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SECO 

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SECOMAX™ C-LOCK CBN INSERTS

IMPROVED ECONOMY, RELIABILITY AND FLEXIBILITY.

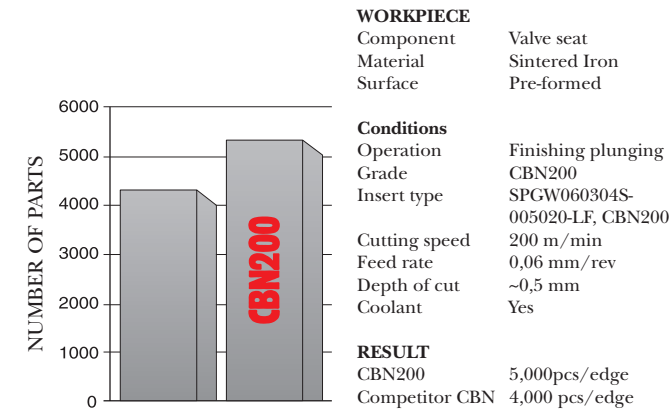
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SECOMAX™ C-LOCK CBN INSERTS: FULL FACED INSERT ECONOMY

HIGH PRODUCTIVITY MACHINING OF HARDENED STEELS AND SOFT ABRASIVE MATERIALS

Secomax Polycrystalline Cubic Boron Nitride inserts are highly wear-resistant and have the capability to maintain a consistent cutting edge while providing long tool life-the two issues that can determine the ultimate productivity of any machining operation.

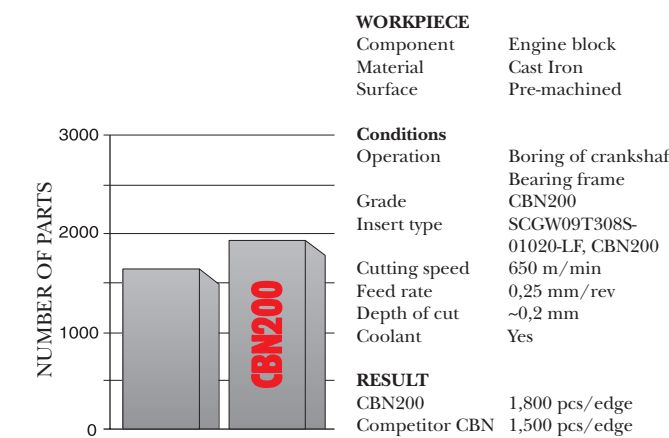
To extend your productivity and economy, SECO introduces a range of full face inserts with a center lock hole giving you a more edges per insert, no tip size limitations and a positive geometry. With the new C-lock inserts you can now plunge turn and carry out a variety of milling operations for dramatically increased performance.



WORKPIECE
Component: Valve seat
Material: Sintered Iron
Surface: Pre-formed

Conditions
Operation: Finishing plunging
Grade: CBN200
Insert type: SPGW060304S-005020-LF, CBN200
Cutting speed: 200 m/min
Feed rate: 0,06 mm/rev
Depth of cut: ~0,5 mm
Coolant: Yes

RESULT
CBN200: 5,000 pcs/edge
Competitor CBN: 4,000 pcs/edge



WORKPIECE
Component: Engine block
Material: Cast Iron
Surface: Pre-machined

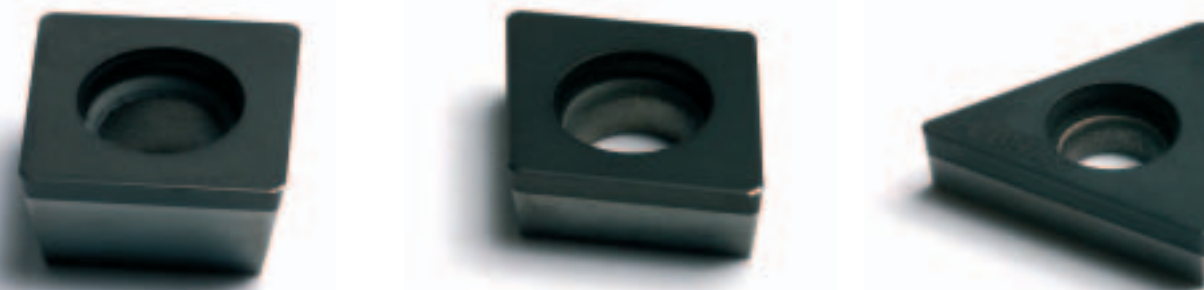
Conditions
Operation: Boring of crankshaft
Grade: CBN200
Insert type: SCGW09T308S-01020-LF, CBN200
Cutting speed: 650 m/min
Feed rate: 0,25 mm/rev
Depth of cut: ~0,2 mm
Coolant: Yes

RESULT
CBN200: 1,800 pcs/edge
Competitor CBN: 1,500 pcs/edge

FULL-FACE C-LOCK INSERTS, ECONOMY, RELIABILITY AND FLEXIBILITY

SECO's new full face inserts are made using a new high-tech manufacturing process that uses no brazing joint and maintains the strength needed for the demanding applications that are typical in high productivity machining.

The result is two-fold: a reduced overall cost per cutting edge and an increased number of parts produced per insert. The effect of which has a significant overall impact on productivity for a variety of applications and materials.



SECOMAX APPLICATIONS, GRADES AND STYLES

SECO engineered these C-Lock inserts for a broad range of applications including turning, boring and milling.

The insert program consists of a range of small C, D, S, and T-style insert shapes, providing 2, 3 and 4 available cutting edges per insert.

Two Secomax grades are offered for various operations in material such as case hardened steels, powder metall (PM) parts and a range of cast irons.

Grades CBN10 and CBN200

For high speed finishing of materials such as case hardened steel, CBN10 is proven to give predictable tool life at speeds up to 200 m/min. CBN200 provides excellent edge

quality and abrasion resistance in not only hardened steels, but also in cast irons and PM materials.

