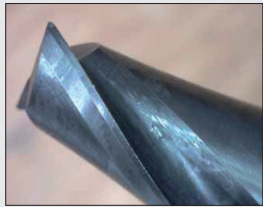


APPLICATION EXAMPLES

JS512 APPLICATION EXAMPLE

Test example	Results between a "conventional" (VHM J93) cutter compared to the new JS512 cutter.	
Material	Ck45W material (Seco material group 3-4)	
Machine	Hermle C600V	
Cutter	JS512	
Cutting data	vc	120 mm
	vf	382 mm/min
	ap	13 mm
	ae	5 mm
	Q	24,8 cm ³ /min
Result	70% improvement	



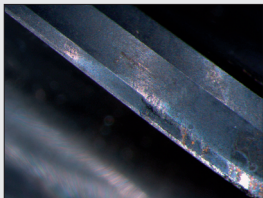
Cutting edge condition after 9 metres.



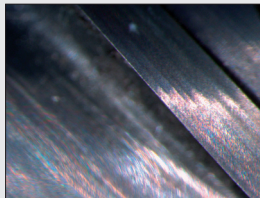
Cutting edge condition after 30 metres.

JS553 APPLICATION EXAMPLE

Test example	Results between a JS553 cutter compared to a competitor 4 flute cutter.		
Material	Seco material group 4		
Cutter	Seco : JS553 vs. Reference		
Cutting data		Reference	JS553
	vc	94 m/min	110 m/min
	fz	0,075 mm	0,10 mm
	ap	5 mm	5 mm
	ae	5 mm	5 mm
	n	3000 rev/min	3500 rev/min
	vf	900 mm/min	1050 mm/min
	Q	22,5 cm ³ /min	26,25 cm ³ /min
Result	Tool life (parts): Reference: 280 parts JS553: 630 parts		



Reference after 280 parts



JS553 after 630 parts

CONTACT & INFORMATION

SECO MACHINING NAVIGATOR:

Update Catalogue 2011

ONLINE INFORMATION:

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

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

TOOLS

MILLING

JABRO™-SOLID²



COST EFFECTIVE SOLID CARBIDE END MILLS FOR GENERAL MACHINING APPLICATIONS

SECO

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

02739986 ST20106250 GB SECO TOOLS AB, PA Group Karlstad 2010

SECO

2 FAMILIES OF COST EFFECTIVE PERFORMANCE END MILLS

Jabro™-Solid2 is a range of new solid carbide end mills for applications in general machining with flexibility, speed and cost efficiency.

JS510 VERSATILE, EASY TO USE CUTTERS

The JS510 cutters are designed to give full flexibility and efficient machining with an excellent price/performance ratio.

Cutter	Diameter	No of flutes	Applications	Materials
JS512	1-25 mm	2	Side milling and slotting	Steel, stainless steel, cast iron
JS513	1-25 mm	3	Side milling and slotting	Steel, stainless steel, cast iron
JS514	1-25 mm	4	Side milling	Steel, stainless steel, cast iron

Version, Depth of cut ap (max)		
Standard: 2 x Dc	L version: 3.5 x Dc	XL version: 5 x Dc (approx)

MAIN BENEFITS

- Increased core diameter for high tool stability
- 2, 3 and 4 fluted cutters for optimised tool selection
- SIRON-A coating for long tool life
- Outstanding cost/performance ratio

JS550 UNIVERSAL PERFORMANCE CUTTERS

The JS550 cutters have additional features for increased performance and productivity. The tools are suitable for machining most materials including hardened steels, aluminium and superalloys.

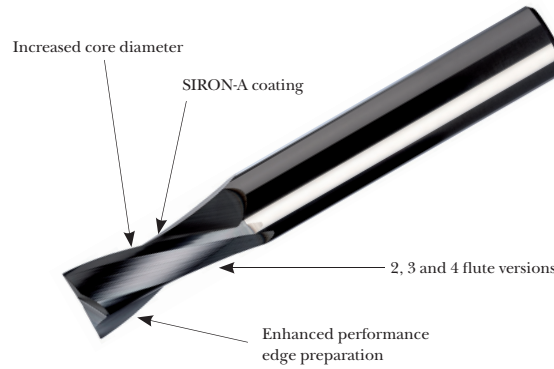
Cutter	Diameter	No of flutes	Applications	Materials
JS553	2-25 mm	3	Side milling and slotting	All materials
JS554	3-25 mm	4	Side milling and slotting	All materials

Version, Depth of cut ap (max)	
Standard: 2 x Dc	L version: 3.5 x Dc

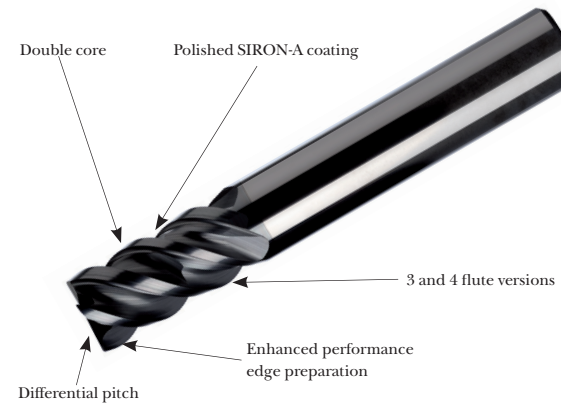
MAIN BENEFITS

- Double core for high tool stability and extra long tool life
- Differential pitch for reduced chatter and increased cutting data
- Polished SIRON-A coating for smooth chip flow and long tool life

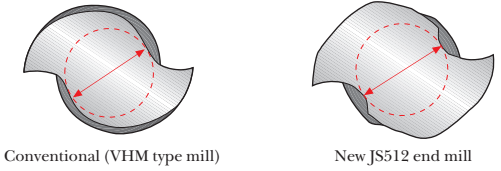
JABRO-SOLID² JS510 FEATURES



JABRO SOLID² JS550 FEATURES

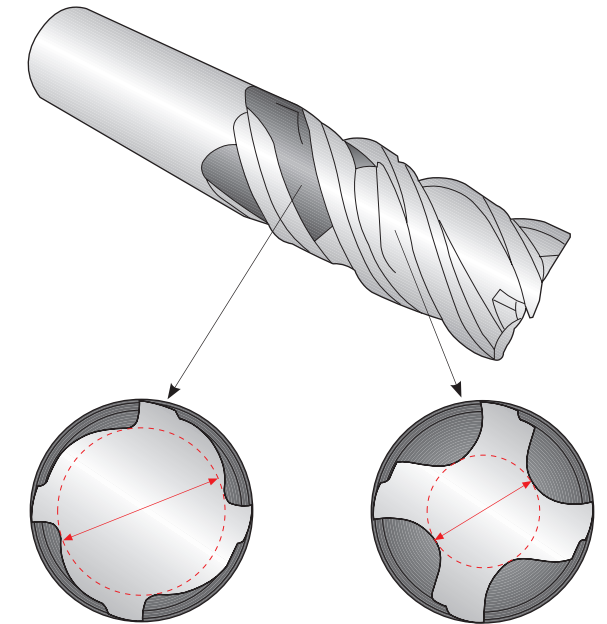


INCREASED CORE DIAMETER



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

DOUBLE CORE TECHNOLOGY



Added stability allows heavier cuts & reduces tool deflection.

Increased flute space gives excellent chip evacuation.