

# SECO DOUBLE TURBO SQUARE SHOULDER MILLING

## PRODUCT SUMMARY & RANGE



# DOUBLE THE EDGES FOR IMPROVED PRODUCTIVITY DOUBLE TURBO

Achieve significant cost per edge savings with the 4 cutting edges of the double-sided Turbo. Use the most positive helix cutting angle geometry on the market for lower power consumption, smoother cutting and longer tool life. Together with high 90° angle accuracy and double-sided inserts, this generates a good surface finish and optimizes costs.

With precise geometry, the Seco Double Turbo insert provides efficient chip evacuation and significantly reduces the generation of workpiece burrs, especially in steel, stainless steel, and titanium part applications. The insert cuts with less force so vibrations are minimized leading to extended tool life and smoother surface finish.

### KEY BENEFITS

- Reduce your cost per edge with double-sided inserts
- Reduce or eliminate finishing operations
- Lower power consumption because of the high helix 11° angle
- Less vibration because of smooth cutting geometry
- Reduced downtime boosts your material removal rate with a depth of cut capability up to 15mm (0.59")
- Good accuracy and high surface quality with 90° angle
- Easy insert indexing

### RANGE OVERVIEW

#### Inserts

- 16 mm (0.63") length, 7 mm (0.275") thickness
- Two available geometries
- ME10 and M12 geometries available
- 0.8mm and 1.6mm radii sizes available
- PVD and CVD Duratomic® grades

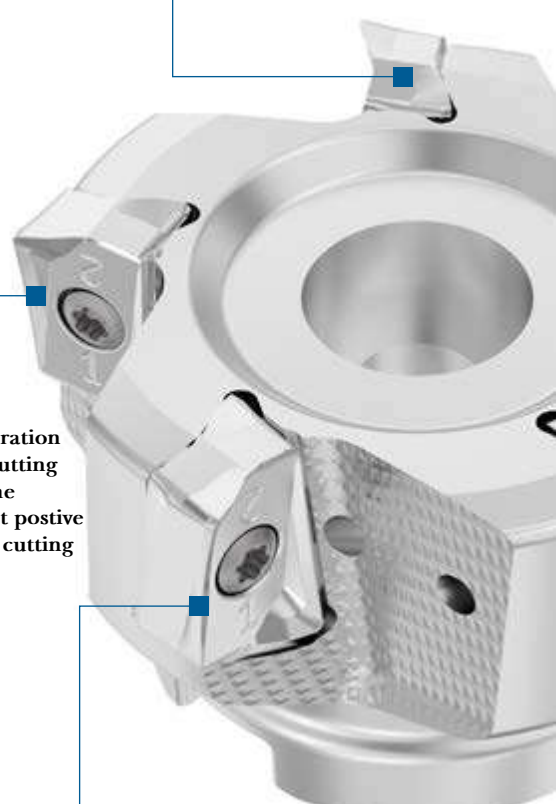
#### Cutter Bodies

- Metric range  $\varnothing 32 - 125$  mm (19 variations)
- Inch range  $\varnothing 1.25 - 5.0$  (16 variations)
- Shanks with Weldon and cylindrical mounting
- Arbor and Combimaster™ heads

Shorten or even completely eliminate finishing operations due to high accuracy 90° wall setting.

Eliminate vibration and reduce cutting forces with the market's most positive double-sided cutting geometry.

Achieve significant cost savings with 4 cutting edges.



#### Contact us:

**CHIHUAHUA. CHIH**  
gerencianoeste@tannerherramientas.com  
Tel: (614) 414 2223

**GUAYMAS. SON**  
gerencianoeste@tannerherramientas.com  
Tel: (622) 224 6081

**QUERÉTARO. QRO**  
gerenciacentro@tannerherramientas.com  
Tel: (442) 216 8862

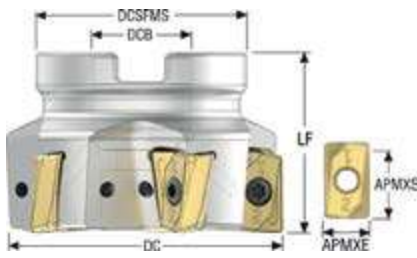
#### Follow us on:



**EL PASO. TX**  
texas@tannerherramientas.com  
Tel: (915) 532 6165

**MONTERREY. NL**  
gerencianoeste@tannerherramientas.com  
Tel: (81) 8312 1711

**TORREÓN. COAH**  
gerenciacoah@tannerherramientas.com  
Tel: (871) 169 3540



## R217.64/R220.64 - METRIC

PRODUCT NUMBER	DESCRIPTION	MOUNTING TYPE	DIMENSIONS IN MM								NUMBER OF INSERTS	RPMX	INSERT
			APMXE	APMXS	DC	DCSFMS / DMM	TDZ	DCB	OAL / LF	LS			
<a href="#">03290222</a>	R217.64-3232.3-Z016-2A	WELDON	5	15	32	32	-	-	110	73	2	11400	ZOMX16..
<a href="#">03290223</a>	R217.64-3240.3-Z016-3A	WELDON	5	15	40	32	-	-	110	73	3	11400	ZOMX16..
<a href="#">03290224</a>	R217.64-3240.3-Z016-4A	WELDON	5	15	40	32	-	-	110	73	4	11400	ZOMX16..
<a href="#">03290227</a>	R217.64-3232.0-Z016-2A	CYLINDRICAL	5	15	32	32	-	-	150	113	2	11400	ZOMX16..
<a href="#">03290228</a>	R217.64-3240.0-Z016-3A	CYLINDRICAL	5	15	40	32	-	-	150	113	3	11400	ZOMX16..
<a href="#">03290229</a>	R217.64-3240.0-Z016-4A	CYLINDRICAL	5	15	40	32	-	-	150	113	4	11400	ZOMX16..
<a href="#">03290232</a>	R217.64-1632.RE-Z016-2A	COMBIMASTER	5	15	32	30	M16	-	45	-	2	11400	ZOMX16..
<a href="#">03290233</a>	R217.64-2040.RE-Z016-3A	COMBIMASTER	5	15	40	37	M20	-	45	-	3	10000	ZOMX16..
<a href="#">03290234</a>	R217.64-2040.RE-Z016-4A	COMBIMASTER	5	15	40	37	M20	-	45	-	4	10000	ZOMX16..
<a href="#">03290239</a>	R220.64-0050-Z016-4A	ARBOR	5	15	50	47	-	22	40	-	4	9000	ZOMX16..
<a href="#">03290240</a>	R220.64-0050-Z016-5A	ARBOR	5	15	50	47	-	22	40	-	5	9000	ZOMX16..
<a href="#">03290241</a>	R220.64-0063-Z016-5A	ARBOR	5	15	63	47	-	22	40	-	5	8200	ZOMX16..
<a href="#">03290242</a>	R220.64-0063-Z016-6A	ARBOR	5	15	63	47	-	22	40	-	6	8200	ZOMX16..
<a href="#">03290243</a>	R220.64-0080-Z016-6A	ARBOR	5	15	80	62	-	27	50	-	6	7200	ZOMX16..
<a href="#">03290244</a>	R220.64-0080-Z016-8A	ARBOR	5	15	80	62	-	27	50	-	8	7200	ZOMX16..
<a href="#">03290245</a>	R220.64-0100-Z016-8A	ARBOR	5	15	100	77	-	32	50	-	8	6500	ZOMX16..
<a href="#">03290246</a>	R220.64-0100-Z016-10A	ARBOR	5	15	100	77	-	32	50	-	10	6500	ZOMX16..
<a href="#">03290247</a>	R220.64-0125-Z016-10A	ARBOR	5	15	125	90	-	40	50	-	10	5800	ZOMX16..
<a href="#">03290248</a>	R220.64-0125-Z016-12A	ARBOR	5	15	125	90	-	40	50	-	12	5800	ZOMX16..

## R217.64/R220.64 - INCH

PRODUCT NUMBER	DESCRIPTION	MOUNTING TYPE	DIMENSIONS IN INCH								NUMBER OF INSERTS	RPMX	INSERT
			APMXE	APMXS	DC	DCSFMS / DMM	TDZ	DCB	OAL / LF	LS			
<a href="#">03290225</a>	R217.64-01.25-3-Z016-2A	WELDON	0.20	0.59	1.25	1.25	-	-	4.33	2.87	2	11400	ZOMX16..
<a href="#">03290226</a>	R217.64-01.50-3-Z016-3A	WELDON	0.20	0.59	1.50	1.25	-	-	4.33	2.87	3	11400	ZOMX16..
<a href="#">03290230</a>	R217.64-01.25-0-Z016-2A	CYLINDRICAL	0.20	0.59	1.25	1.25	-	-	7.67	4.45	2	11400	ZOMX16..
<a href="#">03290231</a>	R217.64-01.50-0-Z016-3A	CYLINDRICAL	0.20	0.59	1.50	1.25	-	-	7.67	4.45	3	11400	ZOMX16..
<a href="#">03290235</a>	R217.64-01.25-16RE-Z016-2A	COMBIMASTER	0.20	0.59	1.25	1.18	M16	-	1.77	-	2	11400	ZOMX16..
<a href="#">03290236</a>	R217.64-01.50-20RE-Z016-3A	COMBIMASTER	0.20	0.59	1.50	1.45	M20	-	1.77	-	3	10000	ZOMX16..
<a href="#">03290250</a>	R220.64-02.00-Z016-4A	ARBOR	0.20	0.59	2.00	1.85	-	0.75	1.57	-	4	9000	ZOMX16..
<a href="#">03290251</a>	R220.64-02.00-Z016-5A	ARBOR	0.20	0.59	2.00	1.85	-	0.75	1.57	-	5	9000	ZOMX16..
<a href="#">03290252</a>	R220.64-02.50-Z016-5A	ARBOR	0.20	0.59	2.50	1.85	-	0.75	1.57	-	5	8200	ZOMX16..
<a href="#">03290253</a>	R220.64-02.50-Z016-6A	ARBOR	0.20	0.59	2.50	1.85	-	0.75	1.57	-	6	8200	ZOMX16..
<a href="#">03290254</a>	R220.64-03.00-Z016-6A	ARBOR	0.20	0.59	3.00	2.44	-	1	1.97	-	6	7200	ZOMX16..
<a href="#">03290255</a>	R220.64-03.00-Z016-8A	ARBOR	0.20	0.59	3.00	2.44	-	1	1.97	-	8	7200	ZOMX16..
<a href="#">03290256</a>	R220.64-04.00-Z016-8A	ARBOR	0.20	0.59	4.00	3.03	-	1.5	1.97	-	8	6500	ZOMX16..
<a href="#">03290257</a>	R220.64-04.00-Z016-10A	ARBOR	0.20	0.59	4.00	3.03	-	1.5	1.97	-	10	6500	ZOMX16..
<a href="#">03290258</a>	R220.64-05.00-Z016-10A	ARBOR	0.20	0.59	5.00	3.54	-	1.5	1.97	-	10	5800	ZOMX16..
<a href="#">03290259</a>	R220.64-05.00-Z016-12A	ARBOR	0.20	0.59	5.00	3.54	-	1.5	1.97	-	12	5800	ZOMX16..

## ZOMX16 INSERTS

PRODUCT NUMBER	DESCRIPTION	GRADE TYPE	DIMENSIONS IN MM			
			LE	RE	S	W1
<a href="#">03290934</a>	ZOMX160708TR-M12, MP1501	CVD	15,5	0,8	7,38	10,76
<a href="#">03290933</a>	ZOMX160708TR-M12, F40M	PVD	15,5	0,8	7,38	10,76
<a href="#">03290938</a>	ZOMX160708TR-M12, MS2500	CVD	15,5	0,8	7,38	10,76
<a href="#">03290935</a>	ZOMX160708TR-M12, MP2501	CVD	15,5	0,8	7,38	10,76
<a href="#">03290936</a>	ZOMX160708TR-M12, MP3000	PVD	15,5	0,8	7,38	10,76
<a href="#">03290937</a>	ZOMX160708TR-M12, MK2050	PVD	15,5	0,8	7,38	10,76
<a href="#">03290927</a>	ZOMX160708TR-ME10, MP2501	CVD	15,5	0,8	7,38	10,76
<a href="#">03290928</a>	ZOMX160708TR-ME10, MS2050	PVD	15,5	0,8	7,38	10,76
<a href="#">03290926</a>	ZOMX160708TR-ME10, F40M	PVD	15,5	0,8	7,38	10,76
<a href="#">03290929</a>	ZOMX160708TR-ME10, MS2500	CVD	15,5	0,8	7,38	10,76
<a href="#">03290941</a>	ZOMX160716TR-M12, MP2501	CVD	15,5	1,6	7,26	10,76
<a href="#">03290940</a>	ZOMX160716TR-M12, MP1501	CVD	15,5	1,6	7,26	10,76
<a href="#">03290942</a>	ZOMX160716TR-M12, MP3000	PVD	15,5	1,6	7,26	10,76
<a href="#">03290943</a>	ZOMX160716TR-M12, MK2050	PVD	15,5	1,6	7,26	10,76
<a href="#">03290939</a>	ZOMX160716TR-M12, F40M	PVD	15,5	1,6	7,26	10,76
<a href="#">03290931</a>	ZOMX160716TR-ME10, MP2501	CVD	15,5	1,6	7,26	10,76
<a href="#">03290932</a>	ZOMX160716TR-ME10, MS2050	PVD	15,5	1,6	7,26	10,76
<a href="#">03290930</a>	ZOMX160716TR-ME10, F40M	PVD	15,5	1,6	7,26	10,76

# SECO DOUBLE TURBO SQUARE SHOULDER MILLING

## PRODUCT SUMMARY & RANGE

## LESS POWER CONSUMPTION WITH BETTER RESULTS

Using the most positive helix cutting angle geometry on the market today means less power consumption, smoother cutting, and longer tool life. Together with the impressive 90° angle accuracy and the double-sided inserts, achieve good surface finish and optimize your square shoulder milling applications.

### INDUSTRY TARGETS

- **General Machining:** Any part or component that requires a square shoulder or facing operation can take advantage of this tool. The high helix geometry allows for machining in stainless steel and high temperature materials.
- **Automotive:** The high volumes of the automotive industry will benefit from the double-sided inserts of the Double Turbo. Many components such as differential cases, transmission carriers, and engine blocks can use a tool like this.

MATERIAL GROUPS
Steel P1-P11
Stainless Steel M1-M5
Cast Iron K1-K7
Superalloys S1-S3

IMPACT	BENEFITS	ADVANTAGES	FEATURES
Reduce cycle times in your square shoulder operations	Depending on finish requirements, the finishing process can be eliminated or reduced	Wall quality is improved and the step between depths is minimized	Produce wall finishes of true 90°
Get more productivity out of your machine tool's capabilities	Improve performance in your square shoulder applications	Reduce cutting forces, machine power consumption, and improve tool life with a smooth cutting process	The Double Turbo offers a high helix angle of 11°
Lower your manufacturing costs	Tooling costs and required stock levels are reduced	The cost per edge is lowered due to the edge number	The Double Turbo offers an insert with four cutting edges

### Contact us:

**CHIHUAHUA. CHIH**  
gerencianoeste@tannerherramientas.com  
Tel: (614) 414 2223

**GUAYMAS. SON**  
gerencianoeste@tannerherramientas.com  
Tel: (622) 224 6081

**QUERÉTARO. QRO**  
gerenciacentro@tannerherramientas.com  
Tel: (442) 216 8862

### Follow us on:



**EL PASO. TX**  
texas@tannerherramientas.com  
Tel: (915) 532 6165

**MONTERREY. NL**  
gerencianoeste@tannerherramientas.com  
Tel: (81) 8312 1711

**TORREÓN. COAH**  
gerenciacoah@tannerherramientas.com  
Tel: (871) 169 3540