

TEDI OCTO CUT
*Shell Mill Line With
CBN Octagonal Inserts*



TEDI OCTO CUT

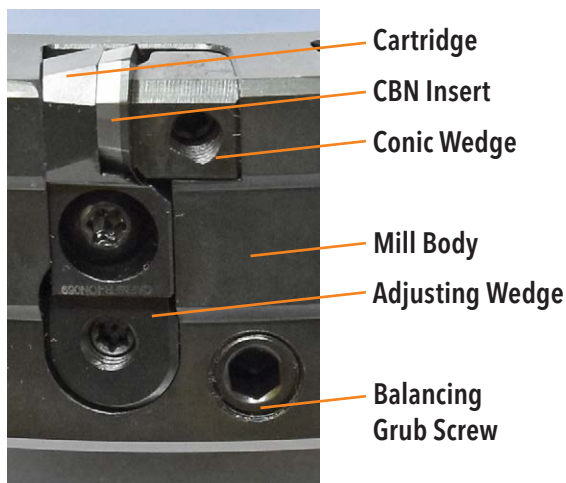
The innovative TEDI OCTO CUT line features CBN inserts for grey cast iron parts in high speed processes with the guarantee of improved cycle times and extended insert usability. When an insert edge is worn, simply rotate the insert to the next edge, and you're ready to get back to work. As the name implies, insert rotation can be performed up to eight times.

TEDI OCTO CUT mills also feature wiper inserts for high quality surface finishing at high feed rates. The seat of the cutting edge pack (wedge, cartridge, and insert) is the same for each pocket, so you can mount wiper or scraper inserts indifferently.

FEATURES

- High speed machining for cast iron applications
- High rigidity
- Simple and precise axial adjustment
- 8 effective corners per insert
- High flexibility so the correct surface finish can be achieved

TEDI OCTO CUT can be used indifferently with a standard face milling adaptor or with an IT.TE.DI. adaptor:



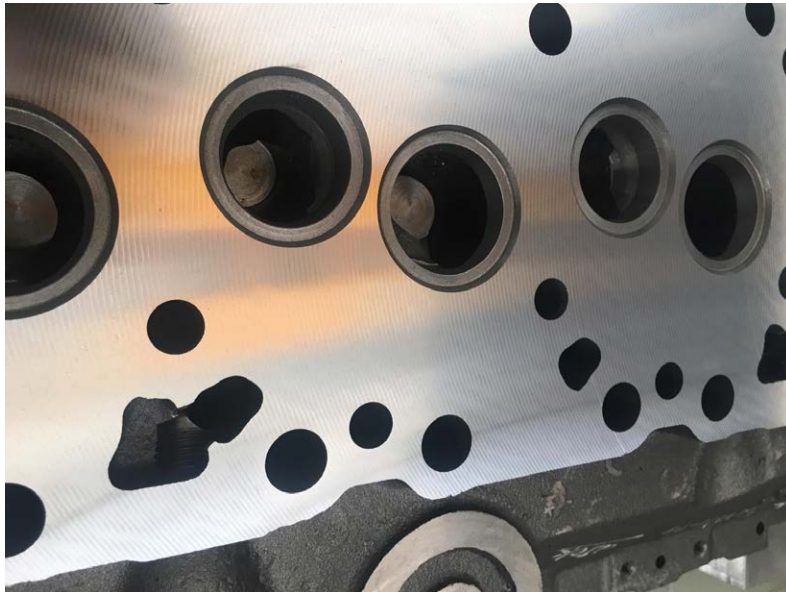
The adjusting wedge (below the cartridge) axially sets the inserts in order to have consistent height within the mill.



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RESULTS

RESULTS ON CAST IRON CYLINDER HEADS



GG40 grey cast iron

TEDI OCTO CUT
Ø315 Z=28+4

RPM	1012
TABLE FEED	1450 mm
DOC	0,5 mm

RESULTS

SURFACE FINISH	Rz 3÷5
FLATNESS	14÷18 µm

RESULTS ON CAST IRON CYLINDER BLOCKS



GG30 grey cast iron

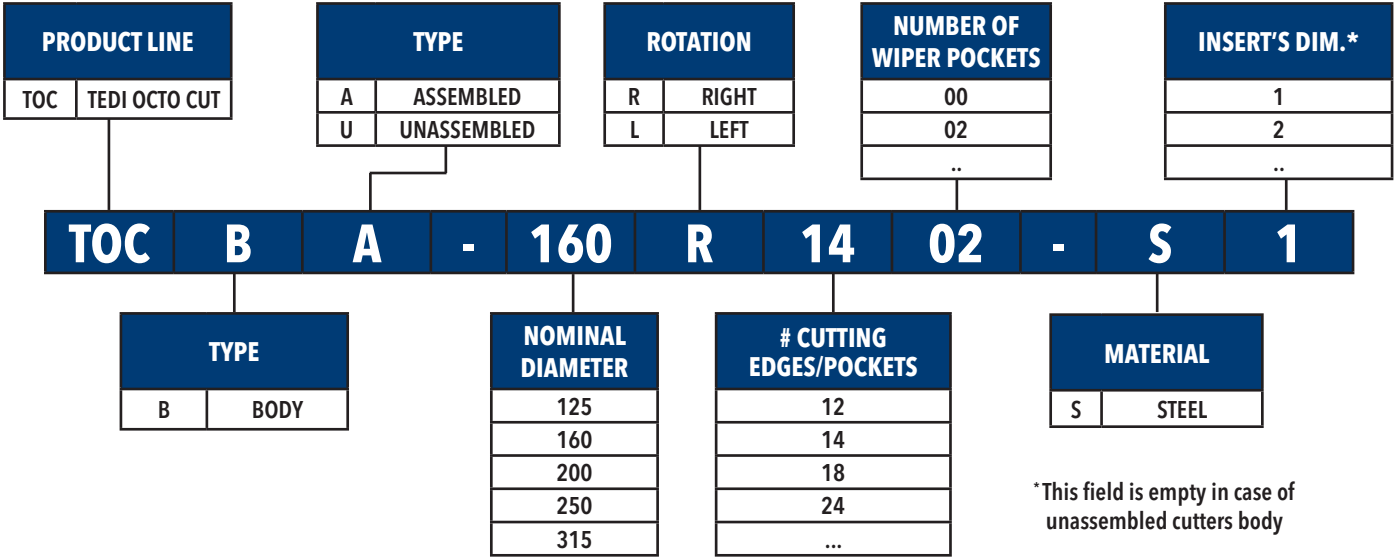
TEDI OCTO CUT
Ø250 Z=22+4

RPM	1520
TABLE FEED	2400 mm
DOC	0,4 mm

RESULTS

SURFACE FINISH	Rz 3÷6
FLATNESS	15÷20 µm

CBN CUTTER BODIES

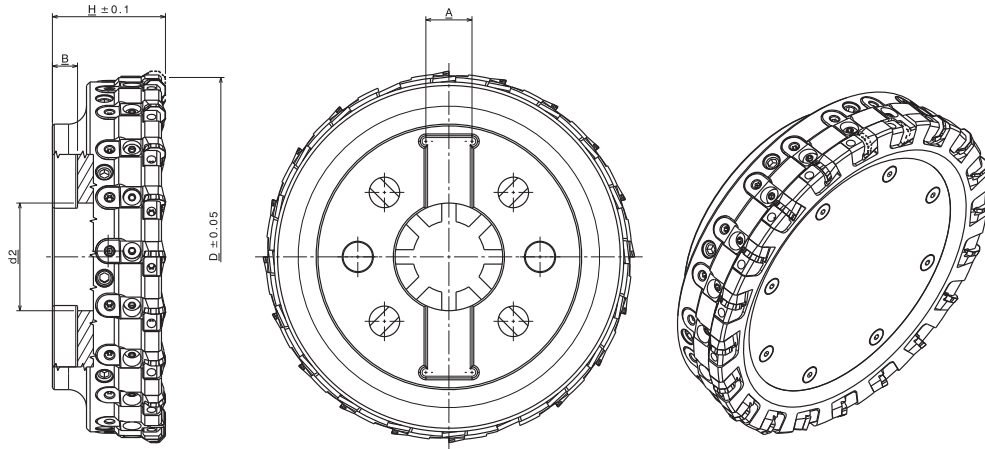


NOTE:
 The assembled bodies don't include inserts
 The unassembled bodies don't include inserts and cartridges

TEDI OCTO CUT[®]

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ASSEMBLED CUTTERS - METRIC



Drive notch measure (A, B) according to ISO 6462-1983

PART NUMBER	d2 (MM)	HOLDER SHAPE	D (*) Ø NOM. (MM)	Z	H	INSERT'S DIM.	MATERIAL	WEIGHT	EDP
TOCBA-100R0800-S1	32	A	100	8	63	1	Steel	2,7	2764834
TOCBA-125R1200-S1	40	A	125	12	63	1	Steel	4,64	2740961
TOCBA-160R1402-S1	40	C	160	14+2	63	1	Steel	6,37	2740962
TOCBA-200R1802-S1	60	C	200	18+2	63	1	Steel	9,23	2740963
TOCBA-250R2402-S1	60	C	250	24+2	63	1	Steel	13,07	2740964
TOCBA-315R2804-S1	60	C	315	28+4	63	1	Steel	19,37	2740965

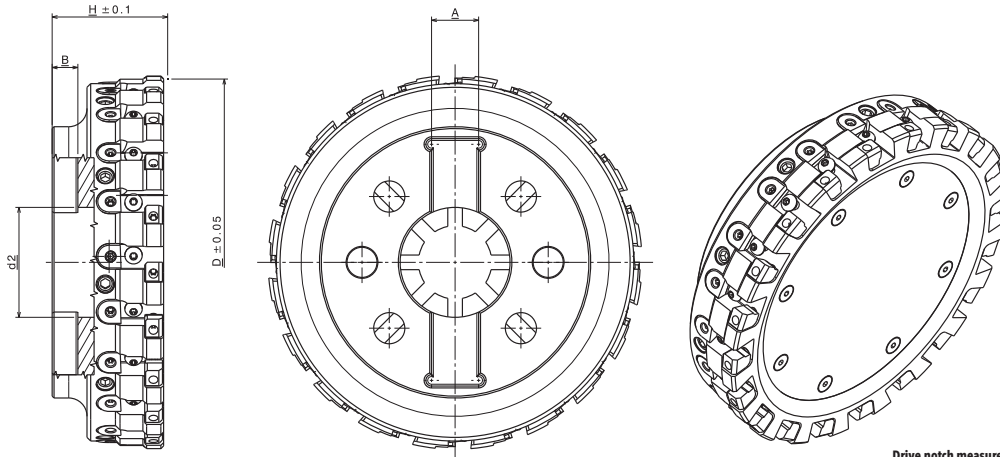
¹Part number refers to the body without inserts. (cartridges are included)

²The weight is referred to the assembled part (cutter body with cutting parts)



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UNASSEMBLED CUTTERS - INCH



Drive notch measure (A, B) according to ISO 6462-1983

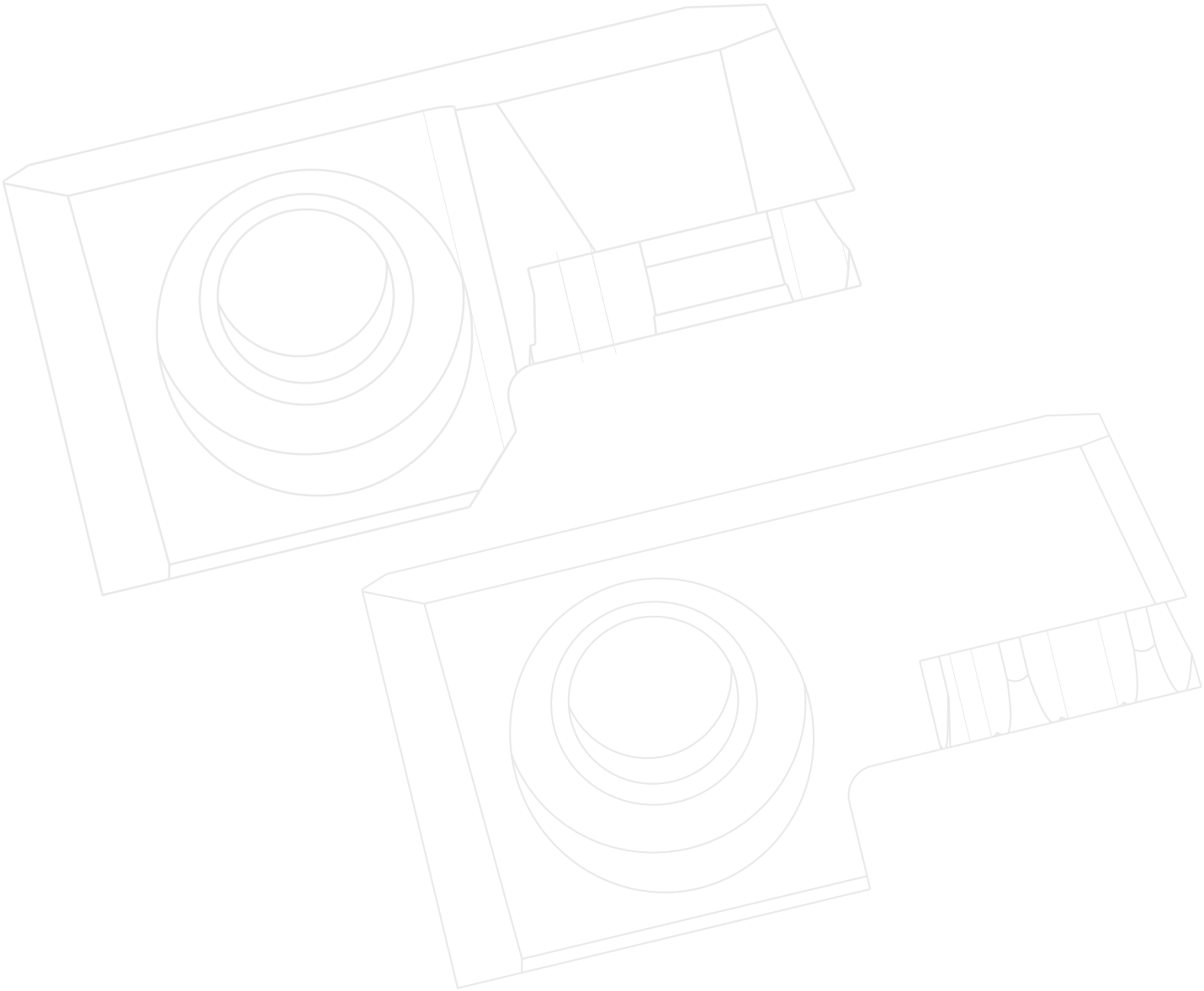
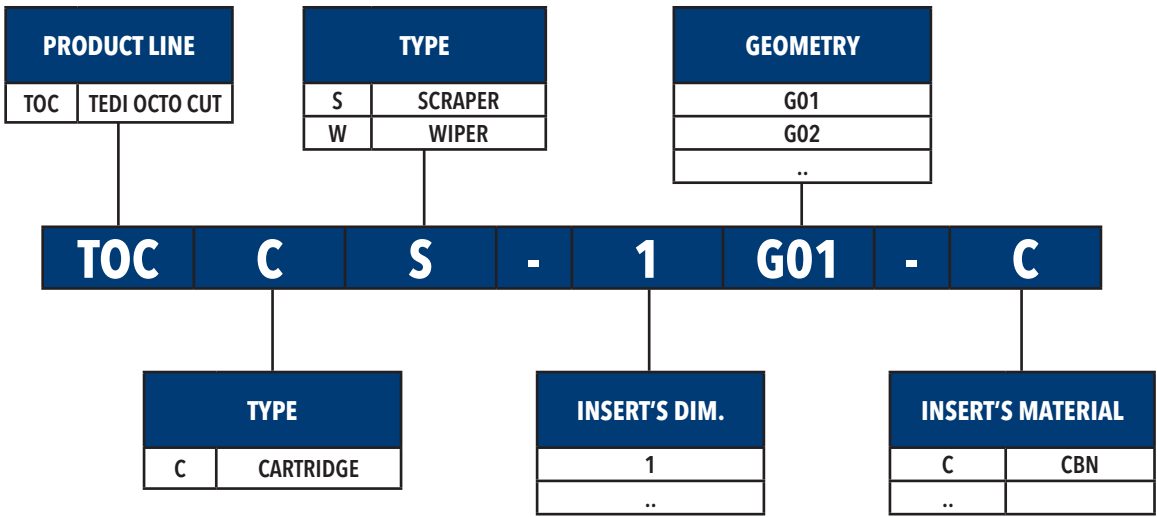
PART NUMBER	d2 (MM)	HOLDER SHAPE	D (*) Ø NOM. (INCH)	Z	H	INSERT'S DIM.	MATERIAL	WEIGHT	EDP
TOCBU-160R1600-S	32	A	100	8	63	1	Steel	2,7	2765959
TOCBU-125R1200-S	40	A	125	12	63	1	Steel	4,38	2743281
TOCBU-160R1600-S	40	C	160	16	63	1	Steel	6,03	2743282
TOCBU-200R2000-S	60	C	200	20	63	1	Steel	8,81	2743283
TOCBU-250R2600-S	60	C	250	26	63	1	Steel	12,52	2743284
TOCBA-315R3200-S	60	C	315	32	63	1	Steel	18,72	2743285

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⁴Part number refers to the body without inserts and cartridges (scraper and adjustment type wedges are included)

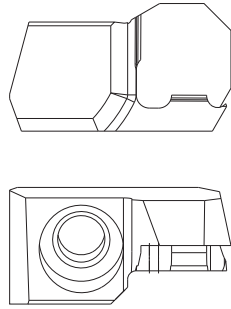


CBN CARTRIDGES

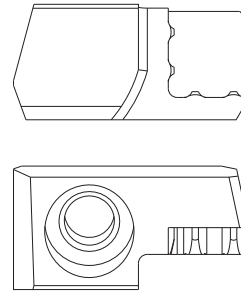


CBN CARTRIDGES

SCRAPER CARTRIDGE



WIPER CARTRIDGE



PART NUMBER	TYPE	INSERT'S DIM.	ROTATION	GEOMETRY	MATERIAL	WEIGHT (kg)	EDP
TOCCS-1G01-C	SCRAPER	1	R	G01	Steel	0,02	2739218
TOCCW-1G01-C	WIPER	1	R	G01	Steel	0,02	2739231



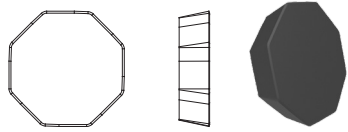
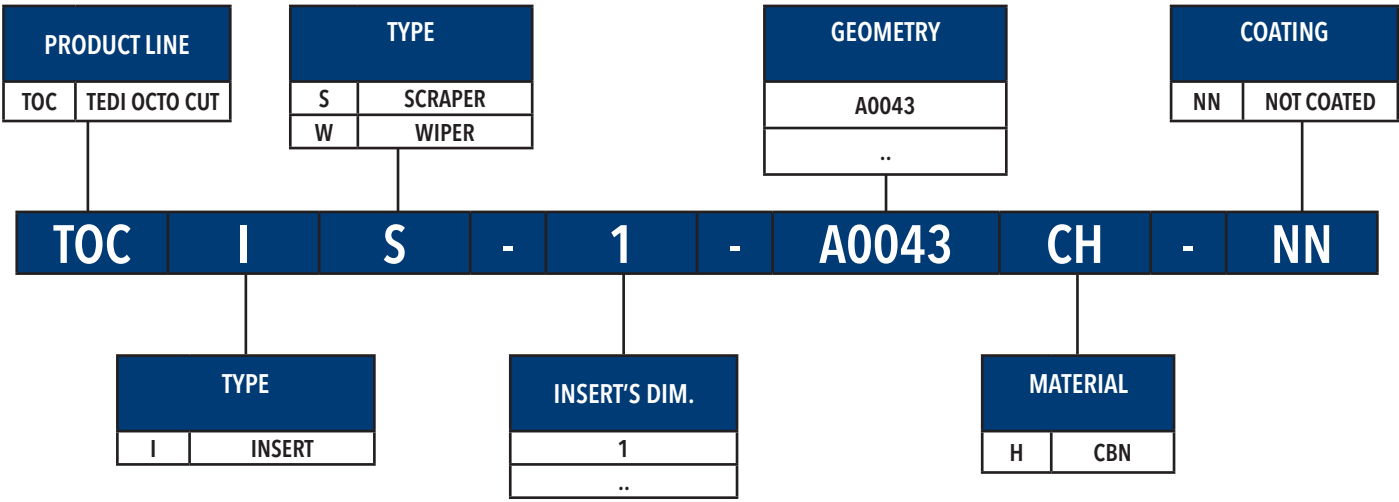
SCRAPER CARTRIDGE



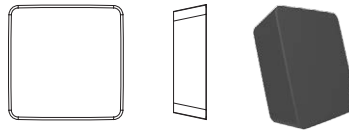
WIPER CARTRIDGE

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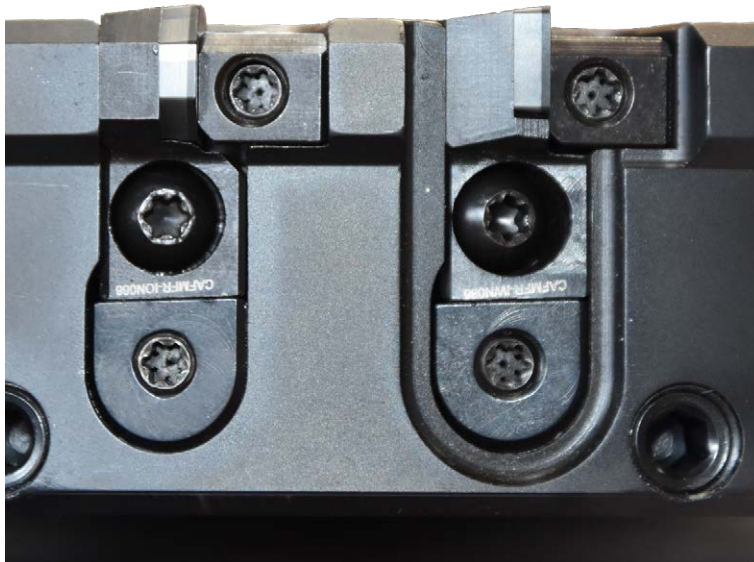
CBN **INSERTS**



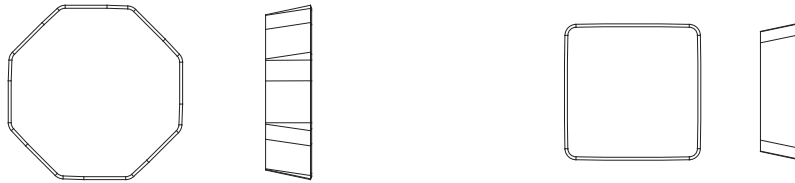
SCRAPER INSERT



WIPER INSERT



CBN **INSERTS**



PRODUCT CODE ⁶	TYPE	INSERT'S DIM.	GEOMETRY	GRADE	COATING	AVAILABILITY	ITEM
TOCIS-1-A0044CH-NN	Scraper	1	A0043	CH	NN	Stock	2737837
TOCIW-1-A0014CH-NN	Wiper	1	A0043	CH	NN	Stock	2737836
TOCIS-1-A0080CB-NN	Scraper	1	A0043	CB	NN	Stock	2744399
TOCIW-1-A0080CB-NN	Wiper	1	A0043	CB	NN	Stock	2744400

TEDI OCTO CUT[®]



SCRAPER INSERT



WIPER INSERT

^{*} Minimum diameter guaranteed with standard inserts. Refer to related table of available cutting geometry for more detail

¹ Item number refers to body only, without inserts.

³ The weight is referred to the assembled part (cutter body with cutting parts)