

# Jiffy Tools

## Indexable Carbide Counterbore Tools

Designed to easily and quickly counterbore and chamfer mold plates for water/oil cooling connectors and fittings

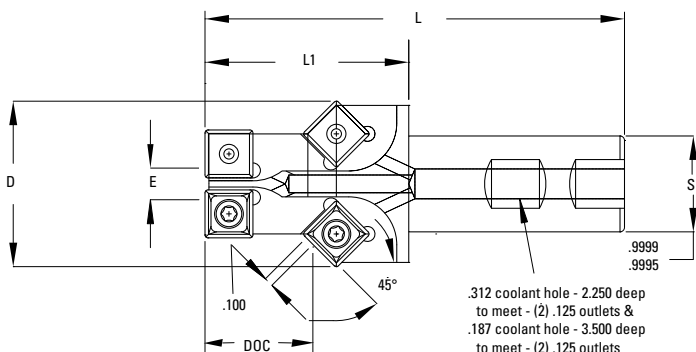


### Features:

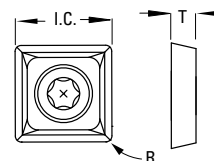
- Save machining time by combining 2 cutting operations into 1 (counterbore and chamfer)
- Designed to provide correct depth of counterbore with a chamfer that will be consistent on every hole
- Interchangeable and replaceable 4 sided carbide inserts are used in all 3 cutter bodies
- Coolant through cutter keeps the cutting surface cool and lubricated for a clean consistent cut

### INDIVIDUAL COUNTERBORES

| ITEM NUMBER | D     | E    | L     | L-1   | DOC   | S     | INCLUDED)                        | FOR                                 |
|-------------|-------|------|-------|-------|-------|-------|----------------------------------|-------------------------------------|
| JT1125      | 1.125 | .330 | 4.375 | 2.125 | 1.125 | 1.000 | (4) JTS SCREWS<br>(1) JTW WRENCH | 1/8 - 27 & 1/4 - 18                 |
| JT1250      | 1.250 | .577 | 4.500 | 2.250 | 1.250 | 1.250 |                                  | 3/8 - 18 & 1/2 - 14                 |
| JT1500      | 1.500 | .827 | 4.750 | 2.500 | 1.500 | 1.250 |                                  | 3/4 - 14, 1 - 11 1/2 & 1/4 - 11 1/2 |



### ACCESSORIES



| ITEM NUMBER | DESC           | I.C. | T    | R    |
|-------------|----------------|------|------|------|
| JTCI        | INSERTS, 10/PK | .500 | .187 | .031 |



| ITEM NUMBER | DESC                         | TORX SIZE | RECOMMENDED TORQUE | MAX TORQUE |
|-------------|------------------------------|-----------|--------------------|------------|
| JTS         | INSERT SCREWS, 4/PK          | .500      | 15.3-18.3          | 30.5       |
| JTW         | WRENCH FOR JTS INSERT SCREWS |           |                    |            |

### SETS

| ITEM NUMBER | INCLUDES: |        |        |        |                     |                      |
|-------------|-----------|--------|--------|--------|---------------------|----------------------|
|             | BODY      |        |        | WRENCH | SCREWS (4 REQ/BODY) | INSERTS (4 REQ/BODY) |
|             | JT1125    | JT1250 | JT1500 | T-15   | JTS(4/PK)           | JTCI (10/PK)         |
| JTSET       | 1         | 1      | 1      | -      | -                   | -                    |
| JTSETAK     | 1         | 1      | 1      | 1      | 1PK                 | 1PK                  |
| JTAK        | -         | -      | -      | 1      | 1PK                 | 1PK                  |

### P20 RECOMMENDED STARTING PARAMETERS

| ITEM NUMBER | 600 SFM  | RPM      | .003-.005 IPT | IPM       |
|-------------|----------|----------|---------------|-----------|
| JT1125      |          | 2037 RPM |               | 12-20 IPM |
| JT1250      |          | 1834 RPM |               | 11-18 IPM |
| JT1500      | 1528 RPM | 9-15 IPM |               |           |