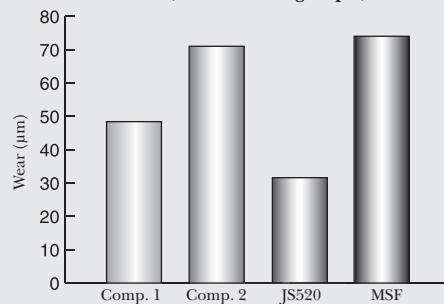


APPLICATION EXAMPLE

APPLICATION EXAMPLE

Material	1.2379 (Seco material group 6)		
Dimensions	200x100x100 mm		
Machine	Hermle C30V		
Tools	Competitor 1 / Competitor 2 / JS520 / 45100-MEGA		
Cutting data	v_c	100 m/min	
	n	3180 rev/min	
	f_z	0.06 mm	
	v_f	1145 mm/min	
	a_p	20 mm	
	a_e	0.21 mm	
Coolant	Emulsion		
Result	Tool	Wear (μm)	Distance (m)
	Competitor 1	52	52,5
	Competitor 2	75	52,5
	JS520	36	52,5
	45100-MEGA (MSF)	78	52,5

Wear (μm) after 52,5 m
1.2379 (Seco material group 6)



CONTACT & INFORMATION

SECO MACHINING NAVIGATOR:

Jabro™-solid end mills
catalogue & technical guide 2011

ONLINE INFORMATION:

More Jabro™-Solid² information:
<http://www.secotools.com/jabrosolid2>

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

TOOLS

MILLING

JABRO™-SOLID² MULTI FLUTE



**SOLID CARBIDE MULTI FLUTE END MILL
FOR SEMI FINISHING**

SECO

SECO

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

JABRO™-SOLID² MULTI FLUTE

Jabro™-Solid² Multi flute (JS520) is a new geometry in the solid² range for general machining with flexibility, speed and cost efficiency.

The JS520 is designed for finishing in square shoulder milling applications in steel, stainless steel and cast iron.

RANGE

Cutter	Diameter	No of flutes	Applications	Materials
JS520	4-25 mm	5-8	Side milling, (semi) finishing	Steel, stainless steel and cast iron

MAIN BENEFIT

- Improved surface quality
- Reduced machine time in (semi) finishing applications due to high feed rate (high number of flutes)



JABRO™-SOLID² MULTI FLUTE

FEATURES

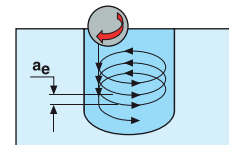
- Differential flute spacing
- to avoid vibrations
- Large core diameter
- for more stability
- Radial relief
- gives a stronger cutting edge
- Defined edge preparation
- Polished Siron-A coating
- gives increased tool life
- 5-8 flutes

ADVANTAGES

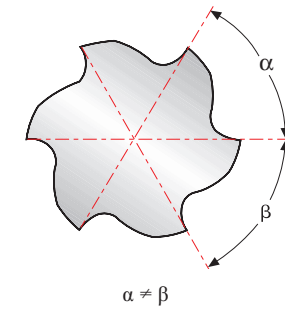
- Vibration free machining
- High process stability
- Can be used with and without coolant
- Can be used in trochoidal milling

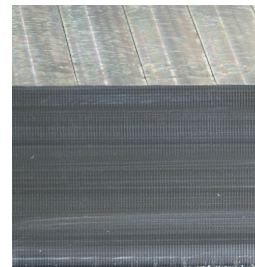
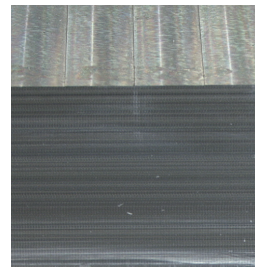
TROCHOIDAL:

Opening a slot by using side milling, making a partial circular movement in X- or Y-axis. (changing slot milling into side milling).

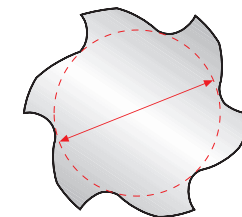


DIFFERENTIAL FLUTE SPACING



$\alpha = \beta$	$\alpha \neq \beta$
Ra=0,7	Ra=0,4
	

LARGE CORE DIAMETER



The large core diameter provides better cutter stability and less tool deflection during machining.