—	—	—	—
S1	43	48	60	70	70	42	47	55	65	70	24	27	32	38	40	46	50	60	75	75
	140	*155*	*195*	*230*	*230*	*140*	*155*	*180*	*215*	*230*	*80*	*90*	*105*	*125*	*130*	*150*	*165*	*195*	*245*	*245*
S2	35	39	46	55	60	34	38	45	55	55	19	21	26	30	32	37	42	50	60	60
	115	*130*	*150*	*180*	*195*	*110*	*125*	*150*	*180*	*180*	*60*	*70*	*85*	*100*	*105*	*120*	*140*	*165*	*195*	*195*
S3	30	34	41	48	50	30	33	40	47	50	17	19	22	27	28	33	36	44	50	55
	100	*110*	*135*	*155*	*165*	*100*	*110*	*130*	*155*	*165*	*55*	*60*	*70*	*90*	*90*	*110*	*120*	*145*	*165*	*180*
S11	60	65	80	95	100	60	65	80	95	100	33	37	45	50	55	65	70	85	100	110
	195	*215*	*260*	*310*	*330*	*195*	*215*	*260*	*310*	*330*	*110*	*120*	*150*	*165*	*180*	*215*	*230*	*280*	*330*	*360*
S12	42	47	55	65	70	41	45	55	65	70	31	34	41	48	50	45	50	60	70	75
	140	*155*	*180*	*215*	*230*	*135*	*150*	*180*	*215*	*230*	*100*	*110*	*135*	*155*	*165*	*150*	*165*	*195*	*230*	*245*
S13	24	27	32	38	40	24	26	32	37	39	18	20	24	28	30	26	29	35	41	43
	80	*90*	*105*	*125*	*130*	*80*	*85*	*105*	*120*	*130*	*60*	*65*	*80*	*90*	*100*	*85*	*95*	*115*	*135*	*140*
H11	47	50	60	75	80	46	50	60	70	75	—	—	—	—	—	—	—	—	—	—
	155	*165*	*195*	*245*	*260*	*150*	*165*	*195*	*230*	*245*	—	—	—	—	—	—	—	—	—	—
H12	70	75	90	105	115	65	75	90	105	110	—	—	—	—	—	—	—	—	—	—
	230	*245*	*295*	*345*	*375*	*215*	*245*	*295*	*345*	*360*	—	—	—	—	—	—	—	—	—	—

R217/220.97-V22

Aluminium routers high productivity cutters are designed to provide optimal performance in slotting, square shoulder milling and pocketing operations in aluminum. These tools are specifically optimized to achieve high speed and high metal removal rates in aluminum.

- Cutter range 32-100mm (1.25 - 4 inch)
- Inserts VPGX2206
- Available in cylindrical, combimaster or for arbor mounting

R217.97-X08 – Metric



- For insert selection and cutting data recommendations, see page(s) 682
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm		mm	mm		kg	
R217.97-1616.0-X08.2A	03245364	Cylindrical	16,0	2	8,0	16,0	67,0	100,0	11,0	26,4	30,0	40000	0,2	XP..08..
R217.97-2020.0-X08.2A	03245365	Cylindrical	20,0	2	8,0	20,0	79,0	120,0	7,2	34,4	38,0	40000	0,3	XP..08..
R217.97-2525.0-X08.3A	03245366	Cylindrical	25,0	3	8,0	25,0	99,0	150,0	5,0	44,4	48,0	40000	0,6	XP..08..

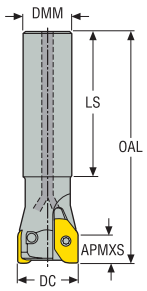
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-1616	C02505-T07P	T00-07P09	0.9NM
R217.97-2020	C02505-T07P	T00-07P09	0.9NM
R217.97-2525	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.97-X08 – Inch



- For insert selection and cutting data recommendations, see page(s) 682
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.97-0.62-0-X08.2A	03245370	Cylindrical	0.625	2	0.315	0.625	2.638	3.937	11,2	1.028	1.171	40000	0.440	XP..08..
R217.97-0.75-0-X08.2A	03245371	Cylindrical	0.750	2	0.315	0.750	3.110	4.724	7,8	1.280	1.421	40000	0.660	XP..08..
R217.97-1.00-0-X08.3A	03245372	Cylindrical	1.000	3	0.315	1.000	3.898	5.906	4,9	1.780	1.921	40000	1.320	XP..08..

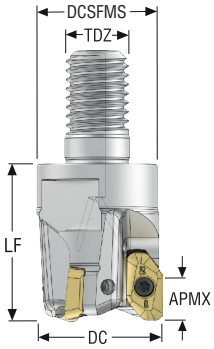
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-0.62	C02505-T07P	T00-07P09	8.0IN.LBS
R217.97-0.75	C02505-T07P	T00-07P09	8.0IN.LBS
R217.97-1.00	C02506-T07P	T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.97-X08 – Metric



- For insert selection and cutting data recommendations, see page(s) 682
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm		mm	mm		mm	mm		kg	
R217.97-0816.RE-X08.2A	03245589	Combimaster	16,0	2	8,0	M8	13,5	23,0	11,0	26,4	30,0	40000	0,1	XP..08..
R217.97-1020.RE-X08.2A	03245362	Combimaster	20,0	2	8,0	M10	18,5	28,0	7,2	34,4	38,0	40000	0,1	XP..08..
R217.97-1020.RE-X08.3A	03308725	Combimaster	20,0	3	8,0	M10	18,5	28,0	7,2	34,4	38,0	40000	0,1	XP..08..
R217.97-1225.RE-X08.3A	03245363	Combimaster	25,0	3	8,0	M12	23,0	30,0	5,0	44,4	48,0	40000	0,1	XP..08..
R217.97-1225.RE-X08.4A	03308726	Combimaster	25,0	4	8,0	M12	23,0	30,0	5,0	44,4	48,0	40000	0,1	XP..08..

For Combimaster Shanks, see Machining Navigator Tooling System

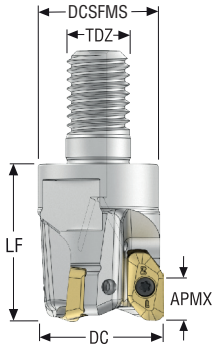
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-0816-1020	C02505-T07P	T00-07P09	0.9NM
R217.97-1225	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.97-X08 – Inch



- For insert selection and cutting data recommendations, see page(s) 682
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch		Inch	Inch		lbs	
R217.97-0.62-08RE-X08.2A	03245367	Combimaster	0.625	2	0.315	M8	0.531	0.906	11,2	1.028	1.171	40000	0.220	XP..08..
R217.97-0.75-10RE-X08.2A	03245368	Combimaster	0.750	2	0.315	M10	0.728	1.102	7,8	1.280	1.421	40000	0.220	XP..08..
R217.97-1.00-12RE-X08.3A	03245369	Combimaster	1.000	3	0.315	M12	0.906	1.181	4,9	1.780	1.921	40000	0.220	XP..08..

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

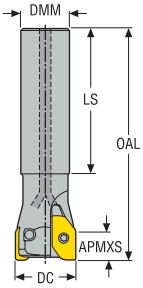
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-0.62-0.75	C02505-T07P	T00-07P09	8.0IN.LBS
R217.97-1.00	C02506-T07P	T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217.97-X12 – Metric



- For insert selection and cutting data recommendations, see page(s) 683
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.97-2525.0-X12.2A	02450300	Cylindrical	25,0	2	12,0	25,0	95,0	150,0	54,5	10,0	40,0	49,0	40000	0,5	XP..12
R217.97-3232.0-X12.2A	02450301	Cylindrical	32,0	2	12,0	32,0	85,0	150,0	64,5	8,0	54,0	63,0	40000	0,8	XP..12
R217.97-3232.0-X12.3A	02450302	Cylindrical	32,0	3	12,0	32,0	85,0	150,0	64,5	8,0	54,0	63,0	40000	0,8	XP..12

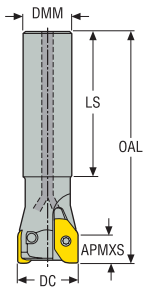
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-..Ø25	C03508-T10P	T00-10P30	3.0NM
R217.97-..Ø32	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.97-X12 – Inch



- For insert selection and cutting data recommendations, see page(s) 683
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.97-01.00-0-12.2A	02450377	Cylindrical	1.000	2	0.472	1.000	3.799	6.000	2.165	10,0	1.606	1.961	40000	1.320	XP..12
R217.97-01.25-0-12.3A	02450387	Cylindrical	1.250	3	0.472	1.250	3.346	5.946	2.559	8,0	2.106	2.461	35000	1.760	XP..12

Spare Parts

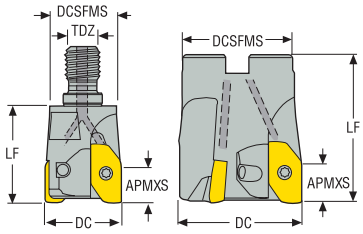
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-01.00	C03508-T10P	T00-10P30	26.6IN.LBS
R217.97-01.25	C03509-T10P	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217/220.97-X12 – Metric



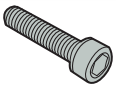
- For insert selection and cutting data recommendations, see page(s) 683
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm		mm	mm		mm	mm		kg	
R217.97-1225.RE-X12.2A	02449582	Combimaster	25,0	2	12,0	M12	23,0	30,0	10,0	40,0	49,0	40000	0,1	XP..12
R217.97-1632.RE-X12.2A	02450297	Combimaster	32,0	2	12,0	M16	30,0	40,0	8,0	54,0	63,0	40000	0,2	XP..12
R217.97-1632.RE-X12.3A	02450299	Combimaster	32,0	3	12,0	M16	30,0	40,0	8,0	54,0	63,0	40000	0,2	XP..12
R217.97-1640.RE-X12.3A	02486599	Combimaster	40,0	3	12,0	M16	30,0	40,0	6,0	70,0	79,0	35000	0,3	XP..12
R217.97-2040.RE-X12.3A	02928076	Combimaster	40,0	3	12,0	M20	36,5	40,0	6,0	70,0	79,0	35000	0,3	XP..12
R220.97-0050-X12.4A	02450306	Arbor	50,0	4	12,0	–	47,0	45,0	5,0	90,0	99,0	30000	0,4	XP..12

For Combimaster Shanks, see Machining Navigator Tooling System

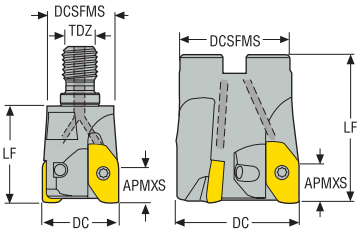
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.97-.. Ø25	–	C03508-T10P	T00-10P30	3.0NM
R217.97-.. Ø32-40	–	C03509-T10P	T00-10P30	3.0NM
R220.97-0050	220.17-692	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.97-X12 – Inch



- For insert selection and cutting data recommendations, see page(s) 683
- For complete insert programme, see page(s) 784
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch		Inch	Inch		lbs	
R217.97-1.00-12RE-12.2A	02450374	Combimaster	1.000	2	0.472	M12	0.906	1.181	10,0	1.606	1.961	40000	0.220	XP..12
R217.97-1.25-16RE-12.3A	02450376	Combimaster	1.250	3	0.472	M16	1.181	1.575	8,0	2.106	2.461	40000	0.440	XP..12
R217.97-01.50-20RE-12.3A	02928061	Combimaster	1.500	3	0.472	M20	1.437	1.575	6,0	2.606	2.961	35000	0.660	XP..12
R217.97-1.50-16RE-12.3A	02520346	Combimaster	1.500	3	0.472	M16	1.181	1.575	6,0	2.606	2.961	35000	0.660	XP..12
R220.97-02.00-12.3A	02534482	Arbor	2.000	3	0.472	–	1.850	1.772	5,0	3.606	3.961	30000	0.880	XP..12
R220.97-02.00-12.4A	02450395	Arbor	2.000	4	0.472	–	1.850	1.772	5,0	3.606	3.961	30000	0.880	XP..12

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

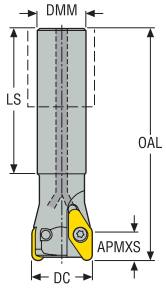
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.97-01.00	–	C03508-T10P	T00-10P30	26.6IN.LBS
R217.97-01.25-01.50	–	C03509-T10P	T00-10P30	26.6IN.LBS
R220.97-..	UC6S3/8UNFX1	C03509-T10P	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217.97-V22 – Metric



- For insert selection and cutting data recommendations, see page(s) 684
- For complete insert programme, see page(s) 771
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm	mm	mm	mm	mm		mm	mm		kg	
R217.97-2532.0-V22.2A	00035425	Cylindrical	32,0	2	14,0	25,0	75,0	120,0	64,0	15,0	56,0	62,0	40000	0,4	
R217.97-3240.0-V22.2A	00035427	Cylindrical	40,0	2	14,0	32,0	105,0	150,0	90,0	10,0	72,0	78,0	35000	0,9	

Spare Parts

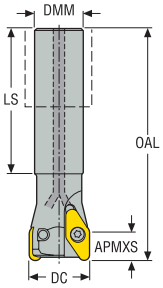
For cutter	Insert screw
R217.97-..	C05010-T20P

Accessories

Torque key	Torque value
T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.97-V22 – Inch



- For insert selection and cutting data recommendations, see page(s) 684
- For complete insert programme, see page(s) 771
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	DMM	LS	OAL	LUX	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch	Inch		Inch	Inch		lbs	
R217.97-01.25-0-V22.2A	00054103	Cylindrical	1.250	2	0.551	1.000	4.000	6.000	3.795	10,0	2.185	2.421	40000	0.220	
R217.97-01.50-0-V22.2A	00054181	Cylindrical	1.500	2	0.551	1.250	4.000	6.000	3.638	10,0	2.685	2.921	35000	1.980	

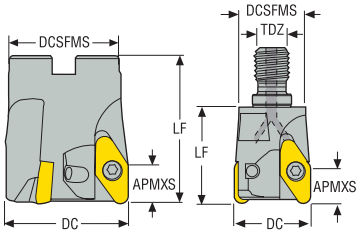
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.97-..	C05010-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.97-V22 – Metric



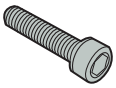
- For insert selection and cutting data recommendations, see page(s) 684
- For complete insert programme, see page(s) 771
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	Cmin	Cmax	RPMX	Weight	Insert
			mm		mm		mm	mm		mm	mm		kg	
R217.97-1632.RE-V22.2A	00035424	Combimaster	32,0	2	14,0	M16	30,0	40,0	15,0	56,0	62,0	40000	0,2	VPGX2206
R217.97-1640.RE-V22.2A	00035426	Combimaster	40,0	2	14,0	M16	30,0	40,0	10,0	72,0	78,0	35000	0,2	VPGX2206
R217.97-2040.RE-V22.2A	02928075	Combimaster	40,0	2	14,0	M20	36,5	45,0	10,0	72,0	78,0	35000	0,3	VPGX2206
R220.97-0050-V22.2A	00035392	Arbor	50,0	2	14,0	–	47,0	57,0	8,0	92,0	98,0	30000	0,5	VPGX2206
R220.97-0050-V22.3A	00035393	Arbor	50,0	3	14,0	–	47,0	57,0	8,0	92,0	98,0	30000	0,5	VPGX2206
R220.97-0063-V22.3A	00035394	Arbor	63,0	3	14,0	–	50,0	57,0	6,0	116,0	125,0	27000	0,6	VPGX2206
R220.97-0063-V22.4A	00035395	Arbor	63,0	4	14,0	–	50,0	57,0	6,0	116,0	125,0	27000	0,6	VPGX2206
R220.97-0080-V22.4A	00035396	Arbor	80,0	4	14,0	–	60,0	57,0	5,0	152,0	158,0	25000	1,0	VPGX2206
R220.97-0100-V22.5A	00035397	Arbor	100,0	5	14,0	–	77,0	57,0	4,0	192,0	198,0	22000	1,7	VPGX2206

For Combimaster Shanks, see Machining Navigator Tooling System

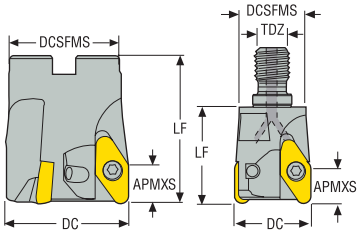
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.97-1632-1640	–	C05010-T20P	T00-20P50	5.0NM
R217.97-2040	–	C05010-T20P	T00-20P50	5.0NM
R220.97-0050	MC6S10X40	C05010-T20P	T00-20P50	5.0NM
R220.97-0063	MC6S12X35	C05013-T20P	T00-20P50	5.0NM
R220.97-0080	220.17-694	C05013-T20P	T00-20P50	5.0NM
R220.97-0100	220.17-694	C05013-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.97-V22 – Inch



- For insert selection and cutting data recommendations, see page(s) 684
- For complete insert programme, see page(s) 771
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	TDZ	DCSFMS	LF	RMPX°	C min	C max	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch		Inch	Inch		lbs	
R217.97-1.25-16REV22.2A	00054077	Combimaster	1.250	2	0.551	M16	1.181	1.600	10,0	2.185	2.421	40000	0.660	VPGX2206
R217.97-1.50-16REV22.2A	00054146	Combimaster	1.500	2	0.551	M16	1.181	1.600	10,0	2.685	2.921	35000	0.880	VPGX2206
R217.97-01.50-20RE-V22.2A	02928060	Combimaster	1.500	2	0.551	M20	1.437	1.772	10,0	2.685	2.921	35000	0.660	VPGX2206
R220.97-02.00-V22.2A	00054269	Arbor	2.000	2	0.551	–	1.850	2.250	8,0	3.685	3.921	30000	1.540	VPGX2206
R220.97-02.00-V22.3A	00054587	Arbor	2.000	3	0.551	–	1.850	2.250	8,0	3.685	3.921	30000	1.320	VPGX2206
R220.97-02.50-V22.4A	00055249	Arbor	2.500	4	0.551	–	2.047	2.250	6,0	4.685	4.921	27000	1.980	VPGX2206
R220.97-03.00-V22.4A	00050756	Arbor	3.000	4	0.551	–	2.441	2.250	5,0	5.685	5.921	25000	2.870	VPGX2206
R220.97-04.00-V22.5A	00050828	Arbor	4.000	5	0.551	–	3.543	2.250	4,0	7.685	7.921	22000	4.850	VPGX2206

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.97-..	–	C05010-T20P	T00-20P50	44.3IN.LBS
R220.97-02.00	UC6S3/8UNFX11/2	C05010-T20P	T00-20P50	44.3IN.LBS
R220.97-02.50-03.00	UC6S1/2UNFX1-1/2	C05013-T20P	T00-20P50	44.3IN.LBS
R220.97-04.00	UC6S3/4UNFX1-1/4	C05013-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.97-X08 – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	70%	30%	10%	5%
N1	XPKX080304PDER-E06 H25	4,0 *0.16*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*	0,26 *0.010*
N2	XPKX080304PDER-E06 H25	4,0 *0.16*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*	0,26 *0.010*
N3	XPKX080304PDER-E06 H25	4,0 *0.16*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*	0,26 *0.010*
N11	XPKX080304PDER-E06 H25	4,0 *0.16*	0,11 *0.0044*	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*	0,26 *0.010*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217.97-XO08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	H25				
	100%	70%	30%	10%	5%
N1	2350 *7700*	2550 *8375*	3100 *10175*	3675 *12050*	3925 *12875*
N2	590 *1925*	640 *2100*	780 *2550*	920 *3025*	990 *3250*
N3	395 *1300*	430 *1400*	520 *1700*	620 *2025*	660 *2175*
N11	450 *1475*	490 *1600*	590 *1925*	700 *2300*	760 *2500*

R217/220.97-X12 – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	70%	30%	10%	5%
N1	XPKX12T304PDER-E08 H25	6,0 *0.24*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,30 *0.012*
N2	XPKX12T304PDER-E08 H25	6,0 *0.24*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,30 *0.012*
N3	XPKX12T304PDER-E08 H25	6,0 *0.24*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,30 *0.012*
N11	XPKX12T304PDER-E08 H25	6,0 *0.24*	0,13 *0.0050*	0,13 *0.0050*	0,14 *0.0055*	0,22 *0.0085*	0,30 *0.012*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.97-X12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	H25				
	100%	70%	30%	10%	5%
N1	2175 *7125*	2375 *7800*	2900 *9525*	3400 *11150*	3700 *12150*
N2	550 *1800*	600 *1975*	730 *2400*	860 *2825*	940 *3075*
N3	365 *1200*	400 *1300*	485 *1600*	570 *1875*	620 *2025*
N11	420 *1375*	455 *1500*	560 *1825*	650 *2125*	710 *2325*

R217/220.97-V22 – Insert selection – mm/*Inch*

SMG		a_p	f_z				
			100%	70%	30%	10%	5%
N1	VPGX220605ER-E10 H25	7,0 *0.28*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*	0,42 *0.017*
N2	VPGX220605ER-E10 H25	7,0 *0.28*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*	0,42 *0.017*
N3	VPGX220605ER-E10 H25	7,0 *0.28*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*	0,42 *0.017*
N11	VPGX220605ER-E10 H25	7,0 *0.28*	0,18 *0.0070*	0,18 *0.0070*	0,20 *0.0080*	0,30 *0.012*	0,42 *0.017*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.97-V22 – Cutting data v_c = (m/min)/*(sf/min)*

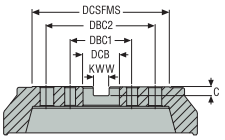
SMG	H15					H25				
	100%	70%	30%	10%	5%	100%	70%	30%	10%	5%
N1	2375 *7800*	2575 *8450*	3125 *10250*	3725 *12225*	4025 *13200*	2050 *6725*	2225 *7300*	2700 *8850*	3225 *10575*	3500 *11475*
N2	600 *1975*	650 *2125*	790 *2600*	940 *3075*	1025 *3375*	520 *1700*	560 *1825*	680 *2225*	810 *2650*	880 *2875*
N3	400 *1300*	435 *1425*	530 *1750*	630 *2075*	680 *2225*	345 *1125*	375 *1225*	455 *1500*	540 *1775*	590 *1925*
N11	455 *1500*	495 *1625*	600 *1975*	710 *2325*	770 *2525*	395 *1300*	425 *1400*	520 *1700*	620 *2025*	670 *2200*

Code keys metric and *inch*

R	217	.	79	-	18	20	.	0	-	10	A
1	2		3		4	5		6		7	8

R	217	.	79	-	01.50	-	3	-	08	3	A
1	2		3		4		5		6	7	8

1.	2.	3.
R = Right hand rotation Cx = For Seco-Capto	217 = With shank 220 = For arbor	Cutter system
4.	**5. (Not for inch designation)**	**6.**
Shank diameter (connecting thread diameter for Combimaster)	Cutter diameter	Shank type RE = Combimaster 0. = Cylindrical 3. = Weldon
7.	**8.**	
Insert size	A = With through coolant supply	



Dimensions in mm					
DCB	DCSFMS	DBC1	DBC2	KWW	C
16	30-35	–	–	8,4	5,6
22	42-47	–	–	10,4	6.3
27	48-62	–	–	12,4	7
32	60-90	–	–	14,4	8
40	90-130	66,7	–	16,4	9
60	130-270	101,6	177,8	25,7	14

Dimensions in inch					
DCB	DCSFMS	DBC1	DBC2	KWW	C
0.500	*1.181 - 1.378*			*0.258*	*0.165*
0.750	*1.378 - 1.850*	–	–	*0.321*	*0.193*
1.000	*1.803 - 2.441*	–	–	*0.382*	*0.224*
1.250	*2.250 - 3.031*	–	–	*0.508*	*0.287*
1.500	*2.750 - 3.543*	–	–	*0.630*	*0.382*
2.000	*4.331*	–	–	*0.756*	*0.445*
2.500	*5.118 - 6.299 (8.858)*	*4.000*	*(7.000)*	*1.000*	*0.551*

Selection – Metric

Insert	a_p max	Material suitability								
		P	M	K	N	S	H			
XO06	3,0	■	■	■	■	■	□	■	◪	■
XO10	6,0	■	■	■	■	■	□	■	■	■
XO12	7,0	■	■	■	■	■	□	◪	■	■
SCET	11,0	■	■	■	■	■	□	-	■	◪
	20,0									
	30,0									
	40,0									
XNEX08..L	7,0	■	■	■	■	■	□	■	■	■

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Metric

Insert	No. of cutting edges	Application	Cutter diameter (mm) available with effective number of teeth												See page
			12	16	20	25	32	40	50	63	80	100	125	160	
XO.X06	2		2	3											697
			3	4											
XO.X10	2				2										700
						3	4	5							
XO.X12	2						2	3	4						707
						2	3	4		5					
SCET12	4						2	3	4	5	6	7	8		714
												4			
													4		
														4	
XNEX08	6							3	4	5	6	7			691
									5	6	7	9			

x	x indicates number of teeth (first choice)
x	x indicates number of teeth

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

Selection – Inch

Insert	a_p max	Material suitability								
		P	M	K	N	S	H			
XO10	0.236	■	■	■	■	■	□	■	■	■
XO12	0.276	■	■	■	■	■	□	◪	■	■
SCET	0.433	■	■	■	■	■	□	-	■	◪
XNEX08..L	0.276	■	■	■	■	■	□	■	■	■

1st choice	■
Alternative choice	◪
Possible choice	□

High speed machine with low power/torque	
Strong stable machine with rigid connecion	
Not recommended	-

Unstable condition suitability	
Ramping ability	
Plunging ability	

Selection – Inch

Insert	No. of cutting edges	Application	Cutter diameter (mm) available with effective number of teeth								See page
			0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	
XO.X10	2		2								700
XO.X12	2										707
				2							
SCET12	4				2	3	4	5	6	7	714
XNEX08	6					3	4	6	7	9	691

x — x indicates number of teeth (first choice)

x — x indicates number of teeth

Troubleshooter for unstable fixturing and/or unstable conditions

Basic choice

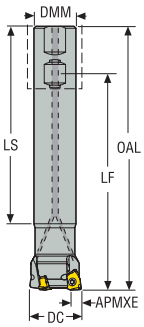
Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

Square 6 PLUNGE MILL

The Plunge Square 6 cutters are equipt with double sided inserts, means 6 cutting edges.

- Cutter range: 40-100 mm (1.5 - 4 inch)
- Max radial depth of cut 7 mm (.275 inch)
- Insert corner radii range 0.8-1.6 mm (.031 - .063 inch)

R217.79-08 – Inch



- For insert selection and cutting data recommendations, see page(s) 694-695
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch		lbs	
R217.79-01.50-3-08-3A	03058336	Weldon	1.500	3	0.276	1.250	5.906	7.874	11800	2.870	XNEX08..L

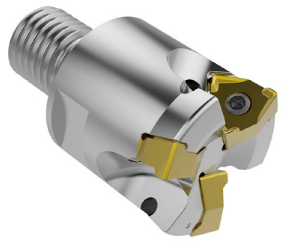
Spare Parts

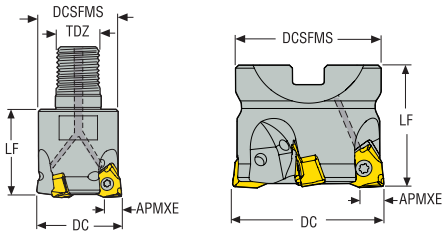
Accessories

For cutter	Insert screw	Torque key	Torque value
R217.79-01.50	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.79-08 – Metric





- For insert selection and cutting data recommendations, see page(s) 694-695
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm		mm	mm	kg		
R217.79-2040.RE-08-3A	03058302	Combimaster	40,0	3	7,0	–	M20	36,5	40,0	0,5	11800	XNEX08..L
R217.79-3240.3-08-3A	03058304	Weldon	40,0	3	7,0	–	–	–	164,0	1,3	11800	XNEX08..L
R220.79-0050-08-4A	03058315	Arbor	50,0	4	7,0	22,0	–	48,0	40,0	1,0	10600	XNEX08..L
R220.79-0050-08-5A	03058316	Arbor	50,0	5	7,0	22,0	–	48,0	40,0	0,5	10600	XNEX08..L
R220.79-0063-08-5A	03058317	Arbor	63,0	5	7,0	27,0	–	60,0	50,0	1,0	9400	XNEX08..L
R220.79-0063-08-6A	03058318	Arbor	63,0	6	7,0	27,0	–	60,0	50,0	1,0	9400	XNEX08..L
R220.79-0080-08-6A	03058319	Arbor	80,0	6	7,0	27,0	–	62,0	50,0	1,2	8400	XNEX08..L
R220.79-0080-08-7A	03058320	Arbor	80,0	7	7,0	27,0	–	62,0	50,0	1,2	8400	XNEX08..L
R220.79-0100-08-7A	03058321	Arbor	100,0	7	7,0	32,0	–	78,0	50,0	2,3	7500	XNEX08..L
R220.79-0100-08-9A	03058322	Arbor	100,0	9	7,0	32,0	–	78,0	50,0	1,9	7500	XNEX08..L

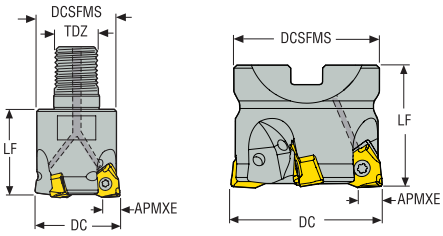
Spare Parts

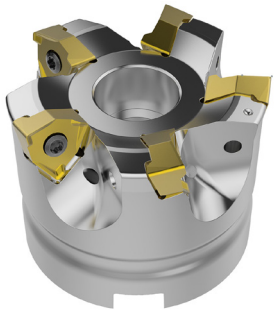
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.79-.. Ø40	–	C04011-T15P	T00-15P35	3.5NM
220.79-Ø50	220.17-696	C04011-T15P	T00-15P35	3.5NM
220.79-Ø63	MC6S12X35	C04011-T15P	T00-15P35	3.5NM
R220.79- Ø80-100	–	C04011-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.79-08 – Inch





- For insert selection and cutting data recommendations, see page(s) 694-695
- For complete insert programme, see page(s) 772
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch		Inch	Inch	lbs		
R217.79-01.50-20RE-08-3A	03058337	Combimaster	1.500	3	0.276	–	M20	1.378	1.575	0.880	11800	XNEX08..L
R220.79-02.00-08-4A	03058348	Arbor	2.000	4	0.276	0.750	–	1.850	1.575	1.100	10600	XNEX08..L
R220.79-02.50-08-6A	03058349	Arbor	2.500	6	0.276	1.000	–	2.250	1.969	2.200	9400	XNEX08..L
R220.79-03.00-08-7A	03058350	Arbor	3.000	7	0.276	1.000	–	2.441	1.969	2.650	8400	XNEX08..L
R220.79-04.00-08-9A	03058351	Arbor	4.000	9	0.276	1.500	–	3.500	1.969	4.410	7500	XNEX08..L

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R217.79-01.50	–	C04011-T15P	T00-15P35	31.0IN.LBS
R217.79-02.00	220.17-698	C04011-T15P	T00-15P35	31.0IN.LBS
R217.79-02.50-03.00	UC6S1/2UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS
R217.79-04.00	UC6S3/4UNFX1-1/4	C04011-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.79-08 – Insert selection – mm/*Inch*

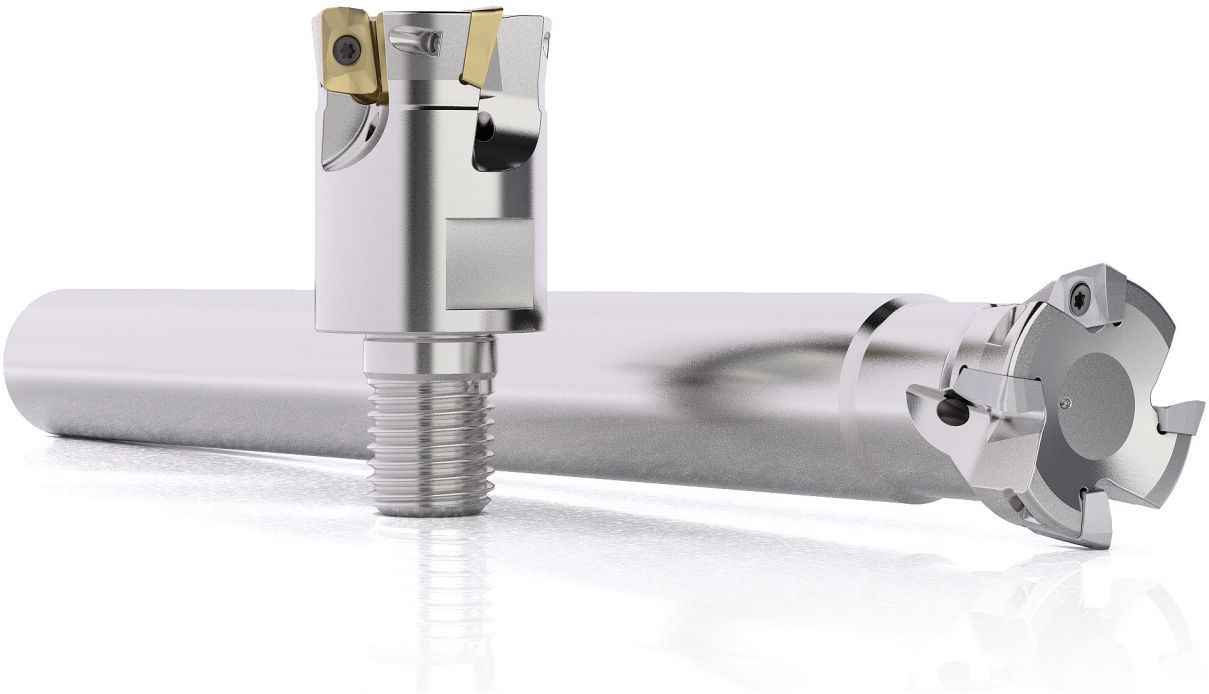
SMG		f_z	a_{so}			
			100%	70%	50%	30%
P1	XNEX080608TL-M13 MP2501	0,18 *0.0070*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P2	XNEX080608TL-M13 MP2501	0,19 *0.0075*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P3	XNEX080608TL-M13 MP2501	0,18 *0.0070*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P4	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P5	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P6	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P7	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P8	XNEX080608TL-M13 MP2501	0,18 *0.0070*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P11	XNEX080608TL-M13 T350M	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P12	XNEX080608TL-M13 T350M	0,11 *0.0044*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
M1	XNEX080608TL-M13 F40M	0,19 *0.0075*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
M2	XNEX080608TL-M13 F40M	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
M3	XNEX080608TL-M13 F40M	0,14 *0.0055*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
M4	XNEX080608TL-M13 T350M	0,12 *0.0048*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
M5	XNEX080608TL-M13 T350M	0,12 *0.0048*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
K1	XNEX080608TL-M13 MP2501	0,19 *0.0075*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K2	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K3	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K4	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K5	XNEX080608TL-M13 MP2501	0,15 *0.0060*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K6	XNEX080608TL-M13 MP2501	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K7	XNEX080608TL-M13 MP2501	0,15 *0.0060*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
S1	XNEX080608TL-M13 T350M	0,12 *0.0048*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S2	XNEX080608TL-M13 T350M	0,12 *0.0048*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S3	XNEX080608TL-M13 T350M	0,11 *0.0044*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S11	XNEX080608TL-M13 MS2050	0,14 *0.0055*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
S12	XNEX080608TL-M13 MS2050	0,14 *0.0055*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
S13	XNEX080608TL-M13 MS2050	0,12 *0.0048*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
H5	XNEX080608TL-M13 T350M	0,11 *0.0044*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
H8	XNEX080608TL-M13 T350M	0,090 *0.0036*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
H11	XNEX080608TL-M13 T350M	0,11 *0.0044*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
H12	XNEX080608TL-M13 T350M	0,090 *0.0036*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.79-08 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP2501				F40M				T350M				MS2050			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	225 *740*	250 *820*	265 *870*	285 *940*	170 *560*	190 *620*	200 *660*	215 *710*	195 *640*	220 *720*	230 *750*	250 *820*	190 *620*	210 *690*	220 *720*	240 *790*
P2	215 *710*	240 *790*	255 *840*	275 *900*	165 *540*	180 *590*	195 *640*	205 *670*	190 *620*	210 *690*	220 *720*	235 *770*	180 *590*	200 *660*	210 *690*	225 *740*
P3	190 *620*	210 *690*	225 *740*	240 *790*	145 *475*	160 *520*	170 *560*	180 *590*	165 *540*	185 *610*	195 *640*	210 *690*	155 *510*	175 *570*	185 *610*	200 *660*
P4	170 *560*	190 *620*	200 *660*	215 *710*	130 *425*	145 *475*	150 *490*	160 *520*	150 *490*	165 *540*	175 *570*	185 *610*	140 *460*	160 *520*	165 *540*	180 *590*
P5	160 *520*	180 *590*	190 *620*	205 *670*	125 *410*	135 *445*	145 *475*	155 *510*	140 *460*	155 *510*	165 *540*	180 *590*	135 *445*	150 *490*	160 *520*	170 *560*
P6	180 *590*	205 *670*	215 *710*	230 *750*	140 *460*	155 *510*	165 *540*	175 *570*	160 *520*	175 *570*	185 *610*	200 *660*	150 *490*	170 *560*	180 *590*	190 *620*
P7	170 *560*	190 *620*	205 *670*	215 *710*	130 *425*	145 *475*	155 *510*	165 *540*	150 *490*	165 *540*	175 *570*	190 *620*	145 *475*	160 *520*	170 *560*	180 *590*
P8	160 *520*	175 *570*	190 *620*	200 *660*	120 *395*	135 *445*	140 *460*	150 *490*	140 *460*	155 *510*	165 *540*	175 *570*	130 *425*	150 *490*	155 *510*	165 *540*
P11	165 *540*	185 *610*	195 *640*	210 *690*	125 *410*	140 *460*	150 *490*	160 *520*	145 *475*	160 *520*	170 *560*	185 *610*	140 *460*	155 *510*	165 *540*	175 *570*
P12	115 *375*	125 *410*	135 *445*	145 *475*	85 *280*	95 *310*	100 *330*	110 *360*	100 *330*	110 *360*	115 *375*	125 *410*	95 *310*	105 *345*	110 *360*	120 *395*
M1	155 *510*	175 *570*	185 *610*	195 *640*	130 *425*	145 *475*	155 *510*	165 *540*	145 *475*	160 *520*	170 *560*	185 *610*	145 *475*	160 *520*	170 *560*	185 *610*
M2	130 *425*	145 *475*	155 *510*	165 *540*	110 *360*	125 *410*	130 *425*	140 *460*	120 *395*	135 *445*	145 *475*	155 *510*	120 *395*	135 *445*	145 *475*	155 *510*
M3	105 *345*	120 *395*	125 *410*	135 *445*	90 *295*	100 *330*	105 *345*	115 *375*	100 *330*	110 *360*	115 *375*	125 *410*	100 *330*	110 *360*	115 *375*	125 *410*
M4	85 *280*	95 *310*	100 *330*	105 *345*	70 *230*	80 *260*	85 *280*	90 *295*	80 *260*	90 *295*	95 *310*	100 *330*	80 *260*	90 *295*	95 *310*	100 *330*
M5	70 *230*	80 *260*	85 *280*	90 *295*	60 *195*	65 *215*	70 *230*	75 *245*	65 *215*	75 *245*	75 *245*	85 *280*	65 *215*	75 *245*	75 *245*	85 *280*
K1	170 *560*	190 *620*	200 *660*	215 *710*	130 *425*	145 *475*	155 *510*	165 *540*	150 *490*	165 *540*	175 *570*	190 *620*	— —	— —	— —	— —
K2	155 *510*	170 *560*	180 *590*	195 *640*	115 *375*	130 *425*	135 *445*	145 *475*	135 *445*	150 *490*	160 *520*	170 *560*	— —	— —	— —	— —
K3	130 *425*	145 *475*	155 *510*	165 *540*	100 *330*	110 *360*	115 *375*	125 *410*	115 *375*	125 *410*	135 *445*	145 *475*	— —	— —	— —	— —
K4	125 *410*	140 *460*	145 *475*	155 *510*	95 *310*	105 *345*	110 *360*	120 *395*	110 *360*	120 *395*	130 *425*	135 *445*	— —	— —	— —	— —
K5	75 *245*	85 *280*	90 *295*	95 *310*	60 *195*	65 *215*	70 *230*	75 *245*	65 *215*	75 *245*	80 *260*	85 *280*	— —	— —	— —	— —
K6	110 *360*	120 *395*	130 *425*	140 *460*	85 *280*	90 *295*	100 *330*	105 *345*	95 *310*	105 *345*	110 *360*	120 *395*	— —	— —	— —	— —
K7	100 *330*	110 *360*	115 *375*	125 *410*	75 *245*	85 *280*	90 *295*	95 *310*	85 *280*	95 *310*	100 *330*	110 *360*	— —	— —	— —	— —
S1	— —	— —	— —	— —	33 *110*	37 *120*	39 *130*	42 *140*	37 *120*	41 *135*	43 *140*	47 *155*	37 *120*	41 *135*	43 *140*	47 *155*
S2	— —	— —	— —	— —	27 *90*	30 *100*	32 *105*	34 *110*	29 *95*	33 *110*	35 *115*	38 *125*	29 *95*	33 *110*	35 *115*	38 *125*
S3	— —	— —	— —	— —	24 *80*	26 *85*	28 *90*	30 *100*	26 *85*	29 *95*	31 *100*	33 *110*	26 *85*	29 *95*	31 *100*	33 *110*
S11	— —	— —	— —	— —	46 *150*	50 *165*	55 *180*	60 *195*	50 *165*	55 *180*	60 *195*	65 *215*	50 *165*	55 *180*	60 *195*	65 *215*
S12	— —	— —	— —	— —	32 *105*	35 *115*	37 *120*	40 *130*	35 *115*	39 *130*	41 *135*	44 *145*	35 *115*	39 *130*	41 *135*	44 *145*
S13	— —	— —	— —	— —	19 *60*	21 *70*	22 *70*	24 *80*	21 *70*	23 *75*	24 *80*	26 *85*	21 *70*	23 *75*	24 *80*	26 *85*
H5	— —	— —	— —	— —	29 *95*	32 *105*	34 *110*	36 *120*	33 *110*	37 *120*	39 *130*	42 *140*	— —	— —	— —	— —
H8	— —	— —	— —	— —	30 *100*	34 *110*	36 *120*	39 *130*	35 *115*	39 *130*	41 *135*	44 *145*	— —	— —	— —	— —
H11	— —	— —	— —	— —	36 *120*	41 *135*	43 *140*	46 *150*	42 *140*	47 *155*	49 *160*	55 *180*	— —	— —	— —	— —
H12	— —	— —	— —	— —	55 *180*	60 *195*	65 *215*	70 *230*	65 *215*	70 *230*	75 *245*	80 *260*	— —	— —	— —	— —

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

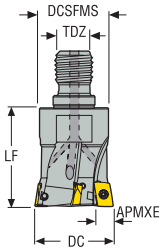


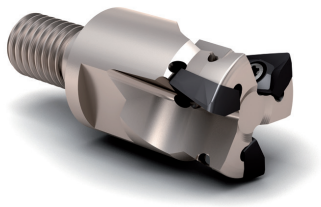
TURBO PLUNGE MILL

Turbo Plunge mills can be used for both up-copying and down-copying in an axial feed direction, such as in deep cavities for mold tools. All cutters in this family incorporate internal coolant to optimize chip evacuation.

- Insert size 06, cutter range 12-18mm
- Insert size 10, cutter range 20-50mm (.75 - 2 inch)
- Insert size 12, cutter range 25-63mm (1 - 2.50 inch)

R217/220.79-06 – Metric





- For insert selection and cutting data recommendations, see page(s) 698-699
- For complete insert programme, see page(s) 775
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm		mm	mm	kg		
R217.79-0612.RE-06.3AN	02705857	Combimaster	12,0	3	3,0	M6	11,0	18,0	0,1	32000	XO..06
R217.79-0816.RE-06.3AN	02705859	Combimaster	16,0	3	3,0	M8	13,5	20,0	0,1	28000	XO..06

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.79-..	C01804-T06P	T00-06P05	0.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-06 – Insert selection – mm/*Inch*

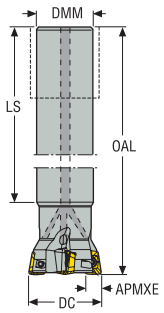
SMG		f_z	a_{so}			
			100%	70%	50%	30%
P1	XOMX060204R-M05 F40M	0,070 *0.0028*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P2	XOMX060204R-M05 F40M	0,070 *0.0028*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P3	XOMX060204R-M05 F40M	0,070 *0.0028*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P4	XOMX060204R-M05 F40M	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P5	XOMX060204R-M05 F40M	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P6	XOMX060204R-M05 F40M	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P7	XOMX060204R-M05 F40M	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P8	XOMX060204R-M05 MP3000	0,070 *0.0028*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P11	XOMX060204R-M05 F40M	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
P12	XOMX060204R-M05 F40M	0,044 *0.0017*	1,7 *0.065*	1,7 *0.065*	1,7 *0.065*	2,0 *0.080*
M1	XOMX060204R-M05 F40M	0,070 *0.0028*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
M2	XOMX060204R-M05 F40M	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
M3	XOMX060204R-M05 F40M	0,050 *0.0020*	1,7 *0.065*	1,7 *0.065*	1,7 *0.065*	2,0 *0.080*
M4	XOMX060204R-M05 F40M	0,046 *0.0018*	1,3 *0.050*	1,3 *0.050*	1,3 *0.050*	1,4 *0.055*
M5	XOMX060204R-M05 F40M	0,046 *0.0018*	1,3 *0.050*	1,3 *0.050*	1,3 *0.050*	1,4 *0.055*
K1	XOMX060204R-M05 MP3000	0,070 *0.0028*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
K2	XOMX060204R-M05 MP3000	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
K3	XOMX060204R-M05 MP3000	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
K4	XOMX060204R-M05 MP3000	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
K5	XOMX060204R-M05 MP3000	0,060 *0.0024*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
K6	XOMX060204R-M05 MP3000	0,065 *0.0026*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
K7	XOMX060204R-M05 MP3000	0,060 *0.0024*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
N1	XOEX060204FR-E03 H15	0,075 *0.0030*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
N2	XOEX060204FR-E03 F40M	0,075 *0.0030*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
N3	XOEX060204FR-E03 F40M	0,075 *0.0030*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
N11	XOEX060204FR-E03 H15	0,075 *0.0030*	2,0 *0.080*	2,0 *0.080*	2,0 *0.080*	2,5 *0.10*
S1	XOMX060204R-M05 F40M	0,046 *0.0018*	1,3 *0.050*	1,3 *0.050*	1,3 *0.050*	1,4 *0.055*
S2	XOMX060204R-M05 F40M	0,046 *0.0018*	1,3 *0.050*	1,3 *0.050*	1,3 *0.050*	1,4 *0.055*
S3	XOMX060204R-M05 F40M	0,042 *0.0017*	1,3 *0.050*	1,3 *0.050*	1,3 *0.050*	1,4 *0.055*
S11	XOMX060204R-M05 F40M	0,050 *0.0020*	1,5 *0.060*	1,5 *0.060*	1,5 *0.060*	1,7 *0.065*
S12	XOMX060204R-M05 F40M	0,050 *0.0020*	1,5 *0.060*	1,5 *0.060*	1,5 *0.060*	1,7 *0.065*
S13	XOMX060204R-M05 F40M	0,046 *0.0018*	1,3 *0.050*	1,3 *0.050*	1,3 *0.050*	1,4 *0.055*
H5	XOMX060204R-M05 MP3000	0,044 *0.0017*	1,7 *0.065*	1,7 *0.065*	1,7 *0.065*	2,0 *0.080*
H8	XOMX060204R-M05 MP3000	0,034 *0.0013*	1,5 *0.060*	1,5 *0.060*	1,5 *0.060*	1,7 *0.065*
H11	XOMX060204R-M05 MP3000	0,044 *0.0017*	1,7 *0.065*	1,7 *0.065*	1,7 *0.065*	2,0 *0.080*
H12	XOMX060204R-M05 MP3000	0,034 *0.0013*	1,5 *0.060*	1,5 *0.060*	1,5 *0.060*	1,7 *0.065*
H21	XOMX060204R-M05 MP3000	0,034 *0.0013*	1,5 *0.060*	1,5 *0.060*	1,5 *0.060*	1,7 *0.065*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217.79-06 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP3000				F40M				MM4500				H15				MS2050			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	290	320	340	360	230	255	270	290	185	210	220	235	—	—	—	—	255	280	300	315
	950	*1050*	*1125*	*1175*	*750*	*840*	*890*	*950*	*610*	*690*	*720*	*770*	—	—	—	—	*840*	*920*	*980*	*1025*
P2	280	310	330	350	225	250	265	280	180	200	215	225	—	—	—	—	245	275	290	310
	920	*1025*	*1075*	*1150*	*740*	*820*	*870*	*920*	*590*	*660*	*710*	*740*	—	—	—	—	*800*	*900*	*950*	*1025*
P3	240	270	285	300	195	215	225	240	155	175	185	195	—	—	—	—	210	235	250	265
	790	*890*	*940*	*980*	*640*	*710*	*740*	*790*	*510*	*570*	*610*	*640*	—	—	—	—	*690*	*770*	*820*	*870*
P4	215	240	255	270	175	195	205	215	140	155	165	175	—	—	—	—	190	210	225	240
	710	*790*	*840*	*890*	*570*	*640*	*670*	*710*	*460*	*510*	*540*	*570*	—	—	—	—	*620*	*690*	*740*	*790*
P5	205	230	245	260	165	185	195	205	135	150	155	165	—	—	—	—	180	200	215	225
	670	*750*	*800*	*850*	*540*	*610*	*640*	*670*	*445*	*490*	*510*	*540*	—	—	—	—	*590*	*660*	*710*	*740*
P6	230	260	275	290	185	205	220	230	150	165	175	190	—	—	—	—	205	225	240	255
	750	*850*	*900*	*950*	*610*	*670*	*720*	*750*	*490*	*540*	*570*	*620*	—	—	—	—	*670*	*740*	*790*	*840*
P7	220	245	255	275	175	195	205	220	140	160	165	175	—	—	—	—	195	215	225	240
	720	*800*	*840*	*900*	*570*	*640*	*670*	*720*	*460*	*520*	*540*	*570*	—	—	—	—	*640*	*710*	*740*	*790*
P8	205	225	240	255	160	180	190	205	130	145	155	165	—	—	—	—	180	200	210	225
	670	*740*	*790*	*840*	*520*	*590*	*620*	*670*	*425*	*475*	*510*	*540*	—	—	—	—	*590*	*660*	*690*	*740*
P11	215	235	250	265	170	190	200	210	140	155	160	170	—	—	—	—	185	210	220	235
	710	*770*	*820*	*870*	*560*	*620*	*660*	*690*	*460*	*510*	*520*	*560*	—	—	—	—	*610*	*690*	*720*	*770*
P12	140	155	165	175	110	125	130	140	90	100	105	115	—	—	—	—	120	135	145	155
	460	*510*	*540*	*570*	*360*	*410*	*425*	*460*	*295*	*330*	*345*	*375*	—	—	—	—	*395*	*445*	*475*	*510*
M1	210	235	245	260	180	200	210	225	155	175	185	195	—	—	—	—	200	220	235	250
	690	*770*	*800*	*850*	*590*	*660*	*690*	*740*	*510*	*570*	*610*	*640*	—	—	—	—	*660*	*720*	*770*	*820*
M2	175	190	205	215	150	165	175	185	130	145	150	160	—	—	—	—	165	180	190	205
	570	*620*	*670*	*710*	*490*	*540*	*570*	*610*	*425*	*475*	*490*	*520*	—	—	—	—	*540*	*590*	*620*	*670*
M3	140	155	165	175	120	135	145	150	105	115	125	130	—	—	—	—	135	150	155	170
	460	*510*	*540*	*570*	*395*	*445*	*475*	*490*	*345*	*375*	*410*	*425*	—	—	—	—	*445*	*490*	*510*	*560*
M4	110	120	130	135	95	105	110	120	80	90	95	100	—	—	—	—	105	115	120	130
	360	*395*	*425*	*445*	*310*	*345*	*360*	*395*	*260*	*295*	*310*	*330*	—	—	—	—	*345*	*375*	*395*	*425*
M5	90	100	105	115	80	85	90	100	65	75	80	85	—	—	—	—	85	95	100	110
	295	*330*	*345*	*375*	*260*	*280*	*295*	*330*	*215*	*245*	*260*	*280*	—	—	—	—	*280*	*310*	*330*	*360*
K1	220	245	260	275	180	200	210	220	—	—	—	—	—	—	—	—	—	—	—	—
	720	*800*	*850*	*900*	*590*	*660*	*690*	*720*	—	—	—	—	—	—	—	—	—	—	—	—
K2	195	220	230	245	155	175	185	195	—	—	—	—	—	—	—	—	—	—	—	—
	640	*720*	*750*	*800*	*510*	*570*	*610*	*640*	—	—	—	—	—	—	—	—	—	—	—	—
K3	165	185	195	205	135	150	155	165	—	—	—	—	—	—	—	—	—	—	—	—
	540	*610*	*640*	*670*	*445*	*490*	*510*	*540*	—	—	—	—	—	—	—	—	—	—	—	—
K4	160	175	185	200	125	140	150	160	—	—	—	—	—	—	—	—	—	—	—	—
	520	*570*	*610*	*660*	*410*	*460*	*490*	*520*	—	—	—	—	—	—	—	—	—	—	—	—
K5	95	105	115	120	75	85	90	95	—	—	—	—	—	—	—	—	—	—	—	—
	310	*345*	*375*	*395*	*245*	*280*	*295*	*310*	—	—	—	—	—	—	—	—	—	—	—	—
K6	140	155	165	175	110	125	130	140	—	—	—	—	—	—	—	—	—	—	—	—
	460	*510*	*540*	*570*	*360*	*410*	*425*	*460*	—	—	—	—	—	—	—	—	—	—	—	—
K7	125	135	145	155	100	110	115	125	—	—	—	—	—	—	—	—	—	—	—	—
	410	*445*	*475*	*510*	*330*	*360*	*375*	*410*	—	—	—	—	—	—	—	—	—	—	—	—
N1	1650	1825	1925	2050	1325	1450	1550	1650	—	—	—	—	1400	1550	1650	1750	—	—	—	—
	5425	*6000*	*6325*	*6725*	*4350*	*4750*	*5075*	*5425*	—	—	—	—	*4600*	*5075*	*5425*	*5750*	—	—	—	—
N2	660	740	780	830	530	590	620	660	—	—	—	—	560	630	660	700	—	—	—	—
	2175	*2425*	*2550*	*2725*	*1750*	*1925*	*2025*	*2175*	—	—	—	—	*1825*	*2075*	*2175*	*2300*	—	—	—	—
N3	440	490	520	550	355	395	415	440	—	—	—	—	375	420	440	470	—	—	—	—
	1450	*1600*	*1700*	*1800*	*1175*	*1300*	*1350*	*1450*	—	—	—	—	*1225*	*1375*	*1450*	*1550*	—	—	—	—
N11	510	560	590	630	405	450	475	510	—	—	—	—	430	480	510	540	—	—	—	—
	1675	*1825*	*1925*	*2075*	*1325*	*1475*	*1550*	*1675*	—	—	—	—	*1400*	*1575*	*1675*	*1775*	—	—	—	—
S1	50	55	60	65	44	49	50	55	25	27	29	31	—	—	—	—	48	55	55	60
	165	*180*	*195*	*215*	*145*	*160*	*165*	*180*	*80*	*90*	*95*	*100*	—	—	—	—	*155*	*180*	*180*	*195*
S2	41	45	48	50	35	39	41	44	20	22	23	25	—	—	—	—	39	43	45	49
	135	*150*	*155*	*165*	*115*	*130*	*135*	*145*	*65*	*70*	*75*	*80*	—	—	—	—	*130*	*140*	*150*	*160*
S3	36	40	42	45	31	34	36	39	17	19	21	22	—	—	—	—	34	38	40	43
	120	*130*	*140*	*150*	*100*	*110*	*120*	*130*	*55*	*60*	*70*	*70*	—	—	—	—	*110*	*125*	*130*	*140*
S11	70	80	85	90	60	70	70	80	35	39	41	44	—	—	—	—	70	75	80	85
	230	*260*	*280*	*295*	*195*	*230*	*230*	*260*	*115*	*130*	*135*	*145*	—	—	—	—	*230*	*245*	*260*	*280*
S12	49	55	60	60	43	47	50	55	32	36	38	40	—	—	—	—	47	50	55	60
	160	*180*	*195*	*195*	*140*	*155*	*165*	*180*	*105*	*120*	*125*	*130*	—	—	—	—	*155*	*165*	*180*	*195*
S13	28	32	33	36	24	27	29	31	18	21	22	23	—	—	—	—	27	30	32	34
	90	*105*	*110*	*120*	*80*	*90*	*95*	*100*	*60*	*70*	*70*	*75*	—	—	—	—	*90*	*100*	*105*	*110*
H5	43	48	50	55	37	41	43	46	—	—	—	—	—	—	—	—	—	—	—	—
	140	*155*	*165*	*180*	*120*	*135*	*140*	*150*	—	—	—	—	—	—	—	—	—	—	—	—
H8	46	50	55	55	39	43	46	49	—	—	—	—	—	—	—	—	—	—	—	—
	150	*165*	*180*	*180*	*130*	*140*	*150*	*160*	—	—	—	—	—	—	—	—	—	—	—	—
H11	55	60	65	70	47	50	55	60	—	—	—	—	—	—	—	—	—	—	—	—
	180	*195*	*215*	*230*	*155*	*165*	*180*	*195*	—	—	—	—	—	—	—	—	—	—	—	—
H12	85	95	105	110	70	80	80	90	—	—	—	—	—	—	—	—	—	—	—	—
	280	*310*	*345*	*360*	*230*	*260*	*260*	*295*	—	—	—	—	—	—	—	—	—	—	—	—
H21	46	50	55	55	39	43	46	49	—	—	—	—	—	—	—	—	—	—	—	—
	150	*165*	*180*	*180*	*130*	*140*	*150*	*160*	—	—	—	—	—	—	—	—	—	—	—	—

R217.79-10 – Metric



- For insert selection and cutting data recommendations, see page(s) 704-706
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			mm		mm	mm	mm	mm		kg	
R217.79-1820.0-10-2A	02842051	Cylindrical	20,0	2	6,0	18,0	130,0	160,0	29000	0,3	XO.X10T3
R217.79-2025.0-10-3A	02842052	Cylindrical	25,0	3	6,0	20,0	170,0	200,0	26000	0,6	XO.X10T3
R217.79-2532.0-10-4A	02842053	Cylindrical	32,0	4	6,0	25,0	218,0	250,0	22900	1,3	XO.X10T3

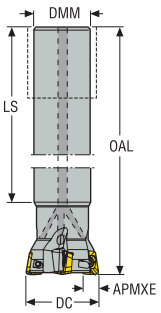
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.79-..	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-10 – Inch



- For insert selection and cutting data recommendations, see page(s) 704-706
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch		lbs	
R217.79-00.75-0-10-2A	02844106	Cylindrical	0.750	2	0.236	0.625	5.118	6.299	29000	0.440	XO.X10T3
R217.79-01.00-0-10-3A	02844107	Cylindrical	1.000	3	0.236	0.750	6.693	7.874	15000	0.880	XO.X10T3

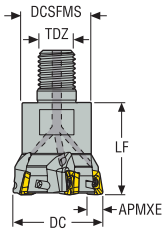
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.79-..	C02506-T07P	T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-10 – Metric



- For insert selection and cutting data recommendations, see page(s) 704-706
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm		mm	mm	kg		
R217.79-1020.RE-10-2A	02842054	Combimaster	20,0	2	6,0	M10	18,0	28,0	0,1	29000	XO.X10T3
R217.79-1225.RE-10-3A	02842056	Combimaster	25,0	3	6,0	M12	22,5	30,0	0,1	26000	XO.X10T3
R217.79-1632.RE-10-4A	02842057	Combimaster	32,0	4	6,0	M16	29,0	40,0	0,2	22900	XO.X10T3
R217.79-1640.RE-10-5A	02842058	Combimaster	40,0	5	6,0	M16	30,0	40,0	0,3	150000	XO.X10T3

For Combimaster Shanks, see Machining Navigator Tooling System

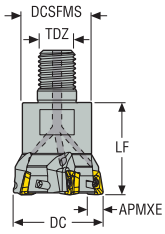
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.79-..	C02506-T07P	T00-07P09	0.9NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-10 – Inch



- For insert selection and cutting data recommendations, see page(s) 704-706
- For complete insert programme, see page(s) 776, 777
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch		Inch	Inch	lbs		
R217.79-1.00-12RE-10.3A	02844109	Combimaster	1.000	3	0.236	M12	0.886	1.181	0.220	150000	XO.X10T3

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

For cutter	Insert screw
R217.79-..	C02506-T07P

Accessories

Torque key	Torque value
T00-07P09	8.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.79-10 – Insert selection – mm/*Inch*

SMG		f_z	a_{so}			
			100%	70%	50%	30%
P1	XOMX10T308TR-ME07 MP2501	0,10 *0.0040*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P2	XOMX10T308TR-ME07 MP2501	0,10 *0.0040*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P3	XOMX10T308TR-ME07 MP2501	0,095 *0.0038*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P4	XOMX10T308TR-ME07 MP2501	0,095 *0.0038*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P5	XOMX10T308TR-ME07 MP2501	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P6	XOMX10T308TR-ME07 MP2501	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P7	XOMX10T308TR-M09 MP2501	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P8	XOMX10T308TR-M09 MP2501	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P11	XOMX10T308TR-M09 MP2501	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
P12	XOMX10T308TR-M09 MP2501	0,080 *0.0032*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
M1	XOMX10T308TR-ME07 F40M	0,10 *0.0040*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
M2	XOMX10T308TR-ME07 F40M	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
M3	XOMX10T308TR-ME07 F40M	0,075 *0.0030*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
M4	XOMX10T308TR-M09 F40M	0,080 *0.0032*	2,5 *0.10*	2,5 *0.10*	2,5 *0.10*	3,0 *0.12*
M5	XOMX10T308TR-M09 F40M	0,080 *0.0032*	2,5 *0.10*	2,5 *0.10*	2,5 *0.10*	3,0 *0.12*
K1	XOMX10T308TR-M09 MK1500	0,13 *0.0050*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
K2	XOMX10T308TR-M09 MK1500	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
K3	XOMX10T308TR-M09 MK1500	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
K4	XOMX10T308TR-M09 MK1500	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
K5	XOMX10T308TR-M09 MK1500	0,11 *0.0044*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
K6	XOMX10T308TR-M09 MK1500	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
K7	XOMX10T308TR-M09 MP1500	0,11 *0.0044*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
N1	XOEX10T308FR-E05 H15	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
N2	XOEX10T308FR-E05 H15	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
N3	XOEX10T308FR-E05 H15	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
N11	XOEX10T308FR-E05 H15	0,090 *0.0036*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	5,0 *0.20*
S1	XOMX10T308TR-ME07 T350M	0,065 *0.0026*	2,5 *0.10*	2,5 *0.10*	2,5 *0.10*	3,0 *0.12*
S2	XOMX10T308TR-ME07 T350M	0,065 *0.0026*	2,5 *0.10*	2,5 *0.10*	2,5 *0.10*	3,0 *0.12*
S3	XOMX10T308TR-M09 T350M	0,075 *0.0030*	2,5 *0.10*	2,5 *0.10*	2,5 *0.10*	3,0 *0.12*
S11	XOMX10T308TR-ME07 MS2050	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S12	XOMX10T308TR-ME07 MS2050	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S13	XOMX10T308TR-ME07 MS2050	0,065 *0.0026*	2,5 *0.10*	2,5 *0.10*	2,5 *0.10*	3,0 *0.12*
H5	XOMX10T308TR-M09 MP1501	0,080 *0.0032*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
H8	XOMX10T308TR-M09 MP1501	0,060 *0.0024*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
H11	XOMX10T308TR-M09 T350M	0,080 *0.0032*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
H12	XOMX10T308TR-M09 T350M	0,060 *0.0024*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
H21	XOMX10T308TR-M09 MP1501	0,060 *0.0024*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

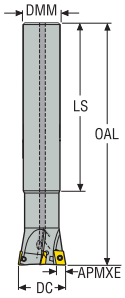
R217/220.79-10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501				MP2501				MP3000				T350M				F40M			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	275	305	325	345	245	270	285	305	230	255	270	290	245	275	290	310	185	205	215	230
	900	*1000*	*1075*	*1125*	*800*	*890*	*940*	*1000*	*750*	*840*	*890*	*950*	*800*	*900*	*950*	*1025*	*610*	*670*	*710*	*750*
P2	270	300	315	335	235	265	280	295	225	250	265	280	240	265	285	300	180	200	210	225
	890	*980*	*1025*	*1100*	*770*	*870*	*920*	*970*	*740*	*820*	*870*	*920*	*790*	*870*	*940*	*980*	*590*	*660*	*690*	*740*
P3	235	265	280	295	210	235	245	260	200	220	235	250	210	235	245	260	160	175	185	200
	770	*870*	*920*	*970*	*690*	*770*	*800*	*850*	*660*	*720*	*770*	*820*	*690*	*770*	*800*	*850*	*520*	*570*	*610*	*660*
P4	210	230	245	260	185	205	215	230	175	195	205	220	185	205	215	230	140	155	165	175
	690	*750*	*800*	*850*	*610*	*670*	*710*	*750*	*570*	*640*	*670*	*720*	*610*	*670*	*710*	*750*	*460*	*510*	*540*	*570*
P5	200	220	235	250	175	195	205	220	165	185	195	210	180	200	210	225	135	150	155	165
	660	*720*	*770*	*820*	*570*	*640*	*670*	*720*	*540*	*610*	*640*	*690*	*590*	*660*	*690*	*740*	*445*	*490*	*510*	*540*
P6	225	250	260	280	200	220	230	245	185	210	220	235	200	225	235	250	150	165	175	185
	740	*820*	*850*	*920*	*660*	*720*	*750*	*800*	*610*	*690*	*720*	*770*	*660*	*740*	*770*	*820*	*490*	*540*	*570*	*610*
P7	210	235	250	265	185	210	220	235	175	195	210	220	190	210	225	235	140	155	165	175
	690	*770*	*820*	*870*	*610*	*690*	*720*	*770*	*570*	*640*	*690*	*720*	*620*	*690*	*740*	*770*	*460*	*510*	*540*	*570*
P8	200	220	235	250	175	195	205	220	165	185	195	210	175	195	205	220	135	150	155	165
	660	*720*	*770*	*820*	*570*	*640*	*670*	*720*	*540*	*610*	*640*	*690*	*570*	*640*	*670*	*720*	*445*	*490*	*510*	*540*
P11	205	230	240	255	180	200	215	225	170	190	200	215	185	205	215	230	135	155	160	170
	670	*750*	*790*	*840*	*590*	*660*	*710*	*740*	*560*	*620*	*660*	*710*	*610*	*670*	*710*	*750*	*445*	*510*	*520*	*560*
P12	135	150	160	170	120	135	140	150	115	125	135	145	120	135	145	155	90	100	110	115
	445	*490*	*520*	*560*	*395*	*445*	*460*	*490*	*375*	*410*	*445*	*475*	*395*	*445*	*475*	*510*	*295*	*330*	*360*	*375*
M1	—	—	—	—	170	190	200	215	170	185	200	210	185	205	220	230	145	160	170	180
	—	—	—	—	*560*	*620*	*660*	*710*	*560*	*610*	*660*	*690*	*610*	*670*	*720*	*750*	*475*	*520*	*560*	*590*
M2	—	—	—	—	140	160	165	175	140	155	165	175	155	170	180	195	120	135	140	150
	—	—	—	—	*460*	*520*	*540*	*570*	*460*	*510*	*540*	*570*	*510*	*560*	*590*	*640*	*395*	*445*	*460*	*490*
M3	—	—	—	—	115	130	135	145	115	125	135	145	125	140	145	155	100	110	115	125
	—	—	—	—	*375*	*425*	*445*	*475*	*375*	*410*	*445*	*475*	*410*	*460*	*475*	*510*	*330*	*360*	*375*	*410*
M4	—	—	—	—	90	105	110	115	90	100	105	115	95	110	115	125	80	85	90	100
	—	—	—	—	*295*	*345*	*360*	*375*	*295*	*330*	*345*	*375*	*310*	*360*	*375*	*410*	*260*	*280*	*295*	*330*
M5	—	—	—	—	75	85	90	95	75	85	90	95	80	90	95	100	65	70	75	80
	—	—	—	—	*245*	*280*	*295*	*310*	*245*	*280*	*295*	*310*	*260*	*295*	*310*	*330*	*215*	*230*	*245*	*260*
K1	210	235	250	265	190	210	220	235	180	200	210	225	—	—	—	—	140	160	170	180
	690	*770*	*820*	*870*	*620*	*690*	*720*	*770*	*590*	*660*	*690*	*740*	—	—	—	—	*460*	*520*	*560*	*590*
K2	190	210	220	235	165	185	195	210	160	175	185	200	—	—	—	—	125	140	150	160
	620	*690*	*720*	*770*	*540*	*610*	*640*	*690*	*520*	*570*	*610*	*660*	—	—	—	—	*410*	*460*	*490*	*520*
K3	160	180	190	200	140	155	165	175	135	150	155	165	—	—	—	—	105	120	125	135
	520	*590*	*620*	*660*	*460*	*510*	*540*	*570*	*445*	*490*	*510*	*540*	—	—	—	—	*345*	*395*	*410*	*445*
K4	150	170	180	190	135	150	160	170	130	140	150	160	—	—	—	—	100	115	120	130
	490	*560*	*590*	*620*	*445*	*490*	*520*	*560*	*425*	*460*	*490*	*520*	—	—	—	—	*330*	*375*	*395*	*425*
K5	95	105	110	115	80	90	95	105	80	85	90	100	—	—	—	—	60	70	75	80
	310	*345*	*360*	*375*	*260*	*295*	*310*	*345*	*260*	*280*	*295*	*330*	—	—	—	—	*195*	*230*	*245*	*260*
K6	135	150	160	170	120	130	140	150	115	125	130	140	—	—	—	—	90	100	105	115
	445	*490*	*520*	*560*	*395*	*425*	*460*	*490*	*375*	*410*	*425*	*460*	—	—	—	—	*295*	*330*	*345*	*375*
K7	120	135	140	150	105	115	125	130	100	110	120	125	—	—	—	—	80	90	95	100
	395	*445*	*460*	*490*	*345*	*375*	*410*	*425*	*330*	*360*	*395*	*410*	—	—	—	—	*260*	*295*	*310*	*330*
N1	—	—	—	—	—	—	—	—	1325	1475	1550	1650	—	—	—	—	1050	1175	1250	1325
	—	—	—	—	—	—	—	—	*4350*	*4850*	*5075*	*5425*	—	—	—	—	*3450*	*3850*	*4100*	*4350*
N2	—	—	—	—	—	—	—	—	530	590	630	670	—	—	—	—	425	475	500	530
	—	—	—	—	—	—	—	—	*1750*	*1925*	*2075*	*2200*	—	—	—	—	*1400*	*1550*	*1650*	*1750*
N3	—	—	—	—	—	—	—	—	355	395	420	445	—	—	—	—	285	315	335	355
	—	—	—	—	—	—	—	—	*1175*	*1300*	*1375*	*1450*	—	—	—	—	*940*	*1025*	*1100*	*1175*
N11	—	—	—	—	—	—	—	—	405	450	480	510	—	—	—	—	325	360	380	405
	—	—	—	—	—	—	—	—	*1325*	*1475*	*1575*	*1675*	—	—	—	—	*1075*	*1175*	*1250*	*1325*
S1	—	—	—	—	45	50	55	55	42	47	50	55	45	50	55	55	36	41	43	46
	—	—	—	—	*150*	*165*	*180*	*180*	*140*	*155*	*165*	*180*	*150*	*165*	*180*	*180*	*120*	*135*	*140*	*150*
S2	—	—	—	—	36	40	43	46	34	38	40	43	37	41	43	46	29	33	35	37
	—	—	—	—	*120*	*130*	*140*	*150*	*110*	*125*	*130*	*140*	*120*	*135*	*140*	*150*	*95*	*110*	*115*	*120*
S3	—	—	—	—	32	35	37	40	30	33	35	38	32	36	38	41	26	29	30	32
	—	—	—	—	*105*	*115*	*120*	*130*	*100*	*110*	*115*	*125*	*105*	*120*	*125*	*135*	*85*	*95*	*100*	*105*
S11	—	—	—	—	60	70	70	75	60	65	70	75	65	70	75	80	50	55	60	65
	—	—	—	—	*195*	*230*	*230*	*245*	*195*	*215*	*230*	*245*	*215*	*230*	*245*	*260*	*165*	*180*	*195*	*215*
S12	—	—	—	—	42	47	50	55	40	45	47	50	44	49	50	55	35	39	41	44
	—	—	—	—	*140*	*155*	*165*	*180*	*130*	*150*	*155*	*165*	*145*	*160*	*165*	*180*	*115*	*130*	*135*	*145*
S13	—	—	—	—	25	28	30	32	24	26	28	30	26	28	30	32	20	23	24	26
	—	—	—	—	*80*	*90*	*100*	*105*	*80*	*85*	*90*	*100*	*85*	*90*	*100*	*105*	*65*	*75*	*80*	*85*
H5	45	50	55	55	36	41	43	46	36	40	42	45	40	45	48	50	30	34	36	38
	150	*165*	*180*	*180*	*120*	*135*	*140*	*150*	*120*	*130*	*140*	*150*	*130*	*150*	*155*	*165*	*100*	*110*	*120*	*125*
H8	49	55	60	60	39	44	46	50	38	43	45	48	43	48	50	55	33	37	39	41
	160	*180*	*195*	*195*	*130*	*145*	*150*	*165*	*125*	*140*	*150*	*155*	*140*	*155*	*165*	*180*	*110*	*120*	*130*	*135*
H11	60	65	70	70	46	50	55	60	45	50	55	55	50	55	60	65	39	43	46	49
	195	*215*	*230*	*230*	*150*	*165*	*180*	*195*	*150*	*165*	*180*	*180*	*165*	*180*	*195*	*215*	*130*	*140*	*150*	*160*
H12	90	100	105	110	80	85	90	100	75	80	85	95	75	85	90	95	60	65	70	75
	295	*330*	*345*	*360*	*260*	*280*	*295*	*330*	*245*	*260*	*280*	*310*	*245*	*280*	*295*	*310*	*195*	*215*	*230*	*245*
H21	49	55	60	60	39	44	46	50	38	43	45	48	43	48	50	55	33	37	39	41
	160	*180*	*195*	*195*	*130*	*145*	*150*	*165*	*125*	*140*	*150*	*155*	*140*	*155*	*165*	*180*	*110*	*120*	*130*	*135*

R217/220.79-10 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500				MK2050				MS2050				MS2500				H15			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	—	—	—	—	240	265	280	300	235	265	280	295	265	295	315	335	—	—	—	—
	—	—	—	—	*790*	*870*	*920*	*980*	*770*	*870*	*920*	*970*	*870*	*970*	*1025*	*1100*	—	—	—	—
P2	—	—	—	—	235	260	275	290	230	255	270	285	260	290	305	325	—	—	—	—
	—	—	—	—	*770*	*850*	*900*	*950*	*750*	*840*	*890*	*940*	*850*	*950*	*1000*	*1075*	—	—	—	—
P3	—	—	—	—	205	230	245	260	200	225	235	250	230	255	270	285	—	—	—	—
	—	—	—	—	*670*	*750*	*800*	*850*	*660*	*740*	*770*	*820*	*750*	*840*	*890*	*940*	—	—	—	—
P4	—	—	—	—	180	200	215	225	175	195	210	220	200	225	235	250	—	—	—	—
	—	—	—	—	*590*	*660*	*710*	*740*	*570*	*640*	*690*	*720*	*660*	*740*	*770*	*820*	—	—	—	—
P5	—	—	—	—	175	195	205	215	170	190	200	215	190	215	225	240	—	—	—	—
	—	—	—	—	*570*	*640*	*670*	*710*	*560*	*620*	*660*	*710*	*620*	*710*	*740*	*790*	—	—	—	—
P6	—	—	—	—	195	215	230	245	190	215	225	240	215	240	255	270	—	—	—	—
	—	—	—	—	*640*	*710*	*750*	*800*	*620*	*710*	*740*	*790*	*710*	*790*	*840*	*890*	—	—	—	—
P7	—	—	—	—	185	205	215	230	180	200	215	225	205	225	240	255	—	—	—	—
	—	—	—	—	*610*	*670*	*710*	*750*	*590*	*660*	*710*	*740*	*670*	*740*	*790*	*840*	—	—	—	—
P8	—	—	—	—	175	195	205	215	170	190	200	210	190	215	225	240	—	—	—	—
	—	—	—	—	*570*	*640*	*670*	*710*	*560*	*620*	*660*	*690*	*620*	*710*	*740*	*790*	—	—	—	—
P11	—	—	—	—	180	200	210	225	175	195	205	220	200	220	230	245	—	—	—	—
	—	—	—	—	*590*	*660*	*690*	*740*	*570*	*640*	*670*	*720*	*660*	*720*	*750*	*800*	—	—	—	—
P12	—	—	—	—	120	130	140	150	115	130	135	145	130	145	155	165	—	—	—	—
	—	—	—	—	*395*	*425*	*460*	*490*	*375*	*425*	*445*	*475*	*425*	*475*	*510*	*540*	—	—	—	—
M1	—	—	—	—	—	—	—	—	185	205	220	230	185	205	220	230	—	—	—	—
	—	—	—	—	—	—	—	—	*610*	*670*	*720*	*750*	*610*	*670*	*720*	*750*	—	—	—	—
M2	—	—	—	—	—	—	—	—	155	170	180	195	155	170	180	190	—	—	—	—
	—	—	—	—	—	—	—	—	*510*	*560*	*590*	*640*	*510*	*560*	*590*	*620*	—	—	—	—
M3	—	—	—	—	—	—	—	—	125	140	145	155	125	140	150	160	—	—	—	—
	—	—	—	—	—	—	—	—	*410*	*460*	*475*	*510*	*410*	*460*	*490*	*520*	—	—	—	—
M4	—	—	—	—	—	—	—	—	95	110	115	125	100	110	120	125	—	—	—	—
	—	—	—	—	—	—	—	—	*310*	*360*	*375*	*410*	*330*	*360*	*395*	*410*	—	—	—	—
M5	—	—	—	—	—	—	—	—	80	90	95	100	85	95	100	105	—	—	—	—
	—	—	—	—	—	—	—	—	*260*	*295*	*310*	*330*	*280*	*310*	*330*	*345*	—	—	—	—
K1	265	295	315	335	250	280	295	315	—	—	—	—	—	—	—	—	—	—	—	—
	870	*970*	*1025*	*1100*	*820*	*920*	*970*	*1025*	—	—	—	—	—	—	—	—	—	—	—	—
K2	235	265	280	295	225	250	265	280	—	—	—	—	—	—	—	—	—	—	—	—
	770	*870*	*920*	*970*	*740*	*820*	*870*	*920*	—	—	—	—	—	—	—	—	—	—	—	—
K3	200	225	235	250	190	210	225	235	—	—	—	—	—	—	—	—	—	—	—	—
	660	*740*	*770*	*820*	*620*	*690*	*740*	*770*	—	—	—	—	—	—	—	—	—	—	—	—
K4	190	215	225	240	180	200	215	225	—	—	—	—	—	—	—	—	—	—	—	—
	620	*710*	*740*	*790*	*590*	*660*	*710*	*740*	—	—	—	—	—	—	—	—	—	—	—	—
K5	115	130	135	145	110	125	130	140	—	—	—	—	—	—	—	—	—	—	—	—
	375	*425*	*445*	*475*	*360*	*410*	*425*	*460*	—	—	—	—	—	—	—	—	—	—	—	—
K6	170	185	200	210	160	175	190	200	—	—	—	—	—	—	—	—	—	—	—	—
	560	*610*	*660*	*690*	*520*	*570*	*620*	*660*	—	—	—	—	—	—	—	—	—	—	—	—
K7	150	165	175	185	140	160	165	175	—	—	—	—	—	—	—	—	—	—	—	—
	490	*540*	*570*	*610*	*460*	*520*	*540*	*570*	—	—	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1300	1450	1525	1625
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*4275*	*4750*	*5000*	*5325*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	520	580	610	650
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1700*	*1900*	*2000*	*2125*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	350	390	410	435
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1150*	*1275*	*1350*	*1425*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	400	445	470	495
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1300*	*1450*	*1550*	*1625*
S1	—	—	—	—	—	—	—	—	45	50	55	55	49	55	60	60	—	—	—	—
	—	—	—	—	—	—	—	—	*150*	*165*	*180*	*180*	*160*	*180*	*195*	*195*	—	—	—	—
S2	—	—	—	—	—	—	—	—	37	41	43	46	39	44	46	50	—	—	—	—
	—	—	—	—	—	—	—	—	*120*	*135*	*140*	*150*	*130*	*145*	*150*	*165*	—	—	—	—
S3	—	—	—	—	—	—	—	—	32	36	38	41	34	38	41	44	—	—	—	—
	—	—	—	—	—	—	—	—	*105*	*120*	*125*	*135*	*110*	*125*	*135*	*145*	—	—	—	—
S11	—	—	—	—	—	—	—	—	65	70	75	80	65	75	80	85	—	—	—	—
	—	—	—	—	—	—	—	—	*215*	*230*	*245*	*260*	*215*	*245*	*260*	*280*	—	—	—	—
S12	—	—	—	—	—	—	—	—	44	49	50	55	46	50	55	60	—	—	—	—
	—	—	—	—	—	—	—	—	*145*	*160*	*165*	*180*	*150*	*165*	*180*	*195*	—	—	—	—
S13	—	—	—	—	—	—	—	—	26	28	30	32	27	31	32	35	—	—	—	—
	—	—	—	—	—	—	—	—	*85*	*90*	*100*	*105*	*90*	*100*	*105*	*115*	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

R217.79-XO12 – Metric



- For insert selection and cutting data recommendations, see page(s) 710-712
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			mm		mm	mm	mm	mm		kg	
R217.79-2025.0-XO12-2AN	02732332	Cylindrical	25,0	2	7,0	20,0	170,0	200,0	20800	0,5	XO..1204
R217.79-2532.0-XO12-3AN	02732333	Cylindrical	32,0	3	7,0	25,0	215,0	250,0	18400	0,9	XO..1204

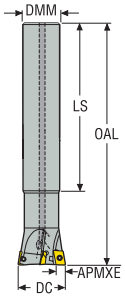
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R217.79-..	C03507-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-XO12 – Inch



- For insert selection and cutting data recommendations, see page(s) 710-712
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch		lbs	
R217.79-1.00.3-XO.2A	00097192	Weldon	1.000	2	0.276	0.750	6.693	7.874	20800	1.100	XO..1204

Spare Parts

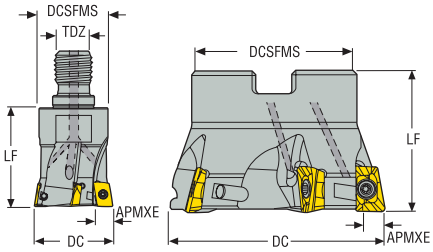
For cutter	Insert screw
R217.79-..	C03507-T10P

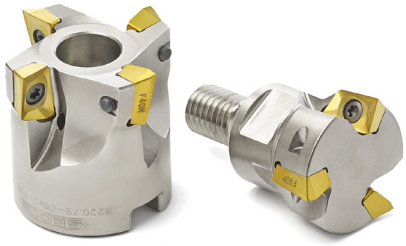
Accessories

Torque key	Torque value
T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-XO12 – Metric





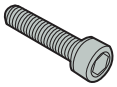
- For insert selection and cutting data recommendations, see page(s) 710-712
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm		mm	mm	kg		
R217.79-1225.RE-XO12-2AN	02732338	Combimaster	25,0	2	7,0	–	M12	23,0	30,0	0,1	20800	XO..1204
R217.79-1632.RE-XO12-3AN	02732344	Combimaster	32,0	3	7,0	–	M16	30,0	40,0	0,2	18400	XO..1204
R220.79-0040-XO12-4AN	02732351	Arbor	40,0	4	7,0	16,0	–	35,0	40,0	0,2	16400	XO..1204
R220.79-0050-XO12-4AN	02732353	Arbor	50,0	4	7,0	22,0	–	42,0	40,0	0,3	14800	XO..1204
R220.79-0063-XO12-5AN	02732354	Arbor	63,0	5	7,0	22,0	–	47,0	40,0	0,5	13200	XO..1204

For Combimaster Shanks, see Machining Navigator Tooling System

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.79-..	–	C03507-T10P	T00-10P30	3.0NM
R220.79-0040	MC6S8X30	C03509-T10P	T00-10P30	3.0NM
R220.79-0050-0063	220.17-692	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.79-XO12 – Insert selection – mm/*Inch*

SMG		f_z	a_{so}			
			100%	70%	50%	30%
P1	XOMX120408TR-ME08 MP2501	0,14 *0.0055*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P2	XOMX120408TR-ME08 MP2501	0,14 *0.0055*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P3	XOMX120408TR-ME08 MP2501	0,14 *0.0055*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P4	XOMX120408TR-ME08 MP2501	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P5	XOMX120408TR-ME08 MP2501	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P6	XOMX120408TR-ME08 MP2501	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P7	XOMX120408TR-M12 MP2501	0,15 *0.0060*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P8	XOMX120408TR-M12 MP2501	0,16 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P11	XOMX120408TR-M12 MP2501	0,15 *0.0060*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
P12	XOMX120408TR-M12 MP2501	0,11 *0.0044*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
M1	XOMX120408TR-ME08 F40M	0,14 *0.0055*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
M2	XOMX120408TR-ME08 F40M	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
M3	XOMX120408TR-ME08 F40M	0,10 *0.0040*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
M4	XOEX120408ZZR-M07 F40M	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
M5	XOEX120408ZZR-M07 F40M	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
K1	XOMX120408TR-M12 MK1500	0,17 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K2	XOMX120408TR-M12 MK1500	0,16 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K3	XOMX120408TR-M12 MK1500	0,16 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K4	XOMX120408TR-M12 MK1500	0,16 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K5	XOMX120408TR-M12 MK1500	0,14 *0.0055*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K6	XOMX120408TR-M12 MK1500	0,16 *0.0065*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
K7	XOMX120408TR-M12 MK1500	0,14 *0.0055*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
N1	XOEX120408FR-E06 H15	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
N2	XOEX120408FR-E06 H15	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
N3	XOEX120408FR-E06 H15	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
N11	XOEX120408FR-E06 H15	0,13 *0.0050*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
S1	XOEX120408R-M07 T350M	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S2	XOEX120408R-M07 T350M	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S3	XOEX120408R-M07 F40M	0,070 *0.0028*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
S11	XOEX120408R-M07 MS2050	0,085 *0.0034*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
S12	XOEX120408R-M07 MS2050	0,085 *0.0034*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
S13	XOEX120408R-M07 MS2050	0,075 *0.0030*	3,0 *0.12*	3,0 *0.12*	3,0 *0.12*	3,5 *0.14*
H5	XOMX120408TR-D14 MP1501	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
H8	XOMX120408TR-D14 MP1501	0,095 *0.0038*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
H11	XOMX120408TR-D14 MP1501	0,12 *0.0048*	4,0 *0.16*	4,0 *0.16*	4,0 *0.16*	4,5 *0.18*
H12	XOMX120408TR-D14 MP1501	0,095 *0.0038*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*
H21	XOMX120408TR-D14 MP1501	0,095 *0.0038*	3,5 *0.14*	3,5 *0.14*	3,5 *0.14*	4,0 *0.16*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

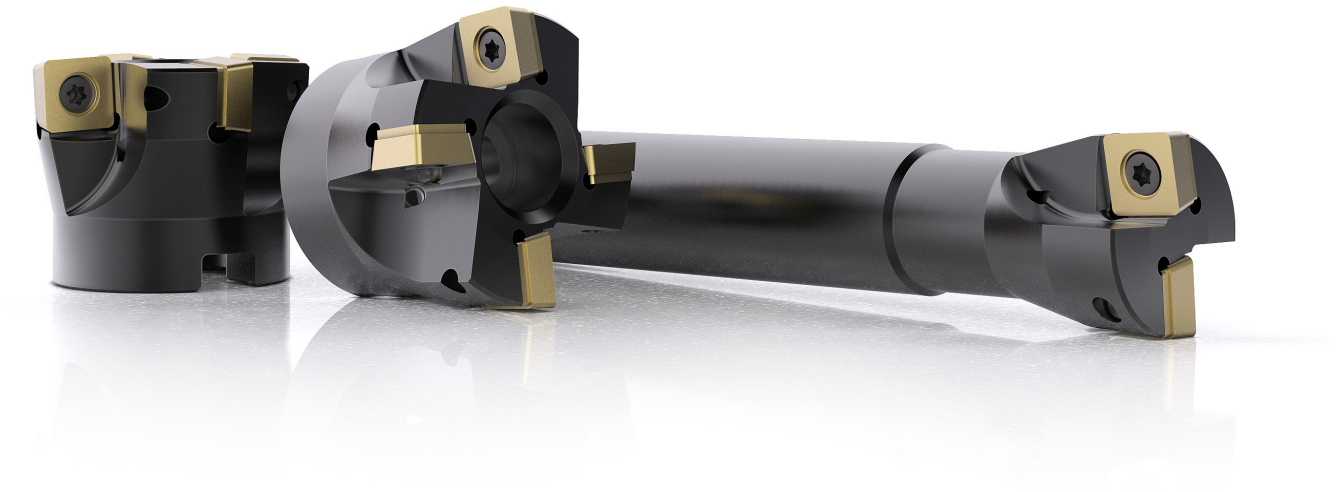
R217/220.79-XO12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501				MP2501				MP3000				T350M				F40M			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	250	280	295	315	220	245	260	280	210	235	245	265	235	265	280	300	190	215	225	240
	820	*920*	*970*	*1025*	*720*	*800*	*850*	*920*	*690*	*770*	*800*	*870*	*770*	*870*	*920*	*980*	*620*	*710*	*740*	*790*
P2	245	270	285	305	215	240	255	270	205	225	240	255	230	255	270	290	185	205	220	235
	800	*890*	*940*	*1000*	*710*	*790*	*840*	*890*	*670*	*740*	*790*	*840*	*750*	*840*	*890*	*950*	*610*	*670*	*720*	*770*
P3	215	235	250	270	190	210	225	240	180	200	210	225	200	220	235	250	160	180	190	200
	710	*770*	*820*	*890*	*620*	*690*	*740*	*790*	*590*	*660*	*690*	*740*	*660*	*720*	*770*	*820*	*520*	*590*	*620*	*660*
P4	190	210	220	235	165	185	195	210	155	175	185	200	175	195	205	220	145	160	170	180
	620	*690*	*720*	*770*	*540*	*610*	*640*	*690*	*510*	*570*	*610*	*660*	*570*	*640*	*670*	*720*	*475*	*520*	*560*	*590*
P5	180	200	210	225	160	175	185	200	150	165	175	190	170	190	200	215	140	155	160	175
	590	*660*	*690*	*740*	*520*	*570*	*610*	*660*	*490*	*540*	*570*	*620*	*560*	*620*	*660*	*710*	*460*	*510*	*520*	*570*
P6	205	230	240	260	180	205	215	230	170	190	205	215	195	215	225	240	155	170	180	195
	670	*750*	*790*	*850*	*590*	*670*	*710*	*750*	*560*	*620*	*670*	*710*	*640*	*710*	*740*	*790*	*510*	*560*	*590*	*640*
P7	195	215	230	245	170	190	200	215	165	180	190	205	180	205	215	230	145	165	170	185
	640	*710*	*750*	*800*	*560*	*620*	*660*	*710*	*540*	*590*	*620*	*670*	*590*	*670*	*710*	*750*	*475*	*540*	*560*	*610*
P8	180	200	210	225	160	175	185	200	150	165	175	190	165	185	195	210	135	150	160	170
	590	*660*	*690*	*740*	*520*	*570*	*610*	*660*	*490*	*540*	*570*	*620*	*540*	*610*	*640*	*690*	*445*	*490*	*520*	*560*
P11	190	210	220	235	165	185	195	210	160	175	185	200	175	195	210	220	140	160	165	180
	620	*690*	*720*	*770*	*540*	*610*	*640*	*690*	*520*	*570*	*610*	*660*	*570*	*640*	*690*	*720*	*460*	*520*	*540*	*590*
P12	125	135	145	155	110	120	130	140	105	115	120	130	115	130	135	145	95	105	110	120
	410	*445*	*475*	*510*	*360*	*395*	*425*	*460*	*345*	*375*	*395*	*425*	*375*	*425*	*445*	*475*	*310*	*345*	*360*	*395*
M1	—	—	—	—	155	175	185	195	150	170	180	190	180	200	210	225	150	165	175	190
	—	—	—	—	*510*	*570*	*610*	*640*	*490*	*560*	*590*	*620*	*590*	*660*	*690*	*740*	*490*	*540*	*570*	*620*
M2	—	—	—	—	130	140	150	160	125	140	150	160	150	165	175	185	125	140	145	155
	—	—	—	—	*425*	*460*	*490*	*520*	*410*	*460*	*490*	*520*	*490*	*540*	*570*	*610*	*410*	*460*	*475*	*510*
M3	—	—	—	—	105	120	125	135	105	120	125	135	120	130	140	150	105	115	120	130
	—	—	—	—	*345*	*395*	*410*	*445*	*345*	*395*	*410*	*445*	*395*	*425*	*460*	*490*	*345*	*375*	*395*	*425*
M4	—	—	—	—	85	95	100	105	80	90	95	105	90	105	110	115	80	90	95	100
	—	—	—	—	*280*	*310*	*330*	*345*	*260*	*295*	*310*	*345*	*295*	*345*	*360*	*375*	*260*	*295*	*310*	*330*
M5	—	—	—	—	70	75	80	90	70	75	80	85	75	85	90	100	65	75	80	85
	—	—	—	—	*230*	*245*	*260*	*295*	*230*	*245*	*260*	*280*	*245*	*280*	*295*	*330*	*215*	*245*	*260*	*280*
K1	190	215	225	240	170	190	200	215	160	180	190	205	185	205	215	230	145	165	175	185
	620	*710*	*740*	*790*	*560*	*620*	*660*	*710*	*520*	*590*	*620*	*670*	*610*	*670*	*710*	*750*	*475*	*540*	*570*	*610*
K2	170	190	200	215	150	170	180	190	145	160	170	180	165	180	190	205	130	145	155	165
	560	*620*	*660*	*710*	*490*	*560*	*590*	*620*	*475*	*520*	*560*	*590*	*540*	*590*	*620*	*670*	*425*	*475*	*510*	*540*
K3	145	160	170	180	125	140	150	160	120	135	140	150	140	155	160	175	110	125	130	140
	475	*520*	*560*	*590*	*410*	*460*	*490*	*520*	*395*	*445*	*460*	*490*	*460*	*510*	*520*	*570*	*360*	*410*	*425*	*460*
K4	135	155	160	175	120	135	145	155	115	130	135	145	130	145	155	165	105	120	125	135
	445	*510*	*520*	*570*	*395*	*445*	*475*	*510*	*375*	*425*	*445*	*475*	*425*	*475*	*510*	*540*	*345*	*395*	*410*	*445*
K5	85	95	100	105	75	85	90	95	70	80	85	90	80	90	95	100	65	70	75	80
	280	*310*	*330*	*345*	*245*	*280*	*295*	*310*	*230*	*260*	*280*	*295*	*260*	*295*	*310*	*330*	*215*	*230*	*245*	*260*
K6	120	135	145	150	105	120	125	135	100	115	120	130	115	130	135	145	95	105	110	115
	395	*445*	*475*	*490*	*345*	*395*	*410*	*445*	*330*	*375*	*395*	*425*	*375*	*425*	*445*	*475*	*310*	*345*	*360*	*375*
K7	110	120	130	140	95	110	115	120	90	100	110	115	100	115	120	130	85	90	95	105
	360	*395*	*425*	*460*	*310*	*360*	*375*	*395*	*295*	*330*	*360*	*375*	*330*	*375*	*395*	*425*	*280*	*295*	*310*	*345*
N1	—	—	—	—	—	—	—	—	1175	1300	1375	1475	—	—	—	—	1075	1200	1275	1350
	—	—	—	—	—	—	—	—	*3850*	*4275*	*4500*	*4850*	—	—	—	—	*3525*	*3925*	*4175*	*4425*
N2	—	—	—	—	—	—	—	—	470	530	560	600	—	—	—	—	435	485	510	550
	—	—	—	—	—	—	—	—	*1550*	*1750*	*1825*	*1975*	—	—	—	—	*1425*	*1600*	*1675*	*1800*
N3	—	—	—	—	—	—	—	—	315	350	370	395	—	—	—	—	290	320	340	365
	—	—	—	—	—	—	—	—	*1025*	*1150*	*1225*	*1300*	—	—	—	—	*950*	*1050*	*1125*	*1200*
N11	—	—	—	—	—	—	—	—	360	400	425	455	—	—	—	—	330	370	390	415
	—	—	—	—	—	—	—	—	*1175*	*1300*	*1400*	*1500*	—	—	—	—	*1075*	*1225*	*1275*	*1350*
S1	—	—	—	—	40	45	48	50	38	43	45	48	43	48	50	55	37	42	44	47
	—	—	—	—	*130*	*150*	*155*	*165*	*125*	*140*	*150*	*155*	*140*	*155*	*165*	*180*	*120*	*140*	*145*	*155*
S2	—	—	—	—	33	36	38	41	31	34	36	39	35	39	41	44	30	34	36	38
	—	—	—	—	*110*	*120*	*125*	*135*	*100*	*110*	*120*	*130*	*115*	*130*	*135*	*145*	*100*	*110*	*120*	*125*
S3	—	—	—	—	29	32	34	37	27	30	32	35	31	34	36	39	26	29	31	33
	—	—	—	—	*95*	*105*	*110*	*120*	*90*	*100*	*105*	*115*	*100*	*110*	*120*	*130*	*85*	*95*	*100*	*110*
S11	—	—	—	—	55	65	65	70	55	60	65	70	60	65	70	75	50	60	60	65
	—	—	—	—	*180*	*215*	*215*	*230*	*180*	*195*	*215*	*230*	*195*	*215*	*230*	*245*	*165*	*195*	*195*	*215*
S12	—	—	—	—	39	44	46	50	37	41	44	47	42	46	49	55	36	40	43	46
	—	—	—	—	*130*	*145*	*150*	*165*	*120*	*135*	*145*	*155*	*140*	*150*	*160*	*180*	*120*	*130*	*140*	*150*
S13	—	—	—	—	23	25	27	29	21	24	25	27	24	27	29	31	21	23	25	27
	—	—	—	—	*75*	*80*	*90*	*95*	*70*	*80*	*80*	*90*	*80*	*90*	*95*	*100*	*70*	*75*	*80*	*90*
H5	41	46	48	50	33	37	39	42	32	36	38	41	38	43	45	49	31	35	37	39
	135	*150*	*155*	*165*	*110*	*120*	*130*	*140*	*105*	*120*	*125*	*135*	*125*	*140*	*150*	*160*	*100*	*115*	*120*	*130*
H8	45	50	55	55	36	40	43	46	35	39	42	45	41	46	48	50	33	37	40	42
	150	*165*	*180*	*180*	*120*	*130*	*140*	*150*	*115*	*130*	*140*	*150*	*135*	*150*	*155*	*165*	*110*	*120*	*130*	*140*
H11	50	60	60	65	42	47	49	55	41	46	48	50	49	55	60	60	40	44	47	50
	165	*195*	*195*	*215*	*140*	*155*	*160*	*180*	*135*	*150*	*155*	*165*	*160*	*180*	*195*	*195*	*130*	*145*	*155*	*165*
H12	80	90	95	100	70	80	85	90	70	75	80	85	75	80	85	95	60	65	70	75
	260	*295*	*310*	*330*	*230*	*260*	*280*	*295*	*230*	*245*	*260*	*280*	*245*	*260*	*280*	*310*	*195*	*215*	*230*	*245*
H21	45	50	55	55	36	40	43	46	35	39	42	45	41	46	48	50	33	37	40	42
	150	*165*	*180*	*180*	*120*	*130*	*140*	*150*	*115*	*130*	*140*	*150*	*135*	*150*	*155*	*165*	*110*	*120*	*130*	*140*

SECO

R217/220.79-XO12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MK1500				MK2050				MS2050				MS2500				H15			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	—	—	—	—	220	240	255	275	210	235	250	265	295	330	350	375	—	—	—	—
	—	—	—	—	*720*	*790*	*840*	*900*	*690*	*770*	*820*	*870*	*970*	*1075*	*1150*	*1225*	—	—	—	—
P2	—	—	—	—	210	235	250	265	205	230	240	260	290	320	340	365	—	—	—	—
	—	—	—	—	*690*	*770*	*820*	*870*	*670*	*750*	*790*	*850*	*950*	*1050*	*1125*	*1200*	—	—	—	—
P3	—	—	—	—	185	205	220	235	175	195	210	220	250	275	295	315	—	—	—	—
	—	—	—	—	*610*	*670*	*720*	*770*	*570*	*640*	*690*	*720*	*820*	*900*	*970*	*1025*	—	—	—	—
P4	—	—	—	—	165	180	195	205	160	175	185	200	220	245	260	275	—	—	—	—
	—	—	—	—	*540*	*590*	*640*	*670*	*520*	*570*	*610*	*660*	*720*	*800*	*850*	*900*	—	—	—	—
P5	—	—	—	—	155	175	185	195	150	170	180	190	215	240	255	270	—	—	—	—
	—	—	—	—	*510*	*570*	*610*	*640*	*490*	*560*	*590*	*620*	*710*	*790*	*840*	*890*	—	—	—	—
P6	—	—	—	—	180	200	210	225	170	190	200	215	240	270	285	305	—	—	—	—
	—	—	—	—	*590*	*660*	*690*	*740*	*560*	*620*	*660*	*710*	*790*	*890*	*940*	*1000*	—	—	—	—
P7	—	—	—	—	170	190	200	215	160	180	190	200	230	255	270	285	—	—	—	—
	—	—	—	—	*560*	*620*	*660*	*710*	*520*	*590*	*620*	*660*	*750*	*840*	*890*	*940*	—	—	—	—
P8	—	—	—	—	155	175	185	195	150	165	175	185	210	235	245	265	—	—	—	—
	—	—	—	—	*510*	*570*	*610*	*640*	*490*	*540*	*570*	*610*	*690*	*770*	*800*	*870*	—	—	—	—
P11	—	—	—	—	165	185	195	205	155	175	185	195	220	245	260	280	—	—	—	—
	—	—	—	—	*540*	*610*	*640*	*670*	*510*	*570*	*610*	*640*	*720*	*800*	*850*	*920*	—	—	—	—
P12	—	—	—	—	105	120	125	135	105	115	120	130	145	160	170	185	—	—	—	—
	—	—	—	—	*345*	*395*	*410*	*445*	*345*	*375*	*395*	*425*	*475*	*520*	*560*	*610*	—	—	—	—
M1	—	—	—	—	—	—	—	—	165	185	195	210	205	230	245	260	—	—	—	—
	—	—	—	—	—	—	—	—	*540*	*610*	*640*	*690*	*670*	*750*	*800*	*850*	—	—	—	—
M2	—	—	—	—	—	—	—	—	135	150	160	170	170	190	205	215	—	—	—	—
	—	—	—	—	—	—	—	—	*445*	*490*	*520*	*560*	*560*	*620*	*670*	*710*	—	—	—	—
M3	—	—	—	—	—	—	—	—	115	125	135	145	140	155	165	175	—	—	—	—
	—	—	—	—	—	—	—	—	*375*	*410*	*445*	*475*	*460*	*510*	*540*	*570*	—	—	—	—
M4	—	—	—	—	—	—	—	—	90	100	105	110	110	120	125	135	—	—	—	—
	—	—	—	—	—	—	—	—	*295*	*330*	*345*	*360*	*360*	*395*	*410*	*445*	—	—	—	—
M5	—	—	—	—	—	—	—	—	75	80	85	95	90	100	105	115	—	—	—	—
	—	—	—	—	—	—	—	—	*245*	*260*	*280*	*310*	*295*	*330*	*345*	*375*	—	—	—	—
K1	240	270	285	305	230	255	270	290	—	—	—	—	—	—	—	—	—	—	—	—
	790	*890*	*940*	*1000*	*750*	*840*	*890*	*950*	—	—	—	—	—	—	—	—	—	—	—	—
K2	215	240	250	270	200	225	240	255	—	—	—	—	—	—	—	—	—	—	—	—
	710	*790*	*820*	*890*	*660*	*740*	*790*	*840*	—	—	—	—	—	—	—	—	—	—	—	—
K3	180	200	215	225	170	190	200	215	—	—	—	—	—	—	—	—	—	—	—	—
	590	*660*	*710*	*740*	*560*	*620*	*660*	*710*	—	—	—	—	—	—	—	—	—	—	—	—
K4	170	190	205	215	165	180	190	205	—	—	—	—	—	—	—	—	—	—	—	—
	560	*620*	*670*	*710*	*540*	*590*	*620*	*670*	—	—	—	—	—	—	—	—	—	—	—	—
K5	105	120	125	135	100	115	120	130	—	—	—	—	—	—	—	—	—	—	—	—
	345	*395*	*410*	*445*	*330*	*375*	*395*	*425*	—	—	—	—	—	—	—	—	—	—	—	—
K6	150	170	180	190	145	160	170	180	—	—	—	—	—	—	—	—	—	—	—	—
	490	*560*	*590*	*620*	*475*	*520*	*560*	*590*	—	—	—	—	—	—	—	—	—	—	—	—
K7	135	155	160	175	130	145	155	165	—	—	—	—	—	—	—	—	—	—	—	—
	445	*510*	*520*	*570*	*425*	*475*	*510*	*540*	—	—	—	—	—	—	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	1200	1325	1400	1500
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*3925*	*4350*	*4600*	*4925*
N2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	480	540	570	600
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1575*	*1775*	*1875*	*1975*
N3	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	320	355	375	405
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1050*	*1175*	*1225*	*1325*
N11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	365	410	430	460
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	*1200*	*1350*	*1400*	*1500*
S1	—	—	—	—	—	—	—	—	41	46	49	50	55	60	60	65	—	—	—	—
	—	—	—	—	—	—	—	—	*135*	*150*	*160*	*165*	*180*	*195*	*195*	*215*	—	—	—	—
S2	—	—	—	—	—	—	—	—	33	37	39	42	42	47	50	55	—	—	—	—
	—	—	—	—	—	—	—	—	*110*	*120*	*130*	*140*	*140*	*155*	*165*	*180*	—	—	—	—
S3	—	—	—	—	—	—	—	—	29	32	34	37	37	42	44	47	—	—	—	—
	—	—	—	—	—	—	—	—	*95*	*105*	*110*	*120*	*120*	*140*	*145*	*155*	—	—	—	—
S11	—	—	—	—	—	—	—	—	55	65	70	75	75	80	85	95	—	—	—	—
	—	—	—	—	—	—	—	—	*180*	*215*	*230*	*245*	*245*	*260*	*280*	*310*	—	—	—	—
S12	—	—	—	—	—	—	—	—	40	44	47	50	50	55	60	65	—	—	—	—
	—	—	—	—	—	—	—	—	*130*	*145*	*155*	*165*	*165*	*180*	*195*	*215*	—	—	—	—
S13	—	—	—	—	—	—	—	—	23	26	27	29	30	33	35	37	—	—	—	—
	—	—	—	—	—	—	—	—	*75*	*85*	*90*	*95*	*100*	*110*	*115*	*120*	—	—	—	—
H5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
H21	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



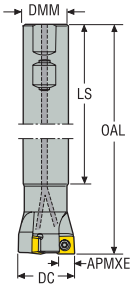
R217/220.79-12

The R217/220.79 for SCET12 inserts are strong and robust plunge mill.

- Cutter range 32-160 mm (1.25 - 6 inch)
- Max radial depth of cut: 11 mm (.433 inch)
- Insert corner radii range 1.2-3.1 mm (.047 - .122 inch)

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R217.79-SC..12 – Metric



- For insert selection and cutting data recommendations, see page(s) 719-720
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			mm		mm	mm	mm	mm		kg	
R217.79-2532.3-12A	00097786	Weldon	32,0	2	11,0	25,0	150,0	200,0	12100	0,7	SC..1206
R217.79-3240.3-12A	00097787	Weldon	40,0	3	11,0	32,0	150,0	200,0	10800	1,1	SC..1206

Spare Parts

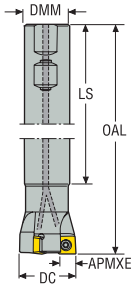
For cutter	Insert screw
R217.79-..	C45011-T20P

Accessories

Torque key	Torque value
T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217.79-SC..12 – Inch



- For insert selection and cutting data recommendations, see page(s) 719-720
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DMM	LS	OAL	RPMX	Weight	Insert
			Inch		Inch	Inch	Inch	Inch		lbs	
R217.79-01.25-3-12A	00057587	Weldon	1.250	2	0.433	1.000	5.906	7.874	12100	1.980	SC..1206
R217.79-01.50-3-12A	00057588	Weldon	1.500	3	0.433	1.250	5.906	7.874	10800	2.870	SC..1206

Spare Parts

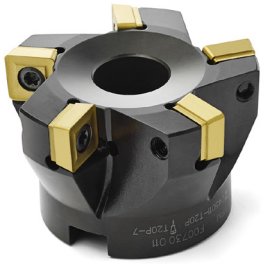
Accessories

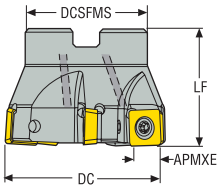
For cutter	Insert screw	Torque key	Torque value
R217.79-..	C45011-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Square shoulder and slot milling cutters
Helical milling cutters
Face milling cutters
Disc milling cutters
High feed milling cutters
Copy milling cutters
Plunge milling cutters
Chamfer milling cutters
Spot facing cutters
Inserts

R220.79-SC..12 – Metric



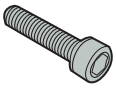


- For insert selection and cutting data recommendations, see page(s) 719-720
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm		mm	mm	kg		
R220.79-0050-12A	00030330	Arbor	50,0	4	11,0	22,0	–	42,0	40,0	0,3	9700	SC..1206
R220.79-0063-12A	00030331	Arbor	63,0	5	11,0	22,0	–	47,0	40,0	0,5	8600	SC..1206
R220.79-0080-12A	00030332	Arbor	80,0	6	11,0	27,0	–	62,0	50,0	1,0	7600	SC..1206
R220.79-0100-12A	00030335	Arbor	100,0	7	11,0	32,0	–	77,0	50,0	1,6	7000	SC..1206
R220.79-0125-12	00069980	Arbor	125,0	8	11,0	40,0	–	90,0	63,0	2,9	6300	SC..1206

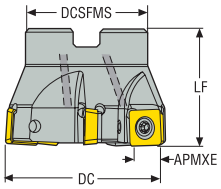
Spare Parts

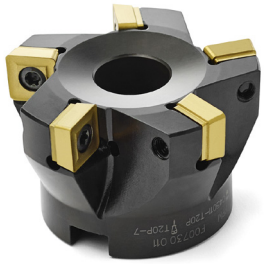
Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.79-0050-0063	220.17-692	C45011-T20P	T00-20P50	5.0NM
R220.79-0080	–	C45011-T20P	T00-20P50	5.0NM
R220.79-0100-0125	–	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.79-SC..12 – Inch





- For insert selection and cutting data recommendations, see page(s) 719-720
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch		Inch	Inch		Inch	Inch	lbs		
R220.79-02.00-12A	00039776	Shell mill	2.000	4	0.433	0.750	–	1.850	1.500	0.880	9700	SC..1206
R220.79-02.50-12A	00039777	Shell mill	2.500	5	0.433	0.750	–	1.850	1.500	1.320	8600	SC..1206
R220.79-03.00-12A	00039778	Shell mill	3.000	6	0.433	1.000	–	2.441	2.000	2.650	7600	SC..1206

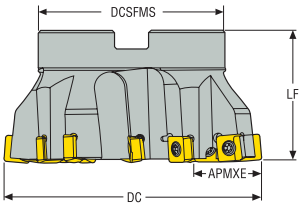
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.79-02.00-02.50	UC6S3/8UNFX1	C45011-T20P	T00-20P50	44.3IN.LBS
R220.79-03.00	UC6S1/2UNFX1-1/4	C45011-T20P	T00-20P50	44.3IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.79-SC..12 – Metric

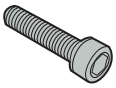


- For insert selection and cutting data recommendations, see page(s) 719-720
- For complete insert programme, see page(s) 751
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXE	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm		mm	mm		mm	mm	kg		
R220.79-0100-20	00045683	Arbor	100,0	4	20,0	32,0	–	77,0	50,0	1,3	7000	SC..1206
R220.79-0125-30	00091797	Arbor	125,0	4	30,0	40,0	–	90,0	63,0	2,6	6300	SC..1206
R220.79-8160-40	00094578	Arbor	160,0	4	40,0	40,0	–	90,0	64,0	4,0	5600	SC..1206

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R220.79-0100	–	C45011-T20P	T00-20P50	5.0NM
R220.79-0125	MC6S20X40	C45011-T20P	T00-20P50	5.0NM
R220.79-8160	–	C45011-T20P	T00-20P50	5.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.79-12 – Insert selection – mm/*Inch*

SMG		f_z	a_{so}			
			100%	70%	50%	30%
P1	SCET120612T-M11 MP2501	0,15 *0.0060*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P2	SCET120612T-M11 MP2501	0,16 *0.0065*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P3	SCET120612T-M11 MP2501	0,15 *0.0060*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P4	SCET120612T-M11 MP2501	0,15 *0.0060*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P5	SCET120612T-M11 MP2501	0,14 *0.0055*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P6	SCET120612T-M11 MP2501	0,14 *0.0055*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P7	SCET120612T-M11 MP2501	0,14 *0.0055*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P8	SCET120612T-M11 MP2501	0,15 *0.0060*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P11	SCET120612T-M11 MP2501	0,14 *0.0055*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
P12	SCET120612T-M11 MP2501	0,095 *0.0038*	6,0 *0.24*	6,0 *0.24*	6,0 *0.24*	7,0 *0.28*
M1	SCET120612T-M14 T350M	0,20 *0.0080*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
M2	SCET120612T-M14 T350M	0,18 *0.0070*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
M3	SCET120612T-M14 T350M	0,15 *0.0060*	6,0 *0.24*	6,0 *0.24*	6,0 *0.24*	7,0 *0.28*
M4	SCET120612T-M14 T350M	0,13 *0.0050*	4,5 *0.18*	4,5 *0.18*	4,5 *0.18*	5,0 *0.20*
M5	SCET120612T-M14 T350M	0,13 *0.0050*	4,5 *0.18*	4,5 *0.18*	4,5 *0.18*	5,0 *0.20*
K1	SCET120612T-M14 MK1500	0,20 *0.0080*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
K2	SCET120612T-M14 MK1500	0,18 *0.0070*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
K3	SCET120612T-M14 MK1500	0,18 *0.0070*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
K4	SCET120612T-M14 MK1500	0,18 *0.0070*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
K5	SCET120612T-M14 MK1500	0,16 *0.0065*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
K6	SCET120612T-M14 MK1500	0,18 *0.0070*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
K7	SCET120612T-M14 MK1500	0,16 *0.0065*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
N1	SCET120612T-M11 F40M	0,20 *0.0080*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
N2	SCET120612T-M11 F40M	0,20 *0.0080*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
N3	SCET120612T-M11 F40M	0,20 *0.0080*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
N11	SCET120612T-M11 F40M	0,20 *0.0080*	8,0 *0.32*	8,0 *0.32*	8,0 *0.32*	9,0 *0.36*
S1	SCET120612T-M14 T350M	0,13 *0.0050*	4,5 *0.18*	4,5 *0.18*	4,5 *0.18*	5,0 *0.20*
S2	SCET120612T-M14 T350M	0,13 *0.0050*	4,5 *0.18*	4,5 *0.18*	4,5 *0.18*	5,0 *0.20*
S3	SCET120612T-M14 T350M	0,12 *0.0048*	4,5 *0.18*	4,5 *0.18*	4,5 *0.18*	5,0 *0.20*
S11	SCET120612T-M14 F40M	0,15 *0.0060*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
S12	SCET120612T-M14 F40M	0,15 *0.0060*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
S13	SCET120612T-M14 F40M	0,13 *0.0050*	4,5 *0.18*	4,5 *0.18*	4,5 *0.18*	5,0 *0.20*
H5	SCET120612T-MD15 MP1501	0,13 *0.0050*	6,0 *0.24*	6,0 *0.24*	6,0 *0.24*	7,0 *0.28*
H8	SCET120612T-MD15 MP1501	0,10 *0.0040*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
H11	SCET120612T-MD15 MP1501	0,13 *0.0050*	6,0 *0.24*	6,0 *0.24*	6,0 *0.24*	7,0 *0.28*
H12	SCET120612T-MD15 MP1501	0,10 *0.0040*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*
H21	SCET120612T-MD15 MP1501	0,10 *0.0040*	5,0 *0.20*	5,0 *0.20*	5,0 *0.20*	6,0 *0.24*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.79-12 – Cutting data v_c = (m/min)/*(sf/min)*

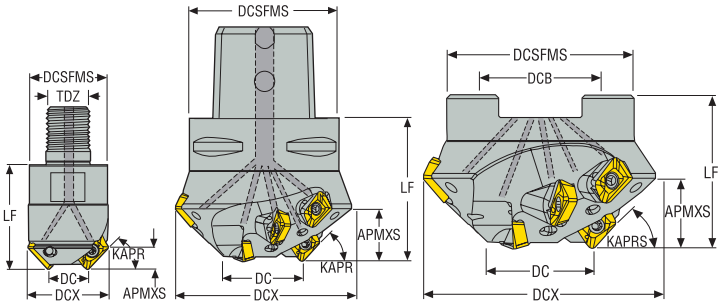
SMG	MP1501				MP2501				T350M				F40M				MK1500			
	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%	100%	70%	50%	30%
P1	270	305	320	345	240	270	285	305	190	215	225	240	165	185	195	210	—	—	—	—
	890	*1000*	*1050*	*1125*	*790*	*890*	*940*	*1000*	*620*	*710*	*740*	*790*	*540*	*610*	*640*	*690*	—	—	—	—
P2	260	290	305	325	230	255	270	290	185	210	220	235	160	180	190	205	—	—	—	—
	850	*950*	*1000*	*1075*	*750*	*840*	*890*	*950*	*610*	*690*	*720*	*770*	*520*	*590*	*620*	*670*	—	—	—	—
P3	230	255	270	285	200	225	240	255	165	180	195	205	140	160	165	180	—	—	—	—
	750	*840*	*890*	*940*	*660*	*740*	*790*	*840*	*540*	*590*	*640*	*670*	*460*	*520*	*540*	*590*	—	—	—	—
P4	200	225	235	255	180	200	210	225	145	160	170	180	125	140	145	160	—	—	—	—
	660	*740*	*770*	*840*	*590*	*660*	*690*	*740*	*475*	*520*	*560*	*590*	*410*	*460*	*475*	*520*	—	—	—	—
P5	195	220	230	245	175	195	205	220	140	155	165	175	120	135	145	155	—	—	—	—
	640	*720*	*750*	*800*	*570*	*640*	*670*	*720*	*460*	*510*	*540*	*570*	*395*	*445*	*475*	*510*	—	—	—	—
P6	220	245	260	275	195	215	230	245	155	175	185	200	135	150	160	170	—	—	—	—
	720	*800*	*850*	*900*	*640*	*710*	*750*	*800*	*510*	*570*	*610*	*660*	*445*	*490*	*520*	*560*	—	—	—	—
P7	210	230	245	260	185	205	215	230	150	165	175	185	130	145	150	165	—	—	—	—
	690	*750*	*800*	*850*	*610*	*670*	*710*	*750*	*490*	*540*	*570*	*610*	*425*	*475*	*490*	*540*	—	—	—	—
P8	190	215	225	240	170	190	200	215	135	155	160	175	120	135	140	150	—	—	—	—
	620	*710*	*740*	*790*	*560*	*620*	*660*	*710*	*445*	*510*	*520*	*570*	*395*	*445*	*460*	*490*	—	—	—	—
P11	200	225	240	255	180	200	210	225	145	160	170	180	125	140	150	160	—	—	—	—
	660	*740*	*790*	*840*	*590*	*660*	*690*	*740*	*475*	*520*	*560*	*590*	*410*	*460*	*490*	*520*	—	—	—	—
P12	135	150	160	170	120	135	140	150	100	110	115	125	85	95	100	105	—	—	—	—
	445	*490*	*520*	*560*	*395*	*445*	*460*	*490*	*330*	*360*	*375*	*410*	*280*	*310*	*330*	*345*	—	—	—	—
M1	—	—	—	—	165	185	195	210	145	160	170	180	130	145	155	165	—	—	—	—
	—	—	—	—	*540*	*610*	*640*	*690*	*475*	*520*	*560*	*590*	*425*	*475*	*510*	*540*	—	—	—	—
M2	—	—	—	—	140	155	165	175	120	135	140	150	110	120	130	140	—	—	—	—
	—	—	—	—	*460*	*510*	*540*	*570*	*395*	*445*	*460*	*490*	*360*	*395*	*425*	*460*	—	—	—	—
M3	—	—	—	—	115	130	135	145	100	110	115	125	90	100	105	115	—	—	—	—
	—	—	—	—	*375*	*425*	*445*	*475*	*330*	*360*	*375*	*410*	*295*	*330*	*345*	*375*	—	—	—	—
M4	—	—	—	—	90	100	105	115	80	85	90	100	70	80	85	90	—	—	—	—
	—	—	—	—	*295*	*330*	*345*	*375*	*260*	*280*	*295*	*330*	*230*	*260*	*280*	*295*	—	—	—	—
M5	—	—	—	—	75	85	90	95	65	70	75	80	60	65	70	75	—	—	—	—
	—	—	—	—	*245*	*280*	*295*	*310*	*215*	*230*	*245*	*260*	*195*	*215*	*230*	*245*	—	—	—	—
K1	205	230	240	260	180	205	215	230	150	165	175	185	130	145	150	160	240	270	285	305
	670	*750*	*790*	*850*	*590*	*670*	*710*	*750*	*490*	*540*	*570*	*610*	*425*	*475*	*490*	*520*	*790*	*890*	*940*	*1000*
K2	185	205	220	235	165	185	195	210	135	150	155	170	115	130	135	145	215	240	255	275
	610	*670*	*720*	*770*	*540*	*610*	*640*	*690*	*445*	*490*	*510*	*560*	*375*	*425*	*445*	*475*	*710*	*790*	*840*	*900*
K3	155	175	185	200	140	155	165	175	110	125	130	140	100	110	115	125	185	205	215	230
	510	*570*	*610*	*660*	*460*	*510*	*540*	*570*	*360*	*410*	*425*	*460*	*330*	*360*	*375*	*410*	*610*	*670*	*710*	*750*
K4	150	165	175	190	135	150	155	170	105	120	125	135	95	105	110	120	175	195	205	220
	490	*540*	*570*	*620*	*445*	*490*	*510*	*560*	*345*	*395*	*410*	*445*	*310*	*345*	*360*	*395*	*570*	*640*	*670*	*720*
K5	90	100	110	115	80	90	95	100	65	75	80	85	60	65	70	75	110	120	125	135
	295	*330*	*360*	*375*	*260*	*295*	*310*	*330*	*215*	*245*	*260*	*280*	*195*	*215*	*230*	*245*	*360*	*395*	*410*	*445*
K6	130	150	155	165	115	130	140	150	95	105	110	120	80	90	95	105	155	170	180	195
	425	*490*	*510*	*540*	*375*	*425*	*460*	*490*	*310*	*345*	*360*	*395*	*260*	*295*	*310*	*345*	*510*	*560*	*590*	*640*
K7	115	130	140	150	105	115	120	130	85	95	100	105	75	80	85	95	140	155	165	175
	375	*425*	*460*	*490*	*345*	*375*	*395*	*425*	*280*	*310*	*330*	*345*	*245*	*260*	*280*	*310*	*460*	*510*	*540*	*570*
N1	—	—	—	—	—	—	—	—	—	—	—	—	940	1050	1100	1175	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*3075*	*3450*	*3600*	*3850*	—	—	—	—
N2	—	—	—	—	—	—	—	—	—	—	—	—	380	420	445	480	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*1250*	*1375*	*1450*	*1575*	—	—	—	—
N3	—	—	—	—	—	—	—	—	—	—	—	—	255	280	300	320	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*840*	*920*	*980*	*1050*	—	—	—	—
N11	—	—	—	—	—	—	—	—	—	—	—	—	290	320	340	365	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	*950*	*1050*	*1125*	*1200*	—	—	—	—
S1	—	—	—	—	44	49	50	55	36	40	43	46	33	37	39	42	—	—	—	—
	—	—	—	—	*145*	*160*	*165*	*180*	*120*	*130*	*140*	*150*	*110*	*120*	*130*	*140*	—	—	—	—
S2	—	—	—	—	35	39	41	45	29	33	34	37	27	30	31	34	—	—	—	—
	—	—	—	—	*115*	*130*	*135*	*150*	*95*	*110*	*110*	*120*	*90*	*100*	*100*	*110*	—	—	—	—
S3	—	—	—	—	31	34	36	39	26	29	30	33	23	26	28	30	—	—	—	—
	—	—	—	—	*100*	*110*	*120*	*130*	*85*	*95*	*100*	*110*	*75*	*85*	*90*	*100*	—	—	—	—
S11	—	—	—	—	60	70	70	75	50	55	60	65	45	50	55	55	—	—	—	—
	—	—	—	—	*195*	*230*	*230*	*245*	*165*	*180*	*195*	*215*	*150*	*165*	*180*	*180*	—	—	—	—
S12	—	—	—	—	42	47	50	55	35	39	41	44	31	35	37	40	—	—	—	—
	—	—	—	—	*140*	*155*	*165*	*180*	*115*	*130*	*135*	*145*	*100*	*115*	*120*	*130*	—	—	—	—
S13	—	—	—	—	24	27	29	31	20	23	24	26	19	21	22	24	—	—	—	—
	—	—	—	—	*80*	*90*	*95*	*100*	*65*	*75*	*80*	*85*	*60*	*70*	*70*	*80*	—	—	—	—
H5	45	50	55	55	36	40	43	46	32	36	38	41	28	31	33	36	—	—	—	—
	150	*165*	*180*	*180*	*120*	*130*	*140*	*150*	*105*	*120*	*125*	*135*	*90*	*100*	*110*	*120*	—	—	—	—
H8	48	55	55	60	39	43	46	49	35	39	41	44	30	34	36	38	—	—	—	—
	155	*180*	*180*	*195*	*130*	*140*	*150*	*160*	*115*	*130*	*135*	*145*	*100*	*110*	*120*	*125*	—	—	—	—
H11	55	65	65	70	46	50	55	60	41	46	49	50	36	40	42	45	—	—	—	—
	180	*215*	*215*	*230*	*150*	*165*	*180*	*195*	*135*	*150*	*160*	*165*	*120*	*130*	*140*	*150*	—	—	—	—
H12	85	95	100	110	75	85	90	95	65	70	75	80	55	60	65	70	—	—	—	—
	280	*310*	*330*	*360*	*245*	*280*	*295*	*310*	*215*	*230*	*245*	*260*	*180*	*195*	*215*	*230*	—	—	—	—
H21	48	55	55	60	39	43	46	49	35	39	41	44	30	34	36	38	—	—	—	—
	155	*180*	*180*	*195*	*130*	*140*	*150*	*160*	*115*	*130*	*135*	*145*	*100*	*110*	*120*	*125*	—	—	—	—

Chamfer Turbo12

R217/220.49-XO12 Chamfer mills, for XOMX12 inserts with 2 cutting edges and is available in many different grades for most common workpiece materials.

- Chamfer angle 30°, 45°, 60° and 75°
- Max. depth of cut 31 mm (1.22 inch) with the 75° milling cutter
- Front chamfering
- Available in combimaster, Seco-Capto or for arbor mounting

R217/220.49-XO12 – Metric

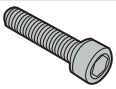


- For insert selection and cutting data recommendations, see page(s) 724-726
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	KAPRS°	DC	DCX	APMXS	ZEFP	ZNP	DCB	DCSFMS	LF	RPMX	Weight	Insert
				mm	mm	mm			mm	mm	mm		kg	
R217.49-1216.RE-XO12-60.2A	02669572	Combimaster	60,0	16,0	27,0	9,0	2	2	–	23,0	30,0	20100	0,1	XO.X12
R217.49-1220.RE-XO12-75.2A	02669576	Combimaster	75,0	20,0	25,4	11,0	2	2	–	23,0	30,0	20500	0,1	XO.X12
R217.49-1616.RE-XO12-45.2A	02669571	Combimaster	45,0	16,0	30,8	8,0	2	2	–	30,0	40,0	18600	0,2	XO.X12
R217.49-1620.RE-XO12-30.3A	02669573	Combimaster	30,0	20,0	39,8	5,5	3	3	–	30,0	40,0	16400	0,3	XO.X12
R217.49-1620.RE-XO12-45.3A	02669574	Combimaster	45,0	20,0	34,8	7,7	3	3	–	30,0	40,0	17400	0,3	XO.X12
R217.49-1620.RE-XO12-60.3A	02669575	Combimaster	60,0	20,0	30,5	9,0	3	3	–	30,0	40,0	18400	0,2	XO.X12
R220.49-0035-15-XO12-30.3A	02669634	Arbor	30,0	35,0	91,9	15,9	3	9	27,0	62,0	50,0	10700	1,1	XO.X12
R220.49-0035-22-XO12-45.3A	02669637	Arbor	45,0	35,0	79,4	22,5	3	9	27,0	62,0	50,0	11600	0,8	XO.X12
R220.49-0035-28-XO12-60.3A	02669638	Arbor	60,0	35,0	67,0	28,0	3	9	27,0	62,0	50,0	12600	0,6	XO.X12
R220.49-0035-31-XO12-75.3A	02669639	Arbor	75,0	35,0	51,5	31,0	3	9	22,0	47,0	50,0	14400	0,4	XO.X12

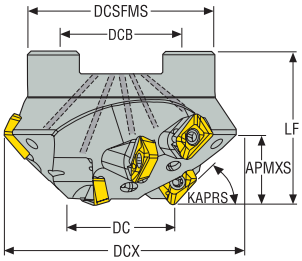
Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
				
R217.49 dia 16 45/60°	–	C03507-T10P	T00-10P30	3.0NM
R217.49 dia 20 60/75°	–	C03507-T10P	T00-10P30	3.0NM
R217.49 dia 20 30/45°	–	C03509-T10P	T00-10P30	3.0NM
R220.49-... 30/45/60°	MC6S12X35	C03509-T10P	T00-10P30	3.0NM
R220.49-...75°	MC6S10X40	C03509-T10P	T00-10P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.49-XO12 – Inch



- For insert selection and cutting data recommendations, see page(s) 724-726
- For complete insert programme, see page(s) 778, 779
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	KAPRS°	DC	DCX	APMXS	ZEFP	ZNP	DCB	DCSFMS	LF	RPMX	Weight	Insert
				Inch	Inch	Inch			Inch	Inch	Inch		lbs	
R220.49-01.38-15-XO12-30.3A	02670045	Arbor	30,0	1.378	3.618	0.626	3	9	1.000	2.441	1.969	14400	2.200	XO.X12
R220.49-01.38-22-XO12-45.3A	02670048	Arbor	45,0	1.378	3.126	0.886	3	9	1.000	2.441	1.969	14400	1.760	XO.X12
R220.49-01.38-28-XO12-60.3A	02670049	Arbor	60,0	1.378	2.638	1.110	3	9	1.000	2.441	1.969	14400	1.320	XO.X12
R220.49-01.38-31-XO12-75.3A	02670051	Arbor	75,0	1.378	2.028	1.244	3	9	0.750	1.850	1.969	14400	0.880	XO.X12

Spare Parts

Accessories

For cutter	Arbor screw	Insert screw	Torque key	Torque value
R220.49-... 30/45/60°	UC6S1/2UNFX1-1/2	C03509-T10P	T00-10P30	26.6IN.LBS
R220.49-...75°	UC6S3/8UNFX11/2	C03509-T10P	T00-10P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.49-XO12 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	XOMX120408TR-ME08 F40M	0,18 *0.0070*	0,22 *0.0085*	0,36 *0.014*
P2	XOMX120408TR-ME08 F40M	0,18 *0.0070*	0,22 *0.0085*	0,38 *0.015*
P3	XOMX120408TR-ME08 MP2501	0,17 *0.0065*	0,22 *0.0085*	0,36 *0.014*
P4	XOMX120408TR-M12 MP2501	0,20 *0.0080*	0,25 *0.010*	0,42 *0.017*
P5	XOMX120408TR-M12 MP2501	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
P6	XOMX120408TR-M12 MP2501	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
P7	XOMX120408TR-M12 MP2501	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
P8	XOMX120408TR-M12 MP2501	0,20 *0.0080*	0,25 *0.010*	0,42 *0.017*
P11	XOMX120408TR-M12 T350M	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
P12	XOEX120408R-M07 MP3000	0,090 *0.0036*	0,11 *0.0044*	0,18 *0.0070*
M1	XOEX120408R-M07 F40M	0,14 *0.0055*	0,18 *0.0070*	0,30 *0.012*
M2	XOEX120408R-M07 F40M	0,13 *0.0050*	0,16 *0.0065*	0,26 *0.010*
M3	XOEX120408R-M07 F40M	0,10 *0.0040*	0,13 *0.0050*	0,22 *0.0085*
M4	XOEX120408R-M07 T350M	0,090 *0.0036*	0,11 *0.0044*	0,19 *0.0075*
M5	XOEX120408R-M07 T350M	0,090 *0.0036*	0,11 *0.0044*	0,19 *0.0075*
K1	XOMX120408TR-M12 MK2050	0,22 *0.0085*	0,26 *0.010*	0,44 *0.017*
K2	XOMX120408TR-M12 MK2050	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
K3	XOMX120408TR-M12 MK2050	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
K4	XOMX120408TR-M12 MK2050	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
K5	XOMX120408TR-M12 MK2050	0,18 *0.0070*	0,22 *0.0085*	0,36 *0.014*
K6	XOMX120408TR-M12 MK2050	0,19 *0.0075*	0,24 *0.0095*	0,40 *0.016*
K7	XOMX120408TR-M12 MK2050	0,18 *0.0070*	0,22 *0.0085*	0,36 *0.014*
N1	XOEX120408FR-E06 H15	0,16 *0.0065*	0,20 *0.0080*	0,34 *0.013*
N2	XOEX120408FR-E06 H15	0,16 *0.0065*	0,20 *0.0080*	0,34 *0.013*
N3	XOEX120408FR-E06 H15	0,16 *0.0065*	0,20 *0.0080*	0,34 *0.013*
N11	XOEX120408FR-E06 H15	0,16 *0.0065*	0,20 *0.0080*	0,34 *0.013*
S1	XOEX120408R-M07 F40M	0,090 *0.0036*	0,11 *0.0044*	0,19 *0.0075*
S2	XOEX120408R-M07 F40M	0,090 *0.0036*	0,11 *0.0044*	0,19 *0.0075*
S3	XOEX120408R-M07 F40M	0,085 *0.0034*	0,10 *0.0040*	0,17 *0.0065*
S11	XOEX120408R-M07 MS2050	0,10 *0.0040*	0,13 *0.0050*	0,22 *0.0085*
S12	XOEX120408R-M07 MS2050	0,10 *0.0040*	0,13 *0.0050*	0,22 *0.0085*
S13	XOEX120408R-M07 MS2050	0,090 *0.0036*	0,11 *0.0044*	0,19 *0.0075*
H5	XOMX120408TR-MD13 MP3000	0,14 *0.0055*	0,17 *0.0065*	0,30 *0.012*
H8	XOMX120408TR-MD13 MP3000	0,11 *0.0044*	0,13 *0.0050*	0,22 *0.0085*
H11	XOMX120408TR-MD13 MP1501	0,14 *0.0055*	0,17 *0.0065*	0,30 *0.012*
H12	XOMX120408TR-MD13 MP1501	0,11 *0.0044*	0,13 *0.0050*	0,22 *0.0085*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R217/220.49-XO12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	MP1501			MP2050			MP2501			MP3000			MM4500			MK1500		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	185 *610*	215 *710*	230 *750*	190 *620*	215 *710*	230 *750*	175 *570*	205 *670*	220 *720*	170 *560*	200 *660*	215 *710*	150 *490*	175 *570*	190 *620*	— —	— —	— —
P2	185 *610*	210 *690*	225 *740*	190 *620*	215 *710*	230 *750*	175 *570*	205 *670*	215 *710*	170 *560*	200 *660*	210 *690*	145 *475*	175 *570*	190 *620*	— —	— —	— —
P3	175 *570*	200 *660*	215 *710*	180 *590*	205 *670*	220 *720*	165 *540*	190 *620*	205 *670*	160 *520*	190 *620*	200 *660*	135 *445*	165 *540*	180 *590*	— —	— —	— —
P4	165 *540*	190 *620*	205 *670*	170 *560*	195 *640*	210 *690*	155 *510*	185 *610*	195 *640*	150 *490*	180 *590*	195 *640*	130 *425*	155 *510*	170 *560*	— —	— —	— —
P5	160 *520*	190 *620*	205 *670*	165 *540*	190 *620*	205 *670*	155 *510*	180 *590*	195 *640*	150 *490*	175 *570*	190 *620*	125 *410*	155 *510*	165 *540*	— —	— —	— —
P6	170 *560*	200 *660*	210 *690*	175 *570*	200 *660*	215 *710*	160 *520*	190 *620*	205 *670*	160 *520*	185 *610*	200 *660*	135 *445*	160 *520*	175 *570*	— —	— —	— —
P7	165 *540*	195 *640*	210 *690*	170 *560*	195 *640*	210 *690*	155 *510*	185 *610*	200 *660*	155 *510*	180 *590*	195 *640*	130 *425*	155 *510*	170 *560*	— —	— —	— —
P8	160 *520*	190 *620*	200 *660*	165 *540*	190 *620*	205 *670*	150 *490*	180 *590*	195 *640*	150 *490*	175 *570*	190 *620*	125 *410*	150 *490*	165 *540*	— —	— —	— —
P11	165 *540*	190 *620*	205 *670*	165 *540*	195 *640*	210 *690*	155 *510*	180 *590*	195 *640*	150 *490*	180 *590*	190 *620*	130 *425*	155 *510*	170 *560*	— —	— —	— —
P12	130 *425*	155 *510*	175 *570*	135 *445*	160 *520*	175 *570*	120 *395*	150 *490*	165 *540*	120 *395*	145 *475*	160 *520*	95 *310*	120 *395*	135 *445*	— —	— —	— —
M1	— —	— —	— —	165 *540*	190 *620*	205 *670*	150 *490*	180 *590*	190 *620*	150 *490*	175 *570*	190 *620*	135 *445*	165 *540*	175 *570*	— —	— —	— —
M2	— —	— —	— —	150 *490*	175 *570*	190 *620*	135 *445*	165 *540*	180 *590*	135 *445*	165 *540*	175 *570*	120 *395*	150 *490*	165 *540*	— —	— —	— —
M3	— —	— —	— —	130 *425*	155 *510*	170 *560*	120 *395*	145 *475*	160 *520*	120 *395*	145 *475*	160 *520*	105 *345*	130 *425*	150 *490*	— —	— —	— —
M4	— —	— —	— —	110 *360*	135 *445*	155 *510*	100 *330*	125 *410*	145 *475*	100 *330*	125 *410*	140 *460*	85 *280*	110 *360*	125 *410*	— —	— —	— —
M5	— —	— —	— —	95 *310*	120 *395*	140 *460*	85 *280*	110 *360*	130 *425*	85 *280*	110 *360*	130 *425*	70 *230*	95 *310*	115 *375*	— —	— —	— —
K1	165 *540*	195 *640*	210 *690*	170 *560*	195 *640*	210 *690*	155 *510*	185 *610*	200 *660*	155 *510*	180 *590*	195 *640*	— —	— —	— —	185 *610*	210 *690*	225 *740*
K2	160 *520*	185 *610*	200 *660*	160 *520*	190 *620*	200 *660*	150 *490*	175 *570*	190 *620*	145 *475*	170 *560*	185 *610*	— —	— —	— —	175 *570*	200 *660*	215 *710*
K3	145 *475*	175 *570*	185 *610*	150 *490*	175 *570*	190 *620*	135 *445*	165 *540*	180 *590*	135 *445*	160 *520*	175 *570*	— —	— —	— —	165 *540*	190 *620*	205 *670*
K4	140 *460*	170 *560*	185 *610*	145 *475*	170 *560*	185 *610*	135 *445*	160 *520*	175 *570*	130 *425*	155 *510*	170 *560*	— —	— —	— —	160 *520*	185 *610*	200 *660*
K5	105 *345*	130 *425*	145 *475*	105 *345*	135 *445*	150 *490*	95 *310*	125 *410*	140 *460*	90 *295*	120 *395*	135 *445*	— —	— —	— —	120 *395*	150 *490*	165 *540*
K6	135 *445*	160 *520*	175 *570*	135 *445*	165 *540*	175 *570*	125 *410*	150 *490*	165 *540*	120 *395*	145 *475*	160 *520*	— —	— —	— —	150 *490*	175 *570*	190 *620*
K7	125 *410*	150 *490*	165 *540*	125 *410*	155 *510*	165 *540*	115 *375*	140 *460*	155 *510*	110 *360*	140 *460*	150 *490*	— —	— —	— —	140 *460*	170 *560*	180 *590*
N1	— —	— —	— —	— —	— —	— —	— —	— —	— —	300 *980*	330 *1075*	345 *1125*	— —	— —	— —	— —	— —	— —
N2	— —	— —	— —	— —	— —	— —	— —	— —	— —	235 *770*	260 *850*	275 *900*	— —	— —	— —	— —	— —	— —
N3	— —	— —	— —	— —	— —	— —	— —	— —	— —	205 *670*	230 *750*	245 *800*	— —	— —	— —	— —	— —	— —
N11	— —	— —	— —	— —	— —	— —	— —	— —	— —	215 *710*	240 *790*	255 *840*	— —	— —	— —	— —	— —	— —
S1	— —	— —	— —	60 *195*	80 *260*	100 *330*	50 *165*	70 *230*	90 *295*	47 *155*	65 *215*	85 *280*	26 *85*	36 *120*	46 *150*	— —	— —	— —
S2	— —	— —	— —	47 *155*	65 *215*	85 *280*	40 *130*	55 *180*	75 *245*	38 *125*	55 *180*	70 *230*	21 *70*	29 *95*	37 *120*	— —	— —	— —
S3	— —	— —	— —	41 *135*	55 *180*	75 *245*	35 *115*	50 *165*	65 *215*	33 *110*	47 *155*	60 *195*	18 *60*	25 *80*	33 *110*	— —	— —	— —
S11	— —	— —	— —	85 *280*	105 *345*	125 *410*	70 *230*	95 *310*	115 *375*	65 *215*	90 *295*	110 *360*	37 *120*	50 *165*	65 *215*	— —	— —	— —
S12	— —	— —	— —	60 *195*	80 *260*	95 *310*	49 *160*	70 *230*	85 *280*	46 *150*	65 *215*	80 *260*	34 *110*	47 *155*	60 *195*	— —	— —	— —
S13	— —	— —	— —	33 *110*	46 *150*	60 *195*	28 *90*	40 *130*	50 *165*	27 *90*	38 *125*	48 *155*	19 *60*	27 *90*	35 *115*	— —	— —	— —
H5	55 *180*	75 *245*	90 *295*	49 *160*	70 *230*	85 *280*	43 *140*	60 *195*	75 *245*	42 *140*	60 *195*	70 *230*	— —	— —	— —	— —	— —	— —
H8	55 *180*	80 *260*	95 *310*	50 *165*	70 *230*	90 *295*	45 *150*	65 *215*	80 *260*	44 *145*	60 *195*	80 *260*	— —	— —	— —	— —	— —	— —
H11	65 *215*	90 *295*	110 *360*	60 *195*	85 *280*	105 *345*	55 *180*	75 *245*	90 *295*	55 *180*	75 *245*	90 *295*	— —	— —	— —	— —	— —	— —
H12	95 *310*	120 *395*	140 *460*	100 *330*	125 *410*	140 *460*	90 *295*	115 *375*	130 *425*	85 *280*	110 *360*	125 *410*	— —	— —	— —	— —	— —	— —

R217/220.49-XO12 – Cutting data v_c = (m/min)/*(sf/min)*

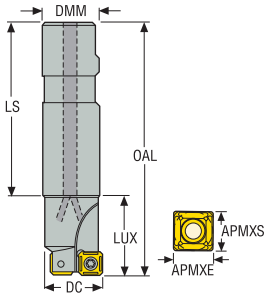
SMG	MK2050			MS2050			MS2500			T350M			F40M			H15		
	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%	100%	30%	10%
P1	175	205	215	170	200	215	195	225	240	165	195	210	155	185	200	—	—	—
	570	*670*	*710*	*560*	*660*	*710*	*640*	*740*	*790*	*540*	*640*	*690*	*510*	*610*	*660*	—	—	—
P2	175	200	215	170	200	210	195	220	235	165	195	205	155	180	195	—	—	—
	570	*660*	*710*	*560*	*660*	*690*	*640*	*720*	*770*	*540*	*640*	*670*	*510*	*590*	*640*	—	—	—
P3	165	190	205	160	185	200	185	210	225	155	180	195	145	170	185	—	—	—
	540	*620*	*670*	*520*	*610*	*660*	*610*	*690*	*740*	*510*	*590*	*640*	*475*	*560*	*610*	—	—	—
P4	155	180	195	150	180	190	175	205	215	145	175	185	135	160	175	—	—	—
	510	*590*	*640*	*490*	*590*	*620*	*570*	*670*	*710*	*475*	*570*	*610*	*445*	*520*	*570*	—	—	—
P5	150	180	195	150	175	190	175	200	215	145	170	185	130	160	175	—	—	—
	490	*590*	*640*	*490*	*570*	*620*	*570*	*660*	*710*	*475*	*560*	*610*	*425*	*520*	*570*	—	—	—
P6	160	190	200	155	185	200	180	210	225	150	180	195	140	170	180	—	—	—
	520	*620*	*660*	*510*	*610*	*660*	*590*	*690*	*740*	*490*	*590*	*640*	*460*	*560*	*590*	—	—	—
P7	155	185	195	155	180	195	175	205	220	145	175	190	135	165	180	—	—	—
	510	*610*	*640*	*510*	*590*	*640*	*570*	*670*	*720*	*475*	*570*	*620*	*445*	*540*	*590*	—	—	—
P8	150	180	190	145	175	190	175	200	215	140	170	185	130	160	170	—	—	—
	490	*590*	*620*	*475*	*570*	*620*	*570*	*660*	*710*	*460*	*560*	*610*	*425*	*520*	*560*	—	—	—
P11	155	180	195	150	180	190	175	200	215	145	170	185	135	160	175	—	—	—
	510	*590*	*640*	*490*	*590*	*620*	*570*	*660*	*710*	*475*	*560*	*610*	*445*	*520*	*570*	—	—	—
P12	120	145	165	115	145	160	140	165	185	110	135	155	100	125	145	—	—	—
	395	*475*	*540*	*375*	*475*	*520*	*460*	*540*	*610*	*360*	*445*	*510*	*330*	*410*	*475*	—	—	—
M1	—	—	—	155	180	195	170	195	210	145	175	185	135	165	180	—	—	—
	—	—	—	*510*	*590*	*640*	*560*	*640*	*690*	*475*	*570*	*610*	*445*	*540*	*590*	—	—	—
M2	—	—	—	140	170	180	155	185	195	130	160	175	125	150	165	—	—	—
	—	—	—	*460*	*560*	*590*	*510*	*610*	*640*	*425*	*520*	*570*	*410*	*490*	*540*	—	—	—
M3	—	—	—	125	150	165	140	165	180	115	140	155	105	135	150	—	—	—
	—	—	—	*410*	*490*	*540*	*460*	*540*	*590*	*375*	*460*	*510*	*345*	*445*	*490*	—	—	—
M4	—	—	—	100	125	145	120	140	160	95	120	140	85	110	130	—	—	—
	—	—	—	*330*	*410*	*475*	*395*	*460*	*520*	*310*	*395*	*460*	*280*	*360*	*425*	—	—	—
M5	—	—	—	90	115	130	105	130	145	80	105	125	75	100	115	—	—	—
	—	—	—	*295*	*375*	*425*	*345*	*425*	*475*	*260*	*345*	*410*	*245*	*330*	*375*	—	—	—
K1	180	205	220	—	—	—	—	—	—	145	175	190	—	—	—	—	—	—
	590	*670*	*720*	—	—	—	—	—	—	*475*	*570*	*620*	—	—	—	—	—	—
K2	170	200	210	—	—	—	—	—	—	140	165	180	—	—	—	—	—	—
	560	*660*	*690*	—	—	—	—	—	—	*460*	*540*	*590*	—	—	—	—	—	—
K3	160	185	200	—	—	—	—	—	—	125	155	165	—	—	—	—	—	—
	520	*610*	*660*	—	—	—	—	—	—	*410*	*510*	*540*	—	—	—	—	—	—
K4	155	180	195	—	—	—	—	—	—	125	150	165	—	—	—	—	—	—
	510	*590*	*640*	—	—	—	—	—	—	*410*	*490*	*540*	—	—	—	—	—	—
K5	115	145	160	—	—	—	—	—	—	85	115	125	—	—	—	—	—	—
	375	*475*	*520*	—	—	—	—	—	—	*280*	*375*	*410*	—	—	—	—	—	—
K6	145	175	185	—	—	—	—	—	—	115	140	155	—	—	—	—	—	—
	475	*570*	*610*	—	—	—	—	—	—	*375*	*460*	*510*	—	—	—	—	—	—
K7	135	165	180	—	—	—	—	—	—	105	130	145	—	—	—	—	—	—
	445	*540*	*590*	—	—	—	—	—	—	*345*	*425*	*475*	—	—	—	—	—	—
N1	—	—	—	—	—	—	—	—	—	—	—	—	285	315	330	305	330	345
	—	—	—	—	—	—	—	—	—	—	—	—	*940*	*1025*	*1075*	*1000*	*1075*	*1125*
N2	—	—	—	—	—	—	—	—	—	—	—	—	215	245	260	235	260	275
	—	—	—	—	—	—	—	—	—	—	—	—	*710*	*800*	*850*	*770*	*850*	*900*
N3	—	—	—	—	—	—	—	—	—	—	—	—	185	215	230	205	230	245
	—	—	—	—	—	—	—	—	—	—	—	—	*610*	*710*	*750*	*670*	*750*	*800*
N11	—	—	—	—	—	—	—	—	—	—	—	—	195	225	240	215	240	255
	—	—	—	—	—	—	—	—	—	—	—	—	*640*	*740*	*790*	*710*	*790*	*840*
S1	—	—	—	50	70	90	65	90	105	45	65	80	41	55	75	—	—	—
	—	—	—	*165*	*230*	*295*	*215*	*295*	*345*	*150*	*215*	*260*	*135*	*180*	*245*	—	—	—
S2	—	—	—	40	55	70	55	75	90	36	50	65	33	46	60	—	—	—
	—	—	—	*130*	*180*	*230*	*180*	*245*	*295*	*120*	*165*	*215*	*110*	*150*	*195*	—	—	—
S3	—	—	—	35	49	65	46	65	80	32	45	55	29	41	50	—	—	—
	—	—	—	*115*	*160*	*215*	*150*	*215*	*260*	*105*	*150*	*180*	*95*	*135*	*165*	—	—	—
S11	—	—	—	70	95	115	90	115	130	65	90	105	55	80	100	—	—	—
	—	—	—	*230*	*310*	*375*	*295*	*375*	*425*	*215*	*295*	*345*	*180*	*260*	*330*	—	—	—
S12	—	—	—	49	70	85	65	85	105	44	60	80	40	55	70	—	—	—
	—	—	—	*160*	*230*	*280*	*215*	*280*	*345*	*145*	*195*	*260*	*130*	*180*	*230*	—	—	—
S13	—	—	—	28	39	50	37	50	65	25	36	45	23	32	41	—	—	—
	—	—	—	*90*	*130*	*165*	*120*	*165*	*215*	*80*	*120*	*150*	*75*	*105*	*135*	—	—	—
H5	—	—	—	—	—	—	—	—	—	41	55	70	36	50	60	—	—	—
	—	—	—	—	—	—	—	—	—	*135*	*180*	*230*	*120*	*165*	*195*	—	—	—
H8	—	—	—	—	—	—	—	—	—	43	60	75	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*140*	*195*	*245*	—	—	—	—	—	—
H11	—	—	—	—	—	—	—	—	—	50	75	90	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*165*	*245*	*295*	—	—	—	—	—	—
H12	—	—	—	—	—	—	—	—	—	80	105	120	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	*260*	*345*	*395*	—	—	—	—	—	—

R417.19 SPOT FACING

Seco spot facing mills are cutters for milling spot faces of blind and countersunk holes. Key benefits include smooth cutting, reduced spindle bearing wear via a highly balanced tool and high security through a center-lock clamping system, all engineered in an economical solution.

- Strong SPMX inserts, available in many different grades for most workpiece materials
- Inserts with 4 cutting edges
- Cutter range metric, Ø 18-42mm (Imperial Ø 0.625-1.620 inch)

R417.19-SPMX – Metric



- For insert selection and cutting data recommendations, see page(s) 730-732
- For complete insert programme, see page(s) 770
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	APMXE	DMM	LUX	LS	OAL	RPMX	Weight	Centre insert SPMX	Periph insert SPMX
			mm			mm	mm	mm	mm	mm	mm		kg		
R417.19-2018.3-06A	00070768	Weldon	18,0	1	2	5,0	9,0	20,0	20,0	87,0	110,0	39200	0,2	0602AP (1)	060204 (1)
R417.19-2020.3-07A	00012939	Weldon	20,0	1	2	7,0	10,0	20,0	28,0	92,0	120,0	26200	0,3	0703AP (1)	070304 (1)
R417.19-2022.3-07A	02201611	Weldon	22,0	1	2	7,0	11,0	20,0	70,0	92,0	120,0	25000	0,3	0703AP (1)	070304 (1)
R417.19-2524.3-07A	02201606	Weldon	24,0	1	2	7,0	12,0	25,0	31,0	98,0	130,0	24000	0,5	0703AP (1)	070304 (1)
R417.19-2526.3-09A	00070772	Weldon	26,0	1	2	8,0	13,0	25,0	74,0	98,0	130,0	21200	0,4	0903AP (1)	090304 (1)
R417.19-2530.3-09A	02201604	Weldon	30,0	1	2	8,0	15,0	25,0	74,0	90,0	130,0	19800	0,5	0903AP (1)	090304 (1)
R417.19-3232.3-09A	02201607	Weldon	32,0	1	2	8,0	16,0	32,0	38,0	90,0	130,0	19200	0,7	0903AP (1)	090304 (1)
R417.19-3236.3-12A	02201608	Weldon	36,0	1	2	11,0	18,0	32,0	70,0	90,0	130,0	12600	0,7	12T3AP (1)	12T308 (1)
R417.19-3238.3-12A	02448870	Weldon	38,0	1	2	11,0	19,0	32,0	70,0	90,0	130,0	12300	0,7	12T3AP (1)	12T308 (1)
R417.19-3242.3-12A	02448871	Weldon	42,0	1	2	11,0	21,0	32,0	70,0	90,0	130,0	12000	0,8	12T3AP (1)	12T308 (1)

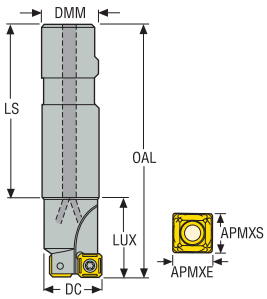
Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R417.19-06A	C02205-T07P	T00-07P09	0.9NM
R417.19-07A	C02506-T07P	T00-07P09	0.9NM
R417.19-09A	C03007-T09P	T00-09P20	2.0NM
R417.19-12A	C03510-T15P	T00-15P30	3.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R417.19-SPMX – Inch



- For insert selection and cutting data recommendations, see page(s) 730-732
- For complete insert programme, see page(s) 770
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	ZNP	APMXS	APMXE	DMM	LUX	LS	OAL	RPMX	Weight	Centre insert SPMX	Periph insert SPMX
			Inch			Inch	Inch	Inch	Inch	Inch	Inch		lbs		
R417.19-00.62-3	75072193	Weldon	0.625	1	2	0.197	0.276	0.750	0.787	2.559	3.740	49100	0.440	0602AP (1)	060204 (1)
R417.19-00.750-3	75072183	Weldon	0.750	1	2	0.197	0.276	0.750	1.181	3.150	4.331	32500	0.660	0602AP (1)	060204 (1)
R417.19-00.81-3	75054856	Weldon	0.812	1	2	0.276	0.276	0.750	2.717	3.346	4.724	26200	0.660	0703AP (1)	070304 (1)
R417.19-01.00-3	75072173	Weldon	1.000	1	2	0.315	0.472	1.000	1.575	3.543	5.118	22500	1.320	0903AP (1)	090304 (1)
R417.19-01.18-3	75054857	Weldon	1.181	1	2	0.315	0.472	1.000	2.874	3.543	5.118	21200	1.100	0903AP (1)	090304 (1)
R417.19-01.37-3	75054858	Weldon	1.375	1	2	0.433	0.472	1.250	2.874	3.543	5.118	12600	1.760	12T3AP (1)	12T308 (1)
R417.19-01.62-3	75054859	Weldon	1.620	1	2	0.433	0.472	1.250	2.874	3.543	5.118	12000	1.760	12T3AP (1)	12T308 (1)

Spare Parts

Accessories

For cutter	Insert screw	Torque key	Torque value
R417.19-00.625-00.750	C02205-T07P	T00-07P09	8.0IN.LBS
R417.19-00.812	C02506-T07P	T00-07P09	8.0IN.LBS
R417.19-01.00-01.18	C03007-T09P	T00-09P20	17.7IN.LBS
R417.19-01.37-01.62	C03510-T15P	T00-15P30	26.6IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R417.19-SPMX06/07 – Insert selection – mm/*Inch*

SMG		f_z		
		100%	30%	10%
P1	SPMX 06/07-75 F40M	0,080 *0.0032*	0,085 *0.0034*	0,13 *0.0050*
P2	SPMX 06/07-75 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
P3	SPMX 06/07-75 F40M	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
P4	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
P5	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
P6	SPMX 06/07-75 F40M	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
P7	SPMX 06/07-75 F40M	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
P8	SPMX 06/07-75 F40M	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
P11	SPMX 06/07-75 F40M	0,070 *0.0028*	0,080 *0.0032*	0,12 *0.0048*
P12	SPMX 06/07-75 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
M1	SPMX 06/07-75 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
M2	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
M3	SPMX 06/07-75 F40M	0,060 *0.0024*	0,065 *0.0026*	0,10 *0.0040*
M4	SPMX 06/07-75 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
M5	SPMX 06/07-75 F40M	0,050 *0.0020*	0,055 *0.0022*	0,085 *0.0034*
K1	SPMX 06/07-75 F40M	0,080 *0.0032*	0,090 *0.0036*	0,13 *0.0050*
K2	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
K3	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
K4	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
K5	SPMX 06/07-75 F40M	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*
K6	SPMX 06/07-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
K7	SPMX 06/07-75 F40M	0,065 *0.0026*	0,070 *0.0028*	0,11 *0.0044*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R417.19-SPMX09/12 – Insert selection – mm/*Inch*

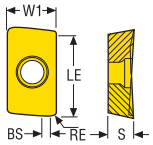
SMG		f_z		
		100%	30%	10%
P1	SPMX 09/12-75 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P2	SPMX 09/12-75 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
P3	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P4	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P5	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P6	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P7	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P8	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,19 *0.0075*
P11	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
P12	SPMX 09/12-75 F40M	0,075 *0.0030*	0,080 *0.0032*	0,12 *0.0048*
M1	SPMX 09/12-75 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
M2	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
M3	SPMX 09/12-75 F40M	0,085 *0.0034*	0,095 *0.0038*	0,15 *0.0060*
M4	SPMX 09/12-75 F40M	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
M5	SPMX 09/12-75 F40M	0,075 *0.0030*	0,085 *0.0034*	0,13 *0.0050*
K1	SPMX 09/12-75 F40M	0,12 *0.0048*	0,13 *0.0050*	0,20 *0.0080*
K2	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K3	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K4	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K5	SPMX 09/12-75 F40M	0,10 *0.0040*	0,11 *0.0044*	0,16 *0.0065*
K6	SPMX 09/12-75 F40M	0,11 *0.0044*	0,12 *0.0048*	0,18 *0.0070*
K7	SPMX 09/12-75 F40M	0,10 *0.0040*	0,11 *0.0044*	0,16 *0.0065*

SMG = Seco material group
f_z = mm/tooth (in/tooth), v_c = m/min (sf/min), a_e/DC = %
All cutting data are start values

R417.19-SPMX06/07/09/12 – Cutting data v_c = (m/min)/*(sf/min)*

SMG	F40M		
	100%	30%	10%
P1	195 *640*	225 *740*	240 *790*
P2	195 *640*	220 *720*	240 *790*
P3	180 *590*	205 *670*	225 *740*
P4	170 *560*	195 *640*	215 *710*
P5	165 *540*	190 *620*	210 *690*
P6	175 *570*	205 *670*	220 *720*
P7	170 *560*	195 *640*	215 *710*
P8	165 *540*	190 *620*	205 *670*
P11	165 *540*	195 *640*	210 *690*
P12	120 *395*	150 *490*	165 *540*
M1	170 *560*	200 *660*	215 *710*
M2	150 *490*	180 *590*	200 *660*
M3	130 *425*	160 *520*	175 *570*
M4	105 *345*	135 *445*	150 *490*
M5	90 *295*	115 *375*	130 *425*
K1	170 *560*	200 *660*	215 *710*
K2	160 *520*	185 *610*	205 *670*
K3	140 *460*	170 *560*	185 *610*
K4	135 *445*	165 *540*	180 *590*
K5	90 *295*	115 *375*	130 *425*
K6	125 *410*	150 *490*	170 *560*
K7	110 *360*	140 *460*	155 *510*

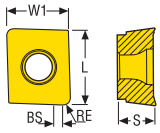
ABEX26



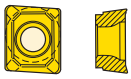
M15

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
ABEX2606ZFFR-M15	1,6 *0.063*	2,0 *0.079*	24,4 *0.961*	14,0 *0.551*	6,35 *0.250*	17,0 °	■		■				■					■				■			
ABEX2606ZZFR-M15	1,6 *0.063*	10,0 *0.394*	24,4 *0.961*	14,0 *0.551*	6,35 *0.250*	17,0 °												■							

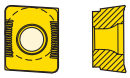
AC..15



M10/M11/M14/MD15

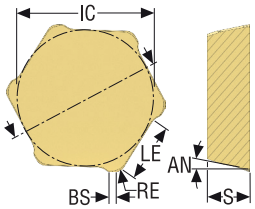


ME10

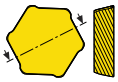


Designation	RE	BS	L	W1	S	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
ACET150612TR-ME10	1,2 *0.047*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	22,0 °									■							■				
ACET150612TL-M11	1,2 *0.047*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	14,0 °																■				
ACET150612TR-M11	1,2 *0.047*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	14,0 °	■		■				■				■	■				■				
ACET150631TR-M11	3,1 *0.122*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	14,0 °																■				
ACET150612TL-M14	1,2 *0.047*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °																■				
ACET150612TR-M14	1,2 *0.047*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °			■				■					■				■	■			
ACET150630TR-M14	3,0 *0.118*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °												■								
ACET150631TR-M14	3,1 *0.122*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °																■				
ACET150660TL-M14	6,0 *0.236*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °																■				
ACET150660TR-M14	6,0 *0.236*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °												■				■				
ACET150612TR-MD15	1,2 *0.047*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °	■			■								■								
ACET150630TR-MD15	3,0 *0.118*	1,7 *0.067*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °	■																			
ACMT150612TR-M14	1,2 *0.047*	– *NaN*	15,0 *0.591*	12,7 *0.500*	6,35 *0.250*	15,0 °			■									■				■				

HPMN12

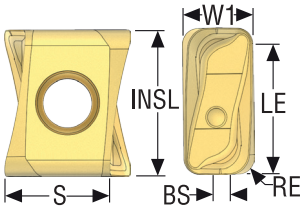


D25

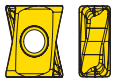


Designation	RE	BS	IC	LE	S	AN°	Grades Coated																		Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
HPMN1206ZETR-D25	1,7 *0.067*	0,8 *0.031*	21,458 *0.845*	– *NaN*	6,35 *0.250*	11,0 *0.433*	■		■																

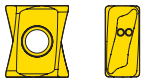
LOEX08/12



M08/MD08



M09/M12/MD13

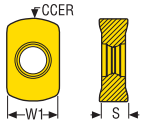


Designation	RE	BS	LE	S	INSL	W1	Cutting rake	Grades																			
								Coated															Uncoated				
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LOEX080404TR-M08	0,4 *0.016*	1,29 *0.051*	8,3 *0.327*	6,67 *0.263*	9,3 *0.366*	4,4 *0.173*	33,3 °	■		■	■				■								■			
LOEX080408TR-M08	0,8 *0.031*	0,9 *0.035*	8,3 *0.327*	6,6 *0.260*	9,3 *0.366*	4,4 *0.173*	34,0 °	■	■	■	■		■	■	■	■			■				■			
LOEX080412TR-M08	1,2 *0.047*	0,52 *0.020*	8,3 *0.327*	6,52 *0.257*	9,3 *0.366*	4,4 *0.173*	33,3 °			■					■								■			
LOEX080416TR-M08	1,6 *0.063*	0,13 *0.005*	8,3 *0.327*	6,45 *0.254*	9,3 *0.366*	4,4 *0.173*	33,3 °		■		■					■	■						■			
LOEX080404TR-MD08	0,4 *0.016*	1,29 *0.051*	8,3 *0.327*	6,67 *0.263*	9,3 *0.366*	4,4 *0.173*	29,0 °			■					■								■			
LOEX080408TR-MD08	0,8 *0.031*	0,92 *0.036*	8,3 *0.327*	6,6 *0.260*	9,3 *0.366*	4,4 *0.173*	29,5 °	■		■				■	■				■				■			
LOEX080412TR-MD08	1,2 *0.047*	0,52 *0.020*	8,3 *0.327*	6,52 *0.257*	9,3 *0.366*	4,4 *0.173*	29,5 °								■											
LOEX080416TR-MD08	1,6 *0.063*	0,13 *0.005*	8,3 *0.327*	6,45 *0.254*	9,3 *0.366*	4,4 *0.173*	29,5 °			■													■			
LOEX120708TR-M12	0,8 *0.031*	2,47 *0.097*	12,0 *0.472*	10,26 *0.404*	14,2 *0.559*	7,5 *0.295*	35,0 °		■	■	■		■		■	■	■		■				■			
LOEX120712TR-M12	1,2 *0.047*	2,1 *0.083*	12,0 *0.472*	10,19 *0.401*	14,2 *0.559*	7,5 *0.295*	35,0 °												■				■			
LOEX120716TR-M12	1,6 *0.063*	1,74 *0.069*	12,0 *0.472*	10,12 *0.398*	14,2 *0.559*	7,5 *0.295*	35,0 °								■								■			
LOEX120720TR-M12	2,0 *0.079*	1,37 *0.054*	12,0 *0.472*	10,04 *0.395*	14,2 *0.559*	7,5 *0.295*	35,0 °			■	■					■			■				■			
LOEX120724TR-M12	2,4 *0.094*	1,01 *0.040*	12,0 *0.472*	9,98 *0.393*	14,2 *0.559*	7,5 *0.295*	35,0 °			■						■							■			
LOEX120731TR-M12	3,1 *0.122*	0,37 *0.015*	12,0 *0.472*	9,88 *0.389*	14,2 *0.559*	7,5 *0.295*	35,0 °			■	■					■			■				■			
LOEX120708TR-MD13	0,8 *0.031*	2,47 *0.097*	12,0 *0.472*	10,26 *0.404*	14,2 *0.559*	7,5 *0.295*	30,0 °	■		■				■	■								■			
LOEX120712TR-MD13	1,2 *0.047*	2,1 *0.083*	12,0 *0.472*	10,19 *0.401*	14,2 *0.559*	7,5 *0.295*	30,0 °			■					■											
LOEX120716TR-MD13	1,6 *0.063*	1,74 *0.069*	12,0 *0.472*	10,12 *0.398*	14,2 *0.559*	7,5 *0.295*	30,0 °	■		■					■				■				■			
LOEX120704R-M09	0,4 *0.016*	2,83 *0.111*	12,0 *0.472*	10,33 *0.407*	14,2 *0.559*	7,5 *0.295*	36,0 °									■							■			
LOEX120708R-M09	0,8 *0.031*	2,47 *0.097*	12,0 *0.472*	10,26 *0.404*	14,2 *0.559*	7,5 *0.295*	36,0 °		■	■	■		■			■	■		■				■			
LOEX120716R-M09	1,6 *0.063*	1,74 *0.069*	12,0 *0.472*	10,12 *0.398*	14,2 *0.559*	7,5 *0.295*	36,0 °		■		■					■							■			
LOEX120724R-M09	2,4 *0.094*	1,01 *0.040*	12,0 *0.472*	9,98 *0.393*	14,2 *0.559*	7,5 *0.295*	36,0 °									■										
LOEX120731R-M09	3,1 *0.122*	0,37 *0.015*	12,0 *0.472*	9,88 *0.389*	14,2 *0.559*	7,5 *0.295*	36,0 °		■		■		■			■			■				■			
LOEX120740R-M09	4,0 *0.157*	0,14 *0.006*	12,0 *0.472*	9,74 *0.383*	14,2 *0.559*	7,5 *0.295*	36,0 °									■							■			

Designation	RE	BS	LE	S	INSL	W1	Cutting rake	Grades																		
								Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LOEX120750R-2-M09	5,0 *0.197*	1,06 *0.042*	12,0 *0.472*	9,52 *0.375*	14,2 *0.559*	7,5 *0.295*	36,0 °																■			
LOEX120763R-2-M09	6,3 *0.248*	0,43 *0.017*	12,0 *0.472*	9,28 *0.365*	14,2 *0.559*	7,5 *0.295*	36,0 °									■							■			

Note: LOEX1207xxR-2-M09 have only 2 edges

LOH.06



D07

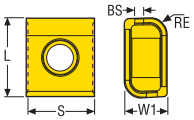
M07

MD07

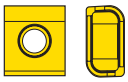
ME06

Designation	RE	W1	S	CCER	Cutting rake	Grades																			
						Coated																	Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LOHT060310TR-M07	1,0 *0.039*	6,35 *0.250*	3,57 *0.141*	5,5 *0.217*	20,0 °		■	■	■					■	■		■				■			
LOHT060310TR-MD07	1,0 *0.039*	6,35 *0.250*	3,57 *0.141*	5,5 *0.217*	7,0 °	■		■	■				■											
LOHT060310TR-ME06	1,0 *0.039*	6,35 *0.250*	3,57 *0.141*	5,5 *0.217*	27,0 °						■			■	■		■				■			
LOHW060310TR-D07	1,0 *0.039*	6,35 *0.250*	3,45 *0.136*	5,5 *0.217*	0,0 °	■			■	■														

LNHQ14/17

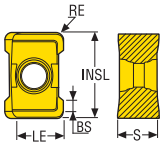


M11/M13

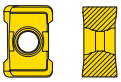


Designation	RE	L	W1	Cutting rake	Grades																			
					Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LNHQ140708TN4-M11	0,8 *0.031*	14,0 *0.551*	7,5 *0.295*	16,0 °			■													■			
LNHQ140731TN4-M11	3,1 *0.122*	14,0 *0.551*	7,5 *0.295*	16,0 °			■													■			
LNHQ140740TN4-M11	4,0 *0.157*	14,0 *0.551*	7,5 *0.295*	16,0 °																■			
LNHQ140750TN4-M11	5,0 *0.197*	14,0 *0.551*	7,5 *0.295*	16,0 °			■													■			
LNHQ140760TN4-M11	6,0 *0.236*	14,0 *0.551*	7,5 *0.295*	16,0 °			■													■			
LNHQ170708TN4-M13	0,8 *0.031*	17,0 *0.669*	7,5 *0.295*	16,0 °																■			
LNHQ170731TN4-M13	3,1 *0.122*	17,0 *0.669*	7,5 *0.295*	16,0 °																■			
LNHQ170740TN4-M13	4,0 *0.157*	17,0 *0.669*	7,5 *0.295*	16,0 °																■			
LNHQ170750TN4-M13	5,0 *0.197*	17,0 *0.669*	7,5 *0.295*	16,0 °																■			
LNHQ170760TN4-M13	6,0 *0.236*	17,0 *0.669*	7,5 *0.295*	16,0 °																■			

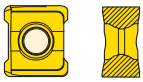
LNK.05/06



LNK.05

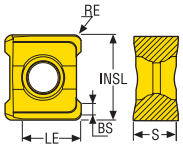


LNK.06

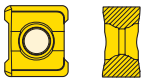


Designation	RE	BS	LE	INSL	S	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LNKT050404PPN4-E05	0,4 *0.016*	1,3 *0.051*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	23,0 °																■			■
LNKT050404PPTN4-M06	0,4 *0.016*	1,3 *0.051*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °				■		■										■			
LNKT050408PPTN4-M06	0,8 *0.031*	1,3 *0.051*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °				■								■				■			
LNKT050416PPTN4-M06	1,6 *0.063*	0,8 *0.031*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT050420PPTN4-M06	2,0 *0.079*	0,8 *0.031*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT050424PPTN2-M06	2,4 *0.094*	0,6 *0.024*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT050431PPTL1-M06	3,1 *0.122*	0,6 *0.024*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT050431PPTR1-M06	3,1 *0.122*	0,6 *0.024*	5,0 *0.197*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT050431PPTR1C-M06	3,1 *0.122*	0,6 *0.024*	4,96 *0.195*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT050431PPTL1C-M06	3,1 *0.122*	0,6 *0.024*	4,96 *0.195*	10,0 *0.394*	4,7 *0.185*	15,0 °																■			
LNKT060504PPN-E05	0,4 *0.016*	1,6 *0.063*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	23,0 °																			■
LNKT060508PPN-E05	0,8 *0.031*	1,1 *0.043*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	23,0 °																			■
LNKT060504PPTN-M06	0,4 *0.016*	1,6 *0.063*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	15,0 °			■									■				■			
LNKT060508PPTN-M06	0,8 *0.031*	1,1 *0.043*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	15,0 °			■	■			■	■				■				■			
LNKT060516PPTN-M06	1,6 *0.063*	1,3 *0.051*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	15,0 °							■	■								■			
LNKT060531PPTN-M06	3,1 *0.122*	0,6 *0.024*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	15,0 °																■			
LNKT060540PPTL-M06	4,0 *0.157*	0,8 *0.031*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	15,0 °																■			
LNKT060540PPTR-M06	4,0 *0.157*	0,8 *0.031*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	15,0 °																■			
LNKW060504PPN-MD08	0,4 *0.016*	1,6 *0.063*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	0,0 °								■											
LNKW060508PPN-MD08	0,8 *0.031*	1,1 *0.043*	6,0 *0.236*	10,0 *0.394*	5,0 *0.197*	0,0 °			■				■												

LNK.08

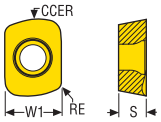


LNK.08



Designation	RE	BS	LE	INSL	S	Cutting rake	Grades																			
							Coated																	Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LNKT080504PPN-E05	0,4 *0.016*	1,6 *0.063*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	23,0 °																				■
LNKT080508PPN-E05	0,8 *0.031*	1,1 *0.043*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	23,0 °																				■
LNKT080520PPN-E05	2,0 *0.079*	0,7 *0.028*	6,7 *0.264*	10,0 *0.394*	5,0 *0.197*	23,0 °																				■
LNKT080531PPN-E05	3,1 *0.122*	0,6 *0.024*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	23,0 °																				■
LNKT080504PPTN-M06	0,4 *0.016*	1,6 *0.063*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	15,0 °			■									■				■				
LNKT080508PPTN-M06	0,8 *0.031*	1,1 *0.043*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	15,0 °			■	■			■	■				■				■				
LNKT080516PPTN-M06	1,6 *0.063*	1,3 *0.051*	7,2 *0.283*	10,0 *0.394*	5,0 *0.197*	15,0 °								■								■				
LNKT080520PPTN-M06	2,0 *0.079*	0,7 *0.028*	6,7 *0.264*	10,0 *0.394*	5,0 *0.197*	15,0 °							■	■								■				
LNKT080524PPTN-M06	2,4 *0.094*	0,5 *0.020*	6,7 *0.264*	10,0 *0.394*	5,0 *0.197*	15,0 °							■	■								■				
LNKT080531PPTN-M06	3,1 *0.122*	0,6 *0.024*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	15,0 °							■	■								■				
LNKT080540PPTL-M06	4,0 *0.157*	0,8 *0.031*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	15,0 °																■				
LNKT080540PPTR-M06	4,0 *0.157*	0,8 *0.031*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	15,0 °																■				
LNKW080508PPN-MD08	0,8 *0.031*	1,1 *0.043*	7,5 *0.295*	10,0 *0.394*	5,0 *0.197*	0,0 °			■				■													

LPH.05/06/09

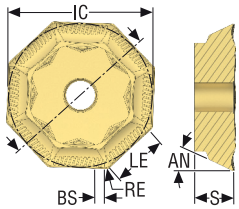


E05/E08/ME04/ME05/ME08/M05/M06/M13

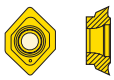
MD05/MD07/MD15/D06/D12/D15

Designation	RE	W1	CCER	S	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
LPHT05T210TR-ME04	1,0 *0.039*	5,07 *0.200*	6,4 *0.252*	2,54 *0.100*	16,0 °						■			■			■				■			
LPHT060310ER-E05	1,0 *0.039*	6,35 *0.250*	8,0 *0.315*	3,18 *0.125*	16,0 °						■										■			■
LPHT060310TR-ME05	1,0 *0.039*	6,35 *0.250*	8,0 *0.315*	3,18 *0.125*	16,0 °				■		■			■							■			
LPHT060310TR-M06	1,0 *0.039*	6,35 *0.250*	8,0 *0.315*	3,18 *0.125*	11,0 °		■	■	■					■	■		■				■			
LPHT09T420R-E08	2,0 *0.079*	9,5 *0.374*	9,75 *0.384*	4,76 *0.187*	20,0 °						■													■
LPHW05T210TR-MD05	1,0 *0.039*	5,07 *0.200*	6,4 *0.252*	2,54 *0.100*	0,0 °					■														
LPHW060310TR-MD07	1,0 *0.039*	6,35 *0.250*	8,0 *0.315*	3,18 *0.125*	0,0 °			■							■									
LPHW060310TR-D06	1,0 *0.039*	6,35 *0.250*	8,0 *0.315*	3,18 *0.125*	0,0 °				■	■														
LPHW09T420TR-D12	2,0 *0.079*	9,5 *0.374*	9,75 *0.384*	4,76 *0.187*	0,0 °					■														
LPKT05T210TR-M05	1,0 *0.039*	5,07 *0.200*	6,4 *0.252*	2,54 *0.100*	11,0 °		■	■	■					■	■						■			
LPKT09T420TR-ME08	2,0 *0.079*	9,5 *0.374*	9,75 *0.384*	4,76 *0.187*	15,0 °						■			■							■			
LPKT09T420TR-M13	2,0 *0.079*	9,5 *0.374*	9,75 *0.384*	4,76 *0.187*	10,0 °	■	■	■	■					■	■		■				■			
LPKW05T210TR-MD05	1,0 *0.039*	5,07 *0.200*	6,4 *0.252*	2,54 *0.100*	0,0 °			■	■															
LPKW09T420TR-MD15	2,0 *0.079*	9,5 *0.374*	9,75 *0.384*	4,76 *0.187*	0,0 °	■	■	■																
LPKW09T420TR-D15	2,0 *0.079*	9,5 *0.374*	9,75 *0.384*	4,76 *0.187*	0,0 °				■				■											

OF..05/07



E04/M05



M08/M14

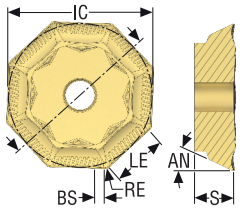
ME07ME12//D09

ME10/ME15/M16

ME13/ME09/M13/M15/D18

Designation	IC	BS	RE	S	AN°	Cutting rake	Grades																			
							Coated																	Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
OFEX05T305N-E04	12,7 *0.500*	1,5 *0.059*	0,5 *0.020*	3,77 *0.148*	26,0 *1.024*	20,0 °													■					■	
OFEX05T305TN-ME07	12,7 *0.500*	1,5 *0.059*	0,5 *0.020*	3,77 *0.148*	26,0 *1.024*	18,0 °			■													■			
OFEX05T305N-M05	12,7 *0.500*	1,5 *0.059*	0,5 *0.020*	3,77 *0.148*	26,0 *1.024*	0,0 °															■				
OFEX05T305TN-M08	12,7 *0.500*	1,5 *0.059*	0,5 *0.020*	3,77 *0.148*	26,0 *1.024*	0,0 °			■				■					■				■			
OFEX05T305TN-D09	12,806 *0.504*	1,5 *0.059*	0,5 *0.020*	3,97 *0.156*	26,0 *1.024*	0,0 °	■																		
OFMT050405TR-ME12	13,18 *0.519*	1,5 *0.059*	0,5 *0.020*	4,76 *0.187*	26,0 *1.024*	18,0 °																■			
OFMT050405TR-M14	13,18 *0.519*	1,4 *0.055*	0,5 *0.020*	4,76 *0.187*	26,0 *1.024*	0,0 °																■			
OFMT070405TN-ME13	17,972 *0.708*	1,1 *0.043*	0,5 *0.020*	4,86 *0.191*	26,0 *1.024*	18,0 °			■																
OFMT070405TN-M15	17,972 *0.708*	1,1 *0.043*	0,5 *0.020*	4,86 *0.191*	26,0 *1.024*	0,0 °			■													■			
OFMT070405TR-ME13	17,972 *0.708*	1,0 *0.039*	0,5 *0.020*	4,86 *0.191*	26,0 *1.024*	15,0 °												■							
OFMT070405TR-M15	17,972 *0.708*	1,0 *0.039*	0,5 *0.020*	4,86 *0.191*	26,0 *1.024*	0,0 °																■			
OFET070405TN-ME10	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	18,0 °															■	■			
OFET070405TN-ME15	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	18,0 °																■			

OFER/OFEN/OFMR07



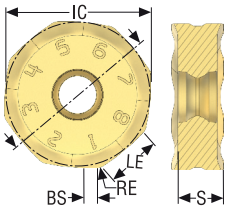
E07/M10/D18/M16

ME10/ME13/ME15/M15

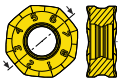
ZZ..M10/M16

Designation	IC	BS	RE	S	AN°	Cutting rake	Grades																		
							Coated																	Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
OFER070405N-E07	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	20,0 °													■					■	
OFER070405TN-ME10	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	18,0 °			■													■			
OFER070405TN-ME15	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	16,0 °			■									■				■			
OFER070405N-M10	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	0,0 °				■											■				
OFER070405TN-M16	17,941 *0.706*	1,4 *0.055*	0,5 *0.020*	4,56 *0.180*	26,0 *1.024*	0,0 °	■		■				■	■				■				■			
OFMR070405TR-ME13	17,972 *0.708*	1,0 *0.039*	0,5 *0.020*	4,86 *0.191*	26,0 *1.024*	15,0 °			■													■			
OFMR070405TR-M15	17,972 *0.708*	1,2 *0.047*	0,5 *0.020*	4,86 *0.191*	26,0 *1.024*	0,0 °			■				■									■			
OFEN070405TN-D18	17,96 *0.707*	2,0 *0.079*	0,5 *0.020*	4,76 *0.187*	26,0 *1.024*	0,0 °	■		■	■			■	■											
OFEN0704ZZR-M10	18,081 *0.712*	6,6 *0.260*	0,5 *0.020*	4,76 *0.187*	26,0 *1.024*	0,0 °				■											■				
OFEN0704ZZTR-M16	18,115 *0.713*	6,6 *0.260*	0,5 *0.020*	4,74 *0.187*	26,0 *1.024*	0,0 °							■					■							

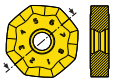
ON.U05/09



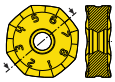
ON.U0504: ME10-11/M10-11



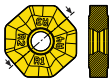
ON.U0905: MD16-17



ON.U0905: ME12-13/M12-15



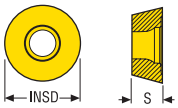
ZZTN4



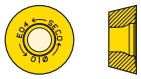
Designation	*	IC	BS	RE	S	Cutting rake	Grades																					
							Coated																		Uncoated			
		mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1500	MP1501	MP2050	MP2500	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
ONMU050410ANTN-ME10	*	12,0 *0.472*	0,3 *0.012*	1,0 *0.039*	4,5 *0.177*	20,0 °					■			■			■							■			
ONMU050410ANTN-ME11		12,0 *0.472*	1,0 *0.039*	1,0 *0.039*	4,5 *0.177*	20,0 °					■	■		■			■							■			
ONMU050410ANTN-M10	*	12,0 *0.472*	0,3 *0.012*	1,0 *0.039*	4,5 *0.177*	20,0 °		■	■		■	■			■	■				■				■			
ONMU050410ANTN-M11		12,0 *0.472*	1,0 *0.039*	1,0 *0.039*	4,5 *0.177*	20,0 °		■	■		■	■			■	■				■				■			
ONEU050410ZZTN4-M10		12,0 *0.472*	3,2 *0.126*	1,0 *0.039*	4,25 *0.167*	20,0 °					■	■				■								■			
ONMU090520ANTN-ME12	**	22,0 *0.866*	0,45 *0.018*	2,0 *0.079*	6,8 *0.268*	20,0 °				■				■			■	■		■				■			
ONMU090520ANTN-ME13		22,0 *0.866*	2,11 *0.083*	2,0 *0.079*	6,8 *0.268*	20,0 °	■			■		■				■	■	■		■				■			
ONMU090510ANTN-M12		22,0 *0.866*	0,0 *NaN*	1,0 *0.039*	6,8 *0.268*	20,0 °			■							■	■	■		■							
ONMU090520ANTN-M12	**	22,0 *0.866*	0,45 *0.018*	2,0 *0.079*	6,8 *0.268*	20,0 °	■		■	■				■		■		■		■				■			
ONMU090520ANTN-M13	***	22,0 *0.866*	2,11 *0.083*	2,0 *0.079*	6,8 *0.268*	20,0 °	■		■	■		■		■	■	■		■		■				■			
ONMU090520ANTN-M14	***	22,0 *0.866*	0,45 *0.018*	2,0 *0.079*	5,56 *0.219*	15,0 °	■			■		■			■	■				■				■			
ONMU090520ANTN-M15		22,0 *0.866*	2,11 *0.083*	2,0 *0.079*	5,56 *0.219*	15,0 °	■			■		■			■	■				■							
ONMU090520ANTN-MD16	***	22,0 *0.866*	0,45 *0.018*	2,0 *0.079*	5,56 *0.219*	0,0 °	■			■					■					■							
ONMU090520ANTN-MD17		22,0 *0.866*	2,11 *0.083*	2,0 *0.079*	5,56 *0.219*	0,0 °	■								■												
ONEU090520ZZTN4-M12		21,41 *0.843*	6,3 *0.248*	2,0 *0.079*	6,8 *0.268*	20,0 °	■	■		■	■					■											
ONEU090520ZZTN4-M14		21,41 *0.843*	6,3 *0.248*	2,0 *0.079*	5,56 *0.219*	15,0 °	■	■		■	■	■			■	■				■				■			

The marked inserts are compatible with these dedicated wiper inserts:
*ONEU050410ZZTN4-M10
**ONEU090520ZZTN4-M12
***ONEU090520ZZTN4-M14

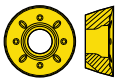
RD..05/06/07/08/10



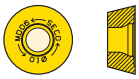
RDHT-Exx



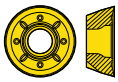
RDHT-Mxx



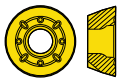
RDHW-MDxx



RDKT-Mxx

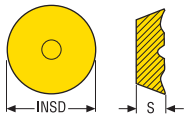


RDKW-MDxx

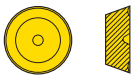


Designation	INSD	S	Cutting rake	Grades																		
				Coated															Uncoated			
	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
RDHT06T1M0-E02	6,0 *0.236*	2,18 *0.086*	18,0 °																■			■
RDHT0803M0-E03	8,0 *0.315*	3,18 *0.125*	20,0 °												■				■			■
RDHW0501M0-MD01	5,0 *0.197*	1,51 *0.059*	0,0 °				■												■			
RDHW06T1M0-MD02	6,0 *0.236*	2,18 *0.086*	0,0 °				■				■					■		■	■			
RDHW0702M0-MD03	7,0 *0.276*	2,38 *0.094*	0,0 °				■												■			
RDHW0702M0T-MD04	7,0 *0.276*	2,38 *0.094*	0,0 °													■						
RDHW0803M0-MD03	8,0 *0.315*	3,18 *0.125*	0,0 °				■					■						■	■			
RDKW0803M0T-MD05	8,0 *0.315*	3,18 *0.125*	0,0 °			■					■		■			■	■		■			
RDHT10T3M0-8-E04	10,0 *0.394*	3,97 *0.156*	20,0 °																■			■
RDHT10T3M0T-8-M11	10,0 *0.394*	3,97 *0.156*	16,0 °		■							■							■			
RDHW10T3M0-8-MD04	10,0 *0.394*	3,97 *0.156*	0,0 °				■												■			
RDHW10T3M0T-8-MD06	10,0 *0.394*	3,97 *0.156*	0,0 °					■														
RDKT10T3M0T-6-M05	10,0 *0.394*	3,97 *0.156*	16,0 °			■						■	■						■			
RDKT10T3M0T-8-M05	10,0 *0.394*	3,97 *0.156*	16,0 °		■				■			■	■		■				■			
RDKT10T3M0T-8-M07	10,0 *0.394*	3,97 *0.156*	11,0 °			■			■		■		■		■				■			
RDKW10T3M0T-6-MD06	10,0 *0.394*	3,97 *0.156*	0,0 °										■			■			■			
RDKW10T3M0T-8-MD06	10,0 *0.394*	3,97 *0.156*	0,0 °	■		■	■				■		■			■	■		■			

REHR16

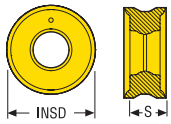


M14/MD15

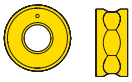


Designation	INSD	S	Cutting rake	Grades																			
				Coated																	Uncoated		
	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
REHR1605M0T-MD15	16,0 *0.630*	5,56 *0.219*		■																		

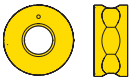
RNMU12



M10

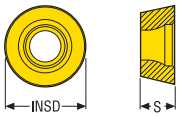


ME10

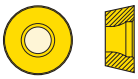


Designation	INSD	S	Cutting rake	Grades																			
				Coated																	Uncoated		
	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
RNMU1204M0-ME10	12,0 *0.472*	4,8 *0.189*	27,0 °		■						■	■	■		■				■			
RNMU1204M0T-M10	12,0 *0.472*	4,8 *0.189*	20,0 °		■	■						■	■		■				■			

ROHT10/12

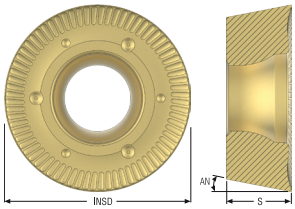


M09/M12/M14



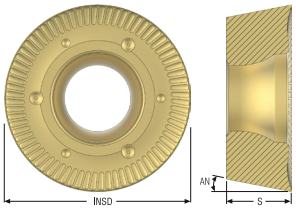
Designation	INSD	S	Cutting rake	Grades																			
				Coated																	Uncoated		
	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
ROHT1204M0-M12	12,0 *0.472*	4,76 *0.187*	10,0 °										■		■							
ROHT1204M0-M14	12,0 *0.472*	4,76 *0.187*	16,0 °										■									

RP..12



Designation	INSD	S	AN°	Cutting rake	Grades																		
					Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
RPHT1204M0T-4-M08	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	16,0 °										■		■				■			
RPKT1204M0T-4-M10	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	11,0 °		■																	
RPHT1204M0T-4-M13	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	16,0 °		■							■	■		■							
RPHT1204M0-6-E05	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	20,0 °									■							■			■
RPHT1204M0T-6-ME07	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	20,0 °						■			■			■				■			
RPHT1204M0T-6-M08	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	16,0 °			■			■			■	■		■				■			
RPHT1204M0T-6-M13	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	16,0 °			■						■	■		■				■			
RPKT1204M0T-6-M15	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	15,0 °	■		■					■		■		■				■			
RPKW1204M0T-6-MD10	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	0,0 °	■		■	■				■											
RPHW1204M0T-6-MD12	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	0,0 °					■														
RPHW1204M0-6-MD05	12,0 *0.472*	4,76 *0.187*	11,0 *0.433*	0,0 °				■	■				■							■			

RP..16/19/20



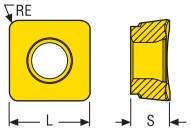
M15/M20

MD10/MD22

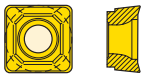
ME12

Designation	INSD	S	AN°	Cutting rake	Grades																		
					Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
RPHT1605M0T-6-ME11	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	21,0 °									■							■			
RPHT1605M0T-6-M12	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	15,0 °																■			
RPKT1605M0T-6-M18	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	15,0 °			■							■									
RPKW1605M0T-6-MD20	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	0,0 °	■		■					■		■									
RPHT1605M0T-8-ME11	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	21,0 °		■				■			■	■		■				■			
RPHT1605M0T-8-M12	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	15,0 °		■				■			■							■			
RPKT1605M0T-8-M12	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	15,0 °			■							■		■							
RPKT1605M0T-8-M18	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	15,0 °	■		■	■				■		■		■				■			
RPKW1605M0T-8-MD20	16,0 *0.630*	5,56 *0.219*	11,0 *0.433*	0,0 °	■		■										■						
RPHT190600T-6-M13	19,05 *0.750*	6,39 *0.252*	11,0 *0.433*	16,0 °									■	■		■				■			
RPHT2006M0T-ME12	20,0 *0.787*	6,35 *0.250*	11,0 *0.433*	20,0 °		■	■			■			■	■		■				■			
RPKT2006M0T-M15	20,0 *0.787*	6,35 *0.250*	11,0 *0.433*	15,0 °			■							■		■				■			
RPKT2006M0T-M20	20,0 *0.787*	6,35 *0.250*	11,0 *0.433*	15,0 °	■		■					■		■		■		■		■			
RPKW2006M0-MD10	20,0 *0.787*	6,35 *0.250*	11,0 *0.433*	0,0 °															■	■			
RPKW2006M0T-MD22	20,0 *0.787*	6,35 *0.250*	11,0 *0.433*	0,0 °	■							■		■			■	■					

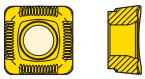
SC..12



M10/M11/M14/MD15/MD16

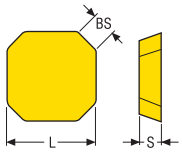


ME10

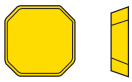


Designation	RE	L	S	Cutting rake	Grades																		
					Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SCET120612R-M10	1,2 *0.047*	12,673 *0.499*	6,35 *0.250*	20,0 °									■										
SCET120612T-ME10	1,2 *0.047*	12,7 *0.500*	6,35 *0.250*	22,0 °									■							■			
SCET120612T-M11	1,2 *0.047*	12,7 *0.500*	6,35 *0.250*	14,0 °	■		■				■					■				■			
SCET120612T-M14	1,2 *0.047*	12,7 *0.500*	6,35 *0.250*	15,0 °			■				■		■			■				■	■		
SCET120612T-MD15	1,2 *0.047*	12,7 *0.500*	6,35 *0.250*	15,0 °	■			■								■							
SCET120630T-M14	3,0 *0.118*	12,7 *0.500*	6,35 *0.250*	15,0 °			■	■				■	■	■		■				■			
SCET120630T-MD16	3,0 *0.118*	12,7 *0.500*	6,35 *0.250*	15,0 °	■		■							■		■				■			
SCEX120660T-M14	6,0 *0.236*	12,7 *0.500*	6,35 *0.250*	15,0 °												■							
SCMT120612T-M14	1,2 *0.047*	12,7 *0.500*	6,35 *0.250*	15,0 °												■				■			

SEAN12

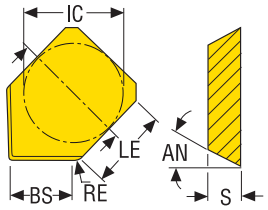


E12-E15/M14-M19

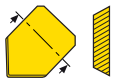


Designation	RE	BS	L	S	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SEAN1203AFN-E12	1,0 *0.039*	1,5 *0.059*	12,7 *0.500*	3,18 *0.125*	0,0 °													■						
SEAN1203AFTN-M14	1,0 *0.039*	1,5 *0.059*	12,7 *0.500*	3,18 *0.125*	0,0 °											■								
SEAN1303AFTN-M14	0,8 *0.031*	3,5 *0.138*	13,44 *0.529*	3,36 *0.132*	0,0 °												■							
SEAN1303AFTN-M15	0,8 *0.031*	3,5 *0.138*	13,44 *0.529*	3,36 *0.132*	0,0 °							■												
SEAN1604AFTN-M19	1,0 *0.039*	4,1 *0.161*	16,8 *0.661*	4,79 *0.189*	0,0 °							■												

SEAN12-ZZ

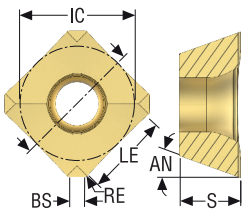


M15-18/MD15

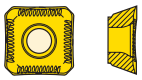


Designation	IC	BS	RE	S	AN°	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SEAN1203ZZTN-M15	12,7 *0.500*	7,3 *0.287*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	0,0 °							■												
SEAN1203ZZTN-MD15	12,7 *0.500*	7,3 *0.287*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	0,0 °	■																		
SEAN1504ZZTN-M18	15,875 *0.625*	9,3 *0.366*	1,0 *0.039*	4,76 *0.187*	20,0 *0.787*	0,0 °							■												

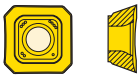
SE.X09



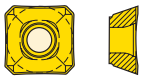
D09/M05/ME07



E04/E08/MD18MD19

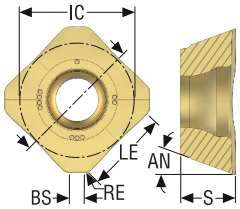


ME06/M08

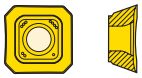


Designation	IC	BS	RE	S	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SEEX09T3AFN-E04	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	25,0 °													■			■		■	
SEEX09T3AFN-M05	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	0,0 °				■					■						■	■			
SEEX09T3AFTN-M08	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	0,0 °							■	■				■				■			
SEEX09T3AFTN-ME07	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	22,0 °			■			■					■	■				■			
SEEX09T3AFTN-D09	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	0,0 °	■																		
SEMX09T3AFTN-M08	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	0,0 °			■									■				■			
SEMX09T3AFTN-ME06	9,525 *0.375*	1,5 *0.059*	0,3 *0.012*	3,97 *0.156*	22,0 °			■									■				■			

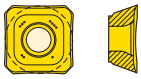
SE.X12/15



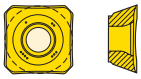
E08/MD18MD19



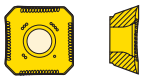
E10



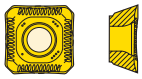
M12/M17/M18/MD20



ME11/ME12/M10/M14/M15

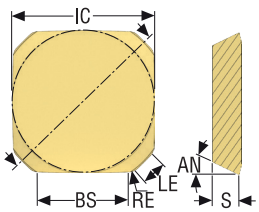


ME15

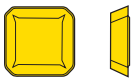


Designation	IC	BS	RE	S	Cutting rake	Grades																			
						Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SEEX1204AFN-E08	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	25,0 °																■			■
SEEX1204AFTN-ME11	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	21,0 °			■			■						■				■			
SEEX1204AFN-M10	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	5,0 °			■	■		■			■			■			■	■			
SEEX1204AFTN-M14	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	5,0 °	■		■			■	■	■				■				■			
SEEX1204ZZTN-M14	12,7 *0.500*	7,4 *0.291*	1,12 *0.044*	4,76 *0.187*	5,0 °	■		■				■					■			■	■			
SEEX1204AFTN-MD18	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	0,0 °	■			■								■							
SEMX1204AFTN-ME12	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	21,0 °			■			■						■				■			
SEMX1204AFTN-M15	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	4,0 °	■		■			■	■	■				■				■			
SEMX1204AFTN-MD19	12,7 *0.500*	1,5 *0.059*	1,12 *0.044*	4,76 *0.187*	0,0 °	■			■			■					■							
SEEX1505AFN-E10	15,875 *0.625*	1,8 *0.071*	1,5 *0.059*	5,56 *0.219*	25,0 °																			■
SEEX1505AFN-M12	15,875 *0.625*	1,8 *0.071*	1,5 *0.059*	5,56 *0.219*	5,0 °		■							■			■				■			
SEEX1505AFTN-M17	15,875 *0.625*	1,8 *0.071*	1,5 *0.059*	5,56 *0.219*	5,0 °	■		■									■				■			
SEEX1505ZZTN-M17	15,875 *0.625*	9,4 *0.370*	1,5 *0.059*	5,56 *0.219*	5,0 °			■									■							
SEMX1505AFTN-ME15	15,875 *0.625*	1,8 *0.071*	1,5 *0.059*	5,56 *0.219*	21,0 °												■				■			
SEMX1505AFTN-M18	15,875 *0.625*	1,8 *0.071*	1,5 *0.059*	5,56 *0.219*	5,0 °	■		■				■	■				■				■			
SEMX1505AFTN-MD20	15,875 *0.625*	1,8 *0.071*	1,5 *0.059*	5,56 *0.219*	0,0 °	■		■	■								■							

SE..12/15

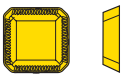


E07

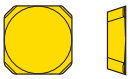


E10-15/M13-18/MD14-20/D16

ME10/ME12/ME13/ME16

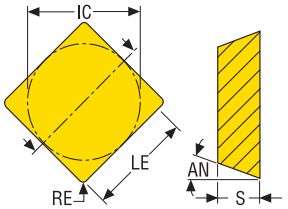


SEEX1203AFTN-M13/MD14

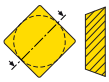


Designation	IC	BS	RE	S	AN°	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SEKR1203AFN-E07	12,7 *0.500*	1,5 *0.059*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	18,0 °											■				■	■	■		
SEKR1203AFTN-ME10	12,7 *0.500*	1,5 *0.059*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	20,0 °											■	■				■			
SEKR1203AFTN-ME13	12,7 *0.500*	1,5 *0.059*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	25,5 °			■								■	■				■			
SEKR1204AFTN-ME16	12,7 *0.500*	1,5 *0.059*	1,0 *0.039*	4,76 *0.187*	20,0 *0.787*	20,0 °											■								
SEKR1303AFTN-ME13	13,44 *0.529*	3,46 *0.136*	0,8 *0.031*	3,36 *0.132*	20,0 *0.787*	24,0 °																■			
SEKR1504AFTN-ME16	15,875 *0.625*	1,5 *0.059*	1,0 *0.039*	4,76 *0.187*	20,0 *0.787*	20,0 °											■								
SEKR1604AFTN-ME16	16,8 *0.661*	4,1 *0.161*	1,0 *0.039*	4,79 *0.189*	20,0 *0.787*	20,0 °											■								
SEEX1203AFTN-M13	12,77 *0.503*	8,0 *0.315*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	0,0 °												■							
SEEX1203AFTN-MD14	12,77 *0.503*	8,0 *0.315*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	0,0 °					■		■						■					■	
SEKN1203AFTN-E10	12,7 *0.500*	2,3 *0.091*	0,0 *NaN*	3,18 *0.125*	20,0 *0.787*	0,0 °															■				
SEKN1203AFN-E12	12,7 *0.500*	1,6 *0.063*	2,0 *0.079*	3,18 *0.125*	20,0 *0.787*	0,0 °																■	■		
SEKN1203AFTN-M14	12,7 *0.500*	1,5 *0.059*	1,0 *0.039*	3,18 *0.125*	20,0 *0.787*	0,0 °	■		■				■	■			■	■				■			
SEKN1203AFTN-D16	12,7 *0.500*	1,6 *0.063*	2,0 *0.079*	3,18 *0.125*	20,0 *0.787*	0,0 °	■																		
SEKN1204AFTN-M18	12,7 *0.500*	1,5 *0.059*	1,0 *0.039*	4,76 *0.187*	20,0 *0.787*	0,0 °												■							
SEKN1504AFN-E15	15,87 *0.625*	1,9 *0.075*	2,0 *0.079*	4,76 *0.187*	20,0 *0.787*	0,0 °																	■		
SEKN1504AFTN-M18	15,87 *0.625*	1,5 *0.059*	1,0 *0.039*	4,76 *0.187*	20,0 *0.787*	0,0 °			■				■				■	■				■			
SEKN1504AFTN-MD20	15,87 *0.625*	1,9 *0.075*	2,0 *0.079*	4,76 *0.187*	20,0 *0.787*	0,0 °	■																		

SENN

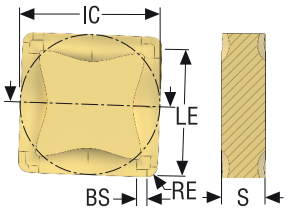


E10/M12

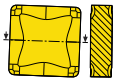


Designation	IC	RE	S	AN°	Cutting rake	Grades Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SENN120308-E10	12,7 *0.500*	0,8 *0.031*	3,175 *0.125*	20,0 *0.787*	0,0 °																	■		
SENN120308T-M12	12,7 *0.500*	0,8 *0.031*	3,175 *0.125*	20,0 *0.787*	0,0 °																■			

SNHF15



M14



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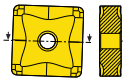
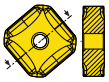
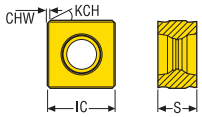


XNN-M14

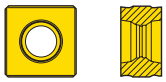


Designation	IC	BS	RE	S	Cutting rake	Grades Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHF150412TN-M14	15,875 *0.625*	1,2 *0.047*	1,2 *0.047*	4,76 *0.187*	15,0 °							■												
SNHF150412TN-M14-H	15,875 *0.625*	1,2 *0.047*	1,2 *0.047*	4,76 *0.187*	15,0 °								■											
SNHF1504XNN-M14	15,875 *0.625*	1,37 *0.054*	1,6 *0.063*	4,76 *0.187*	15,0 °							■												

SNHX11/14

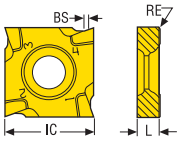


M11/M12



Designation	CHW	S	IC	KCH°	Cutting rake	Grades																			
						Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHX1106TN8-M11	0,5 *0.020*	6,35 *0.250*	11,0 *0.433*	45,0	10,0 °			■									■				■			
SNHX1406TN8-M12	0,8 *0.031*	6,35 *0.250*	14,5 *0.571*	45,0	10,0 °			■									■				■			

SNHQ11

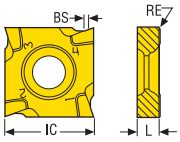


E05/M07

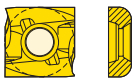
Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ110202EL4-E05	0,2 *0.008*	0,5 *0.020*	2,3 *0.091*	11,0 *0.433*	20,0 °																			■
SNHQ110202ER4-E05	0,2 *0.008*	0,5 *0.020*	2,3 *0.091*	11,0 *0.433*	20,0 °																			■
SNHQ110202TL4-M07	0,2 *0.008*	0,5 *0.020*	2,3 *0.091*	11,0 *0.433*	20,0 °																■			
SNHQ110202TR4-M07	0,2 *0.008*	0,5 *0.020*	2,3 *0.091*	11,0 *0.433*	20,0 °																■			
SNHQ110204TL4-M07	0,4 *0.016*	0,3 *0.012*	2,3 *0.091*	11,0 *0.433*	20,0 °			■												■	■			
SNHQ110204TR4-M07	0,4 *0.016*	0,3 *0.012*	2,3 *0.091*	11,0 *0.433*	20,0 °			■												■	■			
SNHQ110208TL4-M07	0,8 *0.031*	0,2 *0.008*	2,3 *0.091*	11,0 *0.433*	20,0 °						■										■			
SNHQ110208TR4-M07	0,8 *0.031*	0,2 *0.008*	2,3 *0.091*	11,0 *0.433*	20,0 °						■										■			
SNHQ110212TL4-M07	1,2 *0.047*	0,2 *0.008*	2,3 *0.091*	11,0 *0.433*	20,0 °																■			
SNHQ110212TR4-M07	1,2 *0.047*	0,2 *0.008*	2,3 *0.091*	11,0 *0.433*	20,0 °																■			
SNHQ110216TL4-M07	1,6 *0.063*	0,2 *0.008*	2,3 *0.091*	11,0 *0.433*	20,0 °																■			
SNHQ110216TR4-M07	1,6 *0.063*	0,2 *0.008*	2,3 *0.091*	11,0 *0.433*	20,0 °																■			
SNHQ110220TL4-M07	2,0 *0.079*	0,0 *NaN*	2,3 *0.091*	11,0 *0.433*	20,0 °															■				
SNHQ110220TR4-M07	2,0 *0.079*	0,0 *NaN*	2,3 *0.091*	11,0 *0.433*	20,0 °															■				
SNHQ110302EL4-E05	0,2 *0.008*	0,5 *0.020*	2,7 *0.106*	11,0 *0.433*	20,0 °																			■
SNHQ110302ER4-E05	0,2 *0.008*	0,5 *0.020*	2,7 *0.106*	11,0 *0.433*	20,0 °																			■
SNHQ110302TL4-M07	0,2 *0.008*	0,5 *0.020*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110302TR4-M07	0,2 *0.008*	0,5 *0.020*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110304TL4-M07	0,4 *0.016*	0,3 *0.012*	2,7 *0.106*	11,0 *0.433*	20,0 °			■												■	■			
SNHQ110304TR4-M07	0,4 *0.016*	0,3 *0.012*	2,7 *0.106*	11,0 *0.433*	20,0 °			■												■	■			
SNHQ110308TL4-M07	0,8 *0.031*	0,2 *0.008*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110308TR4-M07	0,8 *0.031*	0,2 *0.008*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110312TL4-M07	1,2 *0.047*	0,2 *0.008*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			

Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ110312TR4-M07	1,2 *0.047*	0,2 *0.008*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110316TL4-M07	1,6 *0.063*	0,2 *0.008*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110316TR4-M07	1,6 *0.063*	0,2 *0.008*	2,7 *0.106*	11,0 *0.433*	20,0 °																■			
SNHQ110320TL4-M07	2,0 *0.079*	0,0 *NaN*	2,7 *0.106*	11,0 *0.433*	20,0 °															■				
SNHQ110320TR4-M07	2,0 *0.079*	0,0 *NaN*	2,7 *0.106*	11,0 *0.433*	20,0 °															■				

SNHQ1203/1204



EL/ER2-E05/M07

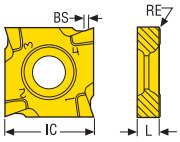


xL/xR4-E05/M07

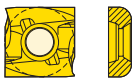
Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ120302EL4-E05	0,2 *0.008*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °																			■
SNHQ120302ER4-E05	0,2 *0.008*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °																			■
SNHQ120302TL4-M07	0,2 *0.008*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120302TR4-M07	0,2 *0.008*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120304TL4-M07	0,4 *0.016*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120304TR4-M07	0,4 *0.016*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120308TL4-M07	0,8 *0.031*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °			■													■			
SNHQ120308TR4-M07	0,8 *0.031*	0,75 *0.030*	3,2 *0.126*	12,7 *0.500*	20,0 °			■													■			
SNHQ120310TL4-M07	1,0 *0.039*	0,6 *0.024*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120310TR4-M07	1,0 *0.039*	0,6 *0.024*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120312TL4-M07	1,2 *0.047*	0,4 *0.016*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120312TR4-M07	1,2 *0.047*	0,4 *0.016*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120316TL4-M07	1,6 *0.063*	0,2 *0.008*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120316TR4-M07	1,6 *0.063*	0,2 *0.008*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120320TL4-M07	2,0 *0.079*	0,2 *0.008*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120320TR4-M07	2,0 *0.079*	0,2 *0.008*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120324EL2-M07	2,4 *0.094*	0,0 *NaN*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120324ER2-M07	2,4 *0.094*	0,0 *NaN*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120330EL2-M07	3,0 *0.118*	0,0 *NaN*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120330ER2-M07	3,0 *0.118*	0,0 *NaN*	3,2 *0.126*	12,7 *0.500*	20,0 °																■			
SNHQ120404EL4-E05	0,4 *0.016*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °																			■
SNHQ120404ER4-E05	0,4 *0.016*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °																			■
SNHQ120402TL4-M07	0,2 *0.008*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			

Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ120402TR4-M07	0,2 *0.008*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120404TL4-M07	0,4 *0.016*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °															■	■			
SNHQ120404TR4-M07	0,4 *0.016*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °															■	■			
SNHQ120408TL4-M07	0,8 *0.031*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120408TR4-M07	0,8 *0.031*	0,75 *0.030*	4,0 *0.157*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120412TL4-M07	1,2 *0.047*	0,4 *0.016*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120412TR4-M07	1,2 *0.047*	0,4 *0.016*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120416TL4-M07	1,6 *0.063*	0,2 *0.008*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120416TR4-M07	1,6 *0.063*	0,2 *0.008*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120420TL4-M07	2,0 *0.079*	0,2 *0.008*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120420TR4-M07	2,0 *0.079*	0,2 *0.008*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120424EL2-M07	2,4 *0.094*	0,0 *NaN*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120424ER2-M07	2,4 *0.094*	0,0 *NaN*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120431EL2-M07	3,1 *0.122*	0,0 *NaN*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120431ER2-M07	3,1 *0.122*	0,0 *NaN*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120435EL2-M07	3,5 *0.138*	0,0 *NaN*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			
SNHQ120435ER2-M07	3,5 *0.138*	0,0 *NaN*	4,0 *0.157*	12,7 *0.500*	20,0 °																■			

SNHQ12045



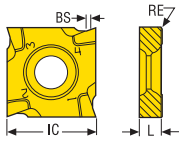
EL/ER2-M07



xL/xR4-E05/M07

Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ1204504EL4-E05	0,4 *0.016*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °																			■
SNHQ1204504ER4-E05	0,4 *0.016*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °																			■
SNHQ1204502TL4-M07	0,2 *0.008*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204502TR4-M07	0,2 *0.008*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204504TL4-M07	0,4 *0.016*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ1204504TR4-M07	0,4 *0.016*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ1204508TL4-M07	0,8 *0.031*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °			■													■			
SNHQ1204508TR4-M07	0,8 *0.031*	0,75 *0.030*	4,5 *0.177*	12,7 *0.500*	20,0 °			■													■			
SNHQ1204512TL4-M07	1,2 *0.047*	0,4 *0.016*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204512TR4-M07	1,2 *0.047*	0,4 *0.016*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204516TL4-M07	1,6 *0.063*	0,2 *0.008*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204516TR4-M07	1,6 *0.063*	0,2 *0.008*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204520TL4-M07	2,0 *0.079*	0,2 *0.008*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204520TR4-M07	2,0 *0.079*	0,2 *0.008*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204524EL2-M07	2,4 *0.094*	0,0 *NaN*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204524ER2-M07	2,4 *0.094*	0,0 *NaN*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204531EL2-M07	3,1 *0.122*	0,0 *NaN*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204531ER2-M07	3,1 *0.122*	0,0 *NaN*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204540EL2-M07	4,0 *0.157*	0,0 *NaN*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			
SNHQ1204540ER2-M07	4,0 *0.157*	0,0 *NaN*	4,5 *0.177*	12,7 *0.500*	20,0 °																■			

SNHQ1205



ER/EL2-M07

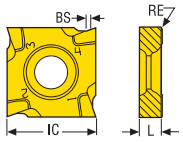
xL/xR4-E05/M07

Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ120504EL4-E05	0,4 *0.016*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °																			■
SNHQ120504ER4-E05	0,4 *0.016*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °																			■
SNHQ120502TL4-M07	0,2 *0.008*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120502TR4-M07	0,2 *0.008*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120504TL4-M07	0,4 *0.016*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °			■			■									■	■			
SNHQ120504TR4-M07	0,4 *0.016*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °			■			■									■	■			
SNHQ120508TL4-M07	0,8 *0.031*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120508TR4-M07	0,8 *0.031*	0,75 *0.030*	5,4 *0.213*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120510TL4-M07	1,0 *0.039*	0,6 *0.024*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120510TR4-M07	1,0 *0.039*	0,6 *0.024*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120512TL4-M07	1,2 *0.047*	0,4 *0.016*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120512TR4-M07	1,2 *0.047*	0,4 *0.016*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120516TL4-M07	1,6 *0.063*	0,2 *0.008*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120516TR4-M07	1,6 *0.063*	0,2 *0.008*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120520TL4-M07	2,0 *0.079*	0,2 *0.008*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120520TR4-M07	2,0 *0.079*	0,2 *0.008*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120524EL2-M07	2,4 *0.094*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120524ER2-M07	2,4 *0.094*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120531EL2-M07	3,1 *0.122*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120531ER2-M07	3,1 *0.122*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120540EL2-M07	4,0 *0.157*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120540ER2-M07	4,0 *0.157*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			
SNHQ120550EL2-M07	5,0 *0.197*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			

Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ120550ER2-M07	5,0 *0.197*	0,0 *NaN*	5,4 *0.213*	12,7 *0.500*	20,0 °																■			

Note: When using SNHQ insert with corner radius = 5 mm,
please modify the external profile of the cutter by adding a corner radius or chamfer = 4 mm

SNHQ1207



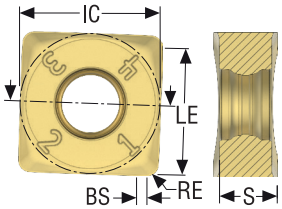
EL/ER2-M07

xL/xR4-E05/M07

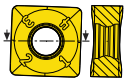
Designation	RE	BS	L	IC	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNHQ120704EL4-E05	0,4 *0.016*	0,75 *0.030*	7,0 *0.276*	12,7 *0.500*	20,0 °																			■
SNHQ120704ER4-E05	0,4 *0.016*	0,75 *0.030*	7,0 *0.276*	12,7 *0.500*	20,0 °																			■
SNHQ120704TL4-M07	0,4 *0.016*	0,75 *0.030*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120704TR4-M07	0,4 *0.016*	0,75 *0.030*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120708TL4-M07	0,8 *0.031*	0,75 *0.030*	7,0 *0.276*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120708TR4-M07	0,8 *0.031*	0,75 *0.030*	7,0 *0.276*	12,7 *0.500*	20,0 °			■												■	■			
SNHQ120712TL4-M07	1,2 *0.047*	0,4 *0.016*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120712TR4-M07	1,2 *0.047*	0,4 *0.016*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120716TL4-M07	1,6 *0.063*	0,2 *0.008*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120716TR4-M07	1,6 *0.063*	0,2 *0.008*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120720TL4-M07	2,0 *0.079*	0,2 *0.008*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120720TR4-M07	2,0 *0.079*	0,2 *0.008*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120724EL2-M07	2,4 *0.094*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120724ER2-M07	2,4 *0.094*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120731EL2-M07	3,1 *0.122*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120731ER2-M07	3,1 *0.122*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120740EL2-M07	4,0 *0.157*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120740ER2-M07	4,0 *0.157*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120750EL2-M07	5,0 *0.197*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120750ER2-M07	5,0 *0.197*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120760EL2-M07	6,0 *0.236*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			
SNHQ120760ER2-M07	6,0 *0.236*	0,0 *NaN*	7,0 *0.276*	12,7 *0.500*	20,0 °																■			

Note: When using SNHQ insert with corner radius = 5 and 6 mm,
please modify the external profile of the cutter by adding a corner radius or chamfer = 4 mm

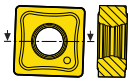
SNMU12/16



M10

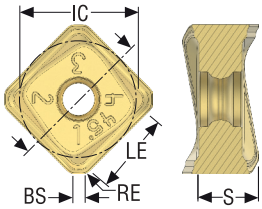


MD13/MD16

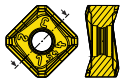


Designation	IC	RE	BS	S	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNMU120408TN-M10	12,0 *0.472*	0,8 *0.031*	0,0 *NaN*	4,8 *0.189*	20,0 °	■		■				■	■											
SNMU120410TN-M10	12,0 *0.472*	1,0 *0.039*	1,0 *0.039*	4,8 *0.189*	20,0 °	■		■					■		■						■			
SNMU120408TN-MD13	12,0 *0.472*	0,8 *0.031*	0,0 *NaN*	4,8 *0.189*	0,0 °			■				■	■											
SNMU120410TN-MD13	12,0 *0.472*	1,0 *0.039*	1,0 *0.039*	4,8 *0.189*	0,0 °	■		■				■	■											
SNMU160610TN-M10	16,0 *0.630*	1,0 *0.039*	0,0 *NaN*	6,4 *0.252*	20,0 °	■		■																
SNMU160612TN-M10	16,0 *0.630*	1,2 *0.047*	1,2 *0.047*	6,4 *0.252*	20,0 °	■		■					■		■									
SNMU160610TN-MD16	16,0 *0.630*	1,0 *0.039*	0,0 *NaN*	6,4 *0.252*	0,0 °	■						■	■											
SNMU160612TN-MD16	16,0 *0.630*	1,2 *0.047*	1,2 *0.047*	6,4 *0.252*	0,0 °	■		■				■	■											

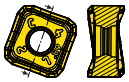
SN.X14/22



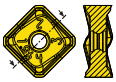
1407AN.R-ME10/M10/M16



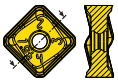
1407ZN.R-ME10/M10/M16



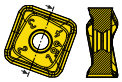
2209ANR-ME12



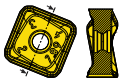
2209ANTR-M12-M18



2209ZNR-ME12

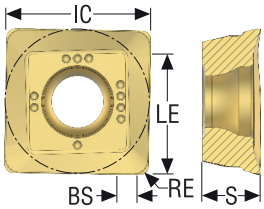


2209ZNTR-M12-M18

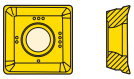


Designation	IC	RE	BS	S	Cutting rake	Grades																		
						Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SNMX1407ANTR-M10	14,0 *0.551*	1,0 *0.039*	1,5 *0.059*	6,59 *0.259*	17,0 °	■	■	■	■		■		■	■	■		■				■			
SNMX1407ANTR-M16	14,0 *0.551*	1,0 *0.039*	1,5 *0.059*	6,59 *0.259*	17,0 °	■		■	■			■	■		■		■				■			
SNMX1407ZNTR-M10	14,0 *0.551*	1,0 *0.039*	1,5 *0.059*	6,59 *0.259*	15,0 °	■	■	■	■		■	■	■	■	■		■				■			
SNMX1407ZNTR-M16	14,0 *0.551*	1,0 *0.039*	1,5 *0.059*	6,59 *0.259*	15,0 °	■		■	■			■	■				■				■			
SNMX2209ANTR-M12	22,0 *0.866*	2,0 *0.079*	1,5 *0.059*	8,81 *0.347*	20,0 °		■	■					■	■	■		■				■			
SNMX2209ANTR-M18	22,0 *0.866*	2,0 *0.079*	1,5 *0.059*	8,81 *0.347*	25,0 °	■		■				■	■		■		■							
SNMX2209ANR-ME12	22,0 *0.866*	2,0 *0.079*	1,5 *0.059*	8,81 *0.347*	20,0 °																■			
SNMX2209ZNTR-M12	22,0 *0.866*	2,0 *0.079*	1,5 *0.059*	8,79 *0.346*	20,0 °		■	■					■	■							■			
SNMX2209ZNTR-M18	22,0 *0.866*	2,0 *0.079*	1,5 *0.059*	8,79 *0.346*	25,0 °	■		■				■	■				■							
SNMX2209ZNR-ME12	22,0 *0.866*	2,0 *0.079*	1,5 *0.059*	8,79 *0.346*	20,0 °									■							■			
SNHX1407ANR-ME10	14,0 *0.551*	1,0 *0.039*	1,5 *0.059*	6,59 *0.259*	20,0 °		■				■			■			■				■			■
SNHX1407ZNR-ME10	14,0 *0.551*	1,0 *0.039*	1,5 *0.059*	6,59 *0.259*	20,0 °									■							■			

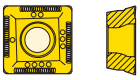
SONX09/12



M10/M12/M14

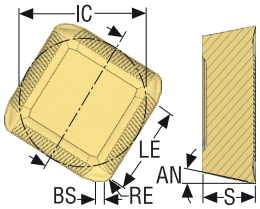


ME06/ME08



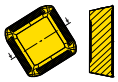
Designation	RE	BS	LE	S	IC	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SONX09T304TR-ME06	0,4 *0.016*	1,3 *0.051*	8,0 *0.315*	3,97 *0.156*	9,55 *0.376*	22,0 °																■			
SONX09T304TR-M10	0,4 *0.016*	1,3 *0.051*	8,0 *0.315*	3,97 *0.156*	9,55 *0.376*	19,0 °							■					■				■			
SONX09T308TR-M10	0,8 *0.031*	1,3 *0.051*	8,0 *0.315*	3,97 *0.156*	9,55 *0.376*	19,0 °			■				■	■								■			
SONX120508TR-ME08	0,8 *0.031*	1,0 *0.039*	11,0 *0.433*	5,17 *0.204*	12,7 *0.500*	24,0 °																■			
SONX120508TR-M12	0,8 *0.031*	1,0 *0.039*	11,0 *0.433*	5,17 *0.204*	12,7 *0.500*	16,0 °	■		■				■	■				■				■			
SONX150508TR-M14	0,8 *0.031*	2,0 *0.079*	14,0 *0.551*	5,56 *0.219*	15,8 *0.622*	22,0 °			■				■					■				■			
SONX150508TR-ME10	0,8 *0.031*	2,0 *0.079*	14,0 *0.551*	5,56 *0.219*	15,8 *0.622*	19,0 °																■			

SP..19/28

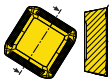


D35

ZETL-M17-MD20

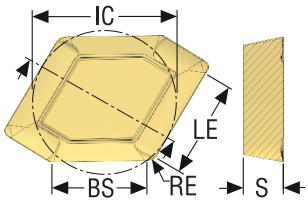


ZETR-M17-MD20-D25



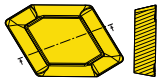
Designation	RE	BS	L	S	AN°	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SPER1906ZETL-M17	3,0 *0.118*	1,8 *0.071*	19,05 *0.750*	6,35 *0.250*	11,0 *0.433*	17,0 °		■																	
SPER1906ZETR-M17	1,6 *0.063*	1,8 *0.071*	19,05 *0.750*	6,35 *0.250*	11,0 *0.433*	17,0 °												■							
SPEN1906ZETL-MD20	1,6 *0.063*	1,8 *0.071*	19,05 *0.750*	6,35 *0.250*	11,0 *0.433*	0,0 °			■																
SPEN1906ZETR-MD20	1,6 *0.063*	1,8 *0.071*	19,05 *0.750*	6,35 *0.250*	11,0 *0.433*	0,0 °			■								■	■							
SPEN1906ZETR-D25	1,6 *0.063*	1,8 *0.071*	19,05 *0.750*	6,35 *0.250*	11,0 *0.433*	0,0 °	■		■																
SPEN2807ZETR-D35	2,0 *0.079*	1,8 *0.071*	28,575 *1.125*	7,938 *0.313*	11,0 *0.433*	0,0 °	■																		
SPMR1906ZETR-M17	1,6 *0.063*	1,0 *0.039*	13,3 *0.524*	6,35 *0.250*	11,0 *0.433*	17,0 °		■																	

SPE.ZZ



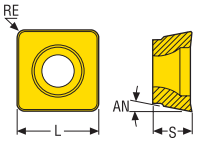
M17/D25/MD20

ZZTL-M17



Designation	RE	BS	L	S	Cutting rake	Grades																			
						Coated																	Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SPER1906ZZTL-M17	3,0 *0.118*	12,0 *0.472*	19,05 *0.750*	6,35 *0.250*	17,0 °		■																	
SPER1906ZZTR-M17	3,0 *0.118*	12,0 *0.472*	19,05 *0.750*	6,35 *0.250*	17,0 °		■	■																
SPEN1906ZZTR-D25	3,0 *0.118*	12,0 *0.472*	20,0 *0.787*	6,35 *0.250*	0,0 °	■		■																
SPEN1906ZZTR-MD20	3,0 *0.118*	12,0 *0.472*	20,0 *0.787*	6,35 *0.250*	0,0 °			■																

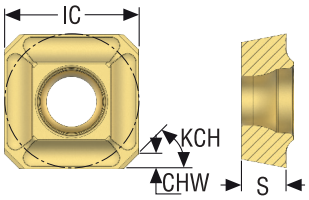
SPMT



M08

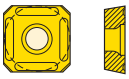
Designation	RE	L	S	AN°	Cutting rake	Grades																		
						Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SPMT100408T-M08	0,8 *0.031*	10,0 *0.394*	4,76 *0.187*	11,0 *0.433*	10,0 °																■			

SPMX



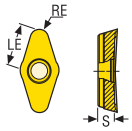
-75

AP-75



Designation	CHW	L	S	KCH°	Cutting rake	Grades																		
						Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
SPMX0602AP-75	0,69 *0.027*	6,35 *0.250*	2,38 *0.094*	45,0	0,0 °																■	■		
SPMX0703AP-75	0,87 *0.034*	7,94 *0.313*	3,18 *0.125*	45,0	0,0 °																■			
SPMX0903AP-75	1,05 *0.041*	9,525 *0.375*	3,18 *0.125*	45,0	0,0 °												■				■	■		
SPMX12T3AP-75	1,39 *0.055*	12,7 *0.500*	3,97 *0.156*	45,0	0,0 °												■				■			
SPMX060204-75	– *NaN*	6,35 *0.250*	2,38 *0.094*	–	20,0 °											■					■			
SPMX070304-75	– *NaN*	7,94 *0.313*	3,18 *0.125*	–	16,0 °											■					■			
SPMX090304-75	– *NaN*	9,525 *0.375*	3,18 *0.125*	–	16,0 °											■					■			
SPMX12T308-75	– *NaN*	12,7 *0.500*	3,97 *0.156*	–	14,0 °																■			

VPGX

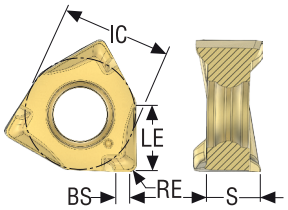


E06/E10

Designation	RE	LE	S	Cutting rake	Grades																		
					Coated																	Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
VPGX220605FR-E06	0,46 *0.018*	14,2 *0.559*	6,35 *0.250*	25,0 °																		■	
VPGX220605ER-E10	0,46 *0.018*	14,2 *0.559*	6,35 *0.250*	25,0 °																			■
VPGX220608PDER-E10	0,85 *0.033*	14,2 *0.559*	6,35 *0.250*	25,0 °																			■
VPGX220616ER-E10	1,64 *0.065*	13,7 *0.539*	6,35 *0.250*	25,0 °																			■
VPGX220620ER-E10	2,05 *0.081*	14,2 *0.559*	6,35 *0.250*	25,0 °																			■
VPGX220624ER-E10	2,5 *0.098*	14,2 *0.559*	6,35 *0.250*	25,0 °																			■
VPGX220631EN-E10	3,18 *0.125*	14,2 *0.559*	6,35 *0.250*	25,0 °																			■
VPGX220631FN-E06	3,18 *0.125*	14,2 *0.559*	6,35 *0.250*	25,0 °																		■	
VPGX220640ER-E10	4,12 *0.162*	14,2 *0.559*	6,35 *0.250*	25,0 °																			■
VPGX220663ER-E10	6,35 *0.250*	11,8 *0.465*	6,35 *0.250*	25,0 °																			■

*Insert with wiper flat 1,5mm

XNEX04/08



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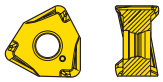
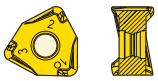
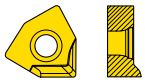


XNEX08..

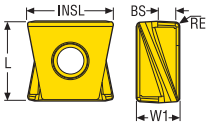


ZZR-M11



Designation	RE	BS	LE	S	IC	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1500	MP2050	MP2500	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XNEX040304R-M06	0,4 *0.016*	0,8 *0.031*	4,0 *0.157*	3,31 *0.130*	6,7 *0.264*	32,6 °				■					■							■			
XNEX040308R-M06	0,8 *0.031*	0,4 *0.016*	4,0 *0.157*	3,31 *0.130*	6,7 *0.264*	32,6 °				■		■			■							■			
XNEX040304TR-M08	0,4 *0.016*	0,8 *0.031*	4,0 *0.157*	3,29 *0.130*	6,7 *0.264*	27,0 °				■			■	■								■			
XNEX040308TR-M08	0,8 *0.031*	0,4 *0.016*	4,0 *0.157*	3,29 *0.130*	6,7 *0.264*	27,0 °				■		■	■	■								■			
XNEX080604TR-M13	0,4 *0.016*	1,8 *0.071*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	22,0 °				■								■				■			
XNEX080604TR-ME09	0,4 *0.016*	1,8 *0.071*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	27,0 °			■	■												■			
XNEX080608TR-ME09	0,8 *0.031*	1,4 *0.055*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	27,0 °	■		■	■		■	■	■				■				■			
XNEX080608R-M08	0,8 *0.031*	1,4 *0.055*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	24,0 °		■		■		■			■	■		■				■			■
XNEX080608TR-M13	0,8 *0.031*	1,3 *0.051*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	22,0 °	■		■	■			■	■				■				■			
XNEX080608TR-MD15	0,8 *0.031*	1,4 *0.055*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	17,0 °	■		■	■			■	■				■				■			
XNEX080612TR-ME09	1,2 *0.047*	1,0 *0.039*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	27,0 °			■			■		■								■			
XNEX080612TR-M13	1,2 *0.047*	0,9 *0.035*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	22,0 °			■				■	■								■			
XNEX080612TR-MD15	1,2 *0.047*	1,0 *0.039*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	17,0 °	■		■				■												
XNEX080616TR-ME09	1,6 *0.063*	0,6 *0.024*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	27,0 °			■	■		■		■								■			
XNEX080616TR-M13	1,6 *0.063*	0,5 *0.020*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	22,0 °	■		■	■			■	■				■				■			
XNEX080616TR-MD15	1,6 *0.063*	0,7 *0.028*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	17,0 °	■		■	■			■	■				■				■			
XNEX080608TL-M13	0,8 *0.031*	1,3 *0.051*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	22,0 °			■						■			■				■			
XNEX080616TL-M13	1,6 *0.063*	0,5 *0.020*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	22,0 °			■																
XNEX080608ZZR-M11	0,8 *0.031*	6,0 *0.236*	7,5 *0.295*	6,45 *0.254*	12,48 *0.491*	19,0 °				■			■									■			

XNHQ09/12/14/17

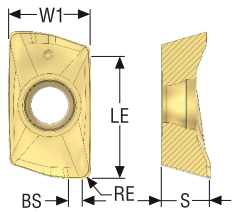


E07/E09/E10/E12/M08/M10/M11/M13

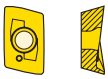
Designation	RE	BS	L	INSL	W1	Cutting rake	Grades																			
							Coated															Uncoated				
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XNHQ090508EN4-E07	0,8 *0.031*	1,8 *0.071*	9,3 *0.366*	11,8 *0.465*	5,5 *0.217*	21,0 °																■			
XNHQ090504TN4-M08	0,4 *0.016*	2,2 *0.087*	9,3 *0.366*	11,81 *0.465*	5,5 *0.217*	16,0 °																■			
XNHQ090508TN4-M08	0,8 *0.031*	1,8 *0.071*	9,3 *0.366*	11,7 *0.461*	5,5 *0.217*	16,0 °			■					■								■			
XNHQ090512TN4-M08	1,2 *0.047*	1,4 *0.055*	9,3 *0.366*	11,58 *0.456*	5,5 *0.217*	16,0 °																■			
XNHQ090516TN4-M08	1,6 *0.063*	1,0 *0.039*	9,3 *0.366*	11,46 *0.451*	5,5 *0.217*	16,0 °			■													■			
XNHQ090520TN4-M08	2,0 *0.079*	0,6 *0.024*	9,3 *0.366*	11,4 *0.449*	5,5 *0.217*	16,0 °																■			
XNHQ090524TN4-M08	2,4 *0.094*	0,2 *0.008*	9,3 *0.366*	11,2 *0.441*	5,5 *0.217*	16,0 °																■			
XNHQ090531TN4-M08	3,1 *0.122*	0,0 *NaN*	9,3 *0.366*	11,0 *0.433*	5,5 *0.217*	16,0 °																■			
XNHQ090540TN4-M08	4,0 *0.157*	0,0 *NaN*	9,3 *0.366*	10,7 *0.421*	5,5 *0.217*	16,0 °																■			
XNHQ120608EN4-E09	0,8 *0.031*	2,3 *0.091*	11,7 *0.461*	13,34 *0.525*	6,5 *0.256*	21,0 °																■			
XNHQ120608TN4-M10	0,8 *0.031*	2,3 *0.091*	11,7 *0.461*	13,16 *0.518*	6,5 *0.256*	16,0 °			■					■								■			
XNHQ120612TN4-M10	1,2 *0.047*	1,9 *0.075*	11,7 *0.461*	13,05 *0.514*	6,5 *0.256*	16,0 °																■			
XNHQ120616TN4-M10	1,6 *0.063*	1,58 *0.062*	11,7 *0.461*	12,94 *0.509*	6,5 *0.256*	16,0 °			■													■			
XNHQ120620TN4-M10	2,0 *0.079*	1,1 *0.043*	11,7 *0.461*	12,81 *0.504*	6,5 *0.256*	16,0 °																■			
XNHQ120624TN4-M10	2,4 *0.094*	0,7 *0.028*	11,7 *0.461*	12,72 *0.501*	6,5 *0.256*	16,0 °																■			
XNHQ120631TN4-M10	3,1 *0.122*	0,15 *0.006*	11,7 *0.461*	12,53 *0.493*	6,5 *0.256*	16,0 °																■			
XNHQ120640TN4-M10	4,0 *0.157*	0,0 *NaN*	11,7 *0.461*	12,25 *0.482*	6,5 *0.256*	16,0 °																■			
XNHQ120650TN4-M10	5,0 *0.197*	0,0 *NaN*	11,7 *0.461*	11,87 *0.467*	6,5 *0.256*	16,0 °																■			
XNHQ140708EN4-E10	0,8 *0.031*	3,0 *0.118*	14,0 *0.551*	15,1 *0.594*	7,5 *0.295*	22,0 °																■			■
XNHQ140708TN4-M11	0,8 *0.031*	3,0 *0.118*	14,0 *0.551*	15,1 *0.594*	7,5 *0.295*	16,0 °			■					■								■			
XNHQ140716TN4-M11	1,6 *0.063*	2,2 *0.087*	14,0 *0.551*	14,8 *0.583*	7,5 *0.295*	16,0 °			■													■			
XNHQ140720TN4-M11	2,0 *0.079*	1,8 *0.071*	14,0 *0.551*	14,7 *0.579*	7,5 *0.295*	16,0 °																■			
XNHQ140724TN4-M11	2,4 *0.094*	1,4 *0.055*	14,0 *0.551*	14,6 *0.575*	7,5 *0.295*	16,0 °																■			

Designation	RE	BS	L	INSL	W1	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XNHQ140731TN4-M11	3,1 *0.122*	0,7 *0.028*	14,0 *0.551*	14,4 *0.567*	7,5 *0.295*	16,0 °			■													■			
XNHQ140740TN4-M11	4,0 *0.157*	0,0 *NaN*	14,0 *0.551*	14,2 *0.559*	7,5 *0.295*	16,0 °																■			
XNHQ140750TN4-M11	5,0 *0.197*	0,0 *NaN*	14,0 *0.551*	13,9 *0.547*	7,5 *0.295*	16,0 °																■			
XNHQ140760TN4-M11	6,0 *0.236*	0,0 *NaN*	14,0 *0.551*	13,6 *0.535*	7,5 *0.295*	16,0 °																■			
XNHQ170708EN4-E12	0,8 *0.031*	3,0 *0.118*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			
XNHQ170708TN4-M13	0,8 *0.031*	3,0 *0.118*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °			■					■								■			
XNHQ170716TN4-M13	1,6 *0.063*	2,2 *0.087*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °			■													■			
XNHQ170720TN4-M13	2,0 *0.079*	1,8 *0.071*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			
XNHQ170724TN4-M13	2,4 *0.094*	1,4 *0.055*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			
XNHQ170731TN4-M13	3,1 *0.122*	0,7 *0.028*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			
XNHQ170740TN4-M13	4,0 *0.157*	0,0 *NaN*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			
XNHQ170750TN4-M13	5,0 *0.197*	0,0 *NaN*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			
XNHQ170760TN4-M13	6,0 *0.236*	0,0 *NaN*	17,0 *0.669*	0,0 *NaN*	7,5 *0.295*	16,0 °																■			

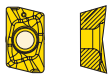
XO.X06



E03

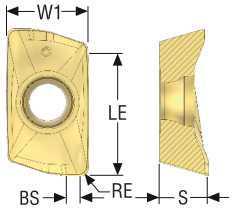


M05

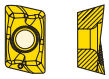


Designation	RE	BS	LE	W1	S	Cutting rake	Grades																			
							Coated																	Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOEX060202FR-E03	0,2 *0.008*	1,1 *0.043*	6,0 *0.236*	4,1 *0.161*	2,45 *0.096*	30,6 °																		■	
XOEX060204FR-E03	0,4 *0.016*	0,9 *0.035*	6,0 *0.236*	4,1 *0.161*	2,45 *0.096*	29,2 °																■		■	
XOMX060202R-M05	0,2 *0.008*	1,1 *0.043*	5,5 *0.217*	4,1 *0.161*	2,45 *0.096*	20,2 °				■											■	■			
XOMX060204R-M05	0,4 *0.016*	0,91 *0.036*	5,5 *0.217*	4,1 *0.161*	2,45 *0.096*	20,2 °				■		■			■						■	■			
XOMX060208R-M05	0,8 *0.031*	0,51 *0.020*	5,5 *0.217*	4,1 *0.161*	2,45 *0.096*	20,2 °				■		■			■				■		■	■			
XOMX060216R-M05	1,6 *0.063*	0,64 *0.025*	5,5 *0.217*	4,1 *0.161*	2,45 *0.096*	20,2 °				■		■			■						■	■			

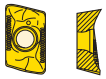
XO.X10



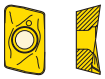
E05/M06



ME07



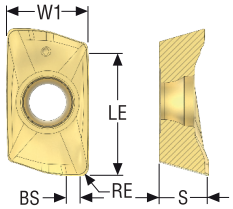
M09



Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOEX10T304FR-E05	0,4 *0.016*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	21,6 °																■		■	
XOEX10T308FR-E05	0,8 *0.031*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	21,6 °																■		■	
XOEX10T312FR-E05	1,2 *0.047*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	21,6 °																		■	
XOEX10T316FR-E05	1,6 *0.063*	1,0 *0.039*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	21,6 °																		■	
XOEX10T320FR-E05	2,0 *0.079*	0,6 *0.024*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	21,6 °																■		■	
XOEX10T331FR-E05	3,1 *0.122*	0,39 *0.015*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	24,1 °																		■	
XOEX10T302R-M06	0,2 *0.008*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	15,1 °																■			
XOEX10T304R-M06	0,4 *0.016*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	15,1 °			■						■			■				■			
XOEX10T308R-M06	0,8 *0.031*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	15,1 °		■	■			■			■	■		■				■			
XOEX10T312R-M06	1,2 *0.047*	1,3 *0.051*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	15,1 °									■							■			
XOEX10T316R-M06	1,6 *0.063*	1,0 *0.039*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	15,1 °									■							■			
XOEX10T320R-M06	2,0 *0.079*	0,6 *0.024*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	18,8 °									■			■							
XOEX10T324R-M06	2,4 *0.094*	0,2 *0.008*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	18,3 °									■										
XOEX10T331R-M06	3,1 *0.122*	0,4 *0.016*	9,7 *0.382*	6,9 *0.272*	3,8 *0.150*	17,3 °		■							■	■						■			
XOMX10T304TR-ME07	0,4 *0.016*	1,3 *0.051*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °	■		■	■			■		■	■		■				■			
XOMX10T308TR-ME07	0,8 *0.031*	1,3 *0.051*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °	■	■	■	■		■	■		■	■		■				■			
XOMX10T312TR-ME07	1,2 *0.047*	1,3 *0.051*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °			■	■					■			■				■			
XOMX10T316TR-ME07	1,6 *0.063*	1,0 *0.039*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °		■	■	■		■			■			■				■			
XOMX10T320TR-ME07	2,0 *0.079*	0,6 *0.024*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °			■	■					■			■				■			
XOMX10T324TR-ME07	2,4 *0.094*	0,2 *0.008*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °			■						■			■				■			
XOMX10T331TR-ME07	3,1 *0.122*	0,4 *0.016*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	20,4 °		■	■						■			■				■			
XOMX10T304TR-M09	0,4 *0.016*	1,3 *0.051*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °	■		■	■			■	■				■				■			
XOMX10T308TR-M09	0,8 *0.031*	1,3 *0.051*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °	■		■	■		■	■	■		■		■				■			

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOMX10T312TR-M09	1,2 *0.047*	1,3 *0.051*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °								■				■				■			
XOMX10T316TR-M09	1,6 *0.063*	1,0 *0.039*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °												■				■			
XOMX10T320TR-M09	2,0 *0.079*	0,6 *0.024*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °												■				■			
XOMX10T324TR-M09	2,4 *0.094*	0,2 *0.008*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °																■			
XOMX10T331TR-M09	3,1 *0.122*	0,4 *0.016*	9,3 *0.366*	6,9 *0.272*	3,83 *0.151*	10,6 °												■				■			

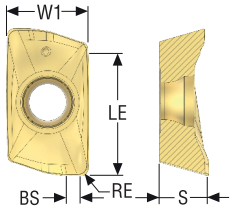
XO.X12



Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOEX120404FR-E06	0,4 *0.016*	2,0 *0.079*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	27,4 °													■			■		■	
XOEX120408FR-E06	0,8 *0.031*	1,6 *0.063*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	27,2 °													■			■		■	
XOEX120420FR-E06	2,0 *0.079*	0,6 *0.024*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	21,2 °													■			■			
XOEX120416FR-E06	1,6 *0.063*	1,2 *0.047*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	26,3 °													■			■			
XOEX120431FR-E06	3,1 *0.122*	– *NaN*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	24,8 °																■			
XOEX120402R-M07	0,2 *0.008*	2,0 *0.079*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	20,5 °																■			
XOEX120404R-M07	0,4 *0.016*	2,0 *0.079*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	20,5 °			■						■						■	■			
XOEX120408R-M07	0,8 *0.031*	1,6 *0.063*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	20,3 °		■	■	■		■			■	■		■			■	■			
XOEX120416R-M07	1,6 *0.063*	1,2 *0.047*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	19,1 °				■		■			■							■			
XOEX120420R-M07	2,0 *0.079*	0,95 *0.037*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	18,6 °						■			■										
XOEX120424R-M07	2,4 *0.094*	0,6 *0.024*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	18,6 °									■						■	■			
XOEX120431R-M07	3,1 *0.122*	– *NaN*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	15,0 °		■							■	■		■				■			
XOEX120440R-M07	4,0 *0.157*	– *NaN*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	16,8 °									■							■			
XOEX120463R-M07	6,3 *0.248*	– *NaN*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	15,3 °									■							■			
XOEX120450R-M07	5,0 *0.197*	– *NaN*	12,0 *0.472*	8,2 *0.323*	5,03 *0.198*	16,8 °									■							■			
XOEX120408ZZR-M07	0,8 *0.031*	6,6 *0.260*	11,1 *0.437*	8,2 *0.323*	5,03 *0.198*	20,3 °				■											■	■			
XOMX120404TR-ME08	0,4 *0.016*	2,0 *0.079*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °			■				■		■							■			
XOMX120408TR-ME08	0,8 *0.031*	1,6 *0.063*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °		■	■			■	■	■	■			■				■			
XOMX120412TR-ME08	1,2 *0.047*	1,2 *0.047*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °			■						■			■				■			
XOMX120416TR-ME08	1,6 *0.063*	1,2 *0.047*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °		■	■			■						■				■			
XOMX120420TR-ME08	2,0 *0.079*	1,0 *0.039*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °			■						■			■				■			
XOMX120424TR-ME08	2,4 *0.094*	0,92 *0.036*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °			■						■			■				■			
XOMX120431TR-ME08	3,1 *0.122*	0,6 *0.024*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °		■	■			■			■			■				■			

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOMX120440TR-ME08	4,0 *0.157*	0,8 *0.031*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	20,1 °		■	■						■			■				■			
XOMX120408TR-M12	0,8 *0.031*	1,6 *0.063*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	10,4 °	■		■	■			■	■				■				■			
XOMX120416TR-M12	1,6 *0.063*	1,2 *0.047*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	10,4 °				■								■				■			
XOMX120431TR-M12	3,1 *0.122*	0,6 *0.024*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	10,4 °				■								■				■			
XOMX120408TR-MD13	0,8 *0.031*	1,6 *0.063*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	14,6 °	■		■	■			■	■				■				■			
XOMX120404TR-MD13	0,4 *0.016*	2,0 *0.079*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	14,6 °	■						■									■			
XOMX120412TR-MD13	1,2 *0.047*	1,2 *0.047*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	14,7 °	■			■			■									■			
XOMX120416TR-MD13	1,6 *0.063*	1,2 *0.047*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	14,7 °	■			■			■									■			
XOMX120408TR-D14	0,8 *0.031*	1,6 *0.063*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	1,0 °	■		■	■			■								■				
XOMX120431TR-D14	3,1 *0.122*	0,6 *0.024*	11,6 *0.457*	8,2 *0.323*	5,07 *0.200*	1,0 °				■											■				

XO.X16



E07/M09

M13

MD14

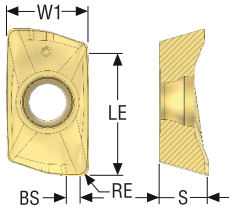
ME11

XOMX-M09

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOEX160504FR-E07	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	23,0 °																			■
XOEX160508FR-E07	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	23,0 °																			■
XOEX160504R-M09	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °			■	■											■				
XOEX160508R-M09	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °		■	■	■					■	■		■				■			
XOEX160516R-M09	1,6 *0.063*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °									■							■			
XOEX160520R-M09	2,0 *0.079*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °									■							■			
XOEX160524R-M09	2,4 *0.094*	1,8 *0.071*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °		■							■							■			
XOEX160531R-M09	3,1 *0.122*	1,6 *0.063*	15,3 *0.602*	10,2 *0.402*	5,9 *0.232*	14,0 °		■							■							■			
XOEX160540R-M09	4,0 *0.157*	1,2 *0.047*	15,2 *0.598*	10,2 *0.402*	5,9 *0.232*	14,0 °									■							■			
XOEX160550R-M09	5,0 *0.197*	0,3 *0.012*	15,0 *0.591*	10,2 *0.402*	5,59 *0.220*	14,0 °									■							■			
XOEX160563R-M09	6,3 *0.248*	0,2 *0.008*	14,7 *0.579*	10,2 *0.402*	5,34 *0.210*	14,0 °									■							■			
XOMX160504TR-ME11	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	19,0 °			■													■			
XOMX160508TR-ME11	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	19,0 °		■	■					■	■			■				■			
XOMX160512TR-ME11	1,2 *0.047*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	19,0 °			■													■			
XOMX160516TR-ME11	1,6 *0.063*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	18,0 °			■													■			
XOMX160520TR-ME11	2,0 *0.079*	1,9 *0.075*	15,4 *0.606*	10,2 *0.402*	5,94 *0.234*	18,0 °			■						■							■			
XOMX160531TR-ME11	3,1 *0.122*	1,6 *0.063*	15,4 *0.606*	10,2 *0.402*	5,93 *0.233*	19,0 °		■							■							■			
XOMX160540TR-ME11	4,0 *0.157*	1,2 *0.047*	15,2 *0.598*	10,2 *0.402*	5,93 *0.233*	19,0 °																■			
XOMX160550TR-ME11	5,0 *0.197*	0,3 *0.012*	15,0 *0.591*	10,2 *0.402*	5,56 *0.219*	18,0 °																■			
XOMX160563TR-ME11	6,3 *0.248*	0,2 *0.008*	14,6 *0.575*	10,2 *0.402*	5,3 *0.209*	18,0 °																■			
XOMX160508R-M09	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,9 *0.232*	14,0 °									■							■			
XOMX160508TR-M13	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,98 *0.235*	9,0 °	■		■	■			■	■				■				■			
XOMX160516TR-M13	1,6 *0.063*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	5,98 *0.235*	9,0 °																■			

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOMX160531TR-M13	3,1 *0.122*	1,6 *0.063*	15,4 *0.606*	10,2 *0.402*	5,98 *0.235*	9,0 °																■			
XOMX160504TR-MD14	0,4 *0.016*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	6,01 *0.237*	4,0 °								■											
XOMX160508TR-MD14	0,8 *0.031*	2,0 *0.079*	15,4 *0.606*	10,2 *0.402*	6,01 *0.237*	4,0 °	■			■				■				■							

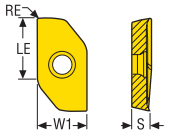
XO.X18



Designation	RE	BS	LE	W1	S	Cutting rake	Grades																		
							Coated															Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOEX180604FR-E10	0,4 *0.016*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	29,0 °																■			■
XOEX180608FR-E10	0,8 *0.031*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	29,0 °																■			■
XOEX180616FR-E10	1,6 *0.063*	2,3 *0.091*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	30,0 °																			■
XOEX180620FR-E10	2,0 *0.079*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	30,0 °																			■
XOEX180631FR-E10	3,1 *0.122*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	29,0 °																			■
XOEX180608ZZR-M10	0,8 *0.031*	9,0 *0.354*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	22,4 °																■			
XOMX180604TR-ME13	0,4 *0.016*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	25,0 °			■													■			
XOMX180608TR-ME13	0,8 *0.031*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	25,3 °			■			■	■					■				■			
XOMX180616TR-ME13	1,6 *0.063*	2,3 *0.091*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	24,7 °			■																
XOMX180620TR-ME13	2,0 *0.079*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	24,7 °			■													■			
XOMX180631TR-ME13	3,1 *0.122*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,38 *0.251*	23,6 °			■													■			
XOMX180640TR-ME13	4,0 *0.157*	0,8 *0.031*	17,0 *0.669*	11,2 *0.441*	6,38 *0.251*	24,0 °			■																
XOMX180604R-M10	0,4 *0.016*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	22,0 °									■							■			
XOMX180608R-M10	0,8 *0.031*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	22,4 °		■	■			■			■			■			■	■			
XOMX180616R-M10	1,6 *0.063*	2,3 *0.091*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	21,7 °						■			■			■				■			
XOMX180620R-M10	2,0 *0.079*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	21,8 °									■			■				■			
XOMX180624R-M10	2,4 *0.094*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,35 *0.250*	21,1 °									■							■			
XOMX180631R-M10	3,1 *0.122*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,35 *0.250*	21,0 °						■			■			■				■			
XOMX180640R-M10	4,0 *0.157*	0,8 *0.031*	17,0 *0.669*	11,2 *0.441*	6,35 *0.250*	21,0 °									■			■				■			
XOMX180650R-M10	5,0 *0.197*	0,3 *0.012*	17,0 *0.669*	11,2 *0.441*	6,35 *0.250*	19,4 °		■							■			■				■			
XOMX180663R-M10	6,3 *0.248*	0,3 *0.012*	17,0 *0.669*	11,2 *0.441*	6,35 *0.250*	19,0 °									■			■				■			
XOMX180608TR-M14	0,8 *0.031*	2,38 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,5 °	■		■	■			■	■				■			■	■			
XOMX180612TR-M14	1,2 *0.047*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,5 °	■		■	■			■	■				■				■			

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XOMX180616TR-M14	1,6 *0.063*	2,3 *0.091*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,0 °			■	■			■					■				■			
XOMX180620TR-M14	2,0 *0.079*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,0 °			■									■				■			
XOMX180624TR-M14	2,4 *0.094*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,37 *0.251*	14,0 °			■									■				■			
XOMX180631TR-M14	3,1 *0.122*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,37 *0.251*	14,0 °			■	■								■				■			
XOMX180608TR-MD15	0,8 *0.031*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,9 °	■		■	■			■	■				■			■	■			
XOMX180612TR-MD15	1,2 *0.047*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,0 °	■			■												■			
XOMX180616TR-MD15	1,6 *0.063*	2,3 *0.091*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	15,3 °				■			■					■				■			
XOMX180608TR-D16	0,8 *0.031*	2,4 *0.094*	17,0 *0.669*	11,2 *0.441*	6,4 *0.252*	11,0 °	■		■				■					■			■				
XOMX180631TR-D16	3,1 *0.122*	2,2 *0.087*	17,0 *0.669*	11,2 *0.441*	6,39 *0.252*	9,0 °	■			■															

XPKX

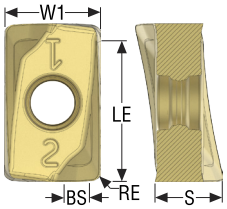


E06

E08

Designation	RE	LE	W1	S	Cutting rake	Grades																		
						Coated																	Uncoated	
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
XPKX080304PDER-E06	0,4 *0.016*	8,0 *0.315*	7,0 *0.276*	3,4 *0.134*	25,0 °																			■
XPKX080308PDER-E06	0,8 *0.031*	8,0 *0.315*	7,0 *0.276*	3,4 *0.134*	25,0 °																			■
XPKX080316PDER-E06	1,6 *0.063*	8,0 *0.315*	7,0 *0.276*	3,4 *0.134*	25,0 °																			■
XPKX080320PDER-E06	2,0 *0.079*	8,0 *0.315*	7,0 *0.276*	3,4 *0.134*	25,0 °																			■
XPKX080324PDER-E06	2,4 *0.094*	8,0 *0.315*	7,0 *0.276*	3,4 *0.134*	25,0 °																			■
XPKX080331PDER-E06	3,1 *0.122*	8,0 *0.315*	7,0 *0.276*	3,4 *0.134*	25,0 °																			■
XPKX12T304PDER-E08	0,4 *0.016*	12,1 *0.476*	10,0 *0.394*	3,97 *0.156*	23,1 °																			■
XPKX12T308PDER-E08	0,8 *0.031*	12,1 *0.476*	10,0 *0.394*	3,97 *0.156*	23,0 °																			■
XPKX12T320PDER-E08	2,0 *0.079*	12,1 *0.476*	10,0 *0.394*	3,97 *0.156*	25,0 °																			■
XPKX12T324PDER-E08	2,4 *0.094*	12,1 *0.476*	10,0 *0.394*	3,97 *0.156*	25,0 °																			■
XPKX12T331PDER-E08	3,1 *0.122*	12,1 *0.476*	10,0 *0.394*	3,97 *0.156*	25,0 °																			■
XPKX12T340PDER-E08	4,0 *0.157*	12,1 *0.476*	10,0 *0.394*	3,97 *0.156*	25,0 °																			■

ZOMX16

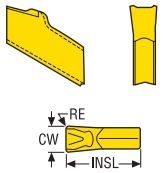


ME10

M12

Designation	RE	BS	LE	W1	S	Cutting rake	Grades																			
							Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1500	MP2050	MP2500	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
ZOMX160708TR-ME10	0,8 *0.031*	2,0 *0.079*	15,5 *0.610*	10,76 *0.424*	7,38 *0.291*	39,1 °			■						■	■						■			
ZOMX160708TR-M12	0,8 *0.031*	2,0 *0.079*	15,5 *0.610*	10,76 *0.424*	7,38 *0.291*	29,0 °	■		■	■				■		■						■			
ZOMX160716TR-ME10	1,6 *0.063*	1,2 *0.047*	15,5 *0.610*	10,76 *0.424*	7,26 *0.286*	39,1 °			■						■							■			
ZOMX160716TR-M12	1,6 *0.063*	1,2 *0.047*	15,5 *0.610*	10,76 *0.424*	7,26 *0.286*	29,0 °	■		■	■				■								■			

150.10



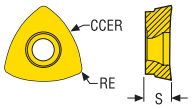
150.10-12

150.10-14

150.10-16

Designation	RE	CW	INSL	Cutting rake	Grades																		
					Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
150.10-2.5N-12	0,17 *0.007*	2,5 *0.098*	9,0 *0.354*												■	■							
150.10-3N-12	0,19 *0.007*	3,1 *0.122*	9,0 *0.354*												■	■							
150.10-2.25N-14	0,15 *0.006*	2,25 *0.089*	9,0 *0.354*													■					■		
150.10-2.5N-14	0,17 *0.007*	2,5 *0.098*	9,0 *0.354*												■						■		
150.10-3N-14	0,19 *0.007*	3,1 *0.122*	9,0 *0.354*												■	■					■		
150.10-2.25N-16	0,15 *0.006*	2,25 *0.089*	9,0 *0.354*												■	■					■		
150.10-2.5N-16	0,17 *0.007*	2,5 *0.098*	9,0 *0.354*												■	■					■		
150.10-3N-16	0,19 *0.007*	3,1 *0.122*	9,0 *0.354*												■	■					■		
150.10-4N-12	0,23 *0.009*	4,1 *0.161*	9,0 *0.354*												■	■							
150.10-4N-14	0,23 *0.009*	4,1 *0.161*	9,0 *0.354*												■	■					■		
150.10-4N-16	0,23 *0.009*	4,1 *0.161*	9,0 *0.354*												■	■					■		

218.19



E04-E07

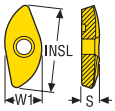
M04-M11

MD04-MD11

ME07-ME12

Designation	RE	S	CCER	Cutting rake	Grades																		
					Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
218.19-160-04-E07	1,2 *0.047*	4,76 *0.187*	16,0 *0.630*	20,0 °																			■
218.19-125T-T3-ME07	0,8 *0.031*	3,97 *0.156*	12,5 *0.492*	20,0 °																■			
218.19-160T-04-ME08	1,2 *0.047*	4,76 *0.187*	16,0 *0.630*	20,0 °																■			
218.19-200T-05-ME10	0,6 *0.024*	5,5 *0.217*	20,0 *0.787*	20,0 °																■			
218.19-080T-M04	0,4 *0.016*	2,38 *0.094*	8,0 *0.315*	7,0 °			■												■	■			
218.19-100T-M06	0,8 *0.031*	2,78 *0.109*	10,0 *0.394*	7,0 °			■	■					■	■		■			■	■			
218.19-125T-T3-M07	0,8 *0.031*	3,97 *0.156*	12,5 *0.492*	10,0 °			■	■		■			■	■		■			■	■			
218.19-160T-04-M11	1,2 *0.047*	4,76 *0.187*	16,0 *0.630*	15,0 °	■		■							■									
218.19-160T-04-M08	1,2 *0.047*	4,76 *0.187*	16,0 *0.630*	10,0 °		■	■	■		■			■	■		■		■	■	■			
218.19-200T-05-M10	0,6 *0.024*	5,5 *0.217*	20,0 *0.787*	10,0 °														■		■			
218.19-080T-MD04	0,4 *0.016*	2,38 *0.094*	8,0 *0.315*	0,0 °										■			■						
218.19-100T-MD08	0,8 *0.031*	2,78 *0.109*	10,0 *0.394*	0,0 °			■		■					■			■	■					
218.19-125T-T3-MD10	0,8 *0.031*	3,97 *0.156*	12,5 *0.492*	0,0 °	■		■		■					■		■	■	■					
218.19-125T-T3-MD08	0,8 *0.031*	3,97 *0.156*	12,5 *0.492*	0,0 °				■											■				
218.19-160T-04-MD11	1,2 *0.047*	4,76 *0.187*	16,0 *0.630*	0,0 °	■		■		■			■		■		■	■	■					
218.19-160T-04-MD09	1,2 *0.047*	4,76 *0.187*	16,0 *0.630*	0,0 °				■											■				

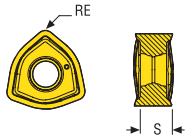
218.20



ME/M

Designation	INSL	W1	S	Cutting rake	Grades																			
					Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
218.20-0.250ER-ME03	12,42 *0.489*	5,46 *0.215*	2,52 *0.099*	11,0 °																■			
218.20-0.250ER-M03	12,42 *0.489*	5,46 *0.215*	2,52 *0.099*	7,0 °																■			
218.20-0.375ER-M05	18,62 *0.733*	8,19 *0.322*	3,85 *0.152*	3,0 °														■		■			
218.20-0.375ER-ME05	18,62 *0.733*	8,19 *0.322*	3,85 *0.152*	11,0 °									■							■			
218.20-0.750ER-M10	36,44 *1.435*	15,12 *0.595*	7,625 *0.300*	-2,0 °						■													
218.20-0.750ER-ME10	36,44 *1.435*	15,12 *0.595*	7,625 *0.300*	6,0 °																■			
218.20-060ER-ME03	11,73 *0.462*	5,16 *0.203*	2,37 *0.093*	12,0 °									■							■			
218.20-080ER-ME04	15,64 *0.616*	6,88 *0.271*	3,21 *0.126*	5,0 °									■			■				■			
218.20-080ER-M04	15,64 *0.616*	6,88 *0.271*	3,21 *0.126*	1,0 °						■								■		■			
218.20-100ER-ME05	19,55 *0.770*	8,59 *0.338*	4,05 *0.159*	3,0 °						■			■							■			
218.20-100ER-M05	19,55 *0.770*	8,59 *0.338*	4,05 *0.159*	2,0 °						■								■		■			
218.20-125ER-ME07	24,48 *0.964*	10,74 *0.423*	5,05 *0.199*	11,0 °						■			■							■			
218.20-125ER-M07	24,48 *0.964*	10,74 *0.423*	5,05 *0.199*	1,0 °														■		■			
218.20-150ER-ME07	28,7 *1.130*	11,91 *0.469*	5,99 *0.236*	6,0 °									■							■			
218.20-150ER-M08	28,7 *1.130*	11,91 *0.469*	5,99 *0.236*	-2,0 °						■										■			
218.20-160ER-ME08	30,61 *1.205*	12,7 *0.500*	6,4 *0.252*	6,0 °						■			■							■			
218.20-160ER-M08	30,61 *1.205*	12,7 *0.500*	6,4 *0.252*	-2,0 °						■								■		■			
218.20-200ER-ME10	38,26 *1.506*	15,88 *0.625*	8,06 *0.317*	6,0 °						■			■							■			
218.20-200ER-M10	38,26 *1.506*	15,88 *0.625*	8,06 *0.317*	-2,0 °																■			
218.20-250ER-ME12	47,83 *1.883*	19,85 *0.781*	10,16 *0.400*	6,0 °						■			■							■			
218.20-250TR-M14	47,83 *1.883*	19,85 *0.781*	10,16 *0.400*	-2,0 °																■			

218.21



M15

MD17

ME13

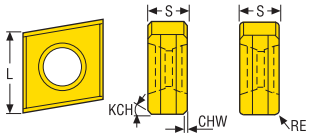
Designation	RE	S	Cutting rake	Grades																			
				Coated																	Uncoated		
	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
218.21-230TR-06-ME13	1,6 *0.063*	5,95 *0.234*	21,0 °		■				■			■	■		■				■			
218.21-230TR-06-M15	1,6 *0.063*	5,95 *0.234*	17,0 °		■	■	■					■	■		■				■			
218.21-230TR-06-MD17	1,6 *0.063*	6,02 *0.237*	7,0 °	■		■	■				■		■									

R235.15

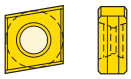
E05

Designation	L	Cutting rake	Grades																		
			Coated																Uncoated		
	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
R235.15-032-E05	42,987 *1.692*	22,0 °															■				
R235.15-050-E05	54,64 *2.151*	22,0 °															■				
R235.15-080-E05	54,746 *2.155*	22,0 °															■		■		

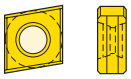
335.18



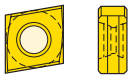
E07/E08/E09



M10/M11/M12

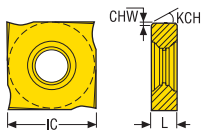


MD10/D13



Designation	CHW	L	S	KCH°	Cutting rake	Grades																		
						Coated																Uncoated		
	mm *Inch*	mm *Inch*	mm *Inch*	mm		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
335.18-1005-E07	0,5 *0.020*	10,0 *0.394*	5,4 *0.213*	45,0	20,0 °																	■		
335.18-1305-E08	0,5 *0.020*	12,7 *0.500*	5,4 *0.213*	45,0	20,0 °																	■		
335.18-1606-E09	0,5 *0.020*	16,0 *0.630*	6,4 *0.252*	45,0	20,0 °																	■		
335.18-1005T-M10	0,5 *0.020*	10,0 *0.394*	5,4 *0.213*	45,0	10,0 °	■		■				■	■								■	■		
335.18-100508-M10	0,0 *NaN*	10,0 *0.394*	5,4 *0.213*	0,0	10,0 °												■							
335.18-1305T-M11	0,5 *0.020*	12,7 *0.500*	5,4 *0.213*	45,0	10,0 °	■		■				■	■								■			
335.18-130508-M11	0,0 *NaN*	12,7 *0.500*	5,4 *0.213*	0,0	10,0 °												■							
335.18-1606T-M12	0,5 *0.020*	16,0 *0.630*	6,4 *0.252*	45,0	10,0 °	■		■													■			
335.18-160608-M12	0,0 *NaN*	16,0 *0.630*	6,4 *0.252*	0,0	10,0 °												■							
335.18-1005ZZ-MD10	0,5 *0.020*	10,0 *0.394*	5,4 *0.213*	45,0	10,0 °																	■		

335.19

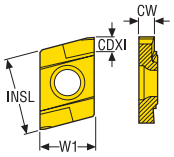


M08

MD09

Designation	CHW	L	IC	KCH°	Cutting rake	Grades																			
						Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
335.19-1102-M08	0,1 *0.004*	2,3 *0.091*	11,0 *0.433*	45,0	15,0 °																■			
335.19-1103-M08	0,1 *0.004*	2,7 *0.106*	11,0 *0.433*	45,0	15,0 °																■			
335.19-1203-M08	0,15 *0.006*	3,2 *0.126*	12,7 *0.500*	45,0	15,0 °																■			
335.19-1204-M08	0,15 *0.006*	4,0 *0.157*	12,7 *0.500*	45,0	15,0 °																■			
335.19-12045-M08	0,15 *0.006*	4,5 *0.177*	12,7 *0.500*	45,0	15,0 °																■			
335.19-1205-M08	0,15 *0.006*	5,4 *0.213*	12,7 *0.500*	45,0	15,0 °																■			
335.19-1207-M08	0,15 *0.006*	7,0 *0.276*	12,7 *0.500*	45,0	15,0 °																■			
335.19-1203T-MD09	0,1 *0.004*	3,2 *0.126*	12,7 *0.500*	20,0	15,0 °																■			
335.19-12045T-MD09	0,1 *0.004*	4,5 *0.177*	12,7 *0.500*	20,0	15,0 °																■			
335.19-1204T-MD09	0,1 *0.004*	4,0 *0.157*	12,7 *0.500*	20,0	15,0 °																■			
335.19-1205T-MD09	0,1 *0.004*	5,4 *0.213*	12,7 *0.500*	20,0	15,0 °			■								■					■			
335.19-1207T-MD09	0,1 *0.004*	7,0 *0.276*	12,7 *0.500*	20,0	15,0 °																■			

R335.15-13/18



E08

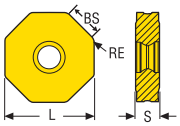
M12

M8

Designation	INSL	W1	CW	CDX	Cutting rake	Grades																			
						Coated																Uncoated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		MP1501	MP2050	MP2501	MP3000	MH1000	MM4500	MK1500	MK2050	MS2050	MS2500	T25M	T350M	F15M	F25M	F30M	F40M	HX	H15	H25
R335.15-13110FG-E08	13,5 *0.531*	9,0 *0.354*	1,13 *0.044*	1,8 *0.071*	15,0 °																■			
R335.15-13130FG-E08	13,5 *0.531*	9,0 *0.354*	1,33 *0.052*	2,0 *0.079*	15,0 °																■			
R335.15-13160FG-E08	13,5 *0.531*	9,0 *0.354*	1,63 *0.064*	2,6 *0.102*	15,0 °																■			
R335.15-13185FG-E08	13,5 *0.531*	9,0 *0.354*	1,88 *0.074*	2,6 *0.102*	15,0 °																■			
R335.15-13215FG-E08	13,5 *0.531*	9,0 *0.354*	2,18 *0.086*	3,15 *0.124*	15,0 °																■			
R335.15-13265FG-E08	13,5 *0.531*	9,0 *0.354*	2,68 *0.106*	3,15 *0.124*	15,0 °																■			
R335.15-13215FG-M10	13,5 *0.531*	9,0 *0.354*	2,18 *0.086*	3,15 *0.124*	0,0 °																■			
R335.15-13265FG-M10	13,5 *0.531*	9,0 *0.354*	2,68 *0.106*	3,15 *0.124*	0,0 °																■			
R335.15-18315FG-M12	18,0 *0.709*	9,0 *0.354*	3,2 *0.126*	3,8 *0.150*	0,0 °																■			
R335.15-18350FG-M12	18,0 *0.709*	9,0 *0.354*	3,55 *0.140*	4,1 *0.161*	0,0 °																■			
R335.15-18400FG-M12	18,0 *0.709*	9,0 *0.354*	4,05 *0.159*	4,8 *0.189*	0,0 °																■			
R335.15-18415FG-M12	18,0 *0.709*	9,0 *0.354*	4,2 *0.165*	4,8 *0.189*	0,0 °																■			
R335.15-18500FG-M12	18,0 *0.709*	9,0 *0.354*	5,05 *0.199*	5,5 *0.217*	0,0 °																■			
R335.15-18515FG-M12	18,0 *0.709*	9,0 *0.354*	5,2 *0.205*	5,5 *0.217*	0,0 °																■			

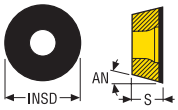
Tolerance (mm): CW: +0/+0.05 - CDX: +0/+0.15

ONEW05



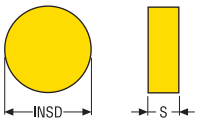
Designation	RE	BS	L	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
ONEW050410ANSN-02020-LF	1,0 *0.039*	0,3 *0.012*	12,0 *0.472*	4,427 *0.174*	0,0 °	■					
ONEW050410ZZSR4-02020LF	1,0 *0.039*	3,26 *0.128*	11,9 *0.469*	4,427 *0.174*	0,0 °	■					

RDHW



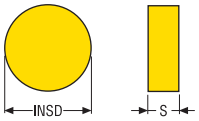
Designation	INSD	S	AN°	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
RDHW0803M0S-01030-LF	8,0 *0.315*	3,18 *0.125*	15,0 *0.591*	0,0 °	■					
RDHW10T3M0S-01030-8-LF	10,0 *0.394*	3,97 *0.156*	15,0 *0.591*	0,0 °	■					

RN.N-LF06/09/12



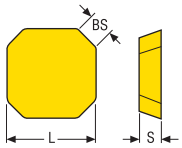
Designation	INSD	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
RNGN060300S-02020-LF	6,35 *0.250*	3,18 *0.125*	0,0 °	■					
RNGN090300S-02020-LF	9,52 *0.375*	3,18 *0.125*	0,0 °	■					
RNGN120400S-02020-LF	12,7 *0.500*	4,76 *0.187*	0,0 °	■					

RN.N-06/09



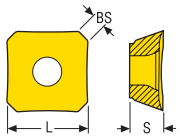
Designation	INSD	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
RNGN060300S	6,35 *0.250*	3,18 *0.125*	0,0 °	■					
RNGN090300S	9,52 *0.375*	3,18 *0.125*	0,0 °	■					
RNMN060300S	6,35 *0.250*	3,18 *0.125*	0,0 °		■	■			
RNMN060300S-02020P	6,35 *0.250*	3,18 *0.125*	0,0 °						■
RNMN090300E	9,52 *0.375*	3,18 *0.125*	0,0 °		■		■		
RNMN090300S	9,52 *0.375*	3,18 *0.125*	0,0 °		■	■			
RNMN090300S-02020	9,52 *0.375*	3,18 *0.125*	0,0 °				■	■	
RNMN090300S-02020P	9,52 *0.375*	3,18 *0.125*	0,0 °						■

SEE.12



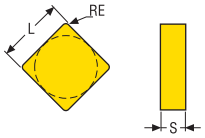
Designation	RE	BS	L	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
SEEN1203AFTN-D16	1,0 *0.039*	1,5 *0.059*	12,7 *0.500*	3,18 *0.125*	0,0 °		■				
SEEX1203AETN-MD13-LF	1,0 *0.039*	1,6 *0.063*	12,7 *0.500*	3,18 *0.125*	0,0 °	■					

SEEX



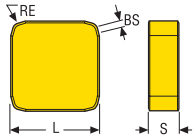
Designation	RE	BS	L	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
SEEX09T3AFTN-D09-LF	0,5 *0.020*	1,25 *0.049*	9,52 *0.375*	3,97 *0.156*	0,0 °	■					
SEEX1204AFTN-D16-LF	1,1 *0.043*	1,6 *0.063*	12,7 *0.500*	4,76 *0.187*	0,0 °	■					
SEEX1204ZZTN-D16-LF	1,0 *0.039*	7,53 *0.296*	12,7 *0.500*	4,76 *0.187*	0,0 °	■					

SN..06/09/SNEX12



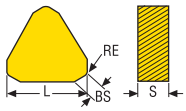
Designation	RE	L	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
SNMN060308E	0,8 *0.031*	6,35 *0.250*	3,18 *0.125*	0,0 °				■		
SNMN060308S	0,8 *0.031*	6,35 *0.250*	3,18 *0.125*	0,0 °		■				
SNMN090308E	0,8 *0.031*	9,525 *0.375*	3,18 *0.125*	0,0 °		■				
SNMN090308S	0,8 *0.031*	9,525 *0.375*	3,18 *0.125*	0,0 °		■				
SNMN090312E	1,2 *0.047*	9,525 *0.375*	3,18 *0.125*	0,0 °		■				
SNMN090312S	1,2 *0.047*	9,525 *0.375*	3,18 *0.125*	0,0 °		■	■			
SNMN090312S-02020P	1,2 *0.047*	9,525 *0.375*	3,18 *0.125*							■
SNMN090316S	1,6 *0.063*	9,525 *0.375*	3,18 *0.125*	0,0 °		■				
SNGN090308E	0,8 *0.031*	9,525 *0.375*	3,18 *0.125*	0,0 °	■					
SNGN090308S	0,8 *0.031*	9,525 *0.375*	3,18 *0.125*	0,0 °	■					
SNGN090312S	1,2 *0.047*	9,525 *0.375*	3,18 *0.125*	0,0 °	■					
SNGN090316S	1,6 *0.063*	9,525 *0.375*	3,18 *0.125*	0,0 °	■					
SNEX120312ZZ	1,2 *0.047*	12,7 *0.500*	3,18 *0.125*	0,0 °	■					

SNEN



Designation	RE	BS	L	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
SNEN0903ENE-M06	0,8 *0.031*	0,9 *0.035*	9,52 *0.375*	3,18 *0.125*	0,0 °	■					
SNEN0903ENS-M08	0,8 *0.031*	0,9 *0.035*	9,52 *0.375*	3,18 *0.125*	0,0 °	■					

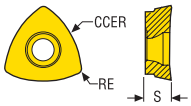
TNGN



TNGN

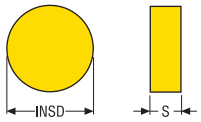
Designation	RE	BS	L	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
TNGN1103PNE	0,8 *0.031*	1,0 *0.039*	10,999 *0.433*	3,18 *0.125*	0,0 °	■					
TNGN1103PNS	0,8 *0.031*	1,0 *0.039*	10,999 *0.433*	3,18 *0.125*	0,0 °	■					
TNGN1103PRS	1,2 *0.047*	1,0 *0.039*	10,999 *0.433*	3,18 *0.125*	0,0 °	■					
TNGN1604PNE	0,8 *0.031*	1,9 *0.075*	16,498 *0.650*	4,76 *0.187*	0,0 °	■					
TNGN1604PNS	0,8 *0.031*	1,9 *0.075*	16,498 *0.650*	4,76 *0.187*	0,0 °	■					
TNGN1604PRS	1,2 *0.047*	1,3 *0.051*	16,498 *0.650*	4,76 *0.187*	0,0 °	■					

218.19



Designation	RE	CCER	S	Cutting rake	Grades Coated					
	mm *Inch*	mm *Inch*	mm *Inch*		CBN200	CBN300	CBN300P	CBN400C	CBN500	CBN600
218.19-100T-MD08-LF	0,8 *0.031*	10,0 *0.394*	2,81 *0.111*	0,0 °	■					

RNGN12

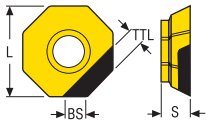


RNGN

RPGN

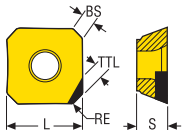
Designation	INSD	S	Cutting rake	Grades Coated				
	mm *Inch*	mm *Inch*		CS300				
RNGN120400T-01020	12,7 *0.500*	4,76 *0.187*	0,0 °	■				
RNGN120700T-01020	12,7 *0.500*	7,94 *0.313*	0,0 °	■				
RPGN120400T-01020	12,7 *0.500*	4,76 *0.187*		■				

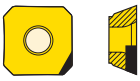
OFEX



Designation	RE	BS	L	TTL	S	Cutting rake	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		PCD05	PCD20	PCD30	
OFEX05T305FN-M05	0,5 *0.020*	4,893 *0.193*	12,79 *0.504*	2,5 *0.098*	3,97 *0.156*	0,0 °		■		

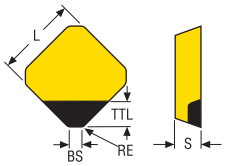
SEEX





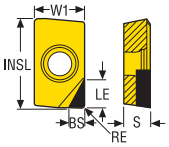
Designation	RE	BS	L	TTL	S	Cutting rake	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		PCD05	PCD20	PCD30	
SEEX09T3AFFN-L1	0,4 *0.016*	1,5 *0.059*	9,525 *0.375*	3,0 *0.118*	3,97 *0.156*	12,0 °	■	■		

SEHN



Designation	RE	BS	L	TTL	S	Cutting rake	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		PCD05	PCD20	PCD30	
SEHN1203AFFN-E08	1,0 *0.039*	1,6 *0.063*	12,7 *0.500*	4,0 *0.157*	3,18 *0.125*	0,0 °		■		

XOEX



Designation	RE	BS	LE	INSL	W1	S	Cutting rake	Grades Coated			
	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*	mm *Inch*		PCD05	PCD20	PCD30	
XOEX060204FR	0,4 *0.016*	1,5 *0.059*	3,4 *0.134*	6,94 *0.273*	4,09 *0.161*	2,45 *0.096*	8,0 °	■			
XOEX10T304F	0,4 *0.016*	1,08 *0.043*	5,51 *0.217*	11,08 *0.436*	6,87 *0.270*	3,77 *0.148*	15,0 °	■	■		
XOEX120404FR	0,4 *0.016*	1,54 *0.061*	5,6 *0.220*	13,88 *0.546*	8,18 *0.322*	5,03 *0.198*	15,0 °		■	■	
XOEX120404FR-L2	0,4 *0.016*	2,39 *0.094*	6,52 *0.257*	13,7 *0.539*	8,18 *0.322*	4,95 *0.195*	14,0 °	■			
XOEX160508F	0,8 *0.031*	1,4 *0.055*	15,7 *0.618*	18,3 *0.720*	10,2 *0.402*	5,8 *0.228*	15,65 °	■	■		■

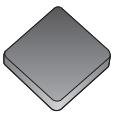
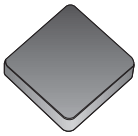
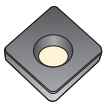
Introduction

Polycrystalline Cubic Boron Nitride (PCBN) is a material which is sintered at extremely high pressure and high temperature into a wear-resistant material with properties close to those of diamond. Due to the hot hardness, oxidation resistance and fracture toughness of the material, inserts made of PCBN have excellent edge strength and long tool life when machining hard ferrous materials and pearlitic grey cast iron.

Secomax™ PCBN inserts are suitable for machining:

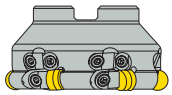
- Hardened steel (including hard-facing alloys)
- Pearlitic grey cast iron
- Chilled and white cast iron
- Manganese steel
- Cemented carbide
- Powder Metallurgy (PM) alloys

For more information including a comprehensive guide to understanding and applying PCBN successfully, please ask your sales representative for the Secomax™ PCBN, Technical Guide (available in English).

Selection of insert type	
	• Solid insert • According to the geometry, two sides can be used. • Grades: CBN200, CBN300, CBN300P, CBN500, CBN600
	• CBN layer sintered on to carbide. One side is usable. • Grades: CBN200
	

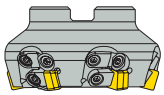
Cutters for PCBN inserts

Face milling cutter type R217/220.70



- Cutter especially developed for CBN inserts, 2 insert sizes.
- Maximum cutting depth 3 mm DC = 20-63 mm and maximum cutting depth 4,5 mm DC = 63-200 mm (DC = 125-200 mm fitted with wiper insert).
- Inserts for finishing: RNGN060300E (E = honed) RNGN/RNMN090300E
- Inserts for roughing: RNGN/RNMN060300S (S = chamfered and honed) RNGN/RNMN090300S
- Wiper insert: SNEX120312ZZ
- The relation between cutting depth and number of usable cutting edges (per side).

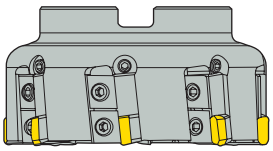
Face milling cutter type 220.74



- Cutter especially developed for CBN inserts, maximum cutting depth 8,0 mm D = 63-200 mm. (D = 125-200 mm fitted with wiper insert).
- Inserts for finishing: SNEN0903ENE-M06 (E = honed) SNMN090308E SNMN090312E
- Inserts for roughing: SNEN0903ENS-M08 (S = chamfered and honed) SNMN090308S SNMN090312S SNMN090316S
- Wiper insert: SNEX120312ZZ

D.O.C a_p (mm)	D.O.C a_p (Inch)	RN.. 060300	RN.. 090300	D.O.C a_p (mm)	D.O.C a_p (Inch)	RN.. 060300	RNMN 090300
0,1	.004	20	24	1,2	.048	5	7
0,15	.006	16	20	1,5	.060	5	6
0,2	.008	14	17	1,8	.072	4	5
0,25	.010	12	15	2,0	.080	4	5
0,3	.012	11	14	2,5	.100	3	4
0,4	.016	10	12	3,0	.120	3	4
0,5	.020	8	10	3,5	.140	–	4
0,8	.032	7	8	4,0	.160	–	3
1,0	.040	6	7	4,5	.200	–	–

Square shoulder and slot milling cutter type R220.68



- Insert with corner chamfernfor finishing operations: TNGN1604PNE
- Insert with corner chamfer for roughing operations: TNGN1604PNS
- Insert with corner radius for roughing operations: TNGN1604PRS

Inserts for standard milling cutters

Face milling cutters	Face milling cutters	Face milling cutters	Face milling cutters
• For roughing • SEEX09T3AFTN-D09-LF • SEEX1204AFTN-D16-LF • R220.53	• For roughing • ONEW05 • Octomill R217/220.48	• For roughing • SEEN1203AFTN-D16 • R220.13	• For finishing • SEEX1203AETN-MD13-LF • R220.30
Wiper insert for high quality surface finish	**Disc milling cutter**	**High feed milling cutter**	**Copy milling cutter**
• SEEX1204ZZTN-D16-LF	• RDHW0803M0S-01030-LF • R335.25/R335.18	• 218.19-100T-MD08-LF	• RDHW0803M0S-01030-LF • R217/220.29

Cutting speed recommendations are in the cutting data table.
Feed rate recommendations are in the cutting data table.
Formulae for cutting data calculation are on page 819

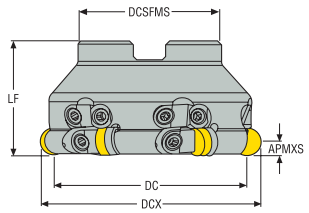
PCBN, Finishing a_p < 0,5 mm/*Inch*

SMG	CBN200		CBN300		CBN500	
	v_c	f_z	v_c	f_z	v_c	f_z
K1	700 — 1900 —	0,050 — 0,20 —	700 — 1700 —	0,050 — 0,20 —	700 — 1700 —	0,050 — 0,20 —
H3	110 — 350 —	0,050 — 0,20 —	— —	— —	— —	— —
H5	200 — 320 —	0,050 — 0,20 —	— —	— —	— —	— —
H7	200 — 300 —	0,050 — 0,20 —	— —	— —	— —	— —
H8	170 — 250 —	0,050 — 0,20 —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —
H21	120 — 220 —	0,050 — 0,20 —	— —	— —	130 — 230 —	0,050 — 0,20 —
H31	120 — 220 —	0,050 — 0,20 —	— —	— —	100 — 270 —	0,050 — 0,20 —
PM1	180 — 400 —	0,050 — 0,20 —	— —	— —	— —	— —
PM2	150 — 300 —	0,050 — 0,20 —	— —	— —	— —	— —
PM3	— —	— —	— —	— —	— —	— —
HF1	— —	— —	— —	— —	— —	— —
HF2	— —	— —	— —	— —	— —	— —

PCBN, Roughing a_p 0,5-3,0 mm/*Inch*

SMG	CBN200		CBN300		CBN500	
	v_c	f_z	v_c	f_z	v_c	f_z
K1	700 — 1700 —	0,050 — 0,20 —	700 — 1700 —	0,050 — 0,20 —	700 — 1700 —	0,050 — 0,20 —
H3	— —	— —	— —	— —	— —	— —
H5	— —	— —	— —	— —	— —	— —
H7	— —	— —	— —	— —	— —	— —
H8	— —	— —	— —	— —	— —	— —
H11	— —	— —	— —	— —	— —	— —
H21	120 — 220 —	0,050 — 0,20 —	— —	— —	130 — 230 —	0,050 — 0,20 —
H31	120 — 220 —	0,050 — 0,20 —	— —	— —	100 — 270 —	0,050 — 0,20 —
PM1	180 — 400 —	0,050 — 0,20 —	— —	— —	— —	— —
PM2	150 — 300 —	0,050 — 0,20 —	— —	— —	— —	— —
PM3	— —	— —	— —	— —	— —	— —
HF1	150 — 240 —	0,050 — 0,20 —	— —	— —	150 — 250 —	0,050 — 0,20 —
HF2	120 — 300 —	0,050 — 0,20 —	— —	— —	120 — 300 —	0,050 — 0,20 —

220.70-06/09 – Metric

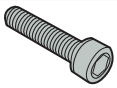
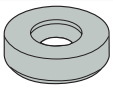


- For insert selection and cutting data recommendations, see page(s) 805, 805
- For complete insert programme, see page(s) 794, 794-794, 794
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.70-0063-09-6	00023749	Arbor	63,0	6	4,5	–	72,5	22,0	47,0	40,0	10200	0,7	RN..09
R220.70-0080-09-6	00023750	Arbor	80,0	6	4,5	–	89,5	27,0	62,0	50,0	9100	1,3	RN..09
R220.70-0100-09-8	00023751	Arbor	100,0	8	4,5	–	109,5	32,0	77,0	50,0	8100	2,0	RN..09
R220.70-8160-09-10	00023753	Arbor	160,0	10	4,5	–	169,5	40,0	90,0	63,0	6400	5,6	RN..09/SNEX12*

Spare Parts

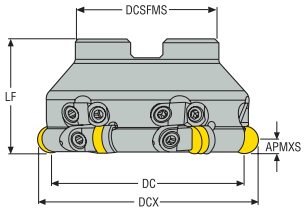
Accessories

For cutter	Arbor screw	Gauge screw	Insert shim	Setting gauge	Setting key	Shim screw	Wedge	Wedge screw	Torque key	Torque value
										
R220.70-0063	220.17-692	LD6019-T15P	117.10-620	AS6011F	T15P-4ST	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM
R220.70-0080-0100	–	LD6019-T15P	117.10-620	AS6011F	T15P-4ST	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM
R220.70-8160	–	LD6019-T15P	117.10-620	AS6011F	T15P-4ST	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Setting wedge AS6011, Insert wedge CW0608S, Anvil screw F94009-T09P and Anvil 268-621 are also included with cutters with dia 8160

220.70-06/09 – Inch

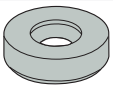


- For insert selection and cutting data recommendations, see page(s) 805, 805
- For complete insert programme, see page(s) 794, 794-794, 794
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	Calculated DC Inch	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.70-03.00-09-6	00059852	Arbor	3.150	6	0.177	–	3.520	1.000	3.543	2.382	15900	3.750	RN..09

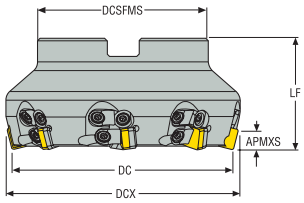
Spare Parts

Accessories

For cutter	Gauge screw	Insert shim	Setting gauge	Setting key	Shim screw	Wedge	Wedge screw	Torque key	Torque value
									
R220.70-03.00	LD6019-T15P	117.10-620	AS6011F	T15P-4ST	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

220.74-09 – Metric

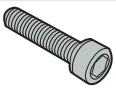
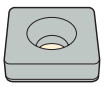


- For insert selection and cutting data recommendations, see page(s) 805, 805
- For complete insert programme, see page(s) 796, 796-797, 797
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm	mm		kg	
R220.74-0063-09-6	00023743	Arbor	63,0	6	8,0	75,0	65,3	22,0	47,0	40,0	10200	0,7	SN..09..
R220.74-0080-09-6	00023744	Arbor	80,0	6	8,0	75,0	82,3	27,0	62,0	50,0	9100	1,4	SN..09..
R220.74-0100-09-8	00023745	Arbor	100,0	8	8,0	75,0	102,3	32,0	77,0	50,0	8100	2,0	SN..09..
R220.74-8160-09-10	00023747	Arbor	160,0	10	8,0	75,0	162,3	40,0	90,0	63,0	6400	6,3	SN..09/SNEX12*
R220.74-8200-09-12	00023748	Arbor	200,0	12	8,0	75,0	202,3	60,0	130,0	63,0	5700	8,9	SN..09/SNEX12*

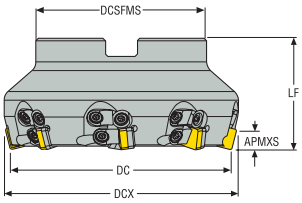
Spare Parts

Accessories

For cutter	Arbor screw	Insert shim	Setting gauge	Setting key	Setting screw	Shim screw	Wedge	Wedge screw	Torque key	Torque value
										
R220.74-0063	220.17-692	174.10-620	AS6011	T15P-4ST	LD6019-T15P	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM
R220.74-0080-0100	–	174.10-620	AS6011	T15P-4ST	LD6019-T15P	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM
R220.74-0125-8160	–	174.10-620	AS6011	T15P-4ST	LD6019-T15P	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM
R220.74-8200	–	174.10-620	AS6011	T15P-4ST	LD6019-T15P	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

220.74-09 – Inch

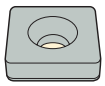


- For insert selection and cutting data recommendations, see page(s) 805, 805
- For complete insert programme, see page(s) 796, 796-797, 797
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCX	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch	Inch		lbs	
R220.74-04.00-09-8	00059859	Arbor	4.028	8	0.315	75,0	4.028	1.500	3.543	2.374	8100	6.390	SN..09
R220.74-05.00-09-8	00059860	Arbor	5.008	8	0.315	75,0	5.012	1.500	3.543	2.374	7200	8.600	SN..09 / SNEX12*
R220.74-06.00-09-10	00059861	Arbor	6.299	10	0.315	75,0	6.390	2.000	4.331	2.374	6400	13.670	SN..09 / SNEX12*

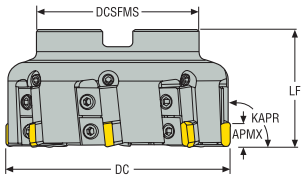
Spare Parts

Accessories

For cutter	Insert shim	Setting gauge	Setting key	Setting screw	Shim screw	Wedge	Wedge screw	Torque key	Torque value
									
R220.74-04.00-808.00	174.10-620	AS6011	T15P-4ST	LD6019-T15P	174.10-652-T07P	CW0608M	LD6018T-T15P	T00-15P35	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.68-T16C – Metric

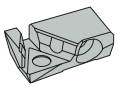
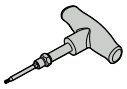


- For insert selection and cutting data recommendations, see page(s) 805, 805
- For complete insert programme, see page(s) 797, 797
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCB	DCSFMS	LF	RPMX	Weight	Insert
			mm		mm		mm	mm	mm		kg	
R220.68-0063-T11C-4	02600204	Arbor	63,0	4	5,0	90,0	22,0	47,0	63,0	20600	1,1	TNGN1103..
R220.68-0080-T11C-5	02600206	Arbor	80,0	5	5,0	90,0	27,0	62,0	63,0	16700	1,7	TNGN1103..
R220.68-0100-T11C-6	02600207	Arbor	100,0	6	5,0	90,0	32,0	77,0	63,0	13400	2,7	TNGN1103..
R220.68-0125-T11C-8	02600208	Arbor	125,0	8	5,0	90,0	40,0	90,0	63,0	10400	3,4	TNGN1103..
R220.68-8160-T11C-10	02600209	Arbor	160,0	10	5,0	90,0	40,0	90,0	63,0	8400	5,6	TNGN1103..
R220.68-0063-T16C-4	00063814	Arbor	63,0	4	14,0	90,0	22,0	47,0	63,0	12000	1,1	TNGN1604..
R220.68-0080-T16C-5	00063812	Arbor	80,0	5	14,0	90,0	27,0	62,0	63,0	9600	1,7	TNGN1604..
R220.68-0125-T16C-8	00063815	Arbor	125,0	8	14,0	90,0	40,0	90,0	63,0	6100	3,4	TNGN1604..
R220.68-8160-T16C-10	00063813	Arbor	160,0	10	14,0	90,0	40,0	140,0	63,0	4800	5,9	TNGN1604..

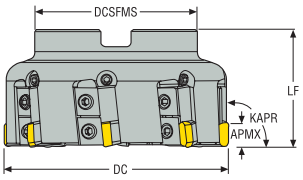
Spare Parts

Accessories

For cutter	Arbor screw	Cassette	Insert wedge	Setting gauge	Wedge clamp	Wedge key	Wedge screw	Torque key	Torque value
									
R220.68-0063-T11C	220.17-696	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25P	LD8020-T25P	T00T-25P60	6.0NM
R220.68-0080-T11C	MC6S12X40	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25P	LD8020-T25P	T00T-25P60	6.0NM
R220.68-0100-T11C	220.17-694	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25PL	LD8020-T25P	T00T-25P60	6.0NM
R220.68-0125-8160-T11C	–	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25PL	LD8020-T25P	T00T-25P60	6.0NM
R220.68-0063-T16C	220.17-696	TN16PR	L257.9-120-T16	AU1114T-T15P	L257.9-120M	–	LD8020-T25P	T00T-25P60	6.0NM
R220.68-0080-T16C	MC6S12X40	TN16PR	L257.9-120-T16	AU1114T-T15P	L257.9-120M	–	LD8020-T25P	T00T-25P60	6.0NM
R220.68-0125-8160-T16C	–	TN16PR	L257.9-120-T16	AU1114T-T15P	L257.9-120M	–	LD8020-T25P	T00T-25P60	6.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R220.68-T16C – Inch

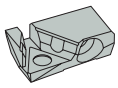
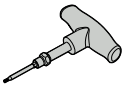


- For insert selection and cutting data recommendations, see page(s) 805, 805
- For complete insert programme, see page(s) 797, 797
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	ZEFP	APMXS	KAPRS°	DCB	DCSFMS	LF	RPMX	Weight	Insert
			Inch		Inch		Inch	Inch	Inch		lbs	
R220.68-02.50-T11C-4	02611344	Arbor	2.500	4	0.197	90,0	0.750	1.850	2.480	20600	2.430	TN..11
R220.68-03.00-T11C-5	02611345	Arbor	3.000	5	0.197	90,0	1.000	2.441	2.480	9600	3.970	TN..11
R220.68-04.00-T11C-6	02611346	Arbor	4.000	6	0.197	90,0	1.500	3.031	2.480	7600	9.920	TN..11
R220.68-05.00-T11C-8	02611347	Arbor	5.000	8	0.197	90,0	1.500	3.543	2.480	6100	7.500	TN..11
R220.68-06.00-T11C-10	02611348	Arbor	6.000	10	0.197	90,0	2.000	4.331	2.480	4800	12.350	TN..11

Spare Parts

Accessories

For cutter	Arbor screw	Cassette	Insert wedge	Setting gauge	Wedge clamp	Wedge key	Wedge screw	Torque key	Torque value
									
R220.68-02.50	220.17-695	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25P	LD8020-T25P	T00T-25P60	6.0NM
R220.68-03.00		TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25P	LD8020-T25P	T00T-25P60	6.0NM
R220.68-04.00	UC6S3/4UNFX2	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25PL	LD8020-T25P	T00T-25P60	6.0NM
R220.68-05.00	UC6S3/4UNFX2	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25PL	LD8020-T25P	T00T-25P60	6.0NM
R220.68-06.00	–	TN11PR	L257.9-120-T11	AU1114T-T15P	L257.9-120M	H6B-T25PL	LD8020-T25P	T00T-25P60	6.0NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Introduction

Application areas

Secomax ceramics include a range of products developed to meet the manufacturing industries ever increasing demands on productivity and product performance.

The inserts are die-pressed and sintered by a HIP process using very fine and pure raw materials with fine microstructure to reach excellent material properties. All surfaces are then ground ensuring a product with superior dimensions and tolerances.

This comes together in a product with outstanding features:

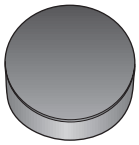
– high thermal shock resistance

– optimised fracture toughness

– excellent wear resistance

– high product quality

CS300



Format:
Solid.

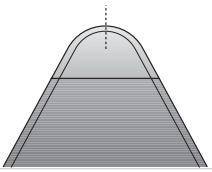
Composition:
Sialon (Si, Al, O, N) ceramic grade.

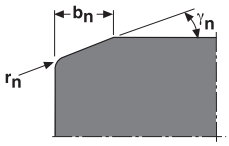
Coating:
No coating.

Chamfer size and angle

CS300	=	0,10 mm x 20°
S	=	Chamfered and honed
T	=	Chamfered, no honing
E	=	Honed

Chamfer size and angle



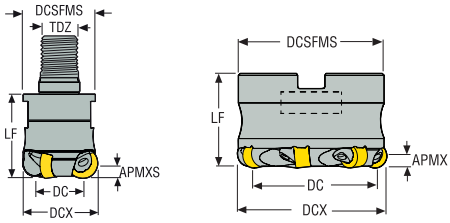


b_n = Chamfer width
γ_n = Chamfer angle
r_n = Hone radius

Ceramic, Roughing a_p 0,5 – 3,0 mm/*Inch*

SMG	CS300	
	v_c	f_z
S1	600 — 1000 *2000 — 3200*	0,050 — 0,15 *0.00197 — 0.00590*
S2	600 — 1000 *2000 — 3200*	0,050 — 0,15 *0.00197 — 0.00590*
S3	600 — 1000 *2000 — 3200*	0,050 — 0,15 *0.00197 — 0.00590*
S11	— —	— —
S12	— —	— —
S13	— —	— —

R217/220.26



- For insert selection and cutting data recommendations, see page(s) 813, 813
- For complete insert programme, see page(s) 799, 799
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	APMXS	ZEFP	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			mm	mm		mm		mm	mm	kg		
R217.26-1632.RE-RN1204.3A	03115686	Combimaster	19,3	6,0	3	–	M16	30,0	35,0	0,2	19100	RN1204
R217.26-1632.RE-RP1204.3A	03204228	Combimaster	19,4	6,0	3	–	M16	30,0	35,0	0,2	20800	RP1204
R217.26-2040.RE-RN1204.4A	03115687	Combimaster	27,3	6,0	4	–	M20	36,5	40,0	0,4	17100	RN1204
R217.26-2040.RE-RP1204.4A	03115679	Combimaster	27,4	6,0	4	–	M20	36,5	40,0	0,4	18600	RP1204
R220.26-0050-RN1204.6A	03115702	Arbor	37,3	6,0	6	22,0	–	47,0	45,0	0,4	16700	RN1204
R220.26-0050-RP1204.6A	03133188	Arbor	37,4	6,0	6	22,0	–	47,0	45,0	0,4	16700	RP1204
R220.26-0050-RN1207.5A	03115710	Arbor	37,3	6,0	5	22,0	–	47,0	45,0	0,4	11900	RN1207
R220.26-0063-RN1207.6A	03115711	Arbor	50,3	6,0	6	27,0	–	60,0	50,0	0,8	10600	RN1207
R220.26-0063-RN1207.7A	03115712	Arbor	50,3	6,0	7	27,0	–	60,0	50,0	0,8	10600	RN1207
R220.26-0080-RN1207.7A	03115713	Arbor	67,3	6,0	7	32,0	–	77,0	50,0	1,6	9400	RN1207
R220.26-0080-RN1207.8A	03115714	Arbor	67,3	6,0	8	32,0	–	77,0	50,0	1,3	9400	RN1207
R220.26-0100-RN1207.8A	03115715	Arbor	87,3	6,0	8	40,0	–	90,0	63,0	2,5	8400	RN1207
R220.26-0125-RN1207.9	03115716	Arbor	112,3	6,0	9	40,0	–	90,0	63,0	3,6	7500	RN1207

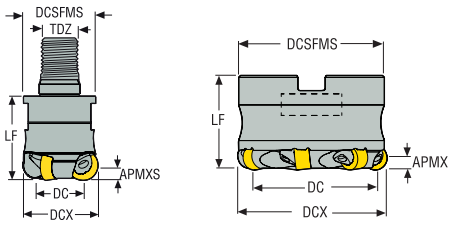
Spare Parts

Accessories

For cutter	Wedge clamp	Wedge key	Wedge screw	Torque key	Torque value
R217/220.26-..	CW0508	H4B-H2.5	LD5015C	H00-2535	3.5NM

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

R217/220.26



- For insert selection and cutting data recommendations, see page(s) 813, 813
- For complete insert programme, see page(s) 799, 799
- For ISO attribute explanation, see page 16

Designation	Item number	Type of mounting	DC	APMXS	ZEFP	DCB	TDZ	DCSFMS	LF	Weight	RPMX	Insert
			Inch	Inch		Inch		Inch	Inch	lbs		
R217.26-01.50-20RE-RN1207.3A	10008700	Arbor	1.001	0.236	3	–	M20	1.437	1.575	2.200	12500	RN1207
R220.26-02.00-RN1207.5A	03115723	Arbor	1.501	0.236	5	0.750	–	1.750	2.000	1.100	11900	RN1207
R220.26-02.50-RN1207.6A	03115724	Arbor	2.001	0.236	6	1.000	–	2.250	2.000	1.760	10600	RN1207
R220.26-03.00-RN1207.7A	03115725	Arbor	2.499	0.236	7	1.250	–	2.750	2.000	2.650	9400	RN1207

Spigot size = DCB

Spare Parts

Accessories

For cutter	Wedge clamp	Wedge key	Wedge screw	Torque key	Torque value
R220.26-..	CW0508	H4B-H2.5	LD5015C	H00-2535	31.0IN.LBS

Torque and fixed keys, see page 829
Please check availability at www.secotools.com / Seco Online Store

Introduction

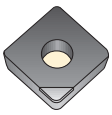
Polycrystalline Diamond (PCD) is produced by sintering together carefully selected particles of diamond under conditions of high temperature and high pressure. PCD cutting tools combine the hardness, abrasion resistance and thermal conductivity of diamond with the toughness of tungsten carbide.

Secomax™ PCD inserts are suitable for machining non-ferrous metals and alloys, e.g.:

- Aluminium
- Copper
- Brass
- Bronze
- Cemented carbide

It can also be used for other materials, e.g.:

- Composites (MMC, ...)
- Reinforced plastics
- Graphite
- Tungsten carbide
- Ceramics
- Titanium alloys

Selection of insert types	
	• Sintered layer -LF • PCD sintered on carbide. • All cutting edges on one side are usable. • Grades: PCD20, PCD30M
	• Brazed tip -L1 and L2 • PCD brazed on to standard carbide inserts. • Grades:PCD05, PCD20, PCD30

Inserts for standard milling cutters

Face milling cutters		Face milling cutters	
• SEHN12 • R220.13 • R220.30		• SEEX12 • R220.53	
Face milling cutters		**Square shoulder milling cutters**	
• OFEX05 • R220.43		• XOEX06/10/12/16 • 217/220.69	

Cutting speed recommendations are in the cutting data table.
Feed rate recommendations are in the cutting data table.
Formulae for cutting data calculation are on page 819

PCD, Roughing a_p 0,5 - 3,0 mm/*Inch*

SMG	PCD05		PCD20		PCD30		PCD30M	
	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
N1	600 — 3500 *2000 — 11400*	0,050 — 0,30 *0.00197 — 0.0118*	600 — 3500 *2000 — 11400*	0,050 — 0,30 *0.00197 — 0.0118*	— —	— —	— —	— —
N2	400 — 2500 *1400 — 8200*	0,050 — 0,20 *0.00197 — 0.00787*	400 — 2500 *1400 — 8200*	0,050 — 0,20 *0.00197 — 0.00787*	— —	— —	— —	— —
N3	300 — 1000 *990 — 3200*	0,050 — 0,10 *0.00197 — 0.00393*	— —	— —	300 — 1000 *990 — 3200*	0,050 — 0,10 *0.00197 — 0.00393*	300 — 1000 *990 — 3200*	0,050 — 0,10 *0.00197 — 0.00393*
N11	600 — 1200 *2000 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*	600 — 1200 *2000 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*	400 — 1200 *1400 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*	600 — 1200 *2000 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*
TS1	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	— —	— —	— —	— —
TS2	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
TS3	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*
TS4	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
TP1	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	— —	— —	— —	— —
TP2	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
TP3	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*
TP4	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
GR1	100 — 1500 *330 — 4900*	0,10 — 0,20 *0.00394 — 0.00787*	100 — 1500 *330 — 4900*	0,10 — 0,20 *0.00394 — 0.00787*	— —	— —	— —	— —

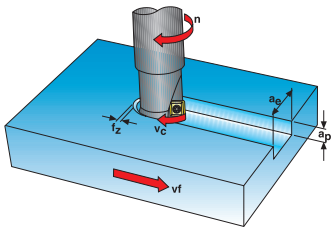
PCD, Finishing a_p < 0,5 mm/*Inch*

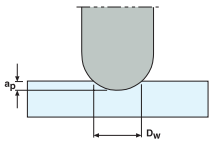
SMG	PCD05		PCD20		PCD30		PCD30M	
	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
N1	600 — 3500 *2000 — 11400*	0,050 — 0,30 *0.00197 — 0.0118*	600 — 3500 *2000 — 11400*	0,050 — 0,30 *0.00197 — 0.0118*	— —	— —	— —	— —
N2	400 — 2500 *1400 — 8200*	0,050 — 0,20 *0.00197 — 0.00787*	400 — 2500 *1400 — 8200*	0,050 — 0,20 *0.00197 — 0.00787*	— —	— —	— —	— —
N3	300 — 1000 *990 — 3200*	0,050 — 0,10 *0.00197 — 0.00393*	— —	— —	300 — 1000 *990 — 3200*	0,050 — 0,10 *0.00197 — 0.00393*	300 — 1000 *990 — 3200*	0,050 — 0,10 *0.00197 — 0.00393*
N11	600 — 1200 *2000 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*	600 — 1200 *2000 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*	400 — 1200 *1400 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*	600 — 1200 *2000 — 3900*	0,10 — 0,50 *0.00394 — 0.0196*
TS1	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	— —	— —	— —	— —
TS2	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
TS3	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*
TS4	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
TP1	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	100 — 1500 *330 — 4900*	0,10 — 0,40 *0.00394 — 0.0157*	— —	— —	— —	— —
TP2	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
TP3	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*	100 — 800 *330 — 2600*	0,050 — 0,20 *0.00197 — 0.00787*
TP4	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*	400 — 800 *1400 — 2600*	0,10 — 0,20 *0.00394 — 0.00787*
GR1	100 — 1500 *330 — 4900*	0,10 — 0,20 *0.00394 — 0.00787*	100 — 1500 *330 — 4900*	0,10 — 0,20 *0.00394 — 0.00787*	— —	— —	— —	— —

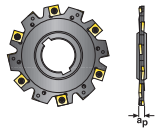
Cutting data calculation		
RPM	$n = \frac{v_c \cdot 1000}{\pi \cdot D_c}$	(rev/min) (inch/min)
Cutting speed	$v_c = \frac{n \cdot \pi \cdot D_c}{1000}$	(m/min) (ft/min)
Feed speed	$v_f = n \cdot ZEFP \cdot f_z$	(mm/min) (inch/min)
Feed per revolution	$f = ZEFP \cdot f_z$	(mm/rev) (inch/rev)
Material removal rate	$Q = \frac{a_e \cdot a_p \cdot v_f}{1000}$	(cm^3/min) ($inch^3$/min)
Cutting speed and RPM for copying	$v_c = \frac{n \cdot \pi \cdot D_w}{1000}$	(m/min) (ft/min)
	$D_w = 2 \cdot \sqrt{a_p (D_c - a_p)}$	(mm) (inch)
	$n = \frac{v_c \cdot 1000}{\pi \cdot D_w}$	(RPM)

Effective No. of teeth (ZEFP)
The effective No. of teeth (ZEFP) is used to calculate the feed speed (v_f) and the feed per revolution (f).
For most of the cutters the effective No. of teeth (ZEFP) is equal to the No. of teeth in the cutter (ZNP), but for some of the cutters ZEFP is less than ZNP.

Cutting data calculation





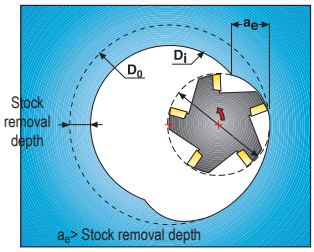


a_e	=	Width of cut mm/radial depth of cut	Example: Disc mill 335.19 Total No. of teeth (ZNP) = 12 Effective No. of teeth (ZEFP) = 6
a_p	=	Depth of cut mm/axial depth of cut	
DC	=	Cutter diameter	Explanation: 6 inserts on one side of the cutter and 6 overlapping inserts on the other side are used to get the full width (a_p) ,which means ZEFP = 6.
f	=	Feed per revolution	
f_z	=	Feed per tooth	
ZEFP	=	Effective No. of teeth for calculation of feed speed or feed per rev (see below)	
n	=	RPM	
Q	=	Material removal rate	
V_c	=	Cutting speed	
v_f	=	Feed speed	
v_f	=	Feed speed	

Cutting data calculation

Internal circular interpolation
When using circular interpolation or helical interpolation ramping to increase the diameter of a hole in a workpiece, the stock removal depth is not the same as the width of cut value. The real width of cut must be calculated from the formula below. The width of cut value is then used for calculation of feed/tooth and feed speed.

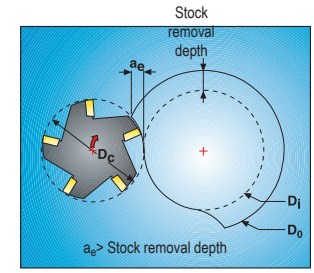
$$a_e = \frac{D_o^2 - D_i^2}{4\,(D_o - D_c)}$$



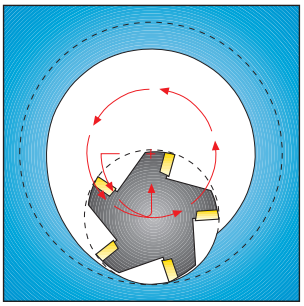
External circular interpolation
When using external circular interpolation or helical interpolation ramping to decrease the diameter of a round workpiece the stock removal depth is not the same as the width of cut value. The real width of cut must be calculated from the formula below.

The width of cut is then used for calculation of feed/tooth and feed speed.

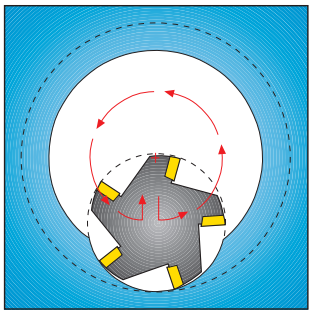
$$a_e = \frac{D_o^2 - D_i^2}{4\,(D_i + D_c)}$$



Increase the width of cut successively to full value
For circular interpolation operations it is recommended to successively increase the width of cut up to full value. When using radial infeed up to full width of cut, reduce the feed/tooth and feed speed to half.

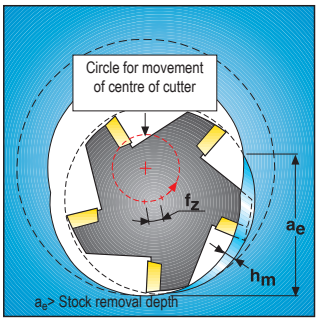


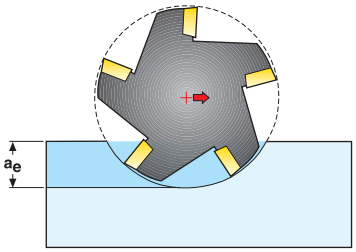
Successive increase of width of cut – recommended method.



Radial infeed – Reduce feed/tooth.

Feed speed related to the centre of the cutter
When calculating feed speed and feed/tooth from average chip thickness using circular interpolation or helical interpolation ramping in an operation, the feed speed and feed/tooth are always related to the centre and not to the periphery of the cutter.



Side milling	
	Relative engagement of the cutter diameter (a_e/DC=%) 30% 20% 10% 5% Multiply the feed per tooth by the following factor 1.25 1.5 2.0 3.0

This table can be used for cutters with cutting edge angle = 90º

a_e/DC %	Feed Per Tooth, mm/tooth (f_z)													Speed Factor
	0,03	0,06	0,08	0,10	0,15	0,20	0,25	0,30	0,40	0,50	0,60	0,80	1,00	
	Average Chip Thickness, mm/tooth (hm)													
Width of cut up to and including DC/2														
2 (0.02)					0,02	0,03	0,04	0,04	0,06	0,07	0,08	0,11	0,14	1.8
3 (0.03)				0,02	0,03	0,03	0,04	0,05	0,07	0,09	0,10	0,14	0,17	1.7
5 (0.05)			0,02	0,02	0,03	0,04	0,06	0,07	0,09	0,11	0,13	0,18	0,22	1.6
10 (0.10)		0,02	0,02	0,03	0,05	0,06	0,08	0,09	0,12	0,16	0,19	0,25	0,31	1.5
15 (0.15)	0,011	0,02	0,03	0,04	0,06	0,08	0,09	0,11	0,15	0,19	0,23	0,30		1.4
20 (0.20)	0,013	0,03	0,03	0,04	0,06	0,09	0,11	0,13	0,17	0,22	0,26			1.35
30 (0.30)	0,016	0,03	0,04	0,05	0,08	0,10	0,13	0,16	0,21	0,26	0,31			1.3
40 (0.40)	0,018	0,04	0,05	0,06	0,09	0,12	0,15	0,18	0,23	0,29				1.25
50 (0.50)	0,02	0,04	0,05	0,06	0,10	0,13	0,16	0,19	0,25	0,32				1.2
Slotting (Width of cut = DC)														
100 (1.00)	0,02	0,04	0,05	0,06	0,10	0,13	0,16	0,19	0,25	0,32				1.0

= Feed per tooth correction example: at 20% engagement also increase speed by 1.35

When using side milling it is necessary to increase the feed per tooth to keep the chip thickness at the same value.
It is also possible to increase the cutting speed and keep the same tool life. Use the tables below.

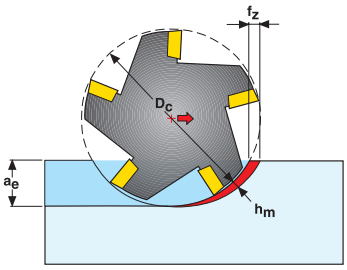
a_e/D_c %	Feed Per Tooth, in/tooth (fz)													Speed Factor
	.0012	.0024	.0031	.004	.006	.008	.010	.012	.016	.020	.024	.031	.039	
	Average Chip Thickness, in/tooth (hm)													
Width of cut up to and including Dc/2														
2 (0.02)					.0008	.0012	.0016	.0016	.0024	.0028	.0031	.0043	.0055	1.8
3 (0.03)				.0008	.0012	.0012	.0016	.0020	.0028	.0035	.0039	.0055	.0067	1.7
5 (0.05)			.0008	.0008	.0012	.0016	.0024	.0028	.0035	.0043	.0051	.0071	.0087	1.6
10 (0.10)		.0008	.0008	.0012	.0020	.0024	.0031	.0035	.0047	.0063	.0075	.0098	.0122	1.5
15 (0.15)	.0004	.0008	.0012	.0016	.0024	.0031	.0035	.0043	.0059	.0075	.0091	.0118		1.4
20 (0.20)	.0005	.0012	.0012	.0016	.0024	.0035	.0043	.0051	.0067	.0087	.0102			1.35
30 (0.30)	.0006	.0012	.0016	.0020	.0031	.0039	.0051	.0063	.0083	.0102	.0122			1.3
40 (0.40)	.0007	.0016	.0020	.0024	.0035	.0047	.0059	.0071	.0091	.0114				1.25
50 (0.50)	.0008	.0016	.0020	.0024	.0039	.0051	.0063	.0075	.0098	.0126				1.2
Slotting (Width of cut = Dc)														
100 (1.00)	.0008	.0016	.0020	.0024	.0039	.0051	.0063	.0075	.0098	.0126				1.0

= Feed per tooth correction example: at 20% engagement also increase speed by 1.35

Instead of using the table above for calculating hm and fz, the following formula could be used if a_e/DC < 30%.

$$h_m = f_z \cdot \sqrt{\frac{a_e}{D_c}}$$

$$f_z = h_m \cdot \sqrt{\frac{D_c}{a_e}}$$



This table can be used for cutters with cutting edge angle = 45º

a_e/DC %	Feed Per Tooth, mm/tooth (f_z)													Speed Factor
	0,03	0,06	0,08	0,10	0,15	0,20	0,25	0,30	0,40	0,50	0,60	0,80	1,00	
	Average Chip Thickness, mm/tooth (hm)													
Width of cut up to and including DC/2														
2 (0.02)					0,01	0,02	0,02	0,03	0,04	0,05	0,06	0,08	0,10	1.8
3 (0.03)				0,01	0,02	0,02	0,03	0,04	0,05	0,06	0,07	0,10	0,12	1.7
5 (0.05)			0,01	0,02	0,02	0,03	0,04	0,05	0,06	0,08	0,09	0,13	0,16	1.6
10 (0.10)		0,01	0,02	0,02	0,03	0,04	0,05	0,07	0,09	0,11	0,13	0,18	0,22	1.5
15 (0.15)	0,008	0,02	0,02	0,03	0,04	0,05	0,07	0,08	0,11	0,13	0,16	0,21		1.4
20 (0.20)	0,009	0,02	0,02	0,03	0,05	0,06	0,08	0,09	0,12	0,15	0,18			1.35
30 (0.30)	0,011	0,02	0,03	0,04	0,05	0,07	0,09	0,11	0,15	0,18	0,22			1.3
40 (0.40)	0,012	0,02	0,03	0,04	0,06	0,08	0,10	0,12	0,17	0,21				1.25
50 (0.50)	0,01	0,03	0,04	0,05	0,07	0,09	0,11	0,14	0,18	0,23				1.2
Face milling full engagement (Width of cut = DC)														
100 (1.00)	0,02	0,04	0,05	0,06	0,10	0,13	0,16	0,19	0,25	0,32				1.0

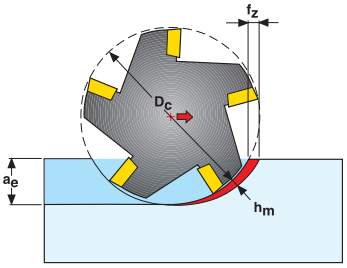
When using side milling it is necessary to increase the feed per tooth to keep the chip thickness at the same value.
It is also possible to increase the cutting speed and keep the same tool life. Use the tables below.

a_e/D_c %	Feed Per Tooth, in/tooth (f_z)													Speed Factor
	.0012	.0024	.0031	.004	.006	.008	.010	.012	.016	.020	.024	.031	.039	
	Average Chip Thickness, in/tooth (hm)													
Width of cut up to and including D_c/2														
2 (0.02)					.0004	.0008	.0008	.0012	.0016	.0020	.0024	.0031	.0039	1.8
3 (0.03)				.0004	.0008	.0008	.0012	.0016	.0020	.0024	.0028	.0039	.0047	1.7
5 (0.05)			.0004	.0008	.0008	.0012	.0016	.0020	.0024	.0031	.0035	.0051	.0063	1.6
10 (0.10)		.0004	.0008	.0008	.0012	.0016	.0020	.0028	.0035	.0043	.0051	.0071	.0087	1.5
15 (0.15)	.0003	.0008	.0008	.0012	.0016	.0020	.0028	.0031	.0043	.0051	.0063	.0083		1.4
20 (0.20)	.0004	.0008	.0008	.0012	.0020	.0024	.0031	.0035	.0047	.0059	.0071			1.35
30 (0.30)	.0004	.0008	.0012	.0016	.0020	.0028	.0035	.0043	.0059	.0071	.0087			1.3
40 (0.40)	.0005	.0008	.0012	.0016	.0024	.0031	.0039	.0047	.0067	.0083				1.25
50 (0.50)	.0004	.0012	.0016	.0020	.0028	.0035	.0043	.0055	.0071	.0091				1.2
Face milling full engagement (Width of cut = D_c)														
100 (1.00)	.0004	.0012	.0016	.0020	.0028	.0035	.0043	.0055	.0071	.0091				1.0

Instead of using the table above for calculating hm and fz, the following formula could be used if a_e/DC < 30%.

$$h_m = f_z \cdot \sqrt{\frac{a_e}{D_c}}$$

$$f_z = h_m \cdot \sqrt{\frac{D_c}{a_e}}$$



This table can be used for cutters with cutting edge angle = 60º

a_e/DC %	Feed Per Tooth, mm/tooth (f_z)													Speed Factor
	0,03	0,06	0,08	0,10	0,15	0,20	0,25	0,30	0,40	0,50	0,60	0,80	1,00	
	Average Chip Thickness, mm/tooth (hm)													
Width of cut up to and including DC/2														
2 (0.02)					0,02	0,02	0,03	0,04	0,05	0,06	0,07	0,10	0,12	1.8
3 (0.03)				0,01	0,02	0,03	0,04	0,04	0,06	0,07	0,09	0,12	0,15	1.7
5 (0.05)			0,02	0,02	0,03	0,04	0,05	0,06	0,08	0,10	0,12	0,15	0,19	1.6
10 (0.10)		0,02	0,02	0,03	0,04	0,05	0,07	0,08	0,11	0,13	0,16	0,22	0,27	1.5
15 (0.15)	0,010	0,02	0,03	0,03	0,05	0,07	0,08	0,10	0,13	0,16	0,20	0,26		1.4
20 (0.20)	0,011	0,02	0,03	0,04	0,06	0,07	0,09	0,11	0,15	0,19	0,22			1.35
30 (0.30)	0,013	0,03	0,04	0,04	0,07	0,08	0,11	0,13	0,18	0,22	0,27			1.3
40 (0.40)	0,015	0,03	0,04	0,05	0,08	0,10	0,13	0,15	0,20	0,25				1.25
50 (0.50)	0,02	0,03	0,04	0,06	0,08	0,11	0,14	0,17	0,22	0,28				1.2
Face milling full engagement (Width of cut = DC)														
100 (1.00)	0,02	0,04	0,05	0,06	0,10	0,13	0,16	0,19	0,25	0,32				1.0

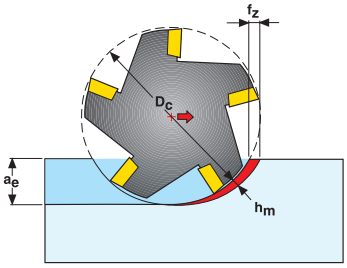
When using side milling it is necessary to increase the feed per tooth to keep the chip thickness at the same value.
It is also possible to increase the cutting speed and keep the same tool life. Use the tables below.

a_e/D_c %	Feed Per Tooth, in/tooth (f_z)													Speed Factor
	.0012	.0024	.0031	.004	.006	.008	.010	.012	.016	.020	.024	.031	1,00	
	Average Chip Thickness, in/tooth (hm)													
Width of cut up to and including D_c/2														
2 (0.02)					.0008	.0008	.0012	.0016	.0020	.0024	.0028	.0039	.0047	1.8
3 (0.03)				.0004	.0008	.0012	.0016	.0016	.0024	.0028	.0035	.0047	.0059	1.7
5 (0.05)			.0008	.0008	.0012	.0016	.0020	.0024	.0031	.0039	.0047	.0059	.0075	1.6
10 (0.10)		.0008	.0008	.0012	.0016	.0020	.0028	.0031	.0043	.0051	.0063	.0087	.0106	1.5
15 (0.15)	.0004	.0008	.0012	.0012	.0020	.0028	.0031	.0039	.0051	.0063	.0079	.0102		1.4
20 (0.20)	.0004	.0008	.0012	.0016	.0024	.0028	.0035	.0043	.0059	.0075	.0087			1.35
30 (0.30)	.0005	.0012	.0016	.0016	.0028	.0031	.0043	.0051	.0071	.0087	.0102			1.3
40 (0.40)	.0006	.0012	.0016	.0020	.0031	.0039	.0051	.0059	.0079	.0098				1.25
50 (0.50)	.0008	.0012	.0016	.0024	.0031	.0043	.0055	.0067	.0087	.0110				1.2
Face milling full engagement (Width of cut = D_c)														
100 (1.00)	.0008	.0012	.0016	.0024	.0031	.0043	.0055	.0067	.0087	.0110				1.0

Instead of using the table above for calculating hm and fz, the following formula could be used if a_e/DC < 30%.

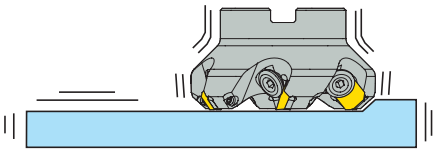
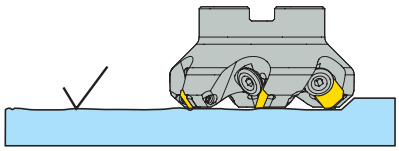
$$h_m = f_z \cdot \sqrt{\frac{a_e}{D_c}}$$

$$f_z = h_m \cdot \sqrt{\frac{D_c}{a_e}}$$



Trouble shooting carbide milling

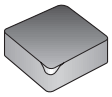
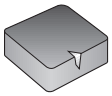
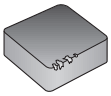
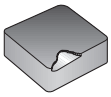
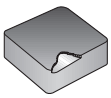
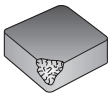
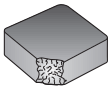
Vibrations

	
• Improve the stability of cutter and workpiece. • Change cutter positioning. • Minimize tool overhang. • Reduce the cutting speed. • Increase the feed rate. • Reduce the depth of cut. • Select a different insert geometriy, see page Insert geometry • Use Steadyline antivibration bar	• Improve the stability of cutter and workpiece. • Minimize tool overhang. • Reduce the feed rate. • Incease the cutting speed • Use coolant. • Use wiper inserts. • Keep feed/rev value within wiper width • Use Steadyline antivibration bar

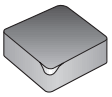
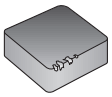
Tool life problems

Rapid flank wear 	• Reduce the cutting speed. • Increase the feed rate. • Climb milling.	**Comb cracks** 	• Reduce the cutting speed. • Reduce the feed rate. • No coolant • Change cutter positioning.
Rapid notch wear 	• Reduce the cutting speed. • Increase the feed rate. • Increase the depth of cut. • Climb milling. • Change cutter positioning	**Built-up edge (BUE)** 	• Increase the cutting speed. • Increase the feed rate • No coolant. • Climb milling. • Change cutter positioning
Chipping 	• Increase the cutting speed. • reduce the feed rate. • Conventional milling. • Improve chip evacuation. • Change cutter positioning. • Minimize tool overhang. • Improve stability.		

Trouble shooting PCBN

Problem	Cause	Suggested action(s)
Flank wear 	Not correct edge temperature	• Increase cutting speed • Increase feed rate • Increase depth of cut • Check cutting tool centre height • Check the ferrite content
Crater wear	Not correct edge temperature	• Decrease cutting speed • Decrease feed rate • Reduce chamfer angle • Use E edge preparation • Use coated insert • Use coolant (only in continuous cut)
Notch wear 	Not correct edge temperature Too high cutting forces	• Increase cutting speed • Decrease feed rate • Increase insert approach angle (preferably round inserts) • Vary the depth of cut • Use inserts with chamfered cutting edges
Edge chipping 	Too high cutting forces	• Use inserts with chamfered cutting edges • Increase system rigidity • For interrupted cuts, chamfer the tool entry/exit slots and holes • Vary the cutting speed to eliminate vibrations
Edge flaking (continuous cut) 	Too high cutting forces	• Increase cutting speed • Reduce feed rate • Use chamfered and honed cutting edges • Check cutting tool center height • Reduce insert approach angle
Edge flaking (interrupted cut) 	Too high cutting forces	• Do not use coolant • Use chamfered and honed cutting edges • Reduce feed rate • Increase cutting speed • Check cutting tool centre height • Reduce insert approach angle
Edge breakage 	Too high cutting forces	• Reduce depth of cut • Reduce cutting speed • Increase nose radius • Use chamfered and honed inserts • Check cutting tool center height
Insert breakage 	Too high cutting forces	• Check insert seating • Check insert shim and insert clamp • Check cutting tool centre height

Trouble shooting PCD

Problem	Cause	Suggested action(s)
Flank wear 	Wrong grade Precense of Fe/Ni/Co	• Change to coarser PCD grade • Check material composition • Reduce cutting speed • Use coolant
Built-up edge	Not correct edge temperature Wrong grade	• Decrease or increase cutting speed • Choose a sharper insert • Change to a finer grade
Edge chipping 	Poor rigidity Wrong grade Incorrect cutting data High run-out	• Minimize vibrations • Change to a tougher grade • Change cutting data • Check set-up
Poor surface finish	Wrong grade Too high cutting data Incrrect wiper position	• Change to a finer PCD grade • Reduce cutting speed and feed rate • Check wiper position
Flaking of workpiece	Too high depth of cut	• Decrease depth of cut • Add entry chamfer on component

Torque keys, insert keys and Combimaster tightening torque

The range of Torque keys with fixed torque values are available in combinations of key grip/torque value for insert locking for most of the Seco milling products. By using a Torque key you always ensure the correct tightening force when mounting the insert.
Torque keys are calibrated according to ISO 6789.

Code key: T00-15P35

T00 = Torque screw driver type for Torx Plus blade
T00T= Torque T-handle type for Torx Plus blade

15P= Torx Plus size
35 = Torque value 3,5 Nm

Please observe that blades are not interchangeable between screw driver type and T-handle type.
Torx Plus® is a registered trade mark belonging to
Camcar-Textron (USA)

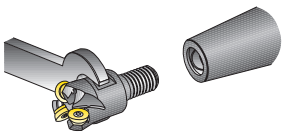
Torque key*	Replaceable blade	Torx Plus size	Torque value Nm/in.lbs
T00-06P05	T00-06P	T06P	0,5 / *4.4*
T00-07P05	T00-07P	T07P	0,5 / *4.4*
T00-07P09	T00-07P	T07P	0,9 / *8.0*
T00-08P12	T00-08P	T08P	1,2 / *10.6*
T00-08P20	T00-08P	T08P	2,0 / *17.7*
T00-09P09	T00-09P	T09P	0,9 / *8.0*
T00-09P12	T00-09P	T09P	1,2 / *10.6*
T00-09P20	T00-09P	T09P	2,0 / *17.7*
T00-10P20	T00-10P	T10P	2,0 / *17.7*
T00-10P30	T00-10P	T10P	3,0 / *26.6*
T00-10P35	T00-10P	T10P	3,5 / *31.0*
T00-15P20	T00-15P	T15P	2,0 / *17.7*
T00-15P30	T00-15P	T15P	3,0 / *26.6*
T00-15P35	T00-15P	T15P	3,5 / *31.0*
T00-15P40	T00-15P	T15P	4,0 / *35.4*
T00-15P50	T00-15P	T15P	5,0 / *44.3*
T00-20P35	T00-20P	T20P	3,5 / *31.0*
T00-20P50	T00-20P	T20P	5,0 / *44.3*
*Including blade			

Torque key*	Replaceable blade	Torx Plus size	Torque value Nm/ in.lbs
T00T-15P50	T00T-15P	T15P	5,0 / *44.3*
T00T-20P50	T00T-20P	T20P	5,0 / *44.3*
T00T-20P60	T00T-20P	T20P	6,0 / *53.1*
T00T-20P80	T00T-20P	T20P	8,0 / *70.8*
T00T-25P50	T00T-25P	T25P	5,0 / *44.3*
T00T-25P60	T00T-25P	T25P	6,0 / *53.1*
T00T-25P80	T00T-25P	T25P	8,0 / *70.8*
T00T-30P80	T00T-30P	T30P	8,0 / *70.8*
*Including blade			

Torx Plus size	Torx Plus bit - short	Torx Plus bit - long	Key (T-handle)
T06P	H4B-T06P	-	DOUBLE-T
T07P	H4B-T07P	-	DOUBLE-T
T08P	H4B-T08P	-	DOUBLE-T
T09P	H4B-T09P	-	DOUBLE-T
T10P	H4B-T10P	H4B-T10PL	DOUBLE-T
T15P	H4B-T15P	H4B-T15PL	DOUBLE-T
T20P	H6B-T20P	H6B-T20PL	DOUBLE-T
T25P	H6B-T25P	H6B-T25PL	DOUBLE-T
T30P	-	H6B-T30PL	DOUBLE-T

Hexagonal size	Hexagonal bit - short	Hexagonal bit - long	Key (T-handle)
2,5 mm	H4B-H2.5	-	DOUBLE-T
3,0 mm	H6B-H3.0	-	DOUBLE-T
5,0 mm	-	H6B-H5.0L	DOUBLE-T

Combimaster size M	Tightening torque
M6	10 Nm
M8	25 Nm
M10	40 Nm
M12	60 Nm
M16	80 Nm
M20	120 Nm



Steels, ferritic and martensitic stainless steels

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
P1	Free-cutting steels	$360 < R_m < 880$	11 SMn30 R_m = 385 N/mm²	1500	0,14
P2	Low-alloy ferritic steels, C < 0.25%wt Low-alloy weldable general structural steels	$320 < R_m < 600$	S235JRG2 R_m = 420 N/mm²	1600	0,23
P3	Ferritic & ferritic/pearlitic steels, C < 0.25%wt Weldable general structural steels Case-hardening steels	$430 < R_m < 610$	16 MnCr 5 R_m = 550 N/mm²	1800	0,14
P4	Low-alloy general structural steels, 0.25% < C < 0.67%wt Low-alloy Quench & Temper steels	$520 < R_m < 1200$	C 45E R_m = 660 N/mm²	2000	0,15
P5	Structural steels, 0.25% < C < 0.67%wt Quench & Temper steels	$550 < R_m < 1200$	42 CrMo 4 R_m = 700 N/mm²	2020	0,18
P6	Low-alloy through-hardening steels, C > 0.67%wt Low-alloy spring and bearing steels	$520 < R_m < 1200$	C 100S R_m = 600 N/mm²	2100	0,17
P7	Through-hardening steels, C > 0.67%wt Spring and bearing steels	$600 < R_m < 1200$	100 Cr 6 R_m = 650 N/mm²	2160	0,17
P8	Tool steels High Speed Steels (HSS)	$600 < R_m < 1200$	X 40 CrMoV 5 1 R_m = 700 N/mm²	2400	0,20
P11	Ferritic & martensitic stainless steels	$415 < R_m < 1200$	X 20 Cr 13 R_m = 675 N/mm²	2000	0,15
P12	Maraging and precipitation-hardening stainless steels	$500 < R_m < 1200$	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm²	2100	0,17

Free-cutting, austenitic and duplex stainless steels

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
M1	Free-cutting austenitic stainless steels		X 10 CrNiS 18 9	1700	0,14
M2	Low-alloy austenitic stainless steels		X 5 CrNi 18 10	1920	0,18
M3	Medium-alloy austenitic stainless steels		X 2 CrNiMo 18 14 3	2070	0,17
M4	High-alloy austenitic and duplex stainless steels		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Difficult high-alloy austenitic and duplex stainless steels		X 2 CrNiMoN 25 7 4	2510	0,13

Cast irons

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
K1	Grey cast irons (GCI)		EN-GJL-250	930	0,32
K2	Compacted graphite irons (CGI)		EN-GJV-400	1000	0,35
K3	Malleable cast irons (MCI)		EN-GJMB-550-4	1050	0,37
K4	Nodular cast irons (SGI)		EN-GJS-500-7	1160	0,37
K5	Austempered ductile irons (ADI)		EN-GJS-1000-5		
K6	Austenitic lamellar cast irons		EN-GJLA-XNiCuCr15-6-2		
K7	Austenitic nodular cast irons		EN-GJSA-XNiMn23-4		

Non-ferrous metals

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
N1	Aluminium alloys, Si < 9%		AW-7075		
N2	Aluminium alloys, 9% < Si < 16%		AC-44200 Si = 12%		
N3	Aluminium alloys, Si >16%		AlSi17Cu5		
N11	Copper alloys		CW614N	740	0,26

Superalloys and titanium

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
S1	Iron-based superalloys		Discalloy		
S2	Cobalt-based superalloys		Stellite 21		
S3	Nickel-based superalloys		Inconel 718	2530	0,21
S11	Titanium, low alloyed, (α)		Ti		
S12	Titanium, medium alloyed, (α+β)		TiAl6V4	1500	0,24
S13	Titanium, high alloyed, (near β and β)		Ti10V2Fe3Al		

Hard materials

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
H3	Case-hardened steels	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Quenched & Tempered steels	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Quenched & Tempered steels Bearing steels	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Tool steels High Speed Steels (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Martensitic stainless steels	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Maraged and precipitation-hardened stainless steels	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Manganese steels	23 < HRC < 64	X 120 Mn 12 50 HRC		
H31	White cast irons	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC		

Other difficult materials

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
PM1	Low-alloy PM-materials		F-0008 Fe-0.7C		
PM2	Medium-alloy PM-materials		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C		
PM3	High-alloy PM-materials Exhaust valve seat materials, etc.				
HF1	Hardfacing alloys Welded or plasma-deposited iron-based alloys				
HF2	Hardfacing alloys Welded or plasma-deposited cobalt- and nickel-based alloys				
CC1	Sintered tungsten carbide		G50		

Plastics and Composites

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
TS1	Thermosetting polymers		Urea formaldehyde (UF)		
TS2	Thermosetting carbon-fibre composites		T300 T700 T800 HTA-S IMA - Epoxy (M21)...		
TS3	Thermosetting glass-fibre composites		Epoxy - HX..(42..)/E glass (7781...)...		
TS4	Thermosetting aramide-fibre composites		Kevlar 49		
TP1	Thermoplastic polymers		Polycarbonate (PC)		
TP2	Thermoplastic carbon-fibre composites		PPS/PEEK - T300..		
TP3	Thermoplastic glass-fibre composites		PPS/PEEK - E glass or A glass...		
TP4	Thermoplastic aramide-fibre composites				

Graphite

SMG	Description	Properties	Reference	$k_{c1.1}$	m_c
GR1	Graphite		R 8500		

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4.5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCR 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCR 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
	1213				Annealed	
	12 L 13				Annealed	
	1108				Annealed	
	11 L 08				Annealed	
					Annealed	
	1140	40			Annealed	
	1146				Annealed	
	1215				Annealed	
	12 L 14				Annealed	
		16D			Annealed	
	A573 Grade 58	18kp	11 378		Annealed	
	A573 Grade 70	St14kP	11 448		Annealed	
	1010	10			Annealed	
F.1110	1015	15			Annealed	
	1020, 1023	20	12 024		Annealed	
		17G1S	11 523		Annealed	
F.1511	1015	15			Annealed	
F.1120	1025	25			Annealed	
					Annealed	
	A204 Grade A		15 020		Annealed	
	4520				Annealed	
	3310, 9314	20X2H4A	16 420		Annealed	
	4320		16 220		Annealed	
					Annealed	
F.1516	5115	12KHN2	14 220		Annealed	
		18HG			Annealed	
	5120	20KH	14 221		Annealed	
	5120 H	20KH			Annealed	
	A182-F11, A182-F12	12KHM	15 121		Annealed	
	A387 Grade 12 Cl. 2				Annealed	
F.155	A182-F22	12KH8	15 313		Annealed	
F.1130	1035	35	12 040		Annealed	
F.5110	1045	45	12 050		Annealed	
	1040	40	12 041		Annealed	
F.1150	1055	55			Annealed	
	1060	60	12 061		Annealed	
	1039	40G			Annealed	
	1330	30G2			Annealed	
F.1135	1035	35			Annealed	
F.1140	1045	45	12 050		Annealed	
F.1150	1064	60			Annealed	
	1060	60			Annealed	
F.144	9255	55S2			Annealed	
F.1250	4135	35KHM			Annealed	
F.5241	S1	5KHV2S			Annealed	
	L6	5KHNV			Annealed	
	5045				Annealed	
	3135				Quenched & Tempered	
	3435				Annealed	
	9840				Quenched & Tempered	
F.1280	4340	38H2N2MA	16 343		Annealed	
	5132	35KH			Quenched & Tempered	
	5140	40H	14 140		Quenched & Tempered	
F.1251	4130	20KHM	15 130		Quenched & Tempered	
F.1252	4142, 4140	38HM	15 142		Annealed	
F.1252	4142, 4140	38HM	15 142		Quenched & Tempered	
					Quenched & Tempered	
F.143	6150	50KHFA	15 260		Quenched & Tempered	
F.1740	A355 Cl. A				Annealed	
F.5103	1070	70			Annealed	
F.5117	1095				Annealed	
F.5118	W1	U10A			Annealed	
		U10			Annealed	
	W1	U13			Annealed	

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
F.520L	L2	11KHF			Annealed	
F.5220	O1	9KHVG			Annealed	
	O2	9G2F			Annealed	
F.5230	52100	SHKH15	14 109		Annealed	
F.5212	D3	KH12			Annealed	
	H11	4KH5MFS			Annealed	
F.5318	H13	4KH5MF1S			Annealed	
F.5227	A2	9KH5VF			Annealed	
	H10	3KH3M3F			Annealed	
F.5213		KH12			Annealed	
		KH12MF			Annealed	
F.520.S	L6	5KHNM			Annealed	
F.5613	M35	R6M5K5			Annealed	
	M42	R2AM9K5			Annealed	
	T4	R18K5F2			Annealed	
F.5603	M2	R6M5			Annealed	
	M7				Annealed	
	T1	R18			Annealed	
	403	08KH13			Annealed	Ferritic
F.3401	410, CA-15	12KH13, 08KH13			Annealed	Martensitic
F.3113	430	12KH17			Annealed	Ferritic
F.5261	420	20KH13	17 022		Annealed	Martensitic
F.3404	420	40KH13			Annealed	Martensitic
	440 A				Annealed	Martensitic
	440 B	95KH18			Annealed	Martensitic
	440 C	95KH18			Annealed	Martensitic
	A182 F6NM			F6NM	Annealed	Martensitic
	446	15KH28			Annealed	Ferritic
	XM-13			PH 13-8 Mo	Solution annealed	Austenitic
	XM-12			15-5 PH	H1150	Martensitic
	XM-12			15-5 PH	Solution annealed	Martensitic
	XM-12			15-5 PH	H1025	Martensitic
	SAE 630			17-4 PH	H1150	Martensitic
	630			17-4 PH	Solution annealed	Martensitic
	631	09KH17N7YU1		17-7 PH	Solution annealed	Austenitic/Ferritic
	AMS 6515			Marage 350	Solution annealed	Martensitic
	AMS 6521			Marage 300	Solution annealed	Martensitic
	AMS 6514			Marage 300, Vascomax C300	Solution annealed	Martensitic
	AMS 6512			Marage 250	Solution annealed	Martensitic
	AMS 6512			Marage 250, Vascomax C250	Solution annealed	Martensitic
F.3508	303	12KH19N9			Annealed	Austenitic
F.3504	304 L	03KH18N11			Annealed	Austenitic
F.3504	304	08KH18N10	17 240		Annealed	Austenitic
F.3534	316	08KH17H13M2T	17 346		Annealed	Austenitic
F.3524	347	08KH18N12B			Annealed	Austenitic
F.3517	301	07KH16N6			Annealed	Austenitic
	302	12KH18N9			Annealed	Austenitic
F.3533	(316 L)	03KH17N14M3	17 349		Annealed	Austenitic
	316 LN	03KH16N15M3			Annealed	Austenitic
F.3541	304 LN	03KH18N11			Annealed	Austenitic
	317	08KH17H15M3T			Annealed	Austenitic
				253 MA	Annealed	Austenitic
	310 S	12KH25N20			Annealed	Austenitic
	329 LN			SAF 2205	Annealed	Duplex
				3RE60	Annealed	Duplex
	904L				Annealed	Super austenitic
	329				Annealed	Duplex
	660			A286	Solution annealed	Austenitic
				254 SMO	Annealed	Super austenitic
				654 SMO	Annealed	Super austenitic
				Alloy 800	Annealed	Austenitic
	F 53			SAF 2507	Annealed	Super duplex

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
K4	EN-GJS-350-22	0.7033	0.7033	GGG-35.3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
	EN-GJS-400-18	0.7043	0.7043	GGG-40.3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
K5										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
N1	AW-1050A	Al99.5	3.0255	Al99.5	A-5/1050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
	A48 25 B	Sc 15	422 415			Grey cast iron (GCI)
	A48 30 B	Sc 20	422 420			Grey cast iron (GCI)
	A48 35 B	Sc 25	422 425			Grey cast iron (GCI)
	A48 50 B	Sc 35				Grey cast iron (GCI)
	G 3500					Grey cast iron (GCI)
	Grade 350					Compacted graphite iron (CGI)
	Grade 400					Compacted graphite iron (CGI)
	Grade 400-15					Compacted graphite iron (CGI)
	Grade 450					Compacted graphite iron (CGI)
	Grade 500					Compacted graphite iron (CGI)
	A220 60004				Tempered	Malleable cast iron (MCI)
						Nodular cast iron (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Nodular cast iron (SGI)
	60-40-18	Vc 42-12				Nodular cast iron (SGI)
FGE 50-7	A536, 80-55-06	Vc 50-2	422 305			Nodular cast iron (SGI)
FGE 60-2	A476, 80-60-03	Vc 60-2	422 306			Nodular cast iron (SGI)
FGE 70-2	A536, 100-70-03	Vc 70-2				Nodular cast iron (SGI)
	1600/1300/-					Austempered ductile iron (ADI)
	1050/700/7					Austempered ductile iron (ADI)
	1200/850/4					Austempered ductile iron (ADI)
	1400/1100/1					Austempered ductile iron (ADI)
	850/550/10					Austempered ductile iron (ADI)
	A436 Type 2			Ni-Resist 2		Austenitic lamellar cast iron
	A436 Type 3			Ni-Resist 3		Austenitic lamellar cast iron
	A436 Type 1			Ni-Resist 1		Austenitic lamellar cast iron
				Nodumag		Austenitic nodular cast iron
	A436 Type D-2			Ni-Resist D-2		Austenitic nodular cast iron
	A439 Type D-2M			Ni-Resist D-2M		Austenitic nodular cast iron
	A436 Type D-3			Ni-Resist D-3		Austenitic nodular cast iron
	A439 Type D-5			Ni-Resist D-5		Austenitic nodular cast iron
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 NiCoMo 18 8 5	1.6359	1.6359	X 2 NiCoMo 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

SMG

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Misc. Brands	Condition	Structure
				Discalloy	Precipitation hardened	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel X-750	Solution annealed	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	Commercially pure	Ti (α)
	AMS 4919			Ti 6-2-4-2	Annealed	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	Annealed	Ti (α+β)
	AMS 4920, Grade 5	VT6		Ti 6Al-4V	Annealed	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	Annealed	Ti (β)
F.1516	5115	12KHN2	14 220		Case hardened	
F.5103	1070	70			Quenched & Tempered	
F.5107	1078, 1080	75			Quenched & Tempered	
F.5117	1095				Quenched & Tempered	
F.5118	W1	U10A			Quenched & Tempered	
	S1	5KHV2SF			Quenched & Tempered	
	5155				Quenched & Tempered	
F.1252	4142, 4140	38HM	15 142		Quenched & Tempered	
F.520L	L2	11KHF			Quenched & Tempered	
F.5220	O1	9KHVG			Quenched & Tempered	
	O2	9G2F			Quenched & Tempered	
F.5230	52100	SHKH15	14 109		Quenched & Tempered	
F.5318	H13	4KH5MF1S			Quenched & Tempered	
F.5227	A2	9KH5VF			Quenched & Tempered	
F.5211	D2	KH12MF			Quenched & Tempered	
F.5213		KH12			Quenched & Tempered	
		KH12MF			Quenched & Tempered	
F.520.S	L6	5KHNM			Quenched & Tempered	
F.5613	M35	R6M5K5			Quenched & Tempered	
	M42	R2AM9K5			Quenched & Tempered	
	T1	R18			Quenched & Tempered	
F.5261	420	20KH13	17 022		Quenched & Tempered	Martensitic
	440 A				Quenched & Tempered	Martensitic
	440 B	95KH18			Quenched & Tempered	Martensitic
	440 C	95KH18			Quenched & Tempered	Martensitic
	XM-12			15-5 PH	H900	Martensitic
	SAE 630			17-4 PH	H1025	Martensitic
	SAE 630			17-4 PH	H900	Martensitic
	AMS 5528	09KH17N7YU1		17-7 PH	TH1050	Martensitic
	632			PH 15-7 Mo	TH1050	Martensitic
	660			A286	Precipitation hardened	Austenitic
	AMS 6512			Marage 250	Precipitation hardened	Martensitic
	AMS 6521			Marage 300	Precipitation hardened	Martensitic
	AMS 6521			Marage 300	Precipitation hardened	Martensitic
	AMS 6515			Marage 350	Precipitation hardened	Martensitic
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		White cast iron
	A532 IA (NiCr-HC)			Ni-Hard 1		White cast iron
	A532 ID (Ni-HiCr)			Ni-Hard 4		White cast iron

Cemented carbide inserts and insert carriers

Cemented carbide inserts and cemented carbide insert carriers from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.
These products meet all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.
Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.

Regrinding:
Wet or dry grinding can produce potentially hazardous dusts or mists that can irritate skin, eyes, nose, throat and result in lung damage or disease. To avoid injury use proper safety precautions and protective equipment.

Disposal:
Seco Tools will buy back used inserts and solid carbide tools for recycling. Inserts and solid carbide tools should be separated from other metal waste (steel, aluminium, copper etc).
All packing material is fully recyclable.

CBN and PCD inserts

Inserts from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.
This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.
Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.

Regrinding:
Wet or dry grinding can produce potentially hazardous dusts or mists that can irritate skin, eyes, nose, throat and result in lung damage or disease. To avoid injury use proper safety precautions and protective equipment.

Disposal:
Seco Tools will buy back used CBN- or PCD-tipped inserts for recycling. Inserts should be separated from other metal waste (steel, aluminium, copper etc). Solid CBN-inserts may be discarded as landfill waste.
All packing material is fully recyclable.

Black oxide insert carriers

Insert carriers from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.
This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.
Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.

Disposal:
Used insert carriers may be sent for recycling together with ordinary steel waste (swarf and discarded steel scrap) for recycling.
All packing material is fully recyclable.

Cermet inserts

Inserts from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.
This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.
Cermet grade C15M inserts do contain nickel and will leach nickel when in contact with the skin. Amount of leaching is higher than specified in norm SS-EN 1811 Reference test method for release of nickel from products intended to come into direct and prolonged contact with the skin. These norms are intended for products that are in direct and prolonged contact with the skin and are therefore not directly applicable for cermet inserts. Persons with known allergic reactions to nickel are advised to wear protective gloves when handling cermet inserts.

Regrinding:
Wet or dry grinding can produce potentially hazardous dusts or mists that can irritate skin, eyes, nose, throat and result in lung damage or disease. To avoid injury use proper safety precautions and protective equipment.

Disposal:
Used inserts may be recycled. Inserts should be separated from other metal waste (steel, aluminium, copper, etc) including cemented carbide inserts.
All packing material is fully recyclable.

Nickel coated insert carriers

Insert carriers from Seco Tools are not included in the product range intended for the following requirements. Nevertheless Seco Tools can make the following declaration.
This product meets all requirements in RoHS (Restriction of the use of certain Hazardous Substances in electrical and electronic equipment), WEEE (Waste Electrical & Electronic Equipment) and ELV (End of Life Vehicles) requirements.
Products do not contain mercury, lead, hexavalent chromium, cadmium, CFC, HCFC, flame retardants or solvents in concentrations that exceed specifications in the regulations.
Insert carriers do contain nickel and will leach nickel when in contact with the skin. Amount of leaching is not higher then norm SS-EN 1811 Reference test method for release of nickel from products intended to come into direct and prolonged contact with the skin.
These norms are intended for products that are in direct and prolonged contact with the skin and are therefore not directly applicable for insert carriers. Persons with known allergic reactions to nickel are advised to wear protective gloves when handling nickel coated insert carriers.

Disposal:
Used tools maybe sent for recycling together with ordinary steel waste (swarf and discarded steel scrap) for recycling.
All packing material is fully recyclable.

Intentionally added alloying elements

Grade	Cemented carbide											Coating						
	W	Ti	Ta	Nb	Co	Cr	Ni	Mo	C	N	Ru	Ti	Al	C	N	O	Si	Nb
CP20	■				■				■			■			■			
CP200	■				■	■			■			■	■		■			
CP300	■	■	■	■	■				■			■	■		■			
CP500	■				■	■			■			■	■		■			
CP600	■				■	■			■			■	■		■			
C15M	■	■	■	■	■		■	■	■	■								
CF	■		■		■		■	■	■									
CM	■		■		■		■	■	■									
DP2000	■		■	■	■				■			■	■	■	■	■		
DP3000	■	■	■	■	■				■	■		■	■	■	■	■		
DS2050	■				■	■			■			■	■		■			■
DS4050	■				■	■			■			■	■		■			■
F15M	■				■	■			■			■	■		■			
F25M	■	■	■	■	■				■			■	■		■			
F30M	■				■	■			■			■	■		■			
F40M	■				■	■			■			■	■		■			
HX	■		■		■				■									
H02	■		■		■	■			■									
H15	■				■	■			■									
H25	■				■	■			■									
KX	■				■	■			■									
MH1000	■				■	■			■			■	■		■			
MK1500	■		■		■				■			■	■	■	■	■		
MK2050	■		■		■	■			■			■	■		■		■	
MM4500	■				■	■			■			■	■	■	■	■		
MP1501	■		■	■	■				■			■	■	■	■	■		
MP2050	■				■						■	■	■		■		■	
MP2501	■		■	■	■				■			■	■	■	■	■		
MP3000	■				■	■			■			■	■		■			
MS2500	■		■	■	■				■			■	■	■	■	■		
MS2050	■				■	■			■			■	■		■			■
RX1500	■		■		■		■	■	■			■	■		■			
RX2000	■		■		■	■			■			■	■		■			
RM2020	■				■				■			■						
RM2090	■				■	■			■			■	■				■	
RN2010	■				■	■			■									
RS2090	■				■	■			■			■	■				■	
T350M	■		■	■	■				■			■	■	■	■	■		
T25M	■		■	■	■				■			■		■	■			
TGH1050	■				■	■			■			■	■		■		■	
TGK1500	■		■		■				■			■	■	■	■	■		
TGP25	■	■	■	■	■				■			■	■	■	■	■		
TGP35	■		■	■	■				■			■	■	■	■	■		
TGP45	■		■	■	■				■			■	■	■	■	■		
TGS2050	■				■	■			■			■	■		■		■	
TH1000	■				■	■			■			■	■		■		■	
TH1500	■				■	■			■			■	■	■	■	■		
TK0501	■				■	■			■			■	■	■	■	■		
TK1501	■		■		■	■			■			■	■	■	■	■		
TM1501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TM2000	■	■	■	■	■				■	■		■	■	■	■	■		
TM2501	■	■	■	■	■				■	■		■	■	■	■	■		
TM3501	■				■				■			■	■	■	■	■		
TM4000	■	■	■	■	■				■	■		■	■	■	■	■		
TP0501	■	■	■	■	■	■			■			■	■	■	■	■		
TP1020	■	■	■	■	■				■	■								
TP1030	■	■	■	■	■				■	■		■	■		■		■	
TP1501	■	■	■	■	■				■	■		■	■	■	■	■		
TP25	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP200	■	■	■	■	■				■	■		■	■	■	■	■		
TP2501	■	■	■	■	■	■			■	■		■	■	■	■	■		
TP3501	■	■	■	■	■				■	■		■	■	■	■	■		
TP40	■		■	■	■				■			■		■	■			
TS2000	■				■	■			■			■	■		■			
TS2050	■				■	■			■			■	■		■		■	
TS2500	■		■		■				■			■	■		■			
TTP2050	■				■	■			■			■	■		■		■	
T250D	■				■	■			■			■	■		■			
T400D	■				■	■			■			■	■		■			
T100R	■		■		■	■			■			■	■		■			
T60M	■	■	■	■	■				■			■	■		■			
883	■		■		■				■									
890	■				■	■			■									

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