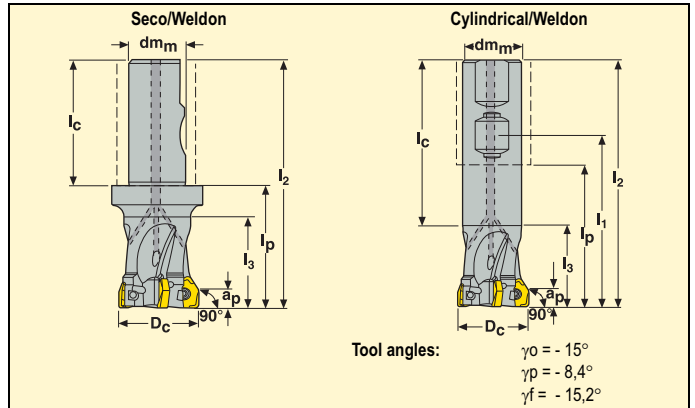


Square shoulder and slot milling cutters

Square 6 – 217.96-08A



- For insert selection and cutting data recommendations, see pages 162 - 163.
- For complete insert programme, see page 507.
- For plunging, see page 556.



Part No.	Dimension in mm											Type of mounting	
	D_c	dm_m	l_1	l_2	l_p	l_3	l_c	a_p					
R217.96 -3240.3S-08-3A	40	32	-	120	60	50	60	7,5	3	0,8	11800	Seco/Weldon	XNEX0806
-3240.3S-08-4A	40	32	-	120	60	50	60	7,5	4	0,8	11800	Seco/Weldon	XNEX0806
R217.96 -3240.3-08-3A	40	32	84	120	60	35	85	7,5	3	0,6	11800	Cyl/Weldon	XNEX0806
-3240.3-08-4A	40	32	84	120	60	35	85	7,5	4	0,6	11800	Cyl/Weldon	XNEX0806

Spare parts

For cutter	Locking screw	Key *
R217.96-3240..	C04011-T15P	T15P-4

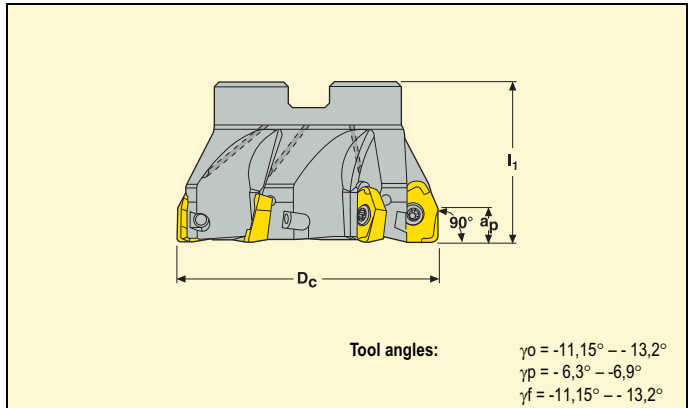
Please check availability in current price and stock-list.
 * Torque value 3,5 Nm. Dynamometric keys, see page 550.

Square shoulder and slot milling cutters

Square 6 – 220.96-08A



- For insert selection and cutting data recommendations, see pages 162 - 163.
- For complete insert programme, see page 507.
- For plunging, see page 555.



Pitch	Part No.	Dimensions in mm						
		D_c	l_1	a_p				
Normal	R220.96 -0050-08-4A	50	40	7,5	4	0,3	10600	XNEX0806
	-0063-08-6A	63	40	7,5	6	0,4	9400	XNEX0806
	-0080-08-7A	80	50	7,5	7	1	8400	XNEX0806
	-0100-08-8A	100	50	7,5	8	1,5	7500	XNEX0806
	-0125-08-11A	125	63	7,5	11	2,8	6700	XNEX0806
	-8160-08-12	160	63	7,5	12	4,8	5900	XNEX0806

Spare parts

	Locking screw	Key *	Arbor screw
For cutter			
R220.96-0050	C04011-T15P	T15P-4	220.17-696
R220.96-0063	C04011-T15P	T15P-4	220.17-692
R220.96-0080-8160	C04011-T15P	T15P-4	—

* Torque value 3,5 Nm. Dynamometric keys, see page 550.

Dimensions of mounting

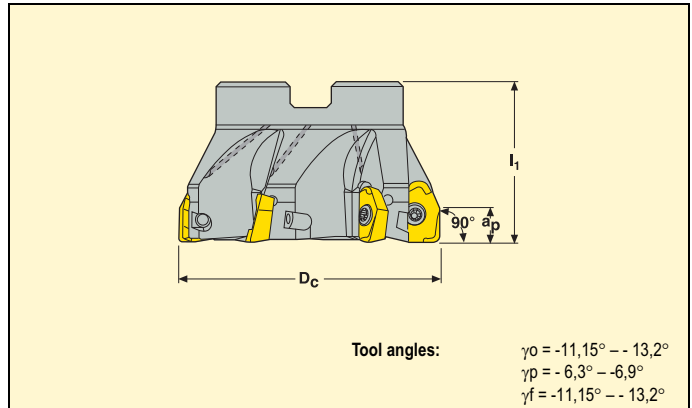
	Dimensions in mm					For arbor
	d_m	D_{sm}	B_{kw}	c	d_{hc1}	
For cutter						
R220.96-0050-0063	22	47	10,4	6,3	—	22
R220.69-0080	27	62	12,4	7	—	27
R220.69-0100	32	77	14,4	8	—	32
R220.69-0125	40	90	16,4	9	—	40
R220.69-8160	40	90	16,4	9	66,7	40

Please check availability in current price and stock-list.

Square 6 – 220.96-08A



- For insert selection and cutting data recommendations, see pages 162 - 163.
- For complete insert programme, see page 507.
- For plunging, see page 555.



Pitch	Part No.	Dimensions in mm						
		D _c	l ₁	a _p				
Close	R220.96 -0050-08-5A	50	40	7,5	5	0,3	10600	XNEX0806
	-0063-08-7A	63	40	7,5	7	0,4	9400	XNEX0806
	-0080-08-9A	80	50	7,5	9	1	8400	XNEX0806
	-0100-08-11A	100	50	7,5	11	1,5	7500	XNEX0806
	-0125-08-14A	125	63	7,5	14	2,8	6700	XNEX0806
	-8160-08-16	160	63	7,5	16	4,8	5900	XNEX0806

Spare parts

	Locking screw	Key *	Arbor screw
For cutter			
R220.96-0050	C04011-T15P	T15P-4	220.17-696
R220.96-0063	C04011-T15P	T15P-4	220.17-692
R220.96-0080-8160	C04011-T15P	T15P-4	-

* Torque value 3,5 Nm. Dynamometric keys, see page 550.

Dimensions of mounting

	Dimensions in mm					For arbor
	For cutter	dm _m	D _{5m}	B _{kw}	c	
R220.96-0050-0063	22	47	10,4	6,3	-	22
R220.69-0080	27	62	12,4	7	-	27
R220.69-0100	32	77	14,4	8	-	32
R220.69-0125	40	90	16,4	9	-	40
R220.69-8160	40	90	16,4	9	66,7	40

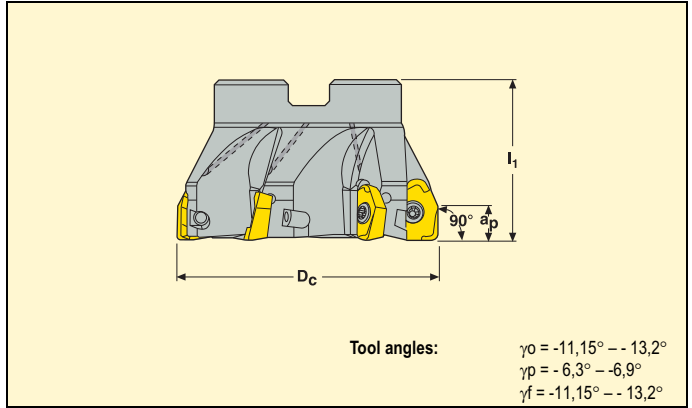
Please check availability in current price and stock-list.

Square shoulder and slot milling cutters

Square 6 – 220.96-08A



- For insert selection and cutting data recommendations, see pages 162 - 163.
- For complete insert programme, see page 507.
- For plunging, see page 555.



Pitch	Part No.	Dimensions in mm						
		D_c	l_1	a_p				
Coarse	R220.96 -0063-08-4A	63	40	7,5	4	0,4	9400	XNEX0806
	-0080-08-5A	80	50	7,5	5	1	8400	XNEX0806
	-0100-08-6A	100	50	7,5	6	1,5	7500	XNEX0806
	-0125-08-7A	125	63	7,5	7	2,8	6700	XNEX0806

Spare parts

For cutter	Locking screw	Key *	Arbor screw
R220.96-0063	C04011-T15P	T15P-4	220.17-692
R220.96-0080-0125	C04011-T15P	T15P-4	-

* Torque value 3,5 Nm. Dynamometric keys, see page 550.

Dimensions of mounting

For cutter	Dimensions in mm				For arbor
	d_{mm}	D_{sm}	B_{kw}	c	
R220.96-0063	22	47	10,4	6,3	22
R220.69-0080	27	62	12,4	7	27
R220.69-0100	32	77	14,4	8	32
R220.69-0125	40	90	16,4	9	40

Please check availability in current price and stock-list.

Square shoulder and slot milling cutters

Insert selection – 220.96-08

Universal insert: XNEX080608-M13 MP2500

Seco Material group No.	Recom. feed f_z mm/tooth $a_e/D_c = 100\%$	First choice	Difficult operations
1	0,10–0,25	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 T350M
2	0,10–0,25	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 T350M
3	0,10–0,23	XNEX 080608TR-M13 MP2500	XNEX 080608TR-M13 T350M
4	0,10–0,21	XNEX 080608TR-M13 MP2500	XNEX 080608TR-M13 T350M
5	0,10–0,19	XNEX 080608TR-M13 MP2500	XNEX 080608TR-M13 T350M
6	0,10–0,17	XNEX 080608TR-MD15 MP1500	XNEX 080608TR-MD15 MP2500
7	0,08–0,15	XNEX 080608TR-MD15 MP1500	XNEX 080608TR-MD15 MP3000
8	0,10–0,20	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 T350M
9	0,10–0,17	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 T350M
10	0,10–0,18	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 F40M
11	0,10–0,15	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 F40M
12	0,10–0,30	XNEX 080608TR-M13 MK1500	XNEX 080608TR-MD15 MK2000
13	0,10–0,25	XNEX 080608TR-M13 MK1500	XNEX 080608TR-MD15 MK2000
14	0,10–0,20	XNEX 080608TR-M13 MK1500	XNEX 080608TR-MD15 MK2000
15	0,10–0,18	XNEX 080608TR-M13 MP1500	XNEX 080608TR-MD15 MP1500
16	0,10–0,20	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 F40M
17	0,10–0,19	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 F40M
20	0,07–0,12	XNEX 080608TR-ME09 T350M	XNEX 080608TR-ME09 F40M
21	0,07–0,09	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 MP3000
22	0,07–0,13	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 F40M

Cutting data – Full engagement width ($a_e/D_c = 100\%$)

Seco Material Group No.	Grades														
	MP1500			MP2500			MP3000			T350M			F40M		
	Feed, f_z (mm/tooth)														
	0,07	0,18	0,30	0,07	0,18	0,30	0,07	0,18	0,30	0,07	0,18	0,30	0,07	0,18	0,30
Cutting speed, v_c (m/min)															
1	475	365	310	420	325	275	395	305	260	365	285	240	320	245	205
2	415	320	270	365	285	240	345	270	225	320	245	210	280	215	180
3	345	265	225	305	235	200	290	225	190	265	205	175	230	180	150
4	315	245	205	280	215	180	265	205	175	245	190	160	210	165	140
5	255	200	165	225	175	150	215	165	140	200	155	130	170	135	110
6	185	145	–	165	130	–	155	120	–	145	110	–	125	95	–
7	60	45	–	50	35	–	45	35	–	45	35	–	40	30	–
8	305	235	200	240	185	160	240	185	155	225	175	145	205	160	135
9	265	205	–	210	165	–	205	160	–	195	150	–	180	140	–
10	225	175	–	180	140	–	175	135	–	165	130	–	150	120	–
11	175	135	–	140	110	–	140	105	–	130	100	–	120	90	–
12	275	215	180	245	190	160	230	180	150	215	165	140	185	145	120
13	245	190	160	220	170	145	205	160	135	190	145	125	165	130	110
14	225	175	150	200	155	130	190	145	125	175	135	115	150	120	100
15	185	140	–	160	125	–	155	120	–	140	110	–	125	95	–
16	–	–	–	1135	880	740	1075	835	700	990	765	645	860	665	560
17	–	–	–	915	710	600	870	670	565	800	620	520	695	540	455
20	–	–	–	65	50	–	60	50	–	60	45	–	55	40	–
21	–	–	–	40	30	–	40	30	–	35	30	–	35	25	–
22	–	–	–	65	50	–	60	50	–	60	45	–	55	40	–

Cutting data – Side milling

Operations	a_e/D_c	Recom. feed f_z mm/tooth			Speed factor
Full engagement	100%	0,07	0,18	0,30	1,00
Side milling	25%	0,09	0,24	0,40	1,30
	10%	0,14	0,37	0,61	1,50
	5%	0,20	0,52	0,86	1,60
Average chip thickness h_m		0,04	0,11	0,19	–

Dimensions in mm

Insert type	Max D.O.C. a_p	Wiper flat width B
080608	7,5	1,3
080616	7,5	0,5

Choose suitable feed. Multiply speed value from basic cutting data by speed factor.

Square shoulder and slot milling cutters

Insert selection – 220.96-08

Universal insert: XNEX080608-M13 MP2500

Seco Material group No.	Recom. feed f_z mm/tooth $a_e/D_c = 100\%$	First choice	Difficult operations
1	0,10–0,25	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 T350M
2	0,10–0,25	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 T350M
3	0,10–0,23	XNEX 080608TR-M13 MP2500	XNEX 080608TR-M13 T350M
4	0,10–0,21	XNEX 080608TR-M13 MP2500	XNEX 080608TR-M13 T350M
5	0,10–0,19	XNEX 080608TR-M13 MP2500	XNEX 080608TR-M13 T350M
6	0,10–0,17	XNEX 080608TR-MD15 MP1500	XNEX 080608TR-MD15 MP2500
7	0,08–0,15	XNEX 080608TR-MD15 MP1500	XNEX 080608TR-MD15 MP3000
8	0,10–0,20	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 T350M
9	0,10–0,17	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 T350M
10	0,10–0,18	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 F40M
11	0,10–0,15	XNEX 080608TR-ME09 F40M	XNEX 080608TR-M13 F40M
12	0,10–0,30	XNEX 080608TR-M13 MK1500	XNEX 080608TR-MD15 MK2000
13	0,10–0,25	XNEX 080608TR-M13 MK1500	XNEX 080608TR-MD15 MK2000
14	0,10–0,20	XNEX 080608TR-M13 MK1500	XNEX 080608TR-MD15 MK2000
15	0,10–0,18	XNEX 080608TR-M13 MP1500	XNEX 080608TR-MD15 MP1500
16	0,10–0,20	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 F40M
17	0,10–0,19	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 F40M
20	0,07–0,12	XNEX 080608TR-ME09 T350M	XNEX 080608TR-ME09 F40M
21	0,07–0,09	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 MP3000
22	0,07–0,13	XNEX 080608TR-ME09 F40M	XNEX 080608TR-ME09 F40M

Cutting data – Full engagement width ($a_e/D_c = 100\%$)

Seco Material Group No.	Grades									
	MK1500			MK2000			MK3000			
	Feed, f_z (mm/tooth)									
	0,07	0,18	0,30	0,07	0,18	0,30	0,07	0,18	0,30	
Cutting speed, v_c (m/min)										
1	–	–	–	415	320	270	385	290	250	
2	–	–	–	360	280	235	335	250	220	
3	–	–	–	300	235	195	280	210	185	
4	–	–	–	275	215	180	255	190	165	
5	–	–	–	225	175	145	210	155	135	
6	–	–	–	165	125	–	150	115	–	
7	–	–	–	50	40	–	50	35	–	
8	–	–	–	265	205	175	240	180	155	
9	–	–	–	230	180	–	205	155	–	
10	–	–	–	200	155	–	175	130	–	
11	–	–	–	155	120	–	140	105	–	
12	345	270	225	240	185	155	225	170	145	
13	310	240	200	215	165	140	200	150	130	
14	285	220	185	200	155	130	185	140	120	
15	230	180	–	160	125	–	150	110	–	
16	–	–	–	1120	865	730	1040	780	680	
17	–	–	–	905	700	590	840	630	550	
20	–	–	–	70	55	–	60	45	–	
21	–	–	–	45	35	–	40	30	–	
22	–	–	–	70	55	–	60	45	–	

Cutting data – Side milling

Operations	a_e/D_c	Recom. feed f_z mm/tooth			Speed factor
Full engagement	100%	0,07	0,18	0,30	1,00
Side milling	25%	0,09	0,24	0,40	1,30
	10%	0,14	0,37	0,61	1,50
	5%	0,20	0,52	0,86	1,60
Average chip thickness h_m		0,04	0,11	0,19	–

Dimensions in mm

	Insert type	Max D.O.C. a_p	Wiper flat width B
	080608	7,5	1,3
080616	7,5	0,5	

Choose suitable feed. Multiply speed value from basic cutting data by speed factor.