

OCTOPLUS™ - Series OP1N/OP6N

45° Lead Angle Face Mill with 16 Indexes



Diameters:
3.00 - 12.00

Maximum Depth of Cut:
.20" along angle
.55" along 90° shoulder

Geometry:
Double Positive

Corner Configuration:
.047R & .031 Faceted

Nominal Lead Angle:
43°

Applications:
Roughing, Finishing and
One Cuts

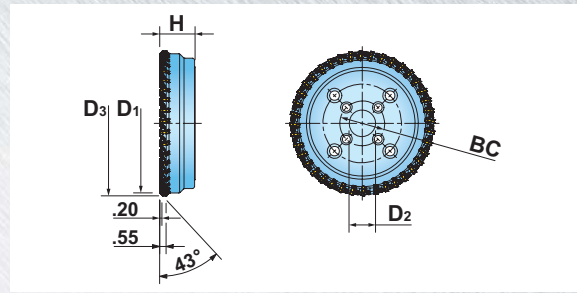
Materials:
Cast Iron, Steel, Stainless Steel,
Titanium and other high
temperature or nickel based
alloys



Series Features:

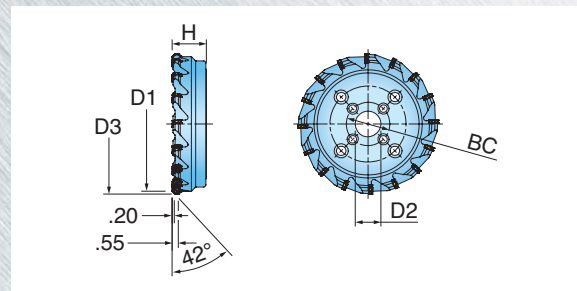
- Multipurpose inserts equipped with (16) .031" integrated wiper edges for finishes as good as 30Ra.
- Wiper insert has .157" integrated wiper on (4) edges (marked with indentation on flank) and improves surface finish by 20-40 points. Cutting edge should set .0015" higher than Multi-Purpose insert.
- Insert geometry produces clean and tightly curled chips.
- Same insert fits in screw held (OP1N) and wedge held (OP6N) cutter body.
- RH & LH cutter body options.
- Cutter body relieved to cut 90° shoulder.

OCTOPLUS™ SERIES OP1N



Cutter Number	D1 Effective Diameter	Number of Inserts	H Height	D2 Bore Dia.	D3 Overall Diameter	K Keyway	Bolt Circle
OP1N-30R01	3.000	8	1.750	1.000	3.53	0.375	NA
OP1N-40R01	4.000	12	2.375	1.500	4.53	0.625	NA
OP1N-50R01	5.000	15	2.375	1.500	5.53	0.625	NA
OP1N-60R01	6.000	19	2.375	1.500	6.53	0.625	NA
OP1N-80L01	8.000	24	2.375	2.500	8.53	1.000	4.00
OP1N-80R01	8.000	24	2.375	2.500	8.53	1.000	4.00
OP1N-10L01	10.000	30	2.375	2.500	10.53	1.000	4.00
OP1N-10R01	10.000	30	2.375	2.500	10.53	1.000	4.00
OP1N-12L01	12.000	38	2.375	2.500	12.53	1.000	4.00, 7.00
OP1N-12R01	12.000	38	2.375	2.500	12.53	1.000	4.00, 7.00

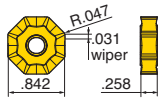
OCTOPLUS™ SERIES OP6N



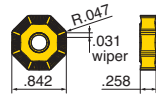
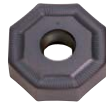
Cutter Number	D1 Effective Diameter	Number of Inserts	H Height	D2 Bore Dia.	D3 Overall Diameter	K Keyway	Bolt Circle	Coolant
OP6N-25R01	2.500	5	1.570	0.750	3.04	0.312	NA	Yes
OP6N-30R01	3.000	6	1.750	1.000	3.54	0.375	NA	Yes
OP6N-40R01	4.000	7	2.375	1.500	4.54	0.625	NA	Yes
OP6N-50R01	5.000	8	2.375	1.500	5.54	0.625	NA	Yes
OP6N-60R01	6.000	10	2.375	1.500	6.54	0.625	NA	No
OP6N-80R01	8.000	12	2.375	2.500	8.54	1.000	4.00	No
OP6N-10R01	10.000	14	2.375	2.500	10.54	1.000	4.00	No
OP6N-12R01	12.000	16	2.375	2.500	12.54	1.000	4.00, 7.00	No

INSERTS

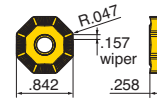
ONCU090612FN-P



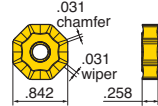
ONCU090612TN-HR



ONCU090612TN-W



ONCU0906ANFN-WE



Part Number	Applications	Grade	IN10K	IN2004	IN2005	IN2030	IN2040	IN2505	IN2510	IN6515
ONCU090612FN-P	Grd/Pol for Al - 0.047" R		●							
ONCU090612TN-HR	Multi-Purpose - 0.047" R				●	●	●			
ONCU090612TN-W	Wiper - 0.047" R							●		
ONCU0906ANFN-WE	Cast Iron - 0.031" Faceted			●					●	●

● = P ● = M ● = K ● = N ● = S

HARDWARE

OP1N



Driver

Wedge

Retention Bolt

Adjusting Screw

OP1N-30R01	DS-H04T	2M0813-01	SD-08-46	SB080-03
OP1N-40R01	DS-H04T	2M0813-01	SD-12-82	SB080-03
OP1N-50R01	DS-H04T	2M0813-01	SD-12-82	SB080-03
OP1N-60R01	DS-H04T	2M0813-01	SD-12-82	SB080-03
OP1N-80L01	DS-H04T	2M0813-01	-	SB080-03
OP1N-80R01	DS-H04T	2M0813-01	-	SB080-03
OP1N-10L01	DS-H04T	2M0813-01	-	SB080-03
OP1N-10R01	DS-H04T	2M0813-01	-	SB080-03
OP1N-12L01	DS-H04T	2M0813-01	-	SB080-03
OP1N-12R01	DS-H04T	2M0813-01	-	SB080-03

OP6N



Screw

Driver

Retention Bolt

(Optional) Coolant Bolt

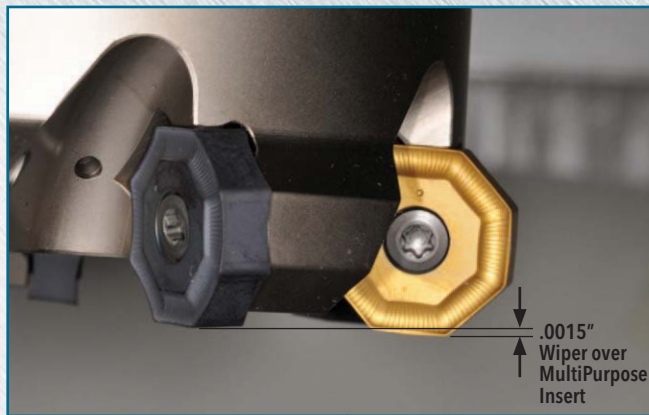
OP6N-25R01	SM50-130-R0	DS-T20T	SD-06-46	SD-06-89
OP6N-30R01	SM50-130-R0	DS-T20T	SD-08-46	SD-08-92
OP6N-40R01	SM50-130-R0	DS-T20T	SD-12-82	SD-12-99
OP6N-50R01	SM50-130-R0	DS-T20T	SD-12-82	SD-12-99
OP6N-60R01	SM50-130-R0	DS-T20T	-	-
OP6N-80R01	SM50-130-R0	DS-T20T	-	-
OP6N-10R01	SM50-130-R0	DS-T20T	-	-
OP6N-12R01	SM50-130-R0	DS-T20T	-	-

Series OP1N, OP6N		Material	Brinell Hardness	SFM	Feed per Insert	Grades*						Coolant
						IN10K	IN2010/IN2510	IN2030	IN2505/IN2005	IN2040	IN2004**	
Aluminum	6061 T-6, 7075 T-6, 2024	-	1500-8000	.006-.012	1							Yes
Cast Iron	Gray	150-250	500-1000	.008-.016	1				3	2		No
	Nodular		400-800	.007-.014	1				3	2		
Steel	Low Carbon 1018, 8620	100-250	400-1000	.006-.015								No
	High Carbon F-6180,	250-400	400-800	.006-.012		1	2	3				
	Alloyed Steel 4140, 4340	150-300	300-700									
	Tool Steel A-6, D-1, D-2	Up to 300	300-500									
Stainless Steel	300 Series, 304, 316	-	300-700	.005-.009							May not be required at high speeds	
	400 Series 15-5 PH, 13-8 PH	Up to 320	400-700		1	2	1				Yes	
		-	200-400									
Nickel Alloys	Inconel, Hastelloy, Waspalloy	-	75-120	.003-.006		2	1				Yes	
Titanium	6AL-4V	-	100-150	.004-.007		1	2	2			Yes	

*Preferred for higher SFM.
 **Preferred for CGI.

TECHNICAL INFORMATION **ONCU090612TN-W**

Wiper Edge is Proud



Wiper Insert Cutting Edge Identification

