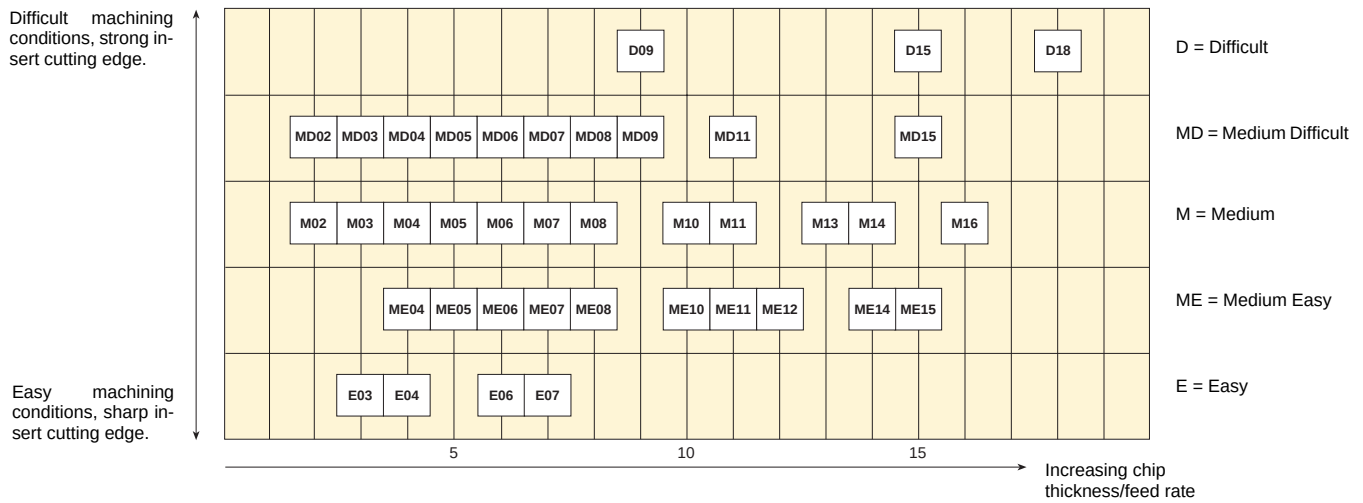
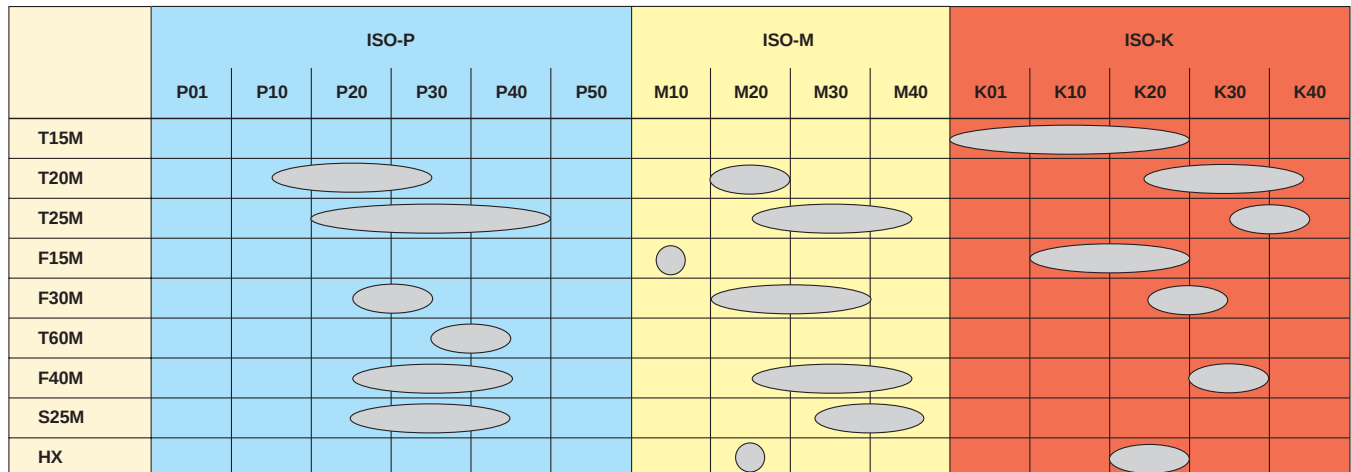


Designation system

The Seco designation system for milling inserts has been developed to provide the user with better guidance concerning the fields of application for the various insert geometries. The cutting geometries included are presented in the chart.



Grades

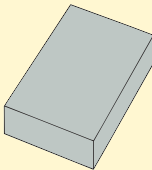
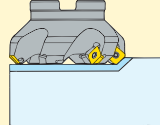
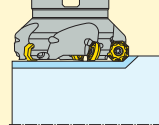
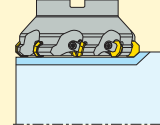
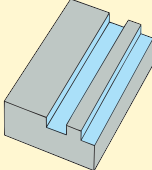
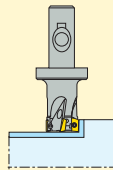
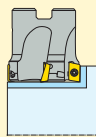
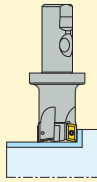
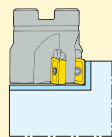
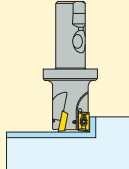
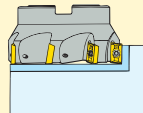
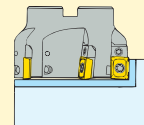
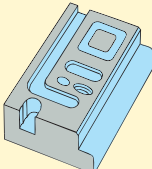
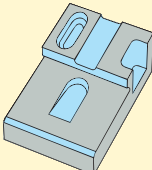
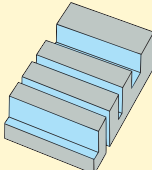
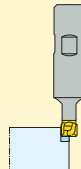
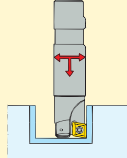
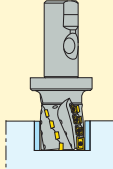
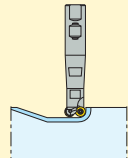
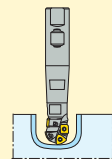
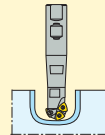
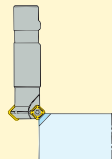
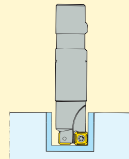
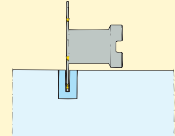
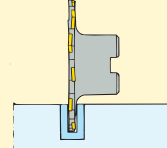
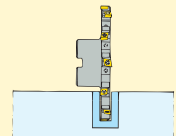


Basic grades

T25M	Coated grade for milling of steels, cast irons, stainless steels and certain super alloys
F40M	PVD-coated grade for milling of steels. Stainless steels and super alloys. Suitable for conditions like low cutting speed, small chip thickness and milling with coolant.

Complementary grades

T15M	Coated grade for milling of cast iron.
T20M	Coated grade for milling of steels and hardened steels.
T60M	PVD-coated grade especially suited for Minimaster and suitable for most workpiece materials.
F15M	PVD-coated grade for milling of aluminium alloys.
F30M	PVD-coated grade for milling of steels, hardened steels and stainless steels.
S25M	Uncoated grade for milling of steels.
HX	Uncoated grade for machining cast irons.

Face milling 	220.13-09 page 64  For small machining centres.	220.43-05 page 66  First choice General purpose.	220.43-07W, -07GW page 68  First choice General purpose.	
Square shoulder milling 	217.69-09TA, -09A, -09T page 70  For small machining centres.	220.69-09, 09T page 72  For small machining centres.	217.69-13, -13A page 74 76  General purpose.	220.69-13 page 78  General purpose.
	217.69-16, -16A page 80  End mills, high capacity.	220.69-16, -16 page 82  First choice General purpose.	220.99-09 page 84  For difficult operations.	
Selected milling applications  Minimaster-applications   Slot milling	Minimaster page 86 87  Small dimensions.	216.19 page 90  Drilling end mills.	215.59 page 92 94  Slotting and contouring.	217.29 page 96 98  Copy milling, round inserts.
	220.29 page 100  Copy milling, round inserts.	218.19 page 102  Copy milling 90°.	218.19 page 104  Copy milling 120°.	215.49 page 106  Chamfering and deburring.
	417.19 page 108  Spot face milling.	335.10 page 110 112 114  High capacity. Width 2,25 – 4,1 mm.	335.19 page 116 118 120  General purpose. Width 4–12 mm.	335.18 page 122  General purpose. Width 14–24,3 mm.

Milling cutters

R220.13-09

General purpose light cutting face mills for mixed production in small machining centres.

Other face milling cutters

R220.43-05 page 66	R220.43-07W, -07GW page 68	
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Application		Part No.	Ordering and Product No.	Dimensions in mm				KG		
				D	A	H	a _p			
		R220.13-0032-09	75037275	32	42	40	4,5	0,3	4	SEEX09T3..
		-0040-09	75037276	40	50	40	4,5	0,5	4	SEEX09T3..
		-0050-09	75037277	50	60	40	4,5	0,5	5	SEEX09T3..
		-0063-09	75037278	63	73	40	4,5	0,6	6	SEEX09T3..
		-0080-09	75037279	80	90	50	4,5	1,0	6	SEEX09T3..

Dimensions of mounting

	Dimensions in mm				For arbor
	D	d	p	q	
	32	16	8,4	5,6	16
	40	22	10,4	6,3	22
	50	22	10,4	6,3	22
	63	22	10,4	6,3	22
	80	27	12,4	7,0	27

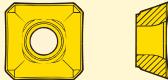
Spare parts, included in delivery

For cutter	Locking screw/ Key*		Arbor screw
R220.13-0032-09	C03007	T09-3	220.17-690
-0040-09	C03007	T09-3	220.17-696
-0050-09	C03007	T09-3	220.17-696
-0063-09	C03007	T09-3	220.17-696
-0080-09	C03007	T09-3	-

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↕ Protected	SEEX 	SEEX 09T3AFN-E04 F15M	74037300								
		09T3AFTN-ME07 T25M	74037297	●		●				●	●
		09T3AFN-M05 F40M	00081503	●		●					
		09T3AFTN-M08 T15M	74037298					●	●		
		09T3AFTN-M08 T25M	74037299		●		●				
		09T3AFTN-D09 T20M	74037302		●				●		

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,10	0,14	0,18
Steel	1-4 Easy-cutting and ordinary steels	SEEX 09T3AFTN-ME07 T25M	270	240	220	200
		09T3AFN-M05 F40M	215	190	175	160
	5-6 Harder steels	SEEX 09T3AFTN-M08 T25M	155	135	125	-
		09T3AFTN-D09 T20M	180	165	145	-
Stainless steel	8-9 Easy-cutting and ordinary stainless steel	SEEX 09T3AFTN-ME07 T25M	280	250	225	-
		09T3AFN-M05 F40M	225	200	180	165
	10 Stainless steels difficult to machine	SEEX 09T3AFTN-M08 T25M	210	185	170	-
Cast iron	12-13 Easy-cutting and ordinary cast iron	SEEX 09T3AFTN-M08 T15M	265	235	215	200
	14-15 Harder cast iron and nodular irons	SEEX 09T3AFTN-M08 T15M	195	175	160	145
		09T3AFTN-D09 T20M	180	160	145	135
Other materials	16-17 Aluminium and other non-ferrous	SEEX 09T3AFN-E04 F15M	1 100	1 000	900	800
	20, 22 Superalloys and titanium-based alloys	SEEX 09T3AFTN-ME07 T25M	70	65	-	-

Milling cutters

R220.43-05

Multi-purpose light cutting face mills. Also suitable for ramping, plunging and slotting operations.

Other face milling cutters

R220.13-09 page 64	R220.43-07W, -07GW page 68	
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Application		Part No.	Ordering and Product No.	Dimensions in mm				KG		
				D	A	H	ap			
R220.43-05		R220.43-0032-05	75069157	32	41	40	3,5	0,2	3	OFEX05T305..
		-0040-05	75069158	40	49	40	3,5	0,3	3	OFEX05T305..
		-0050-05	75069159	50	59	40	3,5	0,4	4	OFEX05T305..
		-0063-05	75069160	63	72	40	3,5	0,6	5	OFEX05T305..
		-0080-05	75069161	80	89	50	3,5	1,1	6	OFEX05T305..
		-0100-05	75069162	100	109	50	3,5	1,7	7	OFEX05T305..
		-0125-05	75079618	125	134	63	3,5	3,1	8	OFEX05T305..
		-8160-05	75080766	160	169	63	3,5	5,7	10	OFEX05T305..

Dimensions of mounting

	Dimensions in mm					For arbor	For spindle-nose
	D	d	p	q	E ₁		
	32	16	8,4	5,6	-	16	-
	40	16	8,4	5,6	-	16	-
	50	22	10,4	6,3	-	22	-
	63	22	10,4	6,3	-	22	-
	80	27	12,4	7	-	27	-
	100	32	14,4	8	-	32	-
	125	40	16,4	9	-	40	-
	160	40	16,4	9	66,7	40	ISO 40

Spare parts, included in delivery

For cutter	Locking screw/ Key*		Arbor screw
R220.43-0032-05	C04008	T15-3	220.17-690
-0040-05	C04008	T15-3	TCEI0825
-0050-05	C04008	T15-3	220.17-692
-0063-05	C04008	T15-3	220.17-692
-0080-05	C04008	T15-3	-
-0100-05	C04008	T15-3	-
-0125-05	C04008	T15-3	-
-8160-05	C04008	T15-3	-

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↕ Protected	OFEX  	OFEX 05T305N-E04 F15M	74069132								
		05T305TN-ME07 T25M	74069128	●		●				●	●
		05T305TN-M08 F40M	00094729		●		●				
		05T305TN-M08 T15M	74069130					●	●		
		05T305TN-M08 T25M	74069131		●		●				
		05T305TN-D09 T20M	74069129		●				●		

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,10	0,14	0,18
Steel	1-4 Easy-cutting and ordinary steels	OFEX 05T305TN-ME07 T25M	270	240	220	205
	5-6 Harder steels	OFEX 05T305TN-M08 F40M	145	125	110	-
		05T305TN-M08 T25M	160	140	130	-
		05T305TN-D09 T20M	185	165	150	-
Stainless steel	8-9 Easy-cutting and ordinary stainless steel	OFEX 05T305TN-ME07 T25M	280	250	230	-
	10 Stainless steels difficult to machine	OFEX 05T305TN-M08 T25M	215	190	175	-
		05T305TN-M08 F40M	195	165	155	145
Cast iron	12-13 Easy-cutting and ordinary cast iron	OFEX 05T305TN-M08 T15M	270	240	220	205
	14-15 Harder cast iron and nodular irons	OFEX 05T305TN-M08 T15M	200	180	160	150
		05T305TN-D09 T20M	180	165	150	140
Other materials	16-17 Aluminium and other non-ferrous	OFEX 05T305N-E04 F15M	1 100	1 000	900	800
	20, 22 Superalloys and titanium-based alloys	OFEX 05T305TN-ME07 T25M	85	75	-	-

Milling cutters

R220.43-07W, -07GW

General purpose light cutting face mills for mixed production.
Type GW especially in low-power machines under unstable conditions.

Other face milling cutters

R220.13-09 page 64	R220.43-05 page 66	
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Application		Part No.	Ordering and Product No.	Dimensions in mm				KG		
				D	A	H	a _p			
		Normal pitch								
		R220.43-0063-07W	00005691	63	75	40	5	0,5	4	OFE.070405..
		-0080-07W	00005692	80	92	50	5	1,2	5	OFE.070405..
		-0100-07W	00005693	100	112	50	5	1,9	6	OFE.070405..
		-0125-07W	00005694	125	137	63	5	3,0	8	OFE.070405..
		-8160-07W	00005695	160	172	63	5	4,7	10	OFE.070405..
		Coarse pitch								
		R220.43-8160-07GW	00005696	160	172	63	5	5,4	7	OFE.070405..

Dimensions of mounting

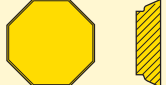
	Dimensions in mm					For arbor	For spindle-nose
	D	d	p	q	E ₁		
	63	22	10,4	6,3	-	22	-
	80	27	12,4	7	-	27	-
	100	32	14,4	8	-	32	-
	125	40	16,4	9	-	40	-
	160	40	16,4	9	66,7	40	ISO 40

Spare parts, included in delivery

For cutter	Wedge/ Wedge screw/ Key			Arbor screw
R220.43-0063-07W	CW0810	LD8020	T25-4	MF6S10x40
-0080-07W	CW0810	LD8020	T25-4	MC6S12x35
-0100-07W	CW0810	LD8020	T25-4	-
-0125-07W	CW0810	LD8020	T25-4	-
-8160-07W	CW0810	LD8020	T25-4	-
R220.43-8160-07GW	CW0810	LD8020	T25-4	-

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↑ ↓ Protected	OFER 	OFER 070405N-E07 F15M	74068306								
		070405TN-ME10 T25M	74069499	●		●					●
		070405TN-ME15 T25M	74068305	●		●					●
		070405TN-M16 F40M	00094730		●		●				
		070405TN-M16 T15M	74068309					●	●		
		070405TN-M16 T20M	74069498		●			●			
		070405TN-M16 T25M	74068307	●	●						
		070405TN-ME10 T25M	74069499	●		●					
	OFEN 	OFEN 070405TN-D18 T20M	74068310		●				●		

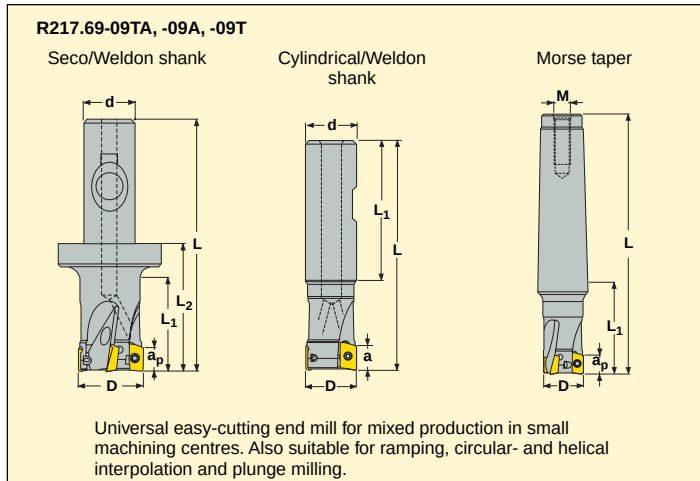
● = first choice

Cutting data

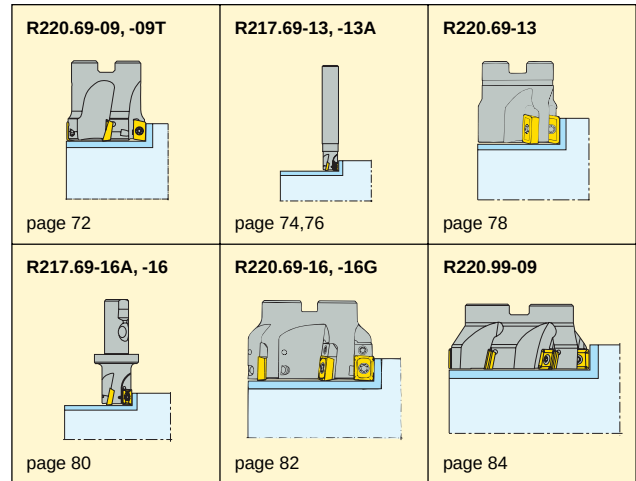


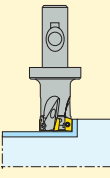
Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,10	0,20	0,40	
Steel	1-4 Easy-cutting and ordinary steels	OFER 070405TN-ME10 T25M	230	175	-	
		070405TN-ME15 T25M	230	175	-	
		070405TN-M16 T25M	205	155	130	
	5-6 Harder steels	OFER 070405TN-M16 F40M	135	110	-	
		070405TN-M16 T20M	155	130	-	
		070405TN-M16 T25M	130	100	85	
		OFEN 070405TN-D18 T20M	155	130	-	
Stainless steel	8-9 Easy-cutting and ordinary stainless steel	OFER 070405TN-ME10 T25M	235	180	150	
		070405TN-ME15 T25M	235	180	150	
	10 Stainless steels difficult to machine	OFER 070405TN-M16 F40M	180	140	120	
Cast iron	12-13 Easy-cutting and ordinary cast iron	OFER 070405TN-M16 T15M	230	185	155	
		070405TN-M16 T20M	210	175	145	
	14-15 Harder cast iron and nodular irons	OFER 070405TN-M16 T15M	170	140	115	
		OFEN 070405TN-D18 T20M	155	130	105	
Other materials	16-17 Aluminium and other non-ferrous	OFER 070405N-E07 F15M	800	600	500	
	20, 22 Superalloys and titanium-based alloys	OFER 070405TN-ME15 T25M	70	55	-	

Milling cutters



Other square shoulder milling cutters



Application		Part No.	Ordering and Product No.	Dimensions in mm								Mounting type			
				D	d	L	L ₁	L ₂	M	a _p					
		Close pitch													
		R217.69-2025.3S-09TA	75069200	25	20	100	50	36	-	8	Seco/Weldon	0,3	4	XOMX0903..	
		-2532.3S-09TA	75069201	32	25	111	55	41	-	8	Seco/Weldon	0,5	4	XOMX0903..	
		Normal pitch													
		R217.69-1612.3-09A	75069203	12	16	73	48	-	-	8	Cyl/Weldon	0,1	1	XOMX0903..	
		-1616.3-09A	75069204	16	16	78	48	-	-	8	Cyl/Weldon	0,1	2	XOMX0903..	
		-2018.3-09A	75069205	18	20	85	50	-	-	8	Cyl/Weldon	0,2	2	XOMX0903..	
		-2020.3-09A	75069211	20	20	90	55	-	-	8	Cyl/Weldon	0,2	2	XOMX0903..	
		-2525.3-09A	75069207	25	25	101	61	-	-	8	Cyl/Weldon	0,3	3	XOMX0903..	
		Close pitch													
		R217.69-2020.3-09TA	75069206	20	20	90	55	-	-	8	Cyl/Weldon	0,2	3	XOMX0903..	
		-2525.3-09TA	75069208	25	25	101	61	-	-	8	Cyl/Weldon	0,3	4	XOMX0903..	
		Close pitch													
	R217.69-0320.2-09T	75069213	20	-	126	45	-	M12	8	Morse No. 3	0,3	3	XOMX0903..		
	-0325.2-09T	75069218	25	-	126	45	-	M12	8	Morse No. 3	0,4	4	XOMX0903..		
	-0332.2-09T	75069219	32	-	126	45	-	M12	8	Morse No. 3	0,4	4	XOMX0903..		

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R217.69-2025.3S-09TA	C02505-T8	T08-3
-2532.3S-09TA	C02505-T8	T08-3
R217.69-1612.3-09A	C02505-T8	T08-3
-1616.3-09A	C02505-T8	T08-3
-2018.3-09A	C02505-T8	T08-3
-2020.3-09A	C02505-T8	T08-3
-2525.3-09A	C02505-T8	T08-3
-2020.3-09TA	C02505-T8	T08-3
-2525.3-09TA	C02505-T8	T08-3
R217.69-0320.2-09T	C02505-T8	T08-3
-0325.2-09T	C02505-T8	T08-3
-0332.2-09T	C02505-T8	T08-3

Extract from Seco Milling Catalogue.

Inserts

Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
	XOMX 090304TR-ME06 F40M	00089961	●		●				●	
	090304TR-ME06 T15M	74068047					●	●		
	090304TR-ME06 T20M	74068046		●				●		
	090304TR-ME06 T25M	74068045	●		●					●
	XOMX 090308TR-ME06 F40M	00089962	●		●				●	
	090308TR-ME06 T25M	74068892	●		●					

The insert programme also includes inserts with nose radii 1.6 and 3.1 mm.

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,09	0,12	0,14
Steel	1-4 Easy-cutting and ordinary steels	XOMX 090304TR-ME06 F40M	190	175	160	155
		090304TR-ME06 T25M	210	195	180	170
		XOMX 090308TR-ME06 F40M	190	175	160	155
		090308TR-ME06 T25M	210	195	180	170
	5-6 Harder steels	XOMX 090304TR-ME06 T20M	140	125	115	-
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	XOMX 090304TR-ME06 F40M	200	180	170	-
		090304TR-ME06 T25M	220	200	185	-
		XOMX 090308TR-ME06 F40M	200	180	170	-
		090308TR-ME06 T25M	220	200	185	-
	10 Stainless steels difficult to machine	XOMX 090304TR-ME06 T25M	185	170	-	-
		XOMX 090308TR-ME06 T25M	185	170	-	-
Cast iron	12-13 Easy-cutting and ordinary cast iron	XOMX 090304TR-ME06 T15M	240	215	200	-
	14-15 Harder cast iron and nodular irons	XOMX 090304TR-ME06 T15M	175	160	150	-
		090304TR-ME06 T20M	165	150	140	-
Other materials	16-17 Aluminium and other non-ferrous	XOMX 090304TR-ME06 F40M	750	700	650	600
		XOMX 090308TR-ME06 F40M	750	700	650	600
	20, 22 Superalloys and titanium-based alloys	XOMX 090304TR-ME06 T25M	65	55	-	-

Milling cutters

R220.69-09, -09T

General purpose square shoulder mills for mixed production in small machining centres. Type T used on high-power machines under stable conditions.

Other square shoulder milling cutters

R217.69-09TA, -09A, -09T page 70	R217.69-13, -13A page 74,76	R220.69-13 page 78
R217.69-16A, -16 page 80	R220.69-16, -16G page 82	R220.99-09 page 84

Application	Part No.	Ordering and Product No.	Dimensions in mm			KG		
			D	H	a _p			
R220.69-09, -09T 		Normal pitch						
	R220.69-0040-09	75069202	40	40	8	0,2	4	XOMX0903..
	-0050-09	00083449	50	40	8	0,4	5	XOMX0903..
		Close pitch						
	R220.69-0040-09T	00083448	40	40	8	0,2	6	XOMX0903..
	-0050-09T	00083450	50	40	8	0,4	7	XOMX0903..

Dimensions of mounting

	Dimensions in mm				For arbor
	D	d	p	q	
	40	16	8,4	5,6	16
	50	22	10,4	6,3	22

Spare parts, included in delivery

For cutter	Locking screw/ Key*		Arbor screw
R220.69-0040-09	C02505-T8	T08-3	MC6S8X30
-0050-09	C02505-T8	T08-3	220.17-692
R220.69-0040-09T	C02505-T8	T08-3	MC6S8X30
-0050-09T	C02505-T8	T08-3	220.17-692

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
XOMX  	XOMX 090304TR-ME06 F40M	00089961	●		●				●	
	090304TR-ME06 T15M	74068047					●	●		
	090304TR-ME06 T20M	74068046		●				●		
	090304TR-ME06 T25M	74068045	●		●					●
	XOMX 090308TR-ME06 F40M	00089962	●		●				●	
	090308TR-ME06 T25M	74068892	●		●					

The insert programme also includes inserts with nose radii 1.6 and 3.1 mm.

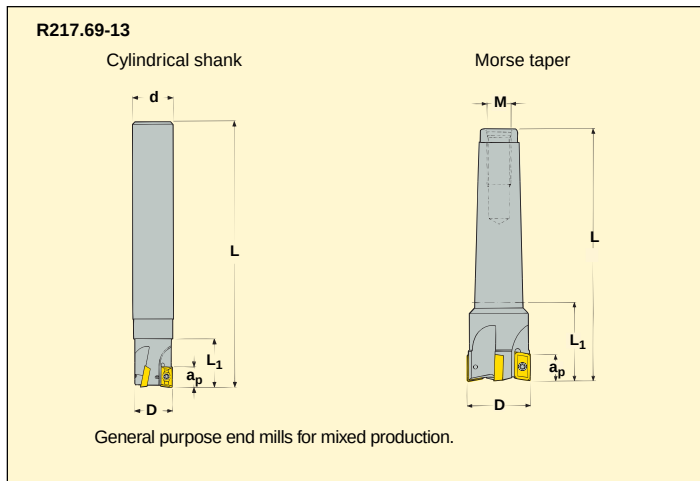
● = first choice

Cutting data

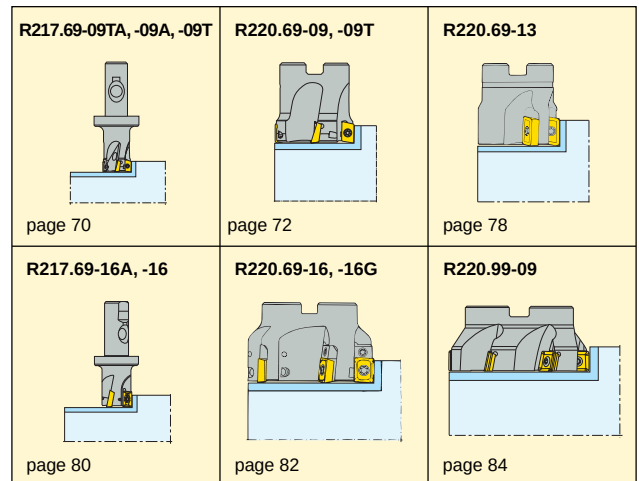


Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,09	0,12	0,14
Steel	1-4 Easy-cutting and ordinary steels	XOMX 090304TR-ME06 F40M	190	175	160	155
		090304TR-ME06 T25M	210	195	180	170
		XOMX 090308TR-ME06 F40M	190	175	160	155
		090308TR-ME06 T25M	210	195	180	170
	5-6 Harder steels	XOMX 090304TR-ME06 T20M	140	125	115	-
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	XOMX 090304TR-ME06 F40M	200	180	170	-
		090304TR-ME06 T25M	220	200	185	-
		XOMX 090308TR-ME06 F40M	200	180	170	-
		090308TR-ME06 T25M	220	200	185	-
	10 Stainless steels difficult to machine	XOMX 090304TR-ME06 T25M	185	170	-	-
		XOMX 090308TR-ME06 T25M	185	170	-	-
Cast iron	12-13 Easy-cutting and ordinary cast iron	XOMX 090304TR-ME06 T15M	240	215	200	-
	14-15 Harder cast iron and nodular irons	XOMX 090304TR-ME06 T15M	175	160	150	-
		090304TR-ME06 T20M	165	150	140	-
Other materials	16-17 Aluminium and other non-ferrous	XOMX 090304TR-ME06 F40M	750	700	650	600
		XOMX 090308TR-ME06 F40M	750	700	650	600
	20, 22 Superalloys and titanium-based alloys	XOMX 090304TR-ME06 T25M	65	55	-	-

Milling cutters



Other square shoulder milling cutters



Application		Part No.	Ordering and Product No.	Dimensions in mm						Mounting type	KG		
				D	d	L	L ₁	M	a _p				
		R217.69-2020.0-13	75033994	20	20	150	115	-	12	Cylindrical	0,4	2	XC..13T3..
		-2525.0-13	75033995	25	25	165	130	-	12	Cylindrical	0,7	3	XC..13T3..
		-3232.0-13	75033996	32	32	195	155	-	12	Cylindrical	1,3	4	XC..13T3..
		R217.69-03020-13	75001807	20	-	126	45	M12	12	Morse No. 3	0,3	2	XC..13T3..
		-03025-13	75001809	25	-	126	45	M12	12	Morse No. 3	0,3	3	XC..13T3..
		-03032-13	75001821	32	-	126	45	M12	12	Morse No. 3	0,4	4	XC..13T3..

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R217.69-2020.0-13	C03007	T09-3
-2525.0-13	C03007	T09-3
-3232.0-13	C03007	T09-3
R217.69-03020-13	C03007	T09-3
-03025-13	C03007	T09-3
-03032-13	C03007	T09-3

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↓ Protected	XCEX	XCEX 13T304FR-E06 HX	74095065								
	XCKX	XCKX 13T304R-ME10 F40M	74079755	●		●					
		XCKX 13T304R-ME10 S25M	74028699	●		●					
		13T304R-ME10 T25M	74028698	●		●					●
		XCKX 13T308R-ME10 F40M	74079756	●		●					
		13T308R-ME10 T25M	74037215	●		●					
	XCMX	XCMX 13T308TR-M11 T15M	74034344					●	●		
		13T308TR-M11 T20M	74034345		●				●		
		13T308TR-M11 T25M	74016924		●	●					

The insert programme also includes inserts with nose radii 1.6, 2.0 and 3.0 mm.

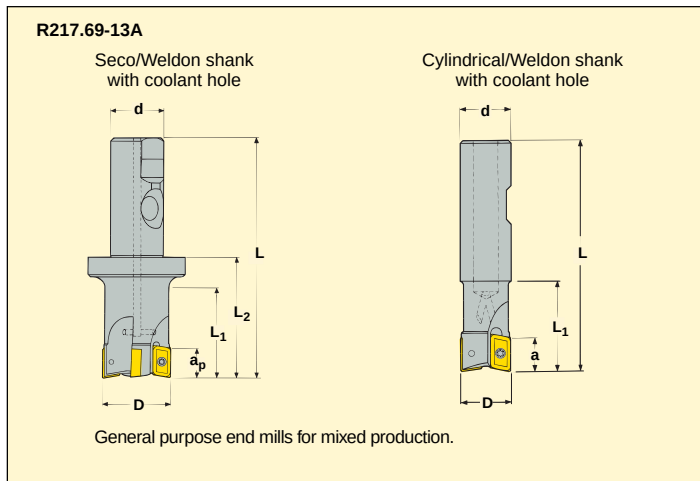
● = first choice

Cutting data

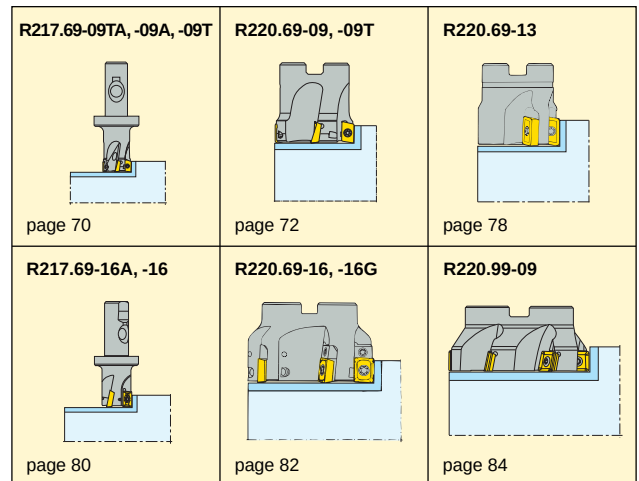


Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,08	0,12	0,16	
Steel	1-4 Easy-cutting and ordinary steels	XCKX 13T304R-ME10 F40M	180	165	150	
		13T304R-ME10 S25M	160	145	135	
		13T304R-ME10 T25M	195	175	160	
		13T308R-ME10 F40M	180	165	150	
		13T308R-ME10 T25M	195	175	160	
	5-6 Harder steels	XCMX 13T308TR-M11 T20M	140	125	-	
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	XCKX 13T304R-ME10 F40M	190	170	155	
		13T304R-ME10 S25M	190	175	165	
		13T304R-ME10 T25M	200	180	170	
		13T308R-ME10 F40M	190	170	155	
		13T308R-ME10 T25M	200	180	170	
	10 Stainless steels difficult to machine	XCMX 13T308TR-M11 T25M	160	145	135	
Cast iron	12-13 Easy-cutting and ordinary cast iron	XCMX 13T308TR-M11 T15M	205	185	170	
	14-15 Harder cast iron and nodular irons	XCMX 13T308TR-M11 T15M	150	135	-	
		13T308TR-M11 T20M	140	125	-	
Other materials	16-17 Aluminium and other non-ferrous	XCEX 13T304FR-E06 HX	650	600	500	
	20, 22 Superalloys and titanium-based alloys	XCKX 13T304R-ME10 T25M	60	55	-	

Milling cutters



Other square shoulder milling cutters



Application		Part No.	Ordering and Product No.	Dimensions in mm							Mounting type	KG		
				D	d	L	L ₁	L ₂	a _p					
R217.69-13A 		R217.69-2025.3S-13A	75001804	25	20	100	36	50	12		Seco/Weldon	0,4	3	XC..13T3..
		-2532.3S-13A	75001805	32	25	111	41	55	12		Seco/Weldon	0,6	4	XC..13T3..
		R217.69-2020.3-13A	75027956	20	20	90	40	-	12		Cyl/Weldon	0,3	2	XC..13T3..
		-2525.3-13A	75033984	25	25	101	40	-	12		Cyl/Weldon	0,4	3	XC..13T3..

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R217.69-2025.3S-13A	C03007	T09-3
-2532.3S-13A	C03007	T09-3
R217.69-2020.3-13A	C03007	T09-3
-2525.3-13A	C03007	T09-3

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↓ Protected	XCEX	XCEX 13T304FR-E06 HX	74095065								
	XCKX	XCKX 13T304R-ME10 F40M	74079755	●		●					
		XCKX 13T304R-ME10 S25M	74028699	●		●					
		XCKX 13T304R-ME10 T25M	74028698	●		●					●
		XCKX 13T308R-ME10 F40M	74079756	●		●					
	XCMX	13T308R-ME10 T25M	74037215	●		●					
		XCMX 13T308TR-M11 T15M	74034344					●	●		
		13T308TR-M11 T20M	74034345		●				●		
		13T308TR-M11 T25M	74016924		●	●					

The insert programme also includes inserts with nose radii 1.6, 2.0 and 3.0 mm.

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,08	0,12	0,16	
Steel	1-4 Easy-cutting and ordinary steels	XCKX 13T304R-ME10 F40M	180	165	150	
		13T304R-ME10 S25M	160	145	135	
		13T304R-ME10 T25M	195	175	160	
		13T308R-ME10 F40M	180	165	150	
		13T308R-ME10 T25M	195	175	160	
	5-6 Harder steels	XCMX 13T308TR-M11 T20M	140	125	-	
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	XCKX 13T304R-ME10 F40M	190	170	155	
		13T304R-ME10 S25M	190	175	165	
		13T304R-ME10 T25M	200	180	170	
		13T308R-ME10 F40M	190	170	155	
		13T308R-ME10 T25M	200	180	170	
	10 Stainless steels difficult to machine	XCMX 13T308TR-M11 T25M	160	145	135	
Cast iron	12-13 Easy-cutting and ordinary cast iron	XCMX 13T308TR-M11 T15M	205	185	170	
	14-15 Harder cast iron and nodular irons	XCMX 13T308TR-M11 T15M	150	135	-	
		13T308TR-M11 T20M	140	125	-	
Other materials	16-17 Aluminium and other non-ferrous	XCEX 13T304FR-E06 HX	650	600	500	
	20, 22 Superalloys and titanium-based alloys	XCKX 13T304R-ME10 T25M	60	55	-	

Milling cutters

R220.69-13

General purpose square shoulder mills for mixed production.

Other square shoulder milling cutters

R217.69-09TA, -09A, -09T page 70	R220.69-09, -09T page 72	R217.69-13, -13A page 74,76
R217.69-16A, -16 page 80	R220.69-16, -16G page 82	R220.99-09 page 84

Application		Part No.	Ordering and Product No.	Dimensions in mm			KG		
				D	H	ap			
R220.69-13 		R220.69-0040-13	75001824	40	40	12	0,2	4	XC..13T3..
		-0050-13	75001825	50	40	12	0,3	5	XC..13T3..

Dimensions of mounting

	Dimensions in mm				For arbor
	D	d	p	q	
	40	16	8,4	5,6	16
	50	22	10,4	6,3	22

Spare parts, included in delivery

	Locking screw/ Key*		Arbor screw
For cutter			
R220.69-0040-13	C03007	T09-3	220.17-690
-0050-13	C03007	T09-3	220.17-692

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↓ Protected	XCEX	XCEX 13T304FR-E06 HX	74095065								
	XCKX	XCKX 13T304R-ME10 F40M	74079755	●		●					
		XCKX 13T304R-ME10 S25M	74028699	●		●					
		13T304R-ME10 T25M	74028698	●		●					●
		XCKX 13T308R-ME10 F40M	74079756	●		●					
		13T308R-ME10 T25M	74037215	●		●					
	XCMX	XCMX 13T308TR-M11 T15M	74034344					●	●		
		13T308TR-M11 T20M	74034345		●				●		
		13T308TR-M11 T25M	74016924		●	●					

The insert programme also includes inserts with nose radii 1.6, 2.0 and 3.0 mm.

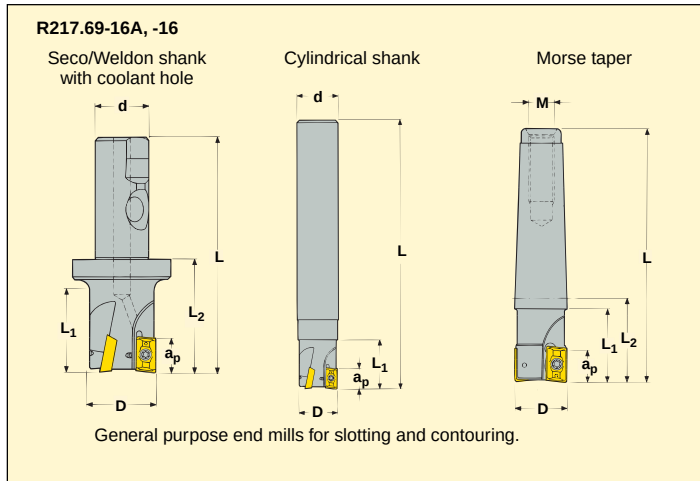
● = first choice

Cutting data

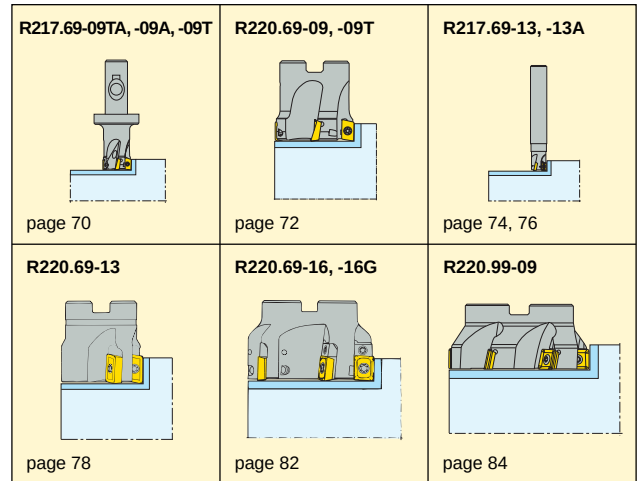


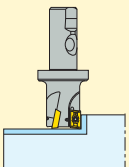
Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,08	0,12	0,16	
Steel	1-4 Easy-cutting and ordinary steels	XCKX 13T304R-ME10 F40M	180	165	150	
		13T304R-ME10 S25M	160	145	135	
		13T304R-ME10 T25M	195	175	160	
		13T308R-ME10 F40M	180	165	150	
		13T308R-ME10 T25M	195	175	160	
	5-6 Harder steels	XCMX 13T308TR-M11 T20M	140	125	-	
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	XCKX 13T304R-ME10 F40M	190	170	155	
		13T304R-ME10 S25M	190	175	165	
		13T304R-ME10 T25M	200	180	170	
		13T308R-ME10 F40M	190	170	155	
		13T308R-ME10 T25M	200	180	170	
	10 Stainless steels difficult to machine	XCMX 13T308TR-M11 T25M	160	145	135	
Cast iron	12-13 Easy-cutting and ordinary cast iron	XCMX 13T308TR-M11 T15M	205	185	170	
	14-15 Harder cast iron and nodular irons	XCMX 13T308TR-M11 T15M	150	135	-	
		13T308TR-M11 T20M	140	125	-	
Other materials	16-17 Aluminium and other non-ferrous	XCEX 13T304FR-E06 HX	650	600	500	
	20, 22 Superalloys and titanium-based alloys	XCKX 13T304R-ME10 T25M	60	55	-	

Milling cutters



Other square shoulder milling cutters



Application		Part No.	Ordering and Product No.	Dimensions in mm										Mounting type	
				D	d	L	L ₁	L ₂	M	a _p					
															
		R217.69-2025.3S-16A	75034527	25	20	100	35	50	-	15	0,3	2	Seco/Weldon	AP..1604..	
		-2532.3S-16A	75034528	32	25	111	40	55	-	15	0,6	3	Seco/Weldon	AP..1604..	
		R217.69-2525.0-16	75034359	25	25	165	120	-	-	15	0,3	2	Cylindrical	AP..1604..	
		-3232.0-16	75034360	32	32	195	160	-	-	15	0,6	3	Cylindrical	AP..1604..	
		R217.69-03025-16	75012513	25	-	121	39	40	M12	15	0,4	2	Morse No. 3	AP..1604..	
	-03032-16	75012514	32	-	126	40	45	M12	15	0,6	3	Morse No. 3	AP..1604..		

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R217.69-2025.3S-16A	C04008	T15-3
-2532.3S-16A	C04011	T15-3
R217.69-2525.0-16	C04008	T15-3
-3232.0-16	C04011	T15-3
R217.69-03025-16	C04008	T15-3
-03032-16	C04011	T15-3

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy	
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15			
Sharp ↑ ↓ Protected	APEX APKX APKT ME14 M14 APFT D15	APEX 160408FR-E07 HX	74095073									
		APKX 1604PDR-ME11 T25M	00078987	●		●					●	
		APKX 1604PDR-ME12 F40M	74069376	●		●						
		1604PDR-ME12 S25M	74000324	●								
		1604PDR-ME12 T25M	74000323	●		●						●
		APKT 1604PDTR-ME14 S25M	74003669	●								
		1604PDTR-ME14 T15M	74036743					●	●			
		1604PDTR-ME14 T25M	74003671	●								
		APKT 1604PDTR-M14 T25M	74017003		●							
		APFT 1604PDTR-D15 S25M	74016338		●							
		1604PDTR-D15 T20M	74034138		●					●		
		1604PDTR-D15 T25M	74016415		●		●					

The insert programme also includes inserts with nose radii 1.6, 2.4, 3.0, 4.0, 4.8 and 6.0 mm.

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,10	0,15	0,20	
Steel	1-4 Easy-cutting and ordinary steels	APKX 1604PDR-ME11 T25M	180	160	145	
		1604PDR-ME12 F40M	170	150	140	
		1604PDR-ME12 S25M	150	135	120	
		1604PDR-ME12 T25M	180	160	145	
		APKT 1604PDTR-ME14 S25M	150	135	120	
		1604PDTR-ME14 T25M	180	160	145	
	5-6 Harder steels	APKT 1604PDTR-M14 T25M	105	95	85	
		APFT 1604PDTR-D15 S25M	85	75	70	
		1604PDTR-D15 T20M	125	110	-	
		1604PDTR-D15 T25M	105	95	85	
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	APKX 1604PDR-ME11 T25M	185	165	150	
		1604PDR-ME12 F40M	175	160	145	
		1604PDR-ME12 T25M	185	165	150	
	10 Stainless steels difficult to machine	APFT 1604PDTR-D15 T25M	140	125	115	
Cast iron	12-13 Easy-cutting and ordinary cast iron	APKT 1604PDTR-ME14 T15M	165	150	135	
	14-15 Harder cast iron and nodular irons	APKT 1604PDTR-ME14 T15M	130	120	110	
		APFT 1604PDTR-D15 T20M	125	110	-	
Other materials	16-17 Aluminium and other non-ferrous	APEX 160408FR-E07 HX	700	650	600	
	20, 22 Superalloys and titanium-based alloys	APKX 1604PDR-ME12 T25M	50	45	-	

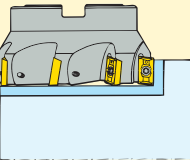
Milling cutters

R220.69-16, -16G

General purpose square shoulder mills for mixed production.

Other square shoulder milling cutters

R217.69-09TA, -09A, -09T page 70	R220.69-09, -09T page 72	R217.69-13, -13A page 74,76
R220.69-13 page 78	R217.69-16A, -16 page 80	R220.99-09 page 84

Application	Part No.	Ordering and Product No.	Dimensions in mm					
			D	H	a _p			
								
	Normal pitch							
	R220.69-0040-16	75012028	40	40	15	0,3	4	AP..1604..
	-0050-16	75011925	50	40	15	0,4	5	AP..1604..
	Coarse pitch							
	R220.69-0063-16G	75012463	63	40	15	0,7	4	AP..1604..
	-0080-16G	75012565	80	50	15	0,9	6	AP..1604..
	-0100-16G	75012566	100	50	15	1,7	6	AP..1604..
	-0125-16G	75012804	125	63	15	2,8	6	AP..1604..

Dimensions of mounting

	Dimensions in mm				For arbor
	D	d	p	q	
	40	16	8,4	5,6	16
	50	22	10,4	6,3	22
	63	22	10,4	6,3	22
	80	27	12,4	7	27
	100	32	14,4	8	32
	125	40	16,4	9	40

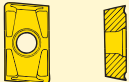
Spare parts, included in delivery

For cutter	Locking screw/ Key*		Arbor screw
R220.69-0040-16	C04011	T15-3	220.17-690
-0050-16	C04011	T15-3	220.17-692
R220.69-0063-16G	C04011	T15-3	220.17-692
-0080-16G	C04011	T15-3	-
-0100-16G	C04011	T15-3	-
-0125-16G	C04011	T15-3	-

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stain-less steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy	
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15			
Sharp ↑ ↓ Protected	APEX											
			APKX									
	APKT			APEX 160408FR-E07 HX	74095073						●	
				APKX 1604PDR-ME11 T25M	00078987	●		●				
				APKX 1604PDR-ME12 F40M	74069376	●		●				
				1604PDR-ME12 S25M	74000324	●						
			1604PDR-ME12 T25M	74000323	●		●				●	
	ME14			APKT 1604PDTR-ME14 S25M	74003669	●						
				1604PDTR-ME14 T15M	74036743				●	●		
				1604PDTR-ME14 T25M	74003671	●						
	APFT			APKT 1604PDTR-M14 T25M	74017003		●					
				APFT 1604PDTR-D15 S25M	74016338		●					
				1604PDTR-D15 T20M	74034138		●				●	
1604PDTR-D15 T25M				74016415		●		●				

The insert programme also includes inserts with nose radii 1.6, 2.4, 3.0, 4.0, 4.8 and 6.0 mm.

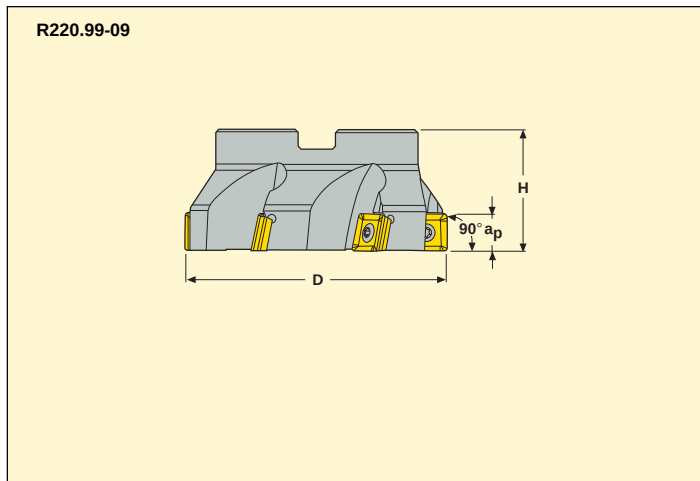
● = first choice

Cutting data

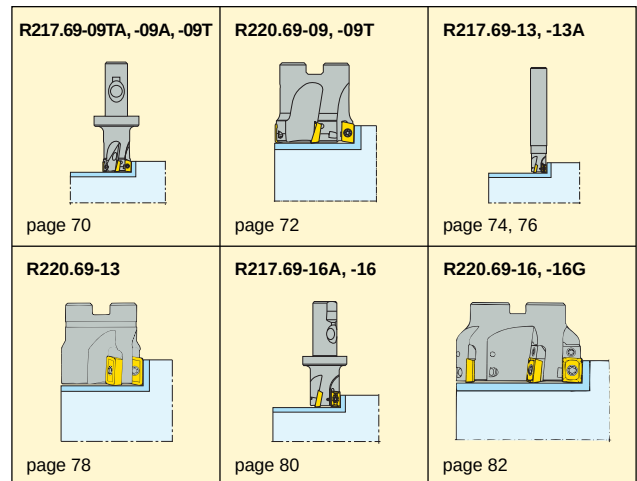


Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,10	0,15	0,20	
Steel	1-4 Easy-cutting and ordinary steels	APKX 1604PDR-ME11 T25M	180	160	145	
		1604PDR-ME12 F40M	170	150	140	
		1604PDR-ME12 S25M	150	135	120	
		1604PDR-ME12 T25M	180	160	145	
		APKT 1604PDTR-ME14 S25M	150	135	120	
		1604PDTR-ME14 T25M	180	160	145	
	5-6 Harder steels	APKT 1604PDTR-M14 T25M	105	95	85	
		APFT 1604PDTR-D15 S25M	85	75	70	
		1604PDTR-D15 T20M	125	110	-	
		1604PDTR-D15 T25M	105	95	85	
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	APKX 1604PDR-ME11 T25M	185	165	150	
		1604PDR-ME12 F40M	175	160	145	
		1604PDR-ME12 T25M	185	165	150	
	10 Stainless steels difficult to machine	APFT 1604PDTR-D15 T25M	140	125	115	
Cast iron	12-13 Easy-cutting and ordinary cast iron	APKT 1604PDTR-ME14 T15M	165	150	135	
	14-15 Harder cast iron and nodular irons	APKT 1604PDTR-ME14 T15M	130	120	110	
		APFT 1604PDTR-D15 T20M	125	110	-	
Other materials	16-17 Aluminium and other non-ferrous	APEX 160408FR-E07 HX	700	650	600	
	20, 22 Superalloys and titanium-based alloys	APKX 1604PDR-ME12 T25M	50	45	-	

Milling cutters



Other square shoulder milling cutters



Application	Part No.	Ordering and Product No.	Dimensions in mm			KG		
			D	H	ap			
R220.99-09	R220.99-0040-09-3	75069189	40	40	8	0,3	3	SONX09T3..
	-0050-09-4	75069191	50	40	8	0,4	4	SONX09T3..
	-0063-09-4	75069193	63	40	8	0,6	4	SONX09T3..
	-0080-09-6	75069195	80	50	8	1,3	6	SONX09T3..

Dimensions of mounting

	Dimensions in mm				For arbor
	D	d	p	q	
	40	16	8,4	5,6	16
	50	22	10,4	6,3	22
	63	22	10,4	6,3	22
	80	27	12,4	7	27

Spare parts, included in delivery

For cutter	Locking screw/ Key*		Arbor screw
R220.99-0040-09-3	C03006	T09-3	MC6S 8x30
-0050-09-4	C03006	T09-3	220.17-692
-0063-09-4	C03006	T09-3	220.17-692
-0080-09-6	C03006	T09-3	MC6S 12x40

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
	SONX	SONX 09T304TR-M10 F40M	74066086	●		●	●			●	
		09T304TR-M10 T15M	74066084					●			
		09T304TR-M10 T20M	74066085		●			●	●		
		09T304TR-M10 T25M	74066082	●		●					●

● = first choice

Cutting data

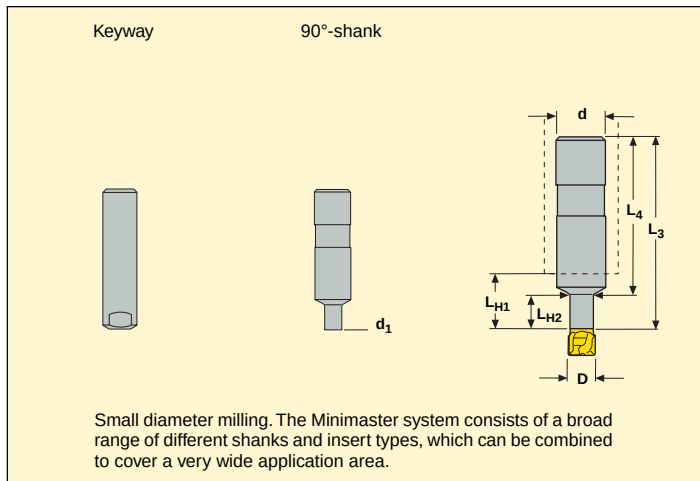


Universal insert for machining steels and stainless steel.

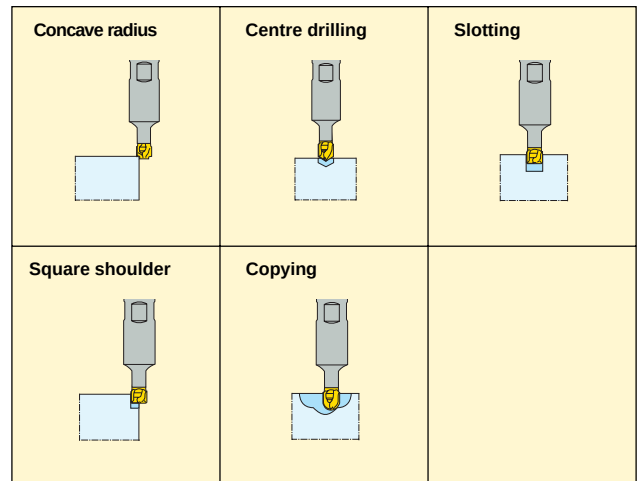
SONX 09T304TR-M10 T25M

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,12	0,18	
Steel	1-4 Easy-cutting and ordinary steels	SONX 09T304TR-M10 F40M	180	155	135	
		09T304TR-M10 T25M	200	170	150	
	5-6 Harder steels	SONX 09T304TR-M10 T20M	155	130	115	
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	SONX 09T304TR-M10 F40M	190	160	140	
		09T304TR-M10 T25M	205	175	155	
	10 Stainless steels difficult to machine	SONX 09T304TR-M10 F40M	160	135	120	
Cast iron	12-13 Easy-cutting and ordinary cast iron	SONX 09T304TR-M10 T15M	225	190	170	
		09T304TR-M10 T20M	210	175	155	
	14-15 Harder cast iron and nodular irons	SONX 09T304TR-M10 T20M	155	130	-	
Other materials	16-17 Aluminium and other non-ferrous	SONX 09T304TR-M10 F40M	730	615	545	
	20, 22 Superalloys and titanium-based alloys	SONX 09T304TR-M10 T25M	60	50	-	

Holders



Applications



		Ordering and Product No.	Dimensions in mm							K*			
	Part No.		D	d	d ₁	L _{H1}	L _{H2}	L ₃	L ₄				
	Keyway												
	MM06-12065.0	75080694	6	12	12	5	-	65	65	2	0,1	1	MM06-
	MM08-12065.0	75034240	8	12	12	17	-	65	65	2	0,1	1	MM08-
	MM10-16065.0	75004925	10	16	16	17	-	65	65	2	0,1	1	MM10-
	MM12-16065.0	75004926	12	16	16	15,3	-	65	65	2	0,1	1	MM12-
	MM16-20070.0	00023548	16	20	20	5	-	70	70	2	0,2	1	MM16-
	90°-shank												
	MM06-12070.3	75080695	6	12	5,7	25	5	70	61	2	0,1	1	MM06-
	MM08-16070.3	75034241	8	16	7,6	22	5	70	65	2	0,1	1	MM08-
	MM10-20075.3	75012787	10	20	9,5	25	10	75	65	2	0,2	1	MM10-
	MM12-20080.3	75012864	12	20	11,4	28	10	80	68	2	0,2	1	MM12-
	MM16-25100.3	75012790	16	25	15,2	40	19	100	81	2	0,3	1	MM16-

Minimaster holders are also available in high density, anti-vibration material.

* Effective number of teeth

Spare parts, included in delivery

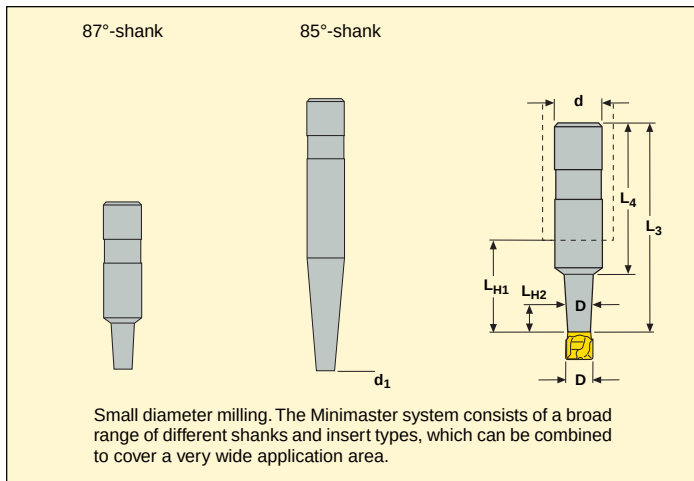
	Tension screw	Sleeve	Allen key*	Wrench**
For cutter				
MM06-12065.0	MM06-03518	MM-035046	H05-4	MM0612
MM08-12065.0	MM08-0524	MM-05044	5 SMS795	MM0812
MM10-16065.0	MM10-0627	MM-06032	6 SMS795	MM0812
MM12-16065.0	MM12-0637	MM-06032	6 SMS795	MM0812***
MM16-20070.0	MM16-1045	MM-10030	8 SMS795	MM1420
MM06-12070.3	MM06-03518	MM-035046	H05-4	MM0612
MM08-16070.3	MM08-0524	MM-05044	5 SMS795	MM0812
MM10-20075.3	MM10-0627	MM-06048	6 SMS795	MM0812
MM12-20080.3	MM12-0637	MM-06048	6 SMS795	MM0812***
MM16-25100.3	MM16-1045	MM-10062	8 SMS795	MM1420

Extract from Seco Milling Catalogue.
Cutting data, see page 89

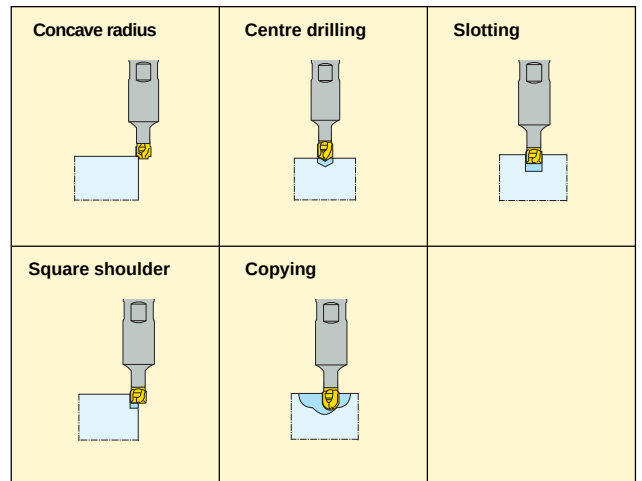
** To be ordered separately
*** For 3-flute Minimaster key MM10-08 should be used, all keys to be ordered separately

*** For insert MM12-14XXX key MM1420 should be used

Holders



Applications



		Ordering and Product No.	Dimensions in mm										
	Part No.		D	d	d ₁	L _{H1}	L _{H2}	L ₃	L ₄	K*			
	87°-shank												
	MM06-16075.3	75080696	6	16	5,7	27	2,86	75	61	2	0,1	1	MM06-
	MM08-16075.3	75034242	8	16	7,6	27	3,8	75	63	2	0,1	1	MM08-
	MM10-20085.3	75012788	10	20	9,5	35	4,8	85	62	2	0,1	1	MM10-
	MM12-20095.3	75012865	12	20	11,4	43	3,7	95	68	2	0,2	1	MM12-
	MM16-25115.3	75012791	16	25	15,2	59	7,6	115	80	2	0,3	1	MM16-
	85°-shank												
	MM06-16110.3	75080697	6	16	5,7	62	1,7	110	51	2		1	MM06-
	MM08-16120.3	75034243	8	16	7,6	72	2,3	120	72	2	0,1	1	MM08-
	MM10-20140.3	75012789	10	20	9,5	90	2,8	140	80	2	0,3	1	MM10-
	MM12-20150.3	75012866	12	20	11,4	99,7	3,4	150	101	2	0,3	1	MM12-
	MM16-25170.3	75012792	16	25	15,2	114	4,5	170	114	2	0,4	1	MM16-

Minimaster holders are also available in high density, anti-vibration material.

* Effective number of teeth

Spare parts, included in delivery

	Tension screw	Sleeve	Allen key*	Wrench**	
For cutter					
MM06-16075.3	MM06-03518	MM-035046	H05-4	MM0612	
MM08-16075.3	MM08-0524	MM-05044	5 SMS795	MM0812	
MM10-20085.3	MM10-0627	MM-06048	6 SMS795	MM0812	
MM12-20095.3	MM12-0637	MM-06048	6 SMS795	MM0812***	
MM16-25115.3	MM16-1045	MM-10062	8 SMS795	MM1420	
MM06-16110.3	MM06-03518	MM-035091	H05-4	MM0612	
MM08-16120.3	MM08-0524	MM-05090	H05-7L	MM0812	
MM10-20140.3	MM10-0627	MM-06116	6 SMS795	MM0812	
MM12-20150.3	MM12-0637	MM-06116	6 SMS795	MM0812***	
MM16-25170.3	MM16-1045	MM-10132	8 SMS795	MM1420	

Extract from Seco Milling Catalogue.
Cutting data, see page 89

** To be ordered separately
** For 3-flute Minimaster key MM10-08 should be used, all keys to be ordered separately

*** For insert MM12-14XXX key MM1420 should be used

Inserts

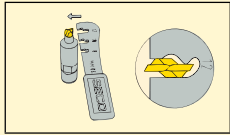
Insert types	Ø	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Slotting/Square shoulder milling MM MM-R MM-R/A8 Easy-cutting	6	MM06-06004-M02 T60M	74080703	●	●	●		●	●	●	
	8	MM08-08005-M03 T60M	74034247	●	●	●		●	●	●	
	10	MM10-10007-M03 T60M	74018865	●	●	●		●	●	●	
	12	MM12-12008-M04 T60M	74017029	●	●	●		●	●	●	
	14	-14009-M04 T60M	74017132	●	●	●		●	●	●	
	16	MM16-16011-M06 T60M	74017035	●	●	●		●	●	●	
	6	MM06-06004-R04-MD02 T60M	74080704	●	●	●		●	●	●	●
	8	MM08-08005-R04-MD03 T60M	74034248	●	●	●		●	●	●	●
	10	MM10-10007-R04-MD04 T60M	74017027	●	●	●		●	●	●	●
	12	MM12-12008-R08-MD05 T60M	74017031	●	●	●		●	●	●	●
	14	-14009-R08-MD05 T60M	74017130	●	●	●		●	●	●	●
	16	MM16-16011-R08-MD07 T60M	74017037	●	●	●		●	●	●	●
	8	MM08-08005-R04A8-E03 T60M	74034549	●	●	●		●	●	●	●
	10	MM10-10007-R04A8-E03 T60M	74034551	●	●	●		●	●	●	●
	12	MM12-12008-R08A8-E04 T60M	74034552	●	●	●		●	●	●	●
	14	-14009-R08A8-E04 T60M	74034553	●	●	●		●	●	●	●
	16	MM16-16011-R08A8-E06 T60M	74034554	●	●	●		●	●	●	●
Centre drilling MM-C90 90° MM-C120 120°		90° angle									
	6	MM06-06003-C90-M02 T60M	74080706	●	●	●		●	●	●	
	8	MM08-08004-C90-M03 T60M	74034245	●	●	●		●	●	●	
	10	MM10-10005-C90-M03 T60M	74001394	●	●	●		●	●	●	
	12	MM12-12006-C90-M04 T60M	74034542	●	●	●		●	●	●	
	16	MM16-16008-C90-M06 T60M	74004538	●	●	●		●	●	●	
		120° angle									
	6	MM06-06003-C120-M02 T60M	74080707	●	●	●		●	●	●	
	8	MM08-08006-C120-M03 T60M	74034249	●	●	●		●	●	●	
	10	MM10-10007-C120-M03 T60M	74004537	●	●	●		●	●	●	
	16	MM16-16011-C120-M06 T60M	74004991	●	●	●		●	●	●	
Concave radius MM-CR 	12	MM12-12010-CR10-MD05 T60M	74034555	●	●	●	●	●	●	●	
	12	MM12-12010-CR20-MD05 T60M	74034556	●	●	●	●	●	●	●	
	12	MM12-12010-CR30-MD05 T60M	74034557	●	●	●	●	●	●	●	
Copying MM-B90/B90P 90° MM-B120P 120°	6	MM06-06006-B90-MD02 F30M	74080708	●	●	●	●	●	●	●	●
	8	MM08-08008-B90-MD03 F30M	74068812	●	●	●	●	●	●	●	●
	10	MM10-10010-B90-MD04 F30M	74068362	●	●	●	●	●	●	●	●
	12	MM12-12012-B90-MD05 F30M	74068363	●	●	●	●	●	●	●	●
	14	-14014-B90-MD05 F30M	74066369	●	●	●	●	●	●	●	●
	16	MM16-16016-B90-MD07 F30M	74068814	●	●	●	●	●	●	●	●
	20	-20020-B90-MD07 F30M	74066370	●	●	●	●	●	●	●	●
	6	MM06-06006-B90P-M02 F30M	74080709	●	●	●	●	●	●	●	●
	8	MM08-08008-B90P-M03 F30M	74068813	●	●	●	●	●	●	●	●
	10	MM10-10010-B90P-M04 F30M	74068357	●	●	●	●	●	●	●	●
	12	MM12-12012-B90P-M05 F30M	74068358	●	●	●	●	●	●	●	●
	14	-14014-B90P-M05 F30M	74068359	●	●	●	●	●	●	●	●
	16	MM16-16016-B90P-M07 F30M	74068365	●	●	●	●	●	●	●	●
	20	-20020-B90P-M07 F30M	74068360	●	●	●	●	●	●	●	●
	6	MM06-08008-B120P-M03 F30M	00083494	●	●	●	●	●	●	●	●
	8	MM08-10010-B120P-M04 F30M	00083493	●	●	●	●	●	●	●	●
	10	MM10-12012-B120P-M05 F30M	00083492	●	●	●	●	●	●	●	●
	12	MM12-14014-B120P-M05 F30M	00083491	●	●	●	●	●	●	●	●
	12	MM12-16016-B120P-M07 F30M	00091006	●	●	●	●	●	●	●	●
	16	MM16-20020-B120P-M07 F30M	00083490	●	●	●	●	●	●	●	●
Slotting/Square shoulder, 3-flute MM-R/A30 K-value = 3	10	MM10-10012-R05A30-E03 F40M	00094843	●	●	●	●	●	●	●	●
	10	-10012-R10A30-E03 F40M	00005902	●	●	●	●	●	●	●	●

● = first choice

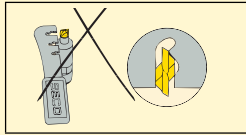
Code key Minimaster inserts Cutting data, full engagement width ($a_e/D = 100\%$)

Ex. MM10 - 100 07 - R04 - MD04	Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
				Feed mm/tooth			
				0,02	0,03	0,05	0,10
MM10 = Taper size 10 mm	Steel	1–4 Easy-cutting and ordinary steels	MM06 - MM16 T60M	140	135	120	105
100 = Diameter 10,0 mm			MM06 - MM16 F30M	175	165	150	130
07 = Cutting edge length approx. 7 mm (T = protection chamfer)			MM10 F40M	165	160	145	125
R04 = Corner radius 0,4 mm No designation in this position means sharp corners. ...A8 = 8° axial rake (easy cutting) B90 = Ballnose 90° (roughing) B90P = Ballnose 90° (semi-finishing, finishing) B120P = Ballnose 120° (semi-finishing, finishing) C90, C120 = Centre drill 90°, 120° CRxx = Concave radius (convex radius on component) 10 = 1,0 mm radius 20 = 2,0 mm radius 30 = 3,0 mm radius ...A30 = 3-flute inserts with 30° helix angle, internal coolant holes		5–6 Harder steels	MM06 - MM16 T60M	95	90	80	70
			MM06 - MM16 F30M	115	110	100	85
			MM10 F40M	110	105	95	80
	Stainless steel	8–9 Easy-cutting and ordinary stainless steels	MM06 - MM16 T60M	145	140	125	110
			MM06 - MM16 F30M	180	170	155	135
			MM10 F40M	175	165	150	125
10 Stainless steels difficult to machine		MM06 - MM16 T60M	125	120	110	90	
		MM06 - MM16 F30M	155	145	135	115	
		MM10 F40M	150	140	125	110	
Cast iron	12–13 Easy-cutting and ordinary cast iron	MM06 - MM16 T60M	125	120	110	90	
		MM06 - MM16 F30M	155	145	135	115	
		MM10 F40M	150	140	125	110	
	14–15 Harder cast iron and nodular irons	MM06 - MM16 T60M	95	90	80	70	
		MM06 - MM16 F30M	115	110	100	85	
		MM10 F40M	110	105	95	80	
Other materials	16–17 Aluminium and other non-ferrous	MM06 - MM16 T60M	600	550	500	400	
		MM06 - MM16 F30M	700	650	600	500	
		MM10 F40M	675	635	580	495	
	20, 22 Superalloys and titanium-based alloys	MM06 - MM16 T60M	45	40	40	30	
		MM06 - MM16 F30M	55	50	45	40	
		MM10 F40M	50	50	45	40	
MD04 = Edge geometry							

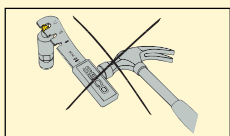
Mounting instruction for 2-flute Minimaster



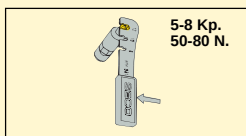
Make sure that the wrench is used correctly...



...if used on the wrong side, it will cause edge damage.



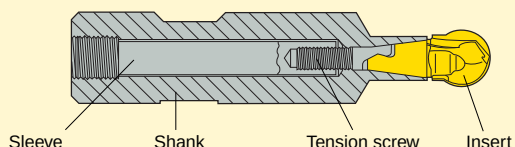
Do not use excessive force...



5-8 Kp.
50-80 N.

...normal hand-power is quite sufficient.

During normal operation inserts are exchanged using the Minimaster wrench.



Sleeve Shank Tension screw Insert

- The sleeve must be securely tightened in the shank before the tension screw and insert are fitted.
- If the wrench cannot be used for changing the insert (if the insert has broken off or jammed in the shank), the sleeve can be released, which will also release the insert.
- Use an allen key (turn it anti-clockwise) to back off the sleeve until the insert is free.
- Retighten the sleeve in the shank before fitting the tension screw and the new insert.

For 3-flute Minimaster another design of key must be used, see page 86 and 87

Milling cutters

R216.19

Cylindrical/Weldon shank

Drill-mill for multiple operations in mixed production. A versatile end mill for circular interpolation and helical interpolation ramping operations.

Other drilling end milling cutters

R217.69-09TA, -09A, -09T page 70	R217.69-13, -13A page 74, 76	R217.69-16A, 16 page 80
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Application		Part No.	Ordering and Product No.	Dimensions in mm					K*				
				D	d	L	L ₁	a _p					
R216.19		R216.19-2015.3-06	75002628	15	20	95	70	5	1	0,2	2	XCMX0502..(1)	SPMX0602..(1)
		-2018.3-06	75002629	18	20	100	75	5	1	0,2	2	CCMX0602..(1)	SPMX0602..(1)
		R216.19-2020.3-08	75002630	20	20	120	85	7	1	0,3	2	CCMX0803..(1)	SPMX0602..(1)
		R216.19-2525.3-09	75002632	25	25	130	90	8	1	0,4	2	CCMX09T3..(1)	SPMX0903..(1)
		R216.19-3232.3-12	75002634	32	32	130	90	11	1	0,7	2	CCMX1204..(1)	SPMX12T3..(1)

* Effective number of teeth.

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R216.19-2015.3-06	C02205	T07-3
-2018.3-06	C02205	T07-3
R216.19-2020.3-08	C02506, C02205	T07-3
R216.19-2525.3-09	C03007	T09-3
R216.19-3232.3-12	C03510	T15-3

Extract from Seco Milling Catalogue.

Inserts

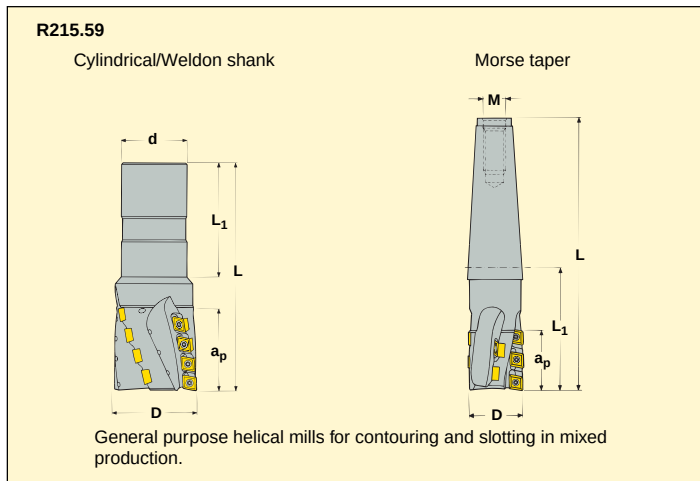
Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
XCMX 	XCMX 050204T-MD05 S60M	74016101	●	●	●	●	●	●	●	
CCMX 	CCMX 060204T-MD06 T25M	74016187	●	●	●	●	●	●	●	
	080308T-MD07 T25M	74016201	●	●	●	●	●	●	●	
	09T308T-MD09 T25M	74016188	●	●	●	●	●	●	●	
	120412T-MD11 T25M	74016200	●	●	●	●	●	●	●	
SPMX  -75 AP-75	SPMX 060204-75 T25M	74016733	●	●	●	●	●	●	●	
	0602AP-75 S60M	74016155	●	●	●	●	●	●	●	
	0602AP-75 T25M	74016162	●	●	●	●	●	●	●	
	090304-75 T25M	74016731	●	●	●	●	●	●	●	
	0903AP-75 T25M	74016175	●	●	●	●	●	●	●	
	12T3AP-75 T25M	74016176	●	●	●	●	●	●	●	

● = first choice

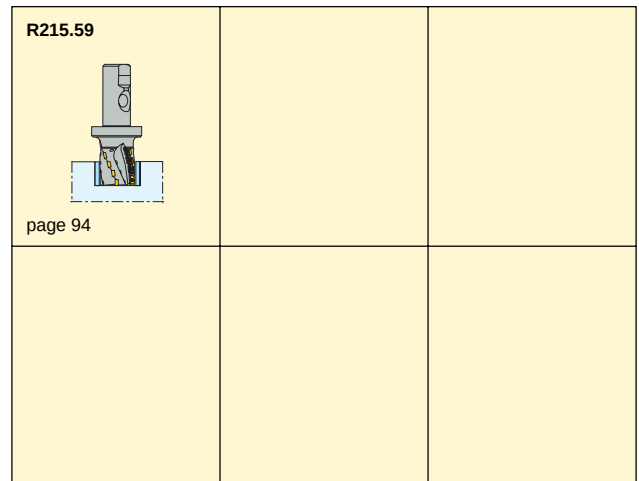
Cutting data

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,04	0,07	0,10	0,14
Steel	1-4 Easy-cutting and ordinary steels	XCMX 050204T-MD05 S60M	140	125	115	105
		CCMX 060204T-MD06 T25M	195	170	155	145
		080308T-MD07 T25M	195	170	155	145
		09T308T-MD09 T25M	195	170	155	145
		120412T-MD11 T25M	195	170	155	145
	5-6 Harder steels	XCMX 050204T-MD05 S60M	90	80	75	70
		CCMX 060204T-MD06 T25M	125	110	105	95
		080308T-MD07 T25M	125	110	105	95
		09T308T-MD09 T25M	125	110	105	95
		120412T-MD11 T25M	125	110	105	95
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	XCMX 050204T-MD05 S60M	165	150	135	125
		CCMX 060204T-MD06 T25M	200	180	165	150
		080308T-MD07 T25M	200	180	165	150
		09T308T-MD09 T25M	200	180	165	150
		120412T-MD11 T25M	200	180	165	150
	10 Stainless steels difficult to machine	XCMX 050204T-MD05 S60M	125	110	100	90
		CCMX 060204T-MD06 T25M	170	150	140	125
		080308T-MD07 T25M	170	150	140	125
		09T308T-MD09 T25M	170	150	140	125
		120412T-MD11 T25M	170	150	140	125
Cast iron	12-13 Easy-cutting and ordinary cast iron	XCMX 050204T-MD05 S60M	125	110	100	90
		CCMX 060204T-MD06 T25M	170	150	140	125
		080308T-MD07 T25M	170	150	140	125
		09T308T-MD09 T25M	170	150	140	125
		120412T-MD11 T25M	170	150	140	125
	14-15 Harder cast iron and nodular irons	XCMX 050204T-MD05 S60M	90	80	75	70
		CCMX 060204T-MD06 T25M	125	110	100	90
		080308T-MD07 T25M	125	110	100	90
		09T308T-MD09 T25M	125	110	100	90
		120412T-MD11 T25M	125	110	100	90
Other materials	16-17 Aluminium and other non-ferrous	XCMX 050204T-MD05 S60M	550	500	450	400
		CCMX 060204T-MD06 T25M	800	700	650	600
		080308T-MD07 T25M	800	700	650	600
		09T308T-MD09 T25M	800	700	650	600
		120412T-MD11 T25M	800	700	650	600

Milling cutters



Other helical milling cutters



Application		Part No.	Ordering and Product No.	Dimensions in mm						K*	No. of flutes	Mounting type	KG
				D	d	L	L ₁	M	a _p				
		R215.59-2520.3.025-06	75002625	20	25	101	56	-	25	1,5	3	Cyl/Weldon	0,3
		-2525.3.025-06	75002626	25	25	106	56	-	25	2	4	Cyl/Weldon	0,4
		-3232.3-036-08	75012393	32	32	112	60	-	36	2	4	Cyl/Weldon	0,6
		R215.59-03020.025-06	75011764	20	-	121	40	M12	25	1,5	3	Morse No. 3	0,3
		-03025.025-06	75011765	25	-	136	55	M12	25	2	4	Morse No. 3	0,4
		-04032.036-08	75012916	32	-	168,5	66	M16	36	2	4	Morse No. 4	1,4

* Effective number of teeth

R215.59-2520.3.025-06	8	CCMX0603..
-2525.3.025-06	10	CCMX0603..
-3232.3-036-08	12	CCMX08T3..
R215.59-03020.025-06	8	CCMX0603..
-03025.025-06	10	CCMX0603..
-04032.036-08	12	CCMX08T3..

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R215.59-2520.3.025-06	C02507	T07-3
-2525.3.025-06	C02507	T07-3
-3232.3-036-08	C03007	T09-3
R215.59-03020.025-06	C02507	T07-3
-03025.025-06	C02507	T07-3
-04032.036-08	C03007	T09-3

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↑ ↓ Protected	CCMX 	CCMX 060304-E06 T25M	74016670	●		●		●		●	
		08T308-E07 T25M	74016671	●		●		●		●	
	CCMX 	CCMX 060304T-M07 T25M	74017053	●	●	●	●		●		
		08T308T-M08 T25M	74017040	●	●	●	●		●		

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,08	0,10	0,12
Steel	1-4 Easy-cutting and ordinary steels	CCMX 060304-E06 T25M	165	155	145	140
		08T308-E07 T25M	165	155	145	140
		060304T-M07 T25M	165	155	145	140
		08T308T-M08 T25M	165	155	145	140
	5-6 Harder steels	CCMX 060304T-M07 T25M	110	100	95	90
		08T308T-M08 T25M	110	100	95	90
Stainless steel	8-9 Easy-cutting and ordinary stainless steel	CCMX 060304-E06 T25M	170	160	155	145
		08T308-E07 T25M	170	160	155	145
		060304T-M07 T25M	170	160	155	145
		08T308T-M08 T25M	170	160	155	145
	10 Stainless steels difficult to machine	CCMX 060304T-M07 T25M	145	135	130	125
		08T308T-M08 T25M	145	135	130	125
Cast iron	12-13 Easy-cutting and ordinary cast iron	CCMX 060304-E06 T25M	145	135	130	125
		08T308-E07 T25M	145	135	130	125
	14-15 Harder cast iron and nodular irons	CCMX 060304T-M07 T25M	110	100	95	90
		08T308T-M08 T25M	110	100	95	90
Other materials	16-17 Aluminium and other non-ferrous	CCMX 060304-E06 T25M	700	650	600	550
		08T308-E07 T25M	700	650	600	550

Milling cutters

R215.59
Seco/Weldon shank with coolant hole

Morse taper

General purpose helical mills for contouring, slotting and plunging in mixed production equipped with strong XC-inserts in the end pockets.

Other helical milling cutters

R215.59

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Application		Part No.	Ordering and Product No.	Dimensions in mm						K*	No. of flutes	Mounting type	KG
				D	d	L	L ₁	M	a _p				
		R215.59-3239.3S.048-08.4A	75036487	39	32	140	80	-	48	2	4	Seco/Weldon	0,9
		R215.59-04039.048-08.4	75036486	39	-	178,5	76	M16	48	2	4	Morse No. 4	0,9

* Effective number of teeth

R215.59-3239.3S.048-08.4A	16	XC..13..(2)	CCMX08..(14)
R215.59-04039.048-08.4	16	XC..13..(2)	CCMX08..(14)

Spare parts, included in delivery

For cutter	Locking screw/ Key	
R215.59-3239.3S.048-08.4A	C03007	T09-3
R215.59-04039.048-08.4	C03007	T09-3

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↑ ↓ Protected	CCMX 	CCMX 08T308-E07 T25M	74016671	●		●		●		●	
	CCMX 	CCMX 08T308T-M08 T25M	74017040	●	●	●	●		●		
	XCMX 	XCMX 13T308TR-M11 T25M	74016924	●	●	●	●	●	●	●	

● = first choice

Cutting data



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,06	0,08	0,10	0,12
Steel	1-4 Lättskärande och allmänna stål	CCMX 08T308-E07 T25M	165	155	145	140
		08T308T-M08 T25M	165	155	145	140
	5-6 Harder steels	CCMX 08T308T-M08 T25M	110	100	95	90
Stainless steel	8-9 Easy-cutting and ordinary stainless steel	CCMX 08T308-E07 T25M	170	160	155	145
		08T308T-M08 T25M	170	160	155	145
	10 Stainless steels difficult to machine	CCMX 08T308T-M08 T25M	145	135	130	125
Cast iron	12-13 Easy-cutting and ordinary cast iron	CCMX 08T308-E07 T25M	145	135	130	125
	14-15 Harder cast iron and nodular irons	CCMX 08T308T-M08 T25M	110	100	95	90
Other materials	16-17 Aluminium and other non-ferrous	CCMX 08T308-E07 T25M	700	650	600	550

Milling cutters

R217.29

Other copy milling cutters

R217.29

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R220.29

page 100

R218.19

page 102

R218.19

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Application		Part No.	Ordering and Product No.	Dimensions in mm							
				D	A	d	L	L ₁	L ₂	L ₄	a _p
		R217.29-2004.0-06.090.1M	75077663	4	16	20	150	90	37	90	6
		R217.29-2508.0-06.140.1M	75077669	8	20	25	200	140	37	100	6

	Mounting type			
R217.29-2004.0-06.090.1M	Cylindrical	0,4	1	RPH.1204..
R217.29-2508.0-06.140.1M	Cylindrical	0,6	1	RPH.1204..

Spare parts, included in delivery

For cutter	Locking screw/ Key*	
R217.29-2004.0-06.090.1M	C03508	T15-3
R217.29-2508.0-06.140.1M	C03508	T15-3

Inserts

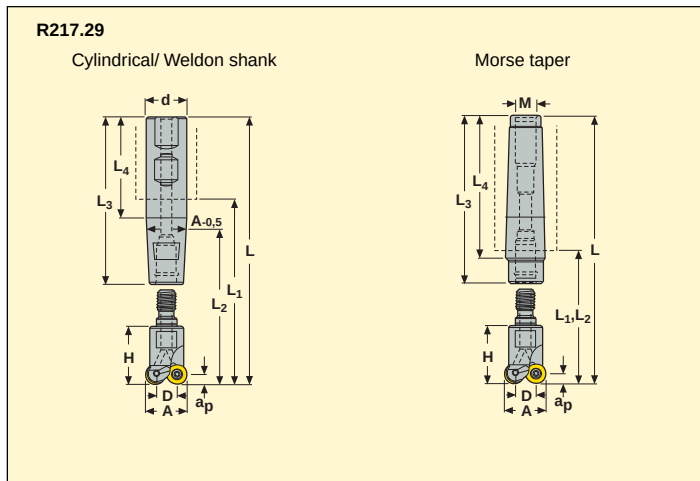
Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
RPHT 	RPHT 1204M0T-M08 F40M	00084919		●		●				
	1204M0T-M08 S25M	74069381	●		●					
	1204M0T-M08 T25M	74069382	●		●	●				
RPHW 	RPHW 1204M0T-MD09 T20M	74069385					●	●		
	1204M0-M05 F40M	00004832	●		●				●	

● = first choice

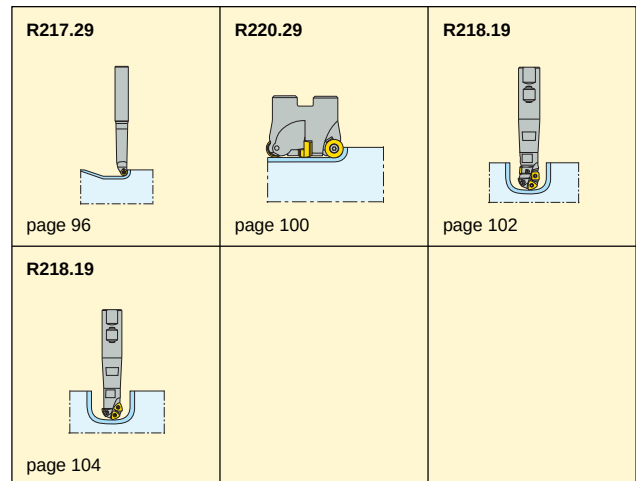
Cutting data, slotting - full engagement

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,08	0,10	0,14	0,18
Steel	1-4 Easy-cutting and ordinary steels	RPHT 1204M0T-M08 S25M	170	165	150	140
		1204M0T-M08 T25M	210	200	185	175
		RPHW 1204M0-M05 F40M	185	175	160	150
	5-6 Harder steels	RPHT 1204M0T-M08 F40M	120	115	105	100
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	RPHT 1204M0T-M08 S25M	180	170	155	145
		1204M0T-M08 T25M	220	210	195	180
		RPHW 1204M0-M05 F40M	190	185	170	160
	10 Stainless steels difficult to machine	RPHT 1204M0T-M08 F40M	165	155	145	135
Cast iron	12-13 Easy-cutting and ordinary cast iron	RPHW 1204M0T-MD09 T20M	200	190	175	160
	14-15 Harder cast iron and nodular irons	RPHW 1204M0T-MD09 T20M	145	140	130	120
Other materials	16-17 Aluminium and other non-ferrous	RPHW 1204M0-M05 F40M	750	710	655	615

Milling cutters



Other copy milling cutters



Application		Cutter heads	Shanks	Dimensions in mm											
		Part No.	Part No.	D	A	d	L	L ₁	L ₂	L ₃	L ₄	H	M	a _p	
		R217.29-1213.RE-06.2MA	R12-25.3-045A R12-03.2-020A	13	25	25	136	76	70	101	61	35	-	6	
				13	25	-	135,5	55	55	100,5	85,5	35	M12	6	
		R217.29-1220.RE-06.3MA	R12-25.3-045A R12-03.2-020A	20	32	25	141	81	85	101	61	40	-	6	
				20	32	-	140,5	60	60	100,5	85,5	40	M12	6	

Cutter heads		Shanks		Mounting type	KG		
Part No.	Ordering and Prod. No.	Part No.	Ordering and Prod. No.				
R217.29-1213.RE-06.2MA	75077659	R12-25.3-045A	75077690	Cyl/Weldon	0,4	2	RPH.1204..
		R12-03.2-020A	75077696	Morse No.3	0,3	2	RPH.1204..
R217.29-1220.RE-06.3MA	75077660	R12-25.3-045A	75077690	Cyl/Weldon	0,4	3	RPH.1204..
		R12-03.2-020A	75077696	Morse No.3	0,4	3	RPH.1204..

Cutter heads		Shanks		Key dimension, mm	Recom. assembling torque, Nm	Spare parts	
Part No.	Ordering and Product No.	Part No.	Ordering and Product No.			Screw/ Key*	
R217.29-1213.RE-06.2MA	75077659	R12-25.3-045A	75077690	17	60	C03508	T15-3
		R12-03.2-020A	75077696	17	60	C03508	T15-3
R217.29-1220.RE-06.3MA	75077660	R12-25.3-045A	75077690	17	60	C03508	T15-3
		R12-03.2-020A	75077696	17	60	C03508	T15-3

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

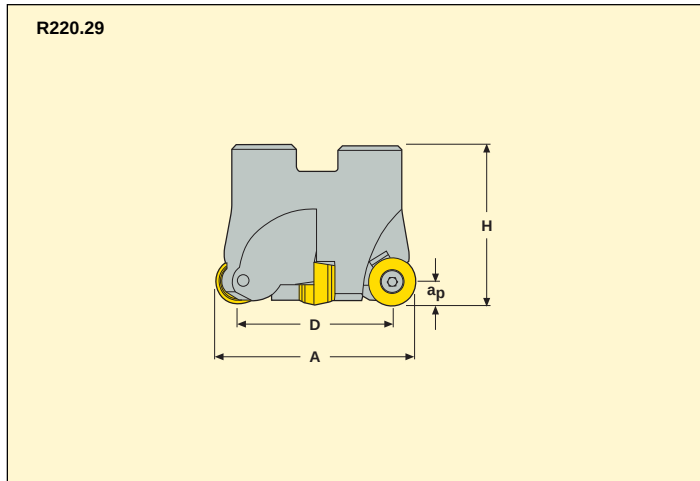
Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
RPHT 	RPHT 1204M0T-M08 F40M	00084919		●		●				
	1204M0T-M08 S25M	74069381	●		●					
	1204M0T-M08 T25M	74069382	●		●	●				
RPHW 	RPHW 1204M0T-MD09 T20M	74069385					●	●		
	1204M0-M05 F40M	00004832	●		●				●	

● = first choice

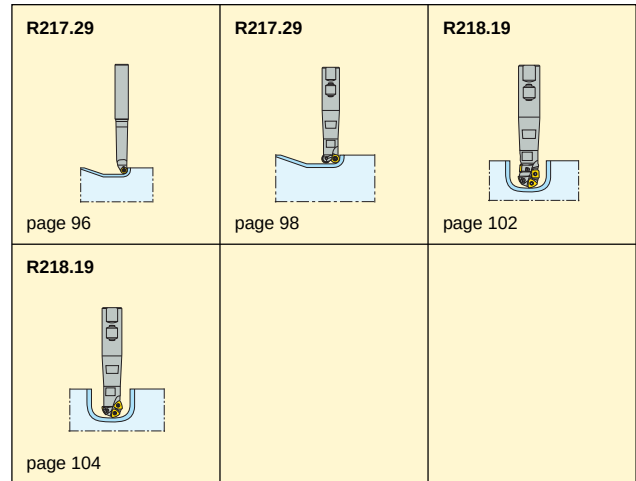
Cutting data, slotting - full engagement

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,08	0,10	0,14	0,18
Steel	1-4 Easy-cutting and ordinary steels	RPHT 1204M0T-M08 S25M	170	165	150	140
		1204M0T-M08 T25M	210	200	185	175
		RPHW 1204M0-M05 F40M	185	175	160	150
	5-6 Harder steels	RPHT 1204M0T-M08 F40M	120	115	105	100
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	RPHT 1204M0T-M08 S25M	180	170	155	145
		1204M0T-M08 T25M	220	210	195	180
		RPHW 1204M0-M05 F40M	190	185	170	160
	10 Stainless steels difficult to machine	RPHT 1204M0T-M08 F40M	165	155	145	135
Cast iron	12-13 Easy-cutting and ordinary cast iron	RPHW 1204M0T-MD09 T20M	200	190	175	160
	14-15 Harder cast iron and nodular irons	RPHW 1204M0T-MD09 T20M	145	140	130	120
Other materials	16-17 Aluminium and other non-ferrous	RPHW 1204M0-M05 F40M	750	710	655	615

Milling cutters



Other copy milling cutters



Application		Part No.	Ordering and Product No.	Dimensions in mm				KG		
				D	A	H	ap			
		R220.29-0028-06.3M	00094715	28	40	40	6	0,2	3	RPH.1204..
		-0038-06.4M	00094716	38	50	40	6	0,3	4	RPH.1204..
		-0051-06.4M	00094719	51	63	40	6	0,5	4	RPH.1204..

Dimensions of mounting

	Dimensions in mm				For arbor
	D	d	p	q	
	28	16	8,4	5,6	16
	38	22	10,4	6,3	22
	51	22	10,4	6,3	22

Spare parts, included in delivery

For cutter	Locking screw/ Key*		Arbor screw
R220.29-0028-06.3M	C03508	T15-3	220.17-690
-0038-06.4M	C03508	T15-3	220.17-691
-0051-06.4M	C03508	T15-3	220.17-691

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

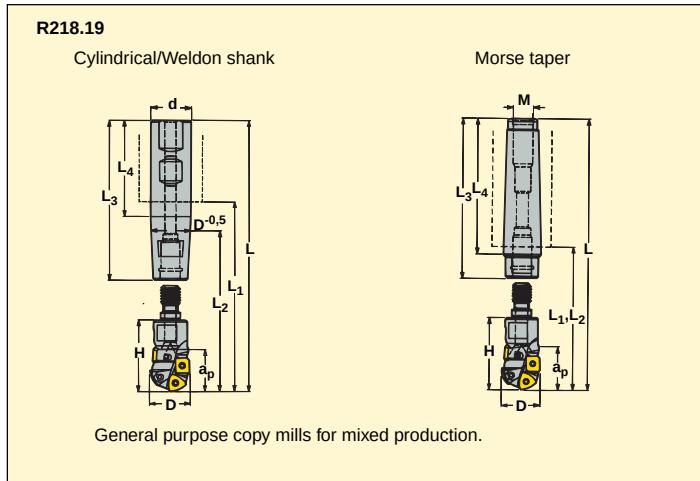
Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
RPHT 	RPHT 1204M0T-M08 F40M	00084919		●		●				
	1204M0T-M08 S25M	74069381	●		●					
	1204M0T-M08 T25M	74069382	●		●	●				
RPHW 	RPHW 1204M0T-MD09 T20M	74069385					●	●		
	1204M0-M05 F40M	00004832	●		●				●	

● = first choice

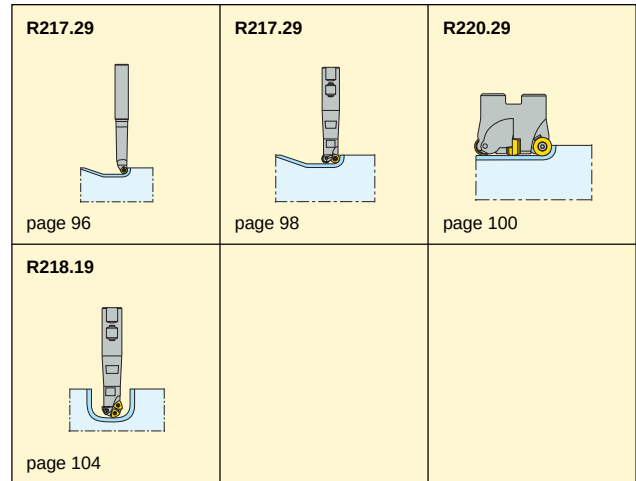
Cutting data, slotting - full engagement

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,08	0,10	0,14	0,18
Steel	1-4 Easy-cutting and ordinary steels	RPHT 1204M0T-M08 S25M	170	165	150	140
		1204M0T-M08 T25M	210	200	185	175
		RPHW 1204M0-M05 F40M	185	175	160	150
	5-6 Harder steels	RPHT 1204M0T-M08 F40M	120	115	105	100
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	RPHT 1204M0T-M08 S25M	180	170	155	145
		1204M0T-M08 T25M	220	210	195	180
		RPHW 1204M0-M05 F40M	190	185	170	160
	10 Stainless steels difficult to machine	RPHT 1204M0T-M08 F40M	165	155	145	135
Cast iron	12-13 Easy-cutting and ordinary cast iron	RPHW 1204M0T-MD09 T20M	200	190	175	160
	14-15 Harder cast iron and nodular irons	RPHW 1204M0T-MD09 T20M	145	140	130	120
Other materials	16-17 Aluminium and other non-ferrous	RPHW 1204M0-M05 F40M	750	710	655	615

Milling cutters



Other copy milling cutters



Application		Cutter heads	Shanks	Dimensions in mm									
		Part No.	Part No.	D	d	L	L ₁	L ₂	L ₃	L ₄	H	M	a _p
		R218.19-1220.RE-21A	R12-25.3-045A	20	25	146	90	29	101	61	45	-	21
		R218.19-1225.RE-26HA		25	25	146	90	80	101	61	45	-	26
		R218.19-1632.RE-36HA		32	32	160	100	90	105	65	55	-	36
		R218.19-1220.RE-21A	R12-03.2-020A	20	-	145,5	65	29	100,5	85,5	45	M12	21
		R218.19-1225.RE-26HA		25	-	145,5	65	65	100,5	85,5	45	M12	26
		R218.19-1632.RE-36HA		32	-	217	115	108	162	108,5	55	M16	36

Cutter heads		Shanks		K*	No. of flutes	Mounting type					
Part No.	Ordering and Prod. No.	Part No.	Ordering and Prod. No.								
R218.19-1220.RE-21A	75077649	R12-25.3-045A	75077690	1	2	Cyl/Weldon	0,4	4	218.19-100.. (2)	SPMX07.. (2)	-
R218.19-1225.RE-26HA	75094632			1	2	Cyl/Weldon	0,4	4	218.19-125(T)-T3 (2)	SPMX09.. (2)	-
R218.19-1632.RE-36HA	75077650			1	2	Cyl/Weldon	0,7	5	218.19-160(T)-04 (2)	-	SPMT10.. (3)
R218.19-1220.RE-21A	75077649	R12-03.2-020A	75077696	1	2	Morse No.3	0,3	4	218.19-100.. (2)	SPMX07.. (2)	-
R218.19-1225.RE-26HA	75094632			1	2	Morse No.3	0,3	4	218.19-125(T)-T3 (2)	SPMX09.. (2)	-
R218.19-1632.RE-36HA	75077650			1	2	Morse No.4	0,8	5	218.19-160(T)-04 (2)	-	SPMT10.. (3)

* Effective number of teeth

Cutter heads		Shanks		Key dimension, mm	Recom. assembling torque, Nm	Spare parts	
Part No.	Ordering and Product No.	Part No.	Ordering and Product No.			Screw/ Key*	
R218.19-1220.RE-21A	75077649	R12-25.3-045A	75077690	17	60	C02506	T07-3
R218.19-1225.RE-26HA	75094632			17	60	C03006	T09-3
R218.19-1632.RE-36HA	75077650			24	80	C03508	T15-3
R218.19-1220.RE-21A	75077649	R12-03.2-020A	75077696	17	60	C02506	T07-3
R218.19-1225.RE-26HA	75094632			17	60	C03006	T09-3
R218.19-1632.RE-36HA	75077650			24	80	C03508	T15-3

Extract from Seco Milling Catalogue.

Inserts

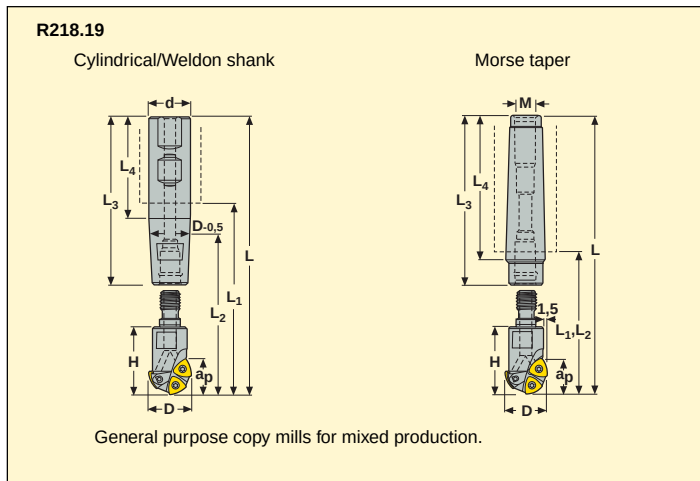
Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
218.19 	218.19-100T-ME05 T25M	74034280	●	●	●	●	●	●	●	
	-100T-M06 T25M	74069517	●	●	●	●	●	●	●	
	-100T-MD06 F25M	74079711	●	●	●	●	●	●	●	
	-125T-T3-ME07 T25M	74069528	●	●	●	●	●	●	●	
	-125T-T3-M07 T25M	74069526	●	●	●	●	●	●	●	
	-125T-T3-MD08 F25M	74079717	●	●	●	●	●	●	●	
	-160T-04-ME08 T25M	74069547	●	●	●	●	●	●	●	
	-160T-04-M08 T25M	74069544	●	●	●	●	●	●	●	
	-160T-04-MD09 F25M	74079738	●	●	●	●	●	●	●	
SPMX 	SPMX 0703AP-75 T25M	74016174	●	●	●	●	●	●	●	
	0903AP-75 T25M	74016175	●	●	●	●	●	●	●	
SPMT 	SPMT 100408T-M08 T25M	74077350	●	●	●	●	●	●	●	

● = first choice

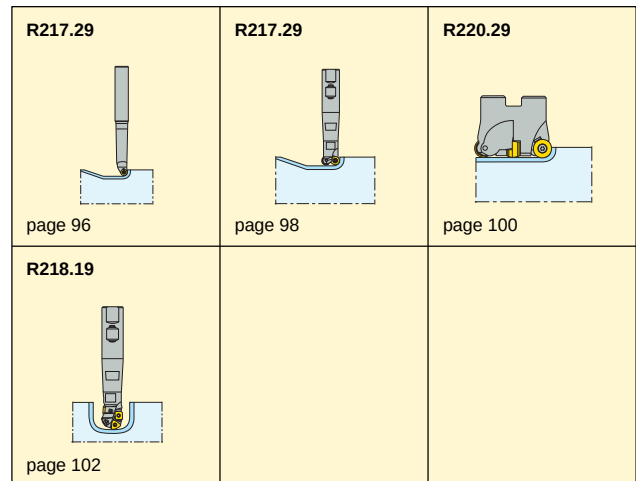
Cutting data, slotting - axial depth of cut larger than half the cutter diameter

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,04	0,06	0,08	0,14
Steel	1-4 Easy-cutting and ordinary steels	218.19-100T-ME05 T25M	245	230	215	190
		-100T-MD06 F25M	220	205	195	170
		-125T-T3-ME07 T25M	245	230	215	190
		-125T-T3-MD08 F25M	220	205	195	170
		-160T-04-ME08 T25M	245	230	215	190
		-160T-04-MD09 F25M	220	205	195	170
	5-6 Harder steels	218.19-100T-M06 T25M	145	135	125	110
		-125T-T3-M07 T25M	145	135	125	110
		-160T-04-M08 T25M	145	135	125	110
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	218.19-100T-ME05 T25M	255	235	225	195
		-100T-MD06 F25M	230	215	200	175
		-125T-T3-ME07 T25M	255	235	225	195
		-125T-T3-MD08 F25M	230	215	215	175
		-160T-04-ME08 T25M	255	235	235	195
		-160T-04-MD09 T25M	230	215	215	175
	10 Stainless steels difficult to machine	218.19-100T-M06 T25M	155	145	135	120
		-125T-T3-M07 T25M	155	145	135	120
		-160-04-M08 T25M	155	145	135	120
Cast iron	12-13 Easy-cutting and ordinary cast iron	218.19-100T-M06 T25M	195	185	170	150
		-100T-MD06 F25M	195	185	170	150
		-125T-T3-M07 T25M	195	185	170	150
		-125T-T3-MD08 F25M	195	185	170	150
		-160T-04-M08 T25M	195	185	170	150
		-160T-04-MD09 F25M	195	185	170	150
	14-15 Harder cast iron and nodular irons	218.19-100T-M06 T25M	145	135	125	110
		-125T-T3-M07 T25M	145	135	125	110
		-160T-04-M08 T25M	145	135	125	110
Other materials	16-17 Aluminium and other non-ferrous	218.19-100T-ME05 T25M	1 000	950	900	800
		-125T-T3-ME07 T25M	1 000	950	900	800
		-160T-04-ME08 T25M	1 000	950	900	800

Milling cutters



Other copy milling cutters



Application		Cutter heads	Shank	Dimensions in mm									
		Part No.	Part No.	D	d	L	L ₁	L ₂	L ₃	L ₄	H	M	a _p
		R218.19-1225.RE-14HFA	R12-25.3-045A	25	25	141	85	75	101	61	40	-	14
			R12-03.2-020A	25	-	140,5	60	60	100,5	85,5	40	M12	14
		R218.19-1632.RE-18HFA	R16-32.3-045A	32	32	145	85	75	105	65	40	-	18
			R16-04.2-060A	32	-	202	100	93	162	108,5	40	M16	18

Cutter heads		Shanks		K*	No. of flutes	Mounting type			
Part No.	Ordering and Prod. No.	Part No.	Ordering and Prod. No.						
R218.19-1225.RE-14HFA	75094633	R12-25.3-045A	75077690	1	2	Cyl/Weldon	0,3	3	218.19-125(T)-T3
		R12-03.2-020A	75077696	1	2	Morse No.3	0,4	3	218.19-125(T)-T3
R218.19-1632.RE-18HFA	75094580	R16-32.3-045A	75077701	1	2	Cyl/Weldon	0,7	3	218.19-160(T)-04
		R16-04.2-060A	75077707	1	2	Morse No.4	0,8	3	218.19-160(T)-04

Cutter heads		Shanks		Key dimension, mm	Recom. assembling torque, Nm	Spare parts	
Part No.	Ordering and Product No.	Part No.	Ordering and Product No.			Screw/ Key*	
R218.19-1225.RE-14HFA	75094633	R12-25.3-045A	75077690	17	60		T09-3
		R12-03.2-020A	75077696	17	60		T09-3
R218.19-1632.RE-18HFA	75094580	R16-32.3-045A	75077701	24	80		T15-3
		R16-04.2-060A	75077707	24	80		T15-3

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

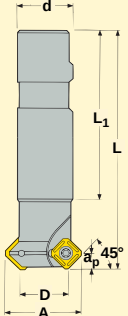
Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
218.19 	218.19-125T-T3-ME07 T25M	74069528	●	●	●	●	●	●	●	
	-125T-T3-M07 T25M	74069526	●	●	●	●	●	●	●	
	-125T-T3-MD08 F25M	74079717	●	●	●	●	●	●	●	
	-160T-04-ME08 T25M	74069547	●	●	●	●	●	●	●	
	-160T-04-M08 T25M	74069544	●	●	●	●	●	●	●	
	-160T-04-MD09 F25M	74079738	●	●	●	●	●	●	●	

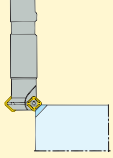
● = first choice

Cutting data, slotting - axial depth of cut larger than half the cutter diameter

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,04	0,06	0,08	0,14
Steel	1-4 Easy-cutting and ordinary steels	218.19-125T-T3-ME07 T25M	245	230	215	190
		-125T-T3-MD08 F25M	220	205	195	170
		-160T-04-ME08 T25M	245	230	215	190
		-160T-04-MD09 F25M	220	205	195	170
	5-6 Harder steels	218.19-125T-T3-M07 T25M	145	135	125	110
		-160T-04-M08 T25M	145	135	125	110
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	218.19-125T-T3-ME07 T25M	255	235	225	195
		-125T-T3-MD08 F25M	230	215	215	175
		-160T-04-ME08 T25M	255	235	235	195
		-160T-04-MD09 T25M	230	215	215	175
	10 Stainless steels difficult to machine	218.19-125T-T3-M07 T25M	155	145	135	120
		-160T-04-M08 T25M	155	145	135	120
Cast iron	12-13 Easy-cutting and ordinary cast iron	218.19-125T-T3-M07 T25M	195	185	170	150
		-125T-T3-MD08 F25M	195	185	170	150
		-160T-04-M08 T25M	195	185	170	150
		-160T-04-MD09 F25M	195	185	170	150
	14-15 Harder cast iron and nodular irons	218.19-125T-T3-M07 T25M	145	135	125	110
		-160T-04-M08 T25M	145	135	125	110
Other materials	16-17 Aluminium and other non-ferrous	218.19-125T-T3-ME07 T25M	1 000	950	900	800
		-160T-04-ME08 T25M	1 000	950	900	800

Milling cutters

R215.49 Cylindrical/Weldon shank  Cutters for chamfering and deburring on the top surface and underside of the workpiece. Can also be used for face milling and milling of V-shaped slots.			

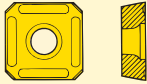
Application		Part No.	Ordering and Product No.	Dimensions in mm						KG		
R215.49 		R215.49-2016.3-09	75002622	16	26	20	110	75	5	0,3	2	SPMX0903..

Spare parts, included in delivery

For cutter	Locking screw/ Key		
R215.49-2016.3-09	C03007	T09-3	

Extract from Seco Milling Catalogue.

Inserts

Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
SPMX 	SPMX 0903AP-75 T25M	74016175	●	●	●	●	●	●	●	

● = first choice

Cutting data

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/ tooth			
			0,08	0,10	0,15	0,20
Steel	1-4 Easy-cutting and ordinary steels	SPMX 0903AP-75 T25M	200	190	170	160
	5-6 Harder steels	SPMX 0903AP-75 T25M	130	125	110	105
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	SPMX 0903AP-75 T25M	205	195	175	165
	8-9 Easy-cutting and ordinary stainless steels	SPMX 0903AP-75 T25M	175	165	150	140
Cast iron	12-13 Easy-cutting and ordinary cast iron	SPMX 0903AP-75 T25M	175	165	150	140
	14-15 Harder cast iron and nodular irons	SPMX 0903AP-75 T25M	130	120	110	100
Other materials	16-17 Aluminium and other non-ferrous	SPMX 0903AP-75 T25M	800	750	700	650

Milling cutters

R417.19 Cylindrical/Weldon shank Centre cutting spot face mills. Drill-milling and slotting by plunging and for normal milling.	
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Application		Part No.	Ordering and Product No.	Dimensions in mm					Drilling depth	K*	
				D	d	L	L ₁	a _p			
R417.19		R417.19-2018.3-06	75002644	18	20	110	80	5	10	1	0,25
		R417.19-2020.3-07	75002645	20	20	120	85	7	12	1	0,28
		-2022.3-07	75094316	22	20	120	85	7	12	1	0,30
		-2524.3-07	75094317	24	25	130	90	7	12	1	0,45
		R417.19-2526.3-09	75002646	26	25	130	90	8	15	1	0,47
		-2530.3-09	75094318	30	25	130	90	8	15	1	0,53
		-3232.3-09	75094319	32	32	130	90	8	15	1	0,77

* Effective number of teeth

		Centre insert	Peripheral insert
R417.19-2018.3-06	2	SPMX 0602AP (1)	SPMX 060204 (1)
R417.19-2020.3-07	2	SPMX 0703AP (1)	SPMX 070304 (1)
-2022.3-07	2	0703AP (1)	070304 (1)
-2524.3-07	2	0703AP (1)	070304 (1)
R417.19-2526.3-09	2	SPMX 0903AP (1)	SPMX 090304 (1)
-2530.3-09	2	0903AP (1)	090304 (1)
-3232.3-09	2	0903AP (1)	090304 (1)

Spare parts, included in delivery

For cutter	Locking screw/ Key*	
R417.19-2018.3-06	C02205	T07-3
R417.19-2020.3-07	C02506	T07-3
-2022.3-07	C02506	T07-3
-2524.3-07	C02506	T07-3
R417.19-2526.3-09	C03007	T09-3
-2530.3-09	C03007	T09-3
-3232.3-09	C03007	T09-3

Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
SPMX  	SPMX 0602AP-75 T25M	74016162	●	●	●	●	●	●	●	
	0703AP-75 T25M	74016174	●	●	●	●	●	●	●	
	0903AP-75 T25M	74016175	●	●	●	●	●	●	●	
SPMX  	SPMX 060204-75 T25M	74016733	●	●	●	●	●	●	●	
	070304-75 T25M	74016732	●	●	●	●	●	●	●	
	090304-75 T25M	74016731	●	●	●	●	●	●	●	

● = first choice

Cutting data

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/ tooth			
			0,07	0,10	0,13	0,16
Steel	1-4 Easy-cutting and ordinary steels	SPMX 0602AP-75 T25M	185	170	155	150
		0703AP-75 T25M	185	170	155	150
		0903AP-75 T25M	185	170	155	150
	5-6 Harder steels	SPMX 0602AP-75 T25M	120	110	105	95
		0703AP-75 T25M	120	110	105	95
		0903AP-75 T25M	120	110	105	95
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	SPMX 0602AP-75 T25M	190	175	165	155
		0703AP-75 T25M	190	175	165	155
		0903AP-75 T25M	190	175	165	155
	8-9 Easy-cutting and ordinary stainless steels	SPMX 0602AP-75 T25M	175	165	150	140
		0703AP-75 T25M	175	165	150	140
		0903AP-75 T25M	175	165	150	140
Cast iron	12-13 Easy-cutting and ordinary cast iron	SPMX 0602AP-75 T25M	165	150	140	130
		0703AP-75 T25M	165	150	140	130
		0903AP-75 T25M	165	150	140	130
	14-15 Harder cast iron and nodular irons	SPMX 0602AP-75 T25M	120	110	100	95
		0703AP-75 T25M	120	110	100	95
		0903AP-75 T25M	120	110	100	95
Other materials	16-17 Aluminium and other non-ferrous	SPMX 0602AP-75 T25M	750	700	650	600
		0703AP-75 T25M	750	700	650	600
		0903AP-75 T25M	750	700	650	600

Disc milling cutters

335.10 Slotting width: 2,25–4,1 mm

General purpose disc mills for mixed production and cutter body in HSS for high security.

Other slot milling cutters

R335.10 page 112	R335.10 page 114	R335.19 page 116
R335.19 page 118	R335.19 page 120	R335.18 page 122

Application		Part No.	Ordering and Product No.	Dimensions in mm					KG		
				D	d	H	ap	ae			
		335.10-080-2	75034458	80	22	1,9	2,25	22	0,1	6	150.10-2N-..
		-100-2	75034459	100	27	1,9	2,25	29	0,1	7	150.10-2N-..
		-125-2	75028096	125	32	1,9	2,25	34	0,2	9	150.10-2N-..
		-160-2	75034460	160	40	1,9	2,25	40	0,3	12	150.10-2N-..
		335.10-080-3	75012752	80	22	2,4	3,1	22	0,1	6	150.10-3N-..
		-100-3	75012754	100	27	2,4	3,1	29	0,1	7	150.10-3N-..
		-125-3	75012756	125	32	2,4	3,1	34	0,2	9	150.10-3N-..
		-160-3	75012758	160	40	2,4	3,1	40	0,3	12	150.10-3N-..
		335.10-080-4	75012753	80	22	3,4	4,1	22	0,1	6	150.10-4N-..
		-100-4	75012755	100	27	3,4	4,1	29	0,1	7	150.10-4N-..
		-125-4	75012757	125	32	3,4	4,1	34	0,2	9	150.10-4N-..
		-160-4	75012759	160	40	3,4	4,1	40	0,4	12	150.10-4N-..

Dimensions of mounting

	Dimensions in mm			
	D	d	A	E
	80	22	-	-
	100	27	-	-
	125	32	45	6
	160	40	63	11

Spare parts, included in delivery

	Insert removal key
For cutter	
All dimensions	150.10-150

Drive rings, to be ordered separately

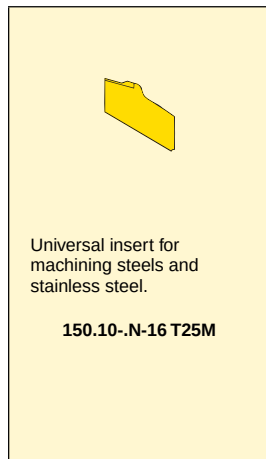
	Part No.	Ordering and Product No.	Dimensions in mm				
			D	d	d1	d2	s
	335.10-14532	75014106	55	32	45	6	11
	-16340	75014105	80	40	63	11	12

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↕ Protected	150.10-14	150.10-3N-14 T25M	74001216	●	●	●	●	●	●	●	●
		-4N-14 T25M	74005310	●	●	●	●	●	●	●	●
	150.10-16	150.10-2N-16 T25M	74016536	●	●	●	●	●	●	●	●
		-3N-16 S25M	74016598	●	●	●	●	●	●	●	●
		-3N-16 T25M	74016599	●	●	●	●	●	●	●	●
		-4N-16 S25M	74016600	●	●	●	●	●	●	●	●
		-4N-16 T25M	74016601	●	●	●	●	●	●	●	●

● = first choice



Cutting data, based on 10% engagement width ($a_e/D = 10\%$)

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,10	0,13	0,16	0,23
Steel	1-4 Easy-cutting and ordinary steels	150.10-2N-16 T25M	185	175	165	150
		-3N-14 T25M	185	175	165	150
		-3N-16 S25M	150	145	135	125
		-4N-14 T25M	185	175	165	150
		-4N-16 S25M	150	145	135	125
	5-6 Harder steels	150.10-2N-16 T25M	120	115	110	100
		-3N-16 S25M	100	95	90	80
		-3N-16 T25M	120	115	110	100
		-4N-16 S25M	100	95	90	80
		-4N-16 T25M	120	115	110	100
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	150.10-2N-16 T25M	190	180	175	160
		-3N-14 T25M	190	180	175	160
		-4N-14 T25M	190	180	175	160
	10 Stainless steels difficult to machine	150.10-2N-16 T25M	165	155	145	135
		-3N-16 T25M	165	155	145	135
		-4N-16 T25M	165	155	145	135
Cast iron	12-13 Easy-cutting and ordinary cast iron	150.10-2N-16 T25M	165	155	145	135
		-3N-14 T25M	165	155	145	135
		-4N-14 T25M	165	155	145	135
	14-15 Harder cast iron and nodular irons	150.10-2N-16 T25M	120	110	105	-
		-3N-16 T25M	120	110	105	-
		-4N-16 T25M	120	110	105	-
Other materials	16-17 Aluminium and other non-ferrous	150.10-2N-16 T25M	750	700	650	600
		-3N-14 T25M	750	700	650	600
		-4N-14 T25M	750	700	650	600

Disc milling cutters

R335.10 Slotting width: 2,25–4,1 mm

General purpose disc mills for mixed production and cutter body in HSS for high security.

Other slot milling cutters

335.10 page 110	R335.10 page 114	R335.19 page 116
R335.19 page 118	R335.19 page 120	R335.18 page 122

Application		Assembled milling cutter Part No.	Ordering and Product No.	Dimensions in mm						KG		
				D	d	H	c	a _p	a _e			
	R335.10	R335.10-063-2.22	75034464	63	22	1,9	32	2,25	15,5	0,5	5	150.10-2N-..
		-080-2.22	75034465	80	22	1,9	40	2,25	20	0,8	6	150.10-2N-..
		R335.10-063-3.22	75027298	63	22	2,4	32	3,1	15,5	0,6	5	150.10-3N-..
		-080-3.22	75027301	80	22	2,4	40	3,1	20	0,8	6	150.10-3N-..
		R335.10-063-4.22	75027299	63	22	3,4	32	4,1	15,5	0,6	5	150.10-4N-..
		-080-4.22	75027302	80	22	3,4	40	4,1	20	0,8	6	150.10-4N-..

Assembly alternatives/ Standard parts

Assembled milling cutter Part No.	Standard parts		
	Cutter body Part No.	Ordering and Product No.	Holder Part No.
R335.10-063-2.22	R335.10-063-2	75036669	335.10-2232
-080-2.22	-080-2	75036673	-2240
R335.10-063-3.22	R335.10-063-3	75027317	335.10-2232
-080-3.22	-080-3	75027319	-2240
R335.10-063-4.22	R335.10-063-4	75027318	335.10-2232
-989-4.22	-080-4	75027321	-2240

Spare parts, included in delivery

	Screw/ Key		Arbor screw	Insert release key
For cutter				
R335.10-063-2.22	335.10-0516	T15-3	220.17-696	150.10-150
-080-2.22	335.10-0516	T15-3	220.17-696	150.10-150
R335.10-063-3.22	335.10-0516	T15-3	220.17-696	150.10-150
-080-3.22	335.10-0516	T15-3	220.17-696	150.10-150
R335.10-063-4.22	335.10-0516	T15-3	220.17-696	150.10-150
-080-4.22	335.10-0516	T15-3	220.17-696	150.10-150

Holder, clamping screw included in delivery

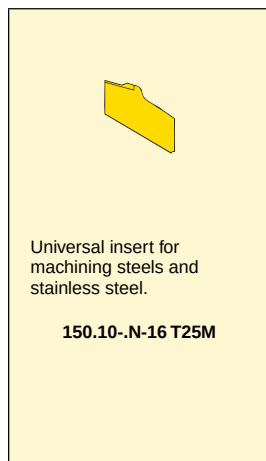
Holder Part No.	Ordering and Product No.	Dimensions in mm					
		d	c	L	L ₁	p	q
335.10-2232	75027333	22	32	50	36	10,4	6,3
-2240	75027334	22	40	50	-	10,4	6,3

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp Protected	150.10-14	150.10-3N-14 T25M	74001216	●	●	●	●	●	●	●	●
		-4N-14 T25M	74005310	●	●	●	●	●	●	●	●
	150.10-16	150.10-2N-16 T25M	74016536	●	●	●	●	●	●	●	●
		-3N-16 S25M	74016598	●	●	●	●	●	●	●	●
		-3N-16 T25M	74016599	●	●	●	●	●	●	●	●
		-4N-16 S25M	74016600	●	●	●	●	●	●	●	●
		-4N-16 T25M	74016601	●	●	●	●	●	●	●	●

● = first choice



Cutting data, based on 10% engagement width ($a_e/D = 10\%$)

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,10	0,13	0,16	0,23
Steel	1-4 Easy cutting and ordinary steels	150.10-2N-16 T25M	185	175	165	150
		-3N-14 T25M	185	175	165	150
		-3N-16 S25M	150	145	135	125
		-4N-14 T25M	185	175	165	150
		-4N-16 S25M	150	145	135	125
	5-6 Harder steels	150.10-2N-16 T25M	120	115	110	100
		-3N-16 S25M	100	95	90	80
		-3N-16 T25M	120	115	110	100
		-4N-16 S25M	100	95	90	80
		-4N-16 T25M	120	115	110	100
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	150.10-2N-16 T25M	190	180	175	160
		-3N-14 T25M	190	180	175	160
		-4N-14 T25M	190	180	175	160
	10 Stainless steels difficult to machine	150.10-2N-16 T25M	165	155	145	135
		-3N-16 T25M	165	155	145	135
		-4N-16 T25M	165	155	145	135
Cast iron	12-13 Easy-cutting and ordinary cast iron	150.10-2N-16 T25M	165	155	145	135
		-3N-14 T25M	165	155	145	135
		-4N-14 T25M	165	155	145	135
	14-15 Harder cast iron and nodular irons	150.10-2N-16 T25M	120	110	105	-
		-3N-16 T25M	120	110	105	-
		-4N-16 T25M	120	110	105	-
Other materials	16-17 Aluminium and other non-ferrous	150.10-2N-16 T25M	750	700	650	600
		-3N-14 T25M	750	700	650	600
		-4N-14 T25M	750	700	650	600

Disc milling cutters

R335.10 Slotting width: 2,25–4,1 mm

General purpose disc mills for mixed production and cutter body in HSS for high security.

Other slot milling cutters

335.10 page 110	R335.10 page 112	R335.19 page 116
R335.19 page 118	R335.19 page 120	R335.18 page 122

Application	Part No.	Ordering and Product No.	Dimensions in mm						KG		
			D	d	H	c	a _p	a _e			
	R335.10-100-2.27	75034466	100	27	1,9	48	2,25	26	0,7	7	150.10-2N-...
	-125-2.32	75034467	125	32	1,9	58	2,25	33,5	1,3	9	150.10-2N-...
	-160-2.40	75034468	160	40	1,9	80	2,25	40	2,4	12	150.10-2N-...
	R335.10-100-3.27	75027303	100	27	2,4	48	3,1	26	0,8	7	150.10-3N-...
	-125-3.32	75027307	125	32	2,4	58	3,1	33,5	1,4	9	150.10-3N-...
	-160-3.40	75027311	160	40	2,4	80	3,1	40	2,5	12	150.10-3N-...
	R335.10-100-4.27	75027304	100	27	3,4	48	4,1	26	0,8	7	150.10-4N-...
	-125-4.32	75027309	125	32	3,4	58	4,1	33,5	1,4	9	150.10-4N-...
	-160-4.40	75027312	160	40	3,4	80	4,1	40	2,5	12	150.10-4N-...

Assembly alternatives/ Standard parts

Assembled milling cutter Part No.	Standard parts		
	Cutter body Part No.	Ordering and Product No.	Holder Part No.
R335.10-100-2.27	R335.10-100-2	75036670	335.10-2748
-125-2.32	-125-2	75036671	-3258
-160-2.40	-160-2	75036672	-4080
R335.10-100-3.27	R335.10-100-3	75027322	335.10-2748
-125-3.32	-125-3	75027324	-3258
-160-3.40	-160-3	75027329	-4080
R335.10-100-4.27	R335.10-100-4	75027323	335.10-2748
-125-4.32	-125-4	75027327	-3258
-160-4.40	-160-4	75027331	-4080

Spare parts, included in delivery

	Screw/ Key		Arbor screw	Insert release key
For cutter				
R335.10-100-2.27	335.10-0516	T15-3	MC6S 12x40	150.10-150
-125-2.32	335.10-0516	T15-3	MC6S 12x40	150.10-150
-160-2.40	335.10-0516	T15-3	MC6S 12x40	150.10-150
R335.10-100-3.27	335.10-0516	T15-3	220.17-694	150.10-150
-125-3.32	335.10-0516	T15-3	220.17-694	150.10-150
-160-3.40	335.10-0516	T15-3	220.17-694	150.10-150
R335.10-100-4.27	335.10-1030	T30-4	MC6S 20x40	150.10-150
-125-4.32	335.10-1030	T30-4	MC6S 20x40	150.10-150
-160-4.40	335.10-1030	T30-4	MC6S 20x40	150.10-150

Holder, clamping screw included in delivery

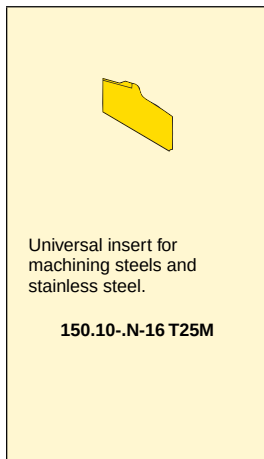
Holder Part No.	Ordering and Product No.	Dimensions in mm				
		d	c	L	p	q
335.10-2748	75027336	27	48	50	12,4	7
-3258	75027337	32	58	63	14,4	8
-4080	75027338	40	80	63	16,4	9

Extract from Seco Milling Catalogue.

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↕ Protected	150.10-14	150.10-3N-14 T25M	74001216	●	●	●	●	●	●		
		-4N-14 T25M	74005310	●	●	●	●	●	●		
	150.10-16	150.10-2N-16 T25M	74016536	●	●	●	●	●	●	●	
		-3N-16 S25M	74016598	●	●	●	●	●	●	●	
		-3N-16 T25M	74016599	●	●	●	●	●	●	●	
		-4N-16 S25M	74016600	●	●	●	●	●	●	●	
		-4N-16 T25M	74016601	●	●	●	●	●	●	●	

● = first choice



Cutting data, based on 10% engagement width ($a_e/D = 10\%$)

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,10	0,13	0,16	0,23
Steel	1-4 Easy-cutting and ordinary steels	150.10-2N-16 T25M	185	175	165	150
		-3N-14 T25M	185	175	165	150
		-3N-16 S25M	150	145	135	125
		-4N-14 T25M	185	175	165	150
		-4N-16 S25M	150	145	135	125
	5-6 Harder steels	150.10-2N-16 T25M	120	115	110	100
		-3N-16 S25M	100	95	90	80
		-3N-16 T25M	120	115	110	100
		-4N-16 S25M	100	95	90	80
		-4N-16 T25M	120	115	110	100
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	150.10-2N-16 T25M	190	180	175	160
		-3N-14 T25M	190	180	175	160
		-4N-14 T25M	190	180	175	160
	10 Stainless steels difficult to machine	150.10-2N-16 T25M	165	155	145	135
		-3N-16 T25M	165	155	145	135
		-4N-16 T25M	165	155	145	135
Cast iron	12-13 Easy-cutting and ordinary cast iron	150.10-2N-16 T25M	165	155	145	135
		-3N-14 T25M	165	155	145	135
		-4N-14 T25M	165	155	145	135
	14-15 Harder cast iron and nodular irons	150.10-2N-16 T25M	120	110	105	-
		-3N-16 T25M	120	110	105	-
		-4N-16 T25M	120	110	105	-
Other materials	16-17 Aluminium and other non-ferrous	150.10-2N-16 T25M	750	700	650	600
		-3N-14 T25M	750	700	650	600
		-4N-14 T25M	750	700	650	600

Disc milling cutters

R335.19 Slotting width: 5–6 mm

Light cutting general purpose disc mills with zig-zag and on-edge insert style for mixed production.

Other slot milling cutters

335.10 page 110	R335.10 page 112	R335.10 page 114
R335.19 page 118	R335.19 page 120	R335.18 page 122

Application		Part No.	Ordering and Product No.	Dimensions in mm						K*	KG		
				D	d	H	c	a _p	a _e				
		R335.19-063-05.22	75011452	63	22	50	40	5	10,5	3	0,5	6	335.19-1103..
		-080-05.22	75066089	80	22	50	40	5	20	4	0,6	8	335.19-1103..
		-100-05.27	75011453	100	27	40	48	5	24,2	6	0,7	12	335.19-1103..
		R335.19-063-06.22	75011448	63	22	50	40	6	10,5	3	0,5	6	335.19-1203..
		-080-06.22	75066090	80	22	50	40	6	20	4	0,6	8	335.19-1203..
		-100-06.27	75011450	100	27	40	48	6	24,2	5	0,7	10	335.19-1203..
		-125-06.40	75012911	125	40	50	70	6	23,7	6	1,5	12	335.19-1203..
		-160-06.40	75012913	160	40	50	70	6	41,2	8	2,0	16	335.19-1203..

* Effective number of teeth

Dimensions of mounting

A technical drawing of a mounting bracket. The drawing shows a cross-section of the bracket with a central rectangular cutout. Dimension lines indicate the following measurements: 'd' is the total width of the bracket; 'p' is the width of the central cutout; 'q' is the height of the central cutout; and 'h' is the total height of the bracket. The bracket is shown in a perspective view, with hatching used to indicate the internal structure and the cutout.

	Dimensions in mm			
For cutter	d	p	q	h
R335.19-063	22	10,4	6,3	20
-080	22	10,4	6,3	20
-100	27	12,4	6,3	22
-125	40	16,4	9	30
-160	40	16,4	9	30

Spare parts, included in delivery

	Locking screw/ Key		Arbor screw
For cutter			
R335.19-063-05.22	C93505	T09-3	MC6S 10x40
-080-05.22	C93505	T09-3	MC6S 10x40
-100-05.27	C93505	T09-3	MC6S 12x35
R335.19-063-06.22	C94005	T15-3	MC6S 10x40
-080-06.22	C94005	T15-3	MC6S 10x40
-100-06.27	C94005	T15-3	MC6S 12x35
-125-06.40	C94005	T15-3	-
-160-06.40	C94005	T15-3	-

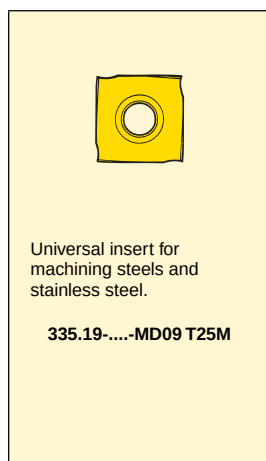
Extract from Seco Milling Catalogue.

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp Protected	335.19-M08	335.19-1103-M08	S25M 74011845	●						●	
		335.19-1203-M08	S25M 74011790	●						●	
	335.19-MD09	335.19-1103T-MD09	T25M 74015255	●	●	●	●	●	●		
		335.19-1203T-MD09	T25M 74016053	●	●	●	●	●	●		

● = first choice



Cutting data, based on 10% engagement width ($a_e/D = 10\%$)

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,13	0,19	0,26	0,32
Steel	1-4 Easy-cutting and ordinary steels	335.19-1103-M08 S25M	155	140	130	120
		-1103T-MD09 T25M	195	175	160	150
		-1203-M08 S25M	155	140	130	120
		-1203T-MD09 T25M	195	175	160	150
	5-6 Harder steels	335.19-1103T-MD09 T25M	100	90	85	80
		-1203T-MD09 T25M	100	90	85	80
Rostfritt stål	8-9 Easy-cutting and ordinary stainless steels	335.19-1103T-MD09 T25M	160	145	135	125
		-1203T-MD09 T25M	160	145	135	125
	10 Stainless steels difficult to machine	335.19-1103-MD09 T25M	135	125	115	110
		-1203T-MD09 T25M	135	125	115	110
Cast iron	12-13 Easy-cutting and ordinary cast iron	335.19-1103T-MD09 T25M	165	155	140	130
		-1203T-MD09 T25M	165	155	140	130
	14-15 Harder cast iron and nodular irons	335.19-1103T-MD09 T25M	125	110	105	-
		-1203T-MD09 T25M	125	110	105	-
Other materials	16-17 Aluminium and other non-ferrous	335.19-1103-M08 S25M	750	700	650	600
		-1203-M08 S25M	750	700	650	600

Disc milling cutters

R335.19 Slotting width: 7–8 mm

Light cutting general purpose disc mills with zig-zag and on-edge insert style for mixed production.

Other slot milling cutters

335.10 page 110	R335.10 page 112	R335.10 page 114
R335.19 page 116	R335.19 page 120	R335.18 page 122

Application	Part No.	Ordering and Product No.	Dimensions in mm						K*	KG
			D	d	H	c	ap**	ae		
	R335.19-063-0708.22	75012680	63	22	50	40	7/8	10,5	3	0,5
	-080-0708.22	75066091	80	22	50/50,5	40	7/8	20	4	0,6
	-100-0708.27	75012681	100	27	50/50,5	48	7/8	24,2	5	0,8
	-125-0708.40	75012683	125	40	50/50,5	70	7/8	23,7	6	1,5
	-160-0708.40	75012685	160	40	50/50,5	70	7/8	41,2	8	2,0

**For $a_p = 7$ mm, use insert -1204. For $a_p = 8$ mm, use insert -12045

* Effective number of teeth

Dimensions of mounting

For cutter		
R335.19-063-0708.22	6	335.19-1204../-12045..
-080-0708.22	8	335.19-1204../-12045..
-100-0708.27	10	335.19-1204../-12045..
-125-0708.40	12	335.19-1204../-12045..
-160-0708.40	16	335.19-1204../-12045..

For cutter	Dimensions in mm			
	d	p	q	h
R335.19-063	22	10,4	6,3	20
-080	22	10,4	6,3	20
-100	27	12,4	6,3	22
-125	40	16,4	9	30
-160	40	16,4	9	30

Spare parts, included in delivery

For cutter	Locking screw/ Key		Arbor screw
R335.19-063-0708.22	C94006	T15-3	MC6S 10X40
-080-0708.22	C94006	T15-3	MC6S 10X40
-100-0708.27	C94006	T15-3	MC6S 12X35
-125-0708.40	C94006	T15-3	-
-160-0708.40	C94006	T15-3	-

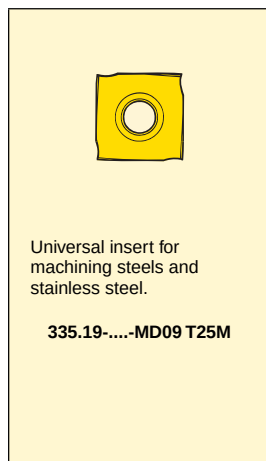
Extract from Seco Milling Catalogue

* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↕ Protected	335.19-M08	335.19-1204-M08	S25M 74018837	●						●	
		335.19-12045-M08	S25M 74016934	●						●	
	335.19-MD09	335.19-1204T-MD09	T25M 74018893	●	●	●	●	●	●		
		335.19-12045T-MD09	T25M 74016936	●	●	●	●	●	●		

● = first choice



Cutting data, based on 10% engagement width ($a_e/D = 10\%$)

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,13	0,19	0,26	0,32
Steel	1-4 Easy-cutting and ordinary steels	335.19-1204-M08 S25M	155	140	130	120
		-1204T-MD09 T25M	195	175	160	150
		-12045-M08 S25M	155	140	130	120
		-12045T-MD09 T25M	195	175	160	150
	5-6 Harder steels	335.19-1204T-MD09 T25M	100	90	85	80
		-12045T-MD09 T25M	100	90	85	80
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	335.19-1204T-MD09 T25M	160	145	135	125
		-12045T-MD09 T25M	160	145	135	125
	10 Stainless steels difficult to machine	335.19-1204T-MD09 T25M	135	125	115	110
		-12045T-MD09 T25M	135	125	115	110
	12-13 Easy-cutting and ordinary cast iron	335.19-1204T-MD09 T25M	165	155	140	130
		-12045T-MD09 T25M	165	155	140	130
Cast iron	14-15 Harder cast iron and nodular irons	335.19-1204T-MD09 T25M	125	110	105	-
		-12045T-MD09 T25M	125	110	105	-
	16-17 Aluminium and other non-ferrous	335.19-1204-M08 S25M	750	700	650	600
		-12045-M08 S25M	750	700	650	600

Disc milling cutters

R335.19 Slotting width: 10–12 mm

Easy cutting disc mills for mixed production.
Normal pitch with fixed pockets.

Other slot milling cutters

335.10 page 110	R335.10 page 112	R335.10 page 114
R335.19 page 116	R335.19 page 118	R335.18 page 122

Application		Part No.	Ordering and Product No.	Dimensions in mm						K*	KG		
				D	d	H	c	a _p	a _e				
		R335.19-100-10.27	75011451	100	27	40	48	10	24,2	5	0,8	10	335.19-1205..
		-125-10.40	75012912	125	40	50	70	10	23,7	6	1,6	12	335.19-1205..
		-160-10.40	75012914	160	40	50	70	10	41,2	8	2,1	16	335.19-1205..
		R335.19-100-12.27.2	75012682	100	27	50	48	12	24,2	5	0,9	10	335.19-1207..
		-125-12.40.2	75012684	125	40	50	70	12	23,7	6	1,6	12	335.19-1207..
		-160-12.40.2	75012686	160	40	50	70	12	41,2	8	2,1	16	335.19-1207..

* Effective number of teeth

Dimensions of mounting

	For cutter	Dimensions in mm			
		d	p	q	h
	R335.19-100	27	12,4	6,3	22
	-125	40	16,4	9	30
	-160	40	16,4	9	30

Spare parts, included in delivery

	Locking screw/ Key		Arbor screw
For cutter			
R335.19-100-10.27	C94008	T15-3	MC6S 12x35
-125-10.40	C94008	T15-3	-
-160-10.40	C94008	T15-3	-
R335.19-100-12.27.2	C94010	T15-3	MC6S 12x35
-125-12.40.2	C94010	T15-3	-
-160-12.40.2	C94010	T15-3	-

Extract from Seco Milling Catalogue.

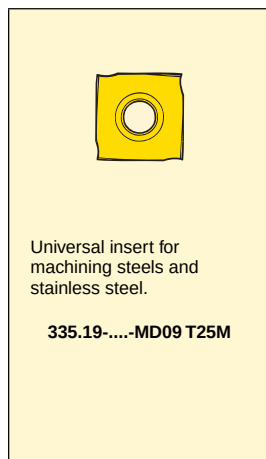
* To be ordered separately

Inserts

Cutting edge	Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
				Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
Sharp ↕ Protected	335.19-M08	335.19-1205-M08	S25M 74011791	●						●	
		335.19-1207-M08	S25M 74018746	●						●	
	335.19-MD09	335.19-1205T-MD09	T25M 74016055	●	●	●	●	●	●		
		335.19-1207T-MD09	T25M 74016937	●	●	●	●	●	●		

● = first choice

Cutting data, based on 10% engagement width ($a_e/D = 10\%$)



Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,13	0,19	0,26	0,32
Steel	1-4 Easy-cutting and ordinary steels	335.19-1205-M08 S25M	155	140	130	120
		-1205T-MD09 T25M	195	175	160	150
		-1207-M08 S25M	155	140	130	120
		-1207T-MD09 T25M	195	175	160	150
	5-6 Harder steels	335.19-1205T-MD09 T25M	100	90	85	80
		-1207T-MD09 T25M	100	90	85	80
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	335.19-1205T-MD09 T25M	160	145	135	125
		-1207T-MD09 T25M	160	145	135	125
	10 Stainless steels difficult to machine	335.19-1205T-MD09 T25M	135	125	115	110
		-1207T-MD09 T25M	135	125	115	110
Cast iron	12-13 Easy-cutting and ordinary cast iron	335.19-1205T-MD09 T25M	165	155	140	130
		-1207T-MD09 T25M	165	155	140	130
	14-15 Harder cast iron and nodular irons	335.19-1205T-MD09 T25M	125	110	105	-
		-1207T-MD09 T25M	125	110	105	-
Other materials	16-17 Aluminium and other non-ferrous	335.19-1205-M08 S25M	750	700	650	600
		-1207-M08 S25M	750	700	650	600

Disc milling cutters

R335.18 Slotting width: 14–24,3 mm

Disc mill for mixed production for arbor mounting.
Normal pitch with adjustable cassettes (width of cut).

Other slot milling cutters

335.10 page 110	R335.10 page 112	R335.10 page 114
R335.19 page 116	R335.19 page 118	R335.19 page 120

Application		Part No.	Ordering and Product No.	Dimensions in mm						K*			
				D	d	H	c	a _p	a _e				
		R335.18-100.1416.27N	75068711	100	27	50	48	14-17	24	4	1,1	8	335.18-1005..
		R335.18-160.1924.40N	75068738	160	40	50	70	18,5-24,3	44	5	3,0	10	335.18-1305..

* Effective number of teeth

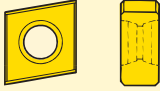
For cutter	Cassettes () = No. of cassettes
R335.18-100.1416.27N	L335.18-1418 (4)
R335.18-160.1924.40N	R335.18-1924 (5), L335.18-1924 (5)

Spare parts, included in delivery

For cutter	Wedge 	Wedge screw 	Locking screw/ Key 	Allen key 	Arbor screw 	Adjusting screw
R335.18-100.1416.27N	335.18-613	LD6018	C04011	T15-3	3+10 SMS795	MC6S 12x35
R335.18-160.1924.40N	335.18-617	268-650	C04011	T15-3	3+4 SMS795	-

Extract from Seco Milling Catalogue.

Inserts

Insert types	Part No.	Ordering and Product No.	Steel		Stainless steel		Cast iron		Aluminium and other non-ferrous	Heat resistant alloy
			Material grp 1-4	Material grp 5-6	Material grp 8-9	Material grp 10	Material grp 12-13	Material grp 14-15		
335.18 	335.18-1005T-M10 S25M	74016435	●	●					●	
	-1005T-M10 T25M	74016410	●	●	●	●	●	●		
	-1305T-M11 S25M	74016438	●	●					●	
	-1305T-M11 T25M	74016406	●	●	●	●	●	●		

● = first choice

Cutting data, based on 10% engagement width ($a_e/D = 10\%$)

Workpiece material	Seco material group No.	Part No.	Recommended cutting speed m/min			
			Feed mm/tooth			
			0,16	0,23	0,32	0,42
Steel	1-4 Easy-cutting and ordinary steels	335.18-1005T-M10 S25M	140	130	115	110
		-1005T-M10 T25M	190	170	155	145
		-1305T-M11 S25M	140	130	115	110
		-1305T-M11 T25M	190	170	155	145
	5-6 Harder steels	335.18-1005T-M10 S25M	90	85	75	70
		-1005T-M10 T25M	125	110	100	95
		-1305T-M11 S25M	90	85	75	70
		-1305T-M11 T25M	125	110	100	95
Stainless steel	8-9 Easy-cutting and ordinary stainless steels	335.18-1005T-M10 T25M	195	180	160	150
		-1305T-M11 T25M	195	180	160	150
	10 Stainless steels difficult to machine					
		335.18-1005T-M10 T25M	165	150	140	125
		-1305T-M11 T25M	165	150	140	125
Cast iron	12-13 Easy-cutting and ordinary cast iron	335.18-1005T-M10 T25M	165	150	140	125
		-1305T-M11 T25M	165	150	140	125
	14-15 Harder cast iron and nodular irons					
		335.18-1005T-M10 T25M	120	110	100	-
		-1305T-M11 T25M	120	110	100	-
Other materials	16-17 Aluminium and other non-ferrous	335.18-1005T-M10 S25M	750	700	600	550
		-1305T-M11 S25M	750	700	600	550