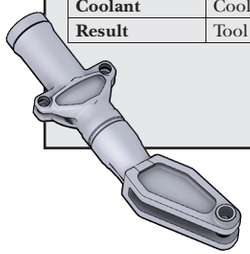
APPLICATION CASES

FINISHING

Material	X22CrMoV12-1	
Cutter	R217.69-1616.0-06.4A	
Insert	XOMX060208R-M05, F40M	
Cutting data	v_c	450 m/min
	f_z	0,125 mm/t
	a_p	0,4 mm
	a_e	3 mm
	v_f	4500 mm/min
	n	9000 rev/min
Result	With this solution it is possible to avoid solid carbide cutters and the regrinding cost	

SQUARE SHOULDER MILLING

Material	Ti 6Al 4V (Ti 6-4)	
Criterion	Metal removal rate, tool life	
Cutter	R220.69-0040-12-5A	
Insert	XOEX120416R-M07, F40M	
Cutting data	v_c	40 m/min
	f_z	0.14 mm/tooth
	a_p	2 mm, a_e=15 mm
Coolant	Coolant pressure 10 bar	
Result	Tool life 230 minutes	



CONTACT & INFORMATION

SECO MACHINING NAVIGATOR:

Update Catalogue 2010

ONLINE INFORMATION:

Complete Turbo information:
http://www.secotools.com/turbo

Seco Tools international website:
http://www.secotools.com

Seco Tools AB, 737 82 Fagersta, Sweden. Tel +46 223 400 00.
www.secotools.com

02739985 ST20106249 GB SECO TOOLS AB, PA Group Karlstad 2010

TOOLS

MILLING

TURBO

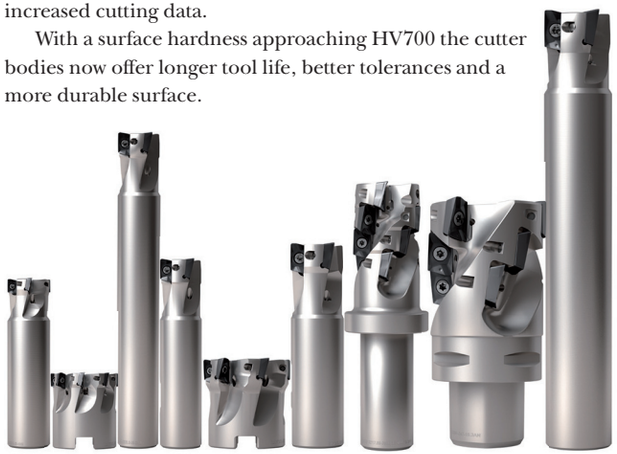
MAXIMUM PERFORMANCE IN SQUARE SHOULDER MILLING

HIGH PERFORMANCE SQUARE SHOULDER MILLING CUTTERS

Turbo square shoulder milling cutters offering you solutions from the most simple to the very complex, depending on your needs. Steel, stainless steel, cast iron, hardened materials and high-temperature alloys can be machined with excellent results.

Our positive cutting rake design not only reduces power consumption, it also leads to longer tool life and the possibility for increased cutting data.

With a surface hardness approaching HV700 the cutter bodies now offer longer tool life, better tolerances and a more durable surface.



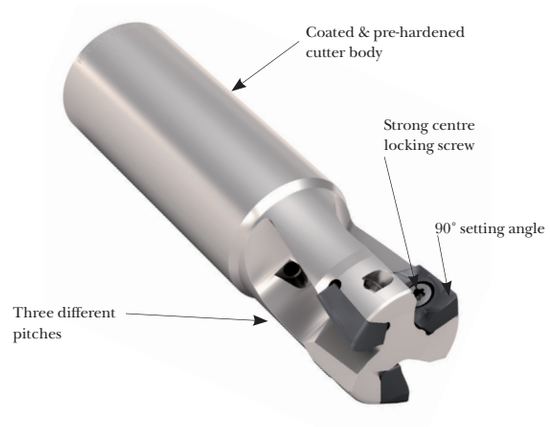
MAIN BENEFITS

- Increased reliability
- Higher precision and tolerances on the parts machined.
- The coated/hardened surface protects the tool from wear
- The coated/hardened surface prevents chips from welding on the cutter body
- 90º shoulder angle.
- Versatile and flexible tool for most materials.
- Wide range, industry leading carbide grades.

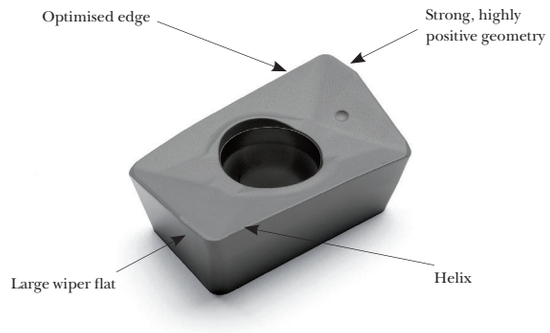
TURBO FAMILY RANGE

Cutter diameter range:	10 - 250mm
Pitch configurations:	Coarse, Normal, Close, Super close
Type of mountings:	Cylindrical, Weldon, Seco Weldon, Shell, Combimaster, Seco Capto™
Insert type and sizes:	XO..06, XO..09, XO..12, XO..18, (2 edges/insert)
Insert radius range:	0.2 - 6.3 mm
Depth of cut:	Max ap = 17 mm

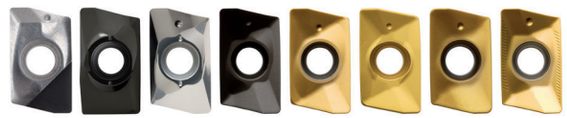
CUTTER CAPABILITY



INSERT CAPABILITY



INSERT GEOMETRIES



PVD, CVD and uncoated grades provide a complete range for machining all types of material.

Including the first choice F40M grade for small depths of cut and the Duratomic® range for the added toughness and heat resistance needed in larger depths of cut.

For geometries Seco offers -E, -ME, -M, -MD and -D for the range of easy to difficult machining conditions.

TURBO HELICAL CUTTERS

Seco helical cutters open the door to new levels of productivity.

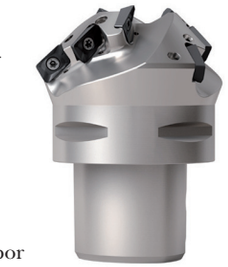
Imagine the free cutting performance of Turbo with dramatically increased depth of cut capability, four or five times that of the standard configuration!

FOR THE SMALLEST TO THE BIGGEST OPERATIONS

For smaller applications, we have engineered both Nano and Micro to be highly-productive and economical alternatives to what has traditionally been an HSS and solid carbide endmill market.

For applications that are medium to large, Seco offers helical cutters in both Super and Power versions – up to 100 mm diameter.

We use strong, thick inserts held securely in the pocket with TorxPlus™ screws, rigid cutter bodies, and a super-positive, free-cutting geometry to make maximum use of available power.



Latest additions to the Super Turbo family is a range of Combimaster chamfering tools, for 30°, 45°, 60° and 75° setting angles, together with helical versions in Seco-Capto™ system and arbor type backends.

APPLICATION AREAS