TurnLine

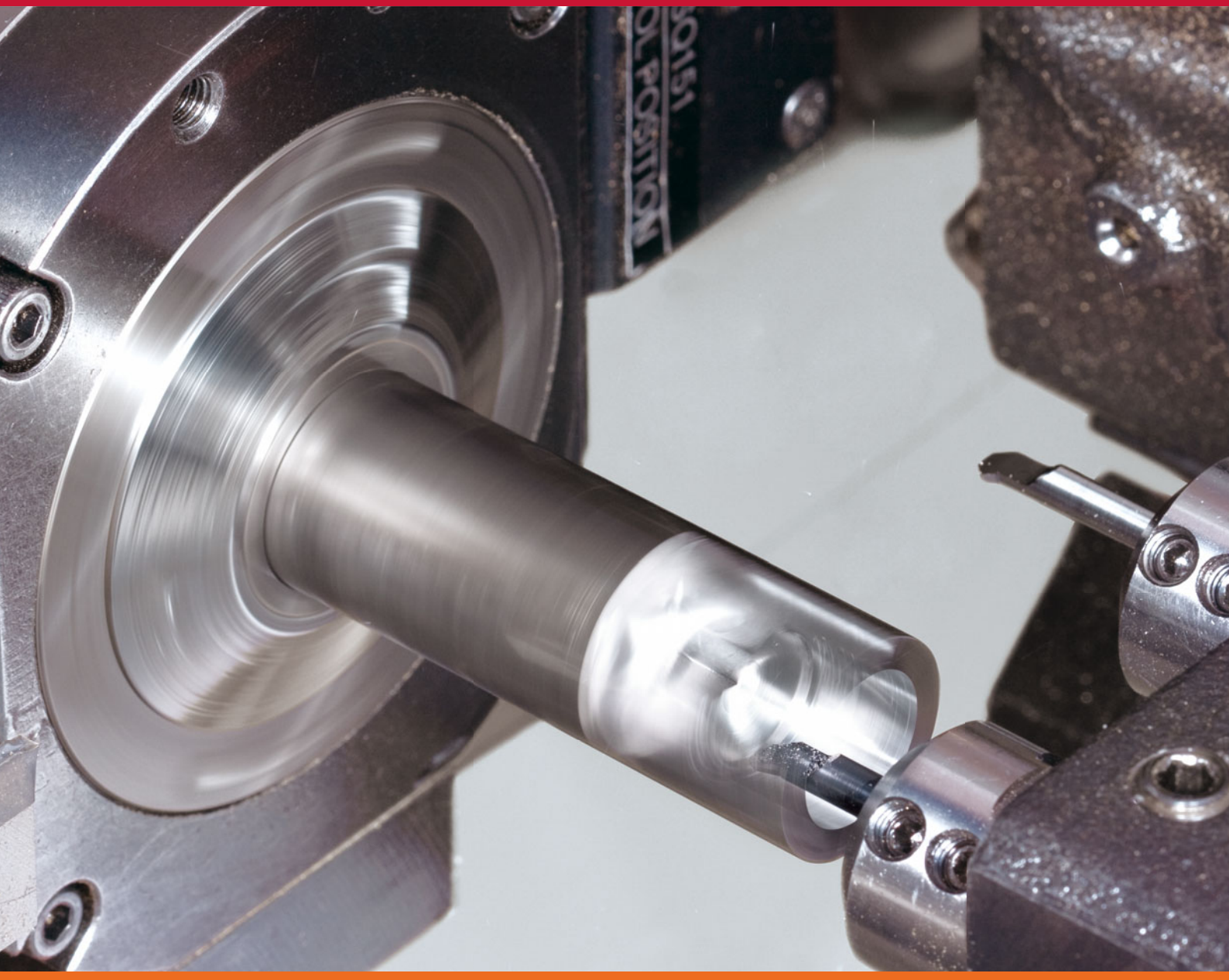
TINYMINITURN

www.tungaloy.com

Tungaloy Report No. 402-G

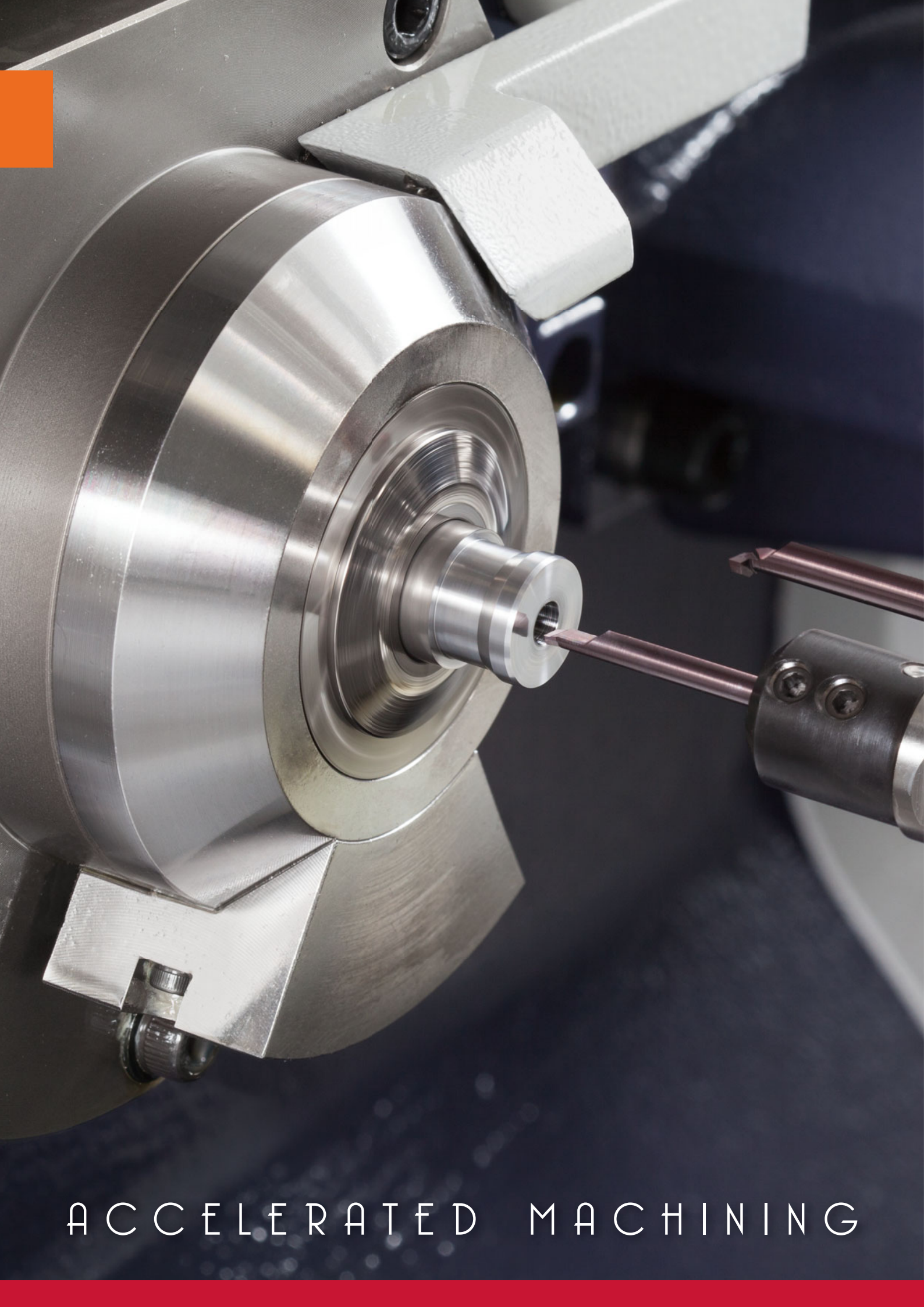
Member IMC Group Tungaloy

Now **offers collet-chuck sleeves** for easy tool changeover and accurate repeatability



INDUSTRY 4.0

FEED the SPEED!


ACCELERATED MACHINING

TurnLine

TINY MINI TURN

TUNGALOY

TUNG FORCE TURN

ACCELERATED MACHINING

New dedicated sleeves,

allowing easy tool changeover with high repeatability!

TINYMINI TURN
TUNGALOY

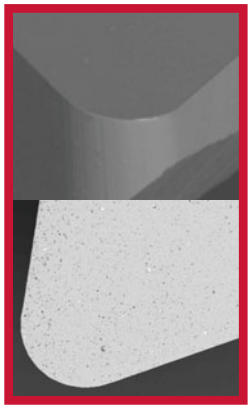
High precision and stability in ID turning of small-diameter holes

Designed for high precision

1. Strong cutting edge

Optimized geometry and coating surface

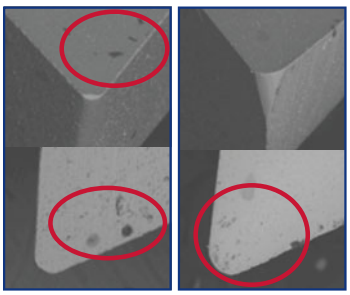
TINYMINI TURN



Smooth cutting edges and coating surface

Improvement

Competitor A Competitor B

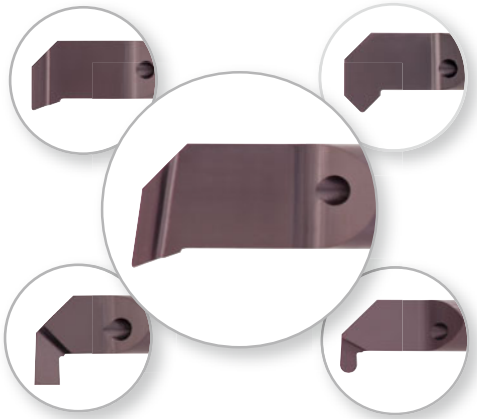


Chipped edge and unevenness on coating surface

▶ Degraded surface finishes
Short tool life due to built-up edge

Enhanced cutting edge integrity over the competitors'

- Strong cutting edge ensures stable and good surface finishes
- Smooth cutting edge provides tight dimensional tolerances



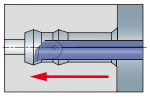
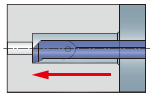
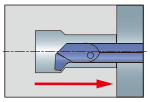
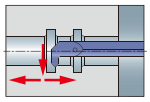
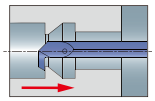
2. Coolant hole

- Supplies coolant directly to the cutting edge.
- Offers remarkable chip evacuation.

3. Enhanced lineup for a variety of ID turning operations of small-diameter holes

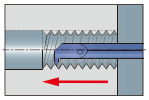
- Full lineup with 146 items of solid carbide boring bars
- Minimum boring diameter : *øD*m = 0.6 mm

Boring, profiling, chamfering

Type	Application	Shank diameter *øD*s (mm)	Min. boring dia. *øD*m (mm)
JBT (P. 10)	 Boring, profiling, chamfering	ø4, ø7	ø0.6 – ø7.0
JBP (P. 11)	 Boring, chamfering	ø4, ø7	ø2.8 – ø5.0
JBU (P. 12)	 Back boring, chamfering	ø7	ø5.0
JBC (P. 12)	 Boring, 45° chamfering	ø7	ø5.0 – ø6.8
JBB (P. 13)	 Back boring	ø4, ø7	ø3.0 – ø7.0

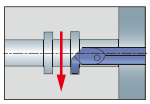
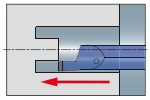
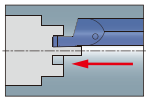
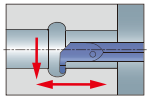
Min. boring dia. *øD*m (mm): 0 2 4 6 8 10

Threading

Type	Application	Shank diameter *øD*s (mm)	Min. boring dia. *øD*m (mm)
JBI (P. 14)	 Internal threading (Metric thread)	ø4, ø7	ø4.0 – ø7.0

Min. boring dia. *øD*m (mm): 0 2 4 6 8 10

Grooving

Type	Application	Shank diameter *øD*s (mm)	Groove widths *W* (mm)	Min. bore boring *øD*m (mm)
JBG (P. 15)	 Grooving	ø4, ø7	0.5 - 2.0	ø2.0 – ø6.8
JBF (P. 17)	 Face grooving	ø7	1.0 - 3.0	ø6.0 – ø15.0
JBS (P. 18)	 Face grooving (for shaft)	ø7	2.0	ø6.0
JBR (P.16)	 Boring, profiling (for full radius)	ø7	1.0	ø5.0 – ø6.8

Min. bore boring *øD*m (mm): 0 2 4 6 8 10 12 14 15

Enhanced lineup with sophisticated designs offers high productivity in small parts machining!

High precision collet chuck sleeves

1. Excellent indexing accuracy

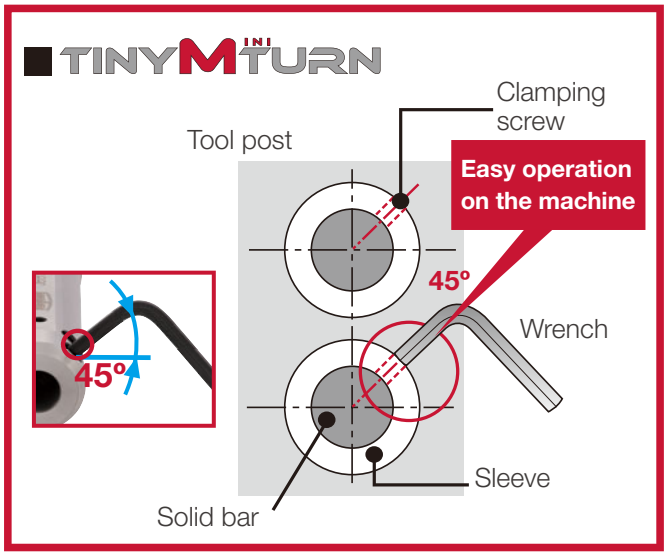
Innovative chucking system ensures excellent repeatability for precision machining

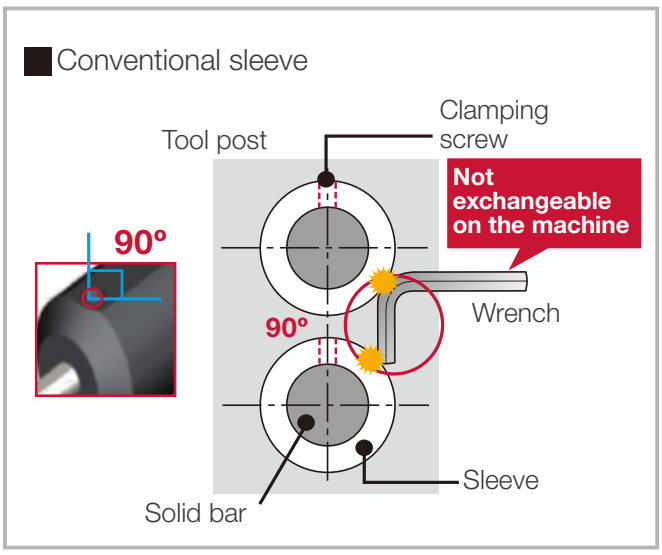
2. Double ended structure for 2 different shank sizes

One sleeve can accommodate either ø4mm or ø7 mm shank boring bars

3. Easy tool changeover

Insert clamping screw can be accessed in 45° direction, making tool changeover easy while the sleeve is on the machine





Functional TinyMiniTurn sleeves ensure stability in boring of small-diameter holes!

Sleeve designed for through-coolant supply

1. Easy connection with coolant tube

Rc1/8 threads are provided at the end of the sleeve for coolant tube connection

2. Designed for optimal overhang lengths

Sleeve and flat lengths are designed to provide optimal overhang lengths

3. High accuracy and efficient tool change

Designed to ensure repetitive accuracy as well as faster and efficient tool change without removing the sleeve from the tool post

New

Collet chuck sleeve

1. Easy tool changeover

Simple and easy tool changeover is possible on the machine

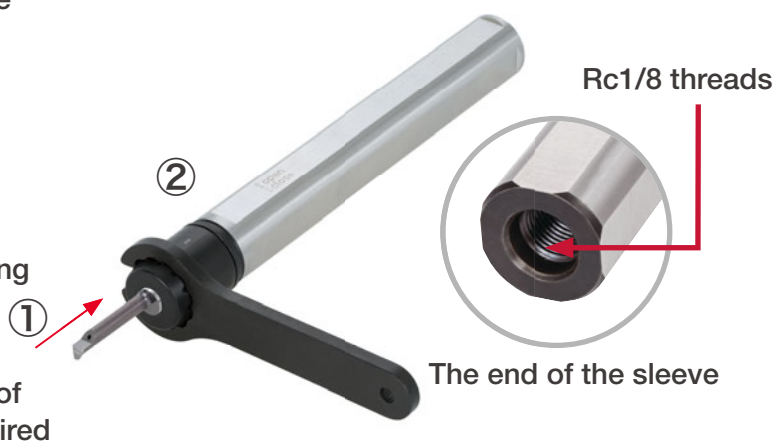
1. Place the tool in the sleeve
2. Tighten the cap with the special wrench

2. High indexing accuracy

Innovative collet chucking system ensures excellent repeatability for precision machining

3. Easy connection to coolant tube

Rc1/8 fitting threads is provided at the end of the sleeve. No additional connection is required for internal coolant supply.



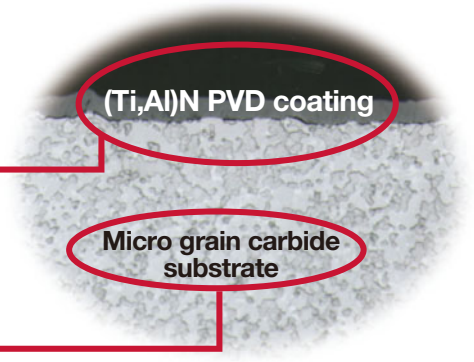
Sleeve selections

Sleeve type	 JBBS	 JBBS-C	New  JBBSA-C
Clamping system	Screw	Screw	Built-in collet
Through-coolant	No	Yes	Yes
Adaptable shank size	Both ø4 mm and ø7 mm can be assembled on the same sleeve	Separate sleeves for ø4 mm and ø7 mm	Separate sleeves for ø4 mm and ø7 mm
Available sleeve diameters	10 sizes, ø12.0 mm - ø25.4 mm	7 sizes, ø15.875 mm - ø25.4 mm	2 sizes, ø16 mm and ø20 mm
Tool changeover in the machine	Efficient	Efficient	Very Efficient

Grade

SH730 PVD coated grade

Optimized combination of (Ti,Al)N coating and extremely tough carbide substrate ensures longer tool life and cutting edge integrity



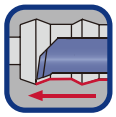
Excellent chipping & welding resistance

Thin (Ti,Al)N coating layer is deposited evenly without sacrificing the cutting edge sharpness

Tough carbide substrate ensures resistance to plastic deformation

Application	ISO classification code	Grade	Substrate			Coating layer		Features
			Specific gravity	Hardness (HRA)	T.R.S. (GPa)	Main Composition	Thickness (µm)	
P Steel	P20 - P30	SH730	14.4	91.5	3.0	(Ti,Al)N	1.0	Versatile PVD coated grade for wide range of materials and applications.
M Stainless	M20 - M30	SH730	14.4	91.5	3.0	(Ti,Al)N	1.0	
K Cast iron	K20 - K30	SH730	14.4	91.5	3.0	(Ti,Al)N	1.0	
N Non-ferrous	N20 - N30	SH730	14.4	91.5	3.0	(Ti,Al)N	1.0	
S Superalloys	S20 - S30	SH730	14.4	91.5	3.0	(Ti,Al)N	1.0	

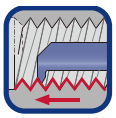
STANDARD CUTTING CONDITIONS



Boring, profiling, chamfering, back boring

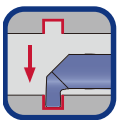
ISO	Workpiece materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	0.01 - 0.08 *
P	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	0.01 - 0.08 *
P	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	0.01 - 0.08 *
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	0.01 - 0.08 *
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	0.01 - 0.08 *
K	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	0.01 - 0.08 *
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	0.01 - 0.08 *
S	Titanium alloys (Ti-6Al-4V, etc.)	SH730	30 - 100	0.01 - 0.08 *
S	Superalloys (Inconel718, etc.)	SH730	30 - 100	0.01 - 0.08 *

* JBTR/L04020004-D006, JBTR/L04030004-D006
Max. *f* = 0.01 mm/rev



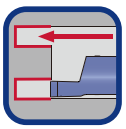
Threading (metric thread)

ISO	Workpiece materials	Grade	Cutting speed *Vc* (m/min)	Number of passes Pitch (mm) 0.5	0.75	1	1.25	1.5
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
P	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
P	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	8	10	12	15	18
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	7	9	12	14	17
K	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	7	9	12	14	17
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	6	8	10	12	15



Internal grooving

ISO	Workpiece materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	0.01 - 0.03
P	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	0.01 - 0.03
P	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	0.01 - 0.03
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	0.01 - 0.03
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	0.01 - 0.03
K	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	0.01 - 0.03
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	0.01 - 0.03
S	Titanium alloys Ti-6Al-4V etc.	SH730	30 - 100	0.01 - 0.03
S	Superalloys (Inconel718, etc.)	SH730	30 - 100	0.01 - 0.03

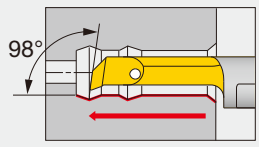


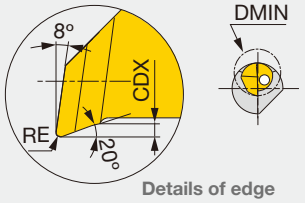
Face grooving

ISO	Workpiece materials	Grade	Cutting speed *Vc* (m/min)	Feed *f* (mm/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	0.01 - 0.05
P	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	0.01 - 0.05
P	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	0.01 - 0.05
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	0.01 - 0.05
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	0.01 - 0.05
K	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	0.01 - 0.05
N	Aluminium alloys, Copper alloys Si < 12%	SH730	90 - 200	0.01 - 0.05
S	Titanium alloys Ti-6Al-4V etc.	SH730	30 - 100	0.01 - 0.05
S	Superalloys (Inconel718, etc.)	SH730	30 - 100	0.01 - 0.05

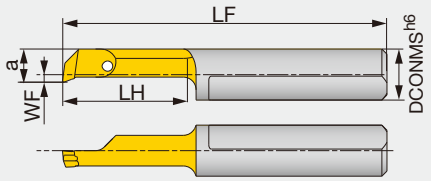
JBT R/L

Solid boring bars for boring, profiling & chamfering





Details of edge



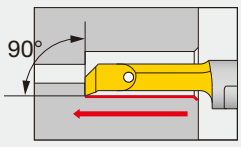
Right hand (R) shown.

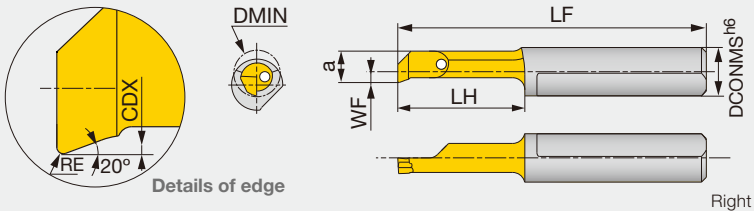
Designation	SH730	DMIN	DCONMS	WF	a	LF	LH	CDX	RE $^{+0.05}_{0}$
JBTR04020004-D006	●	0.6	4	-	0.5	18.5	2	0.08	0.04
JBTR04030004-D006	●	0.6	4	-	0.5	19.5	3	0.08	0.04
JBTR04045005-D010	●	1	4	-	0.9	21	4.5	0.1	0.05
JBTR04065005-D010	●	1	4	-	0.9	23	6.5	0.1	0.05
JBTR04040005-D020	●	2	4	-	1.7	20.5	4	0.1	0.05
JBTR04090005-D020	●	2	4	-	1.7	25.5	9	0.1	0.05
JBTR04140005-D020	●	2	4	-	1.7	30.5	14	0.1	0.05
JBTR/L04090010-D028	●	2.8	4	0.9	2.6	25.5	9	0.2	0.1
JBTR/L04150010-D028	●	2.8	4	0.9	2.6	31.5	15	0.2	0.1
JBTR/L04190010-D028	●	2.8	4	0.9	2.6	35.5	19	0.2	0.1
JBTR/L04090010-D040	●	4	4	1.5	3.5	25.5	9	0.3	0.1
JBTR/L04150010-D040	●	4	4	1.5	3.5	31.5	15	0.3	0.1
JBTR/L04190010-D040	●	4	4	1.5	3.5	35.5	19	0.3	0.1
JBTR04230010-D040	●	4	4	1.5	3.5	39.5	23	0.3	0.1
JBTR04270010-D040	●	4	4	1.5	3.5	43.5	27	0.3	0.1
JBTR/L07090015-D050	●	5	7	0.9	4.4	25	9	0.5	0.15
JBTR/L07140015-D050	●	5	7	0.9	4.4	30	14	0.5	0.15
JBTR/L07190015-D050	●	5	7	0.9	4.4	35	19	0.5	0.15
JBTR/L07240015-D050	●	5	7	0.9	4.4	40	24	0.5	0.15
JBTR/L07290015-D050	●	5	7	0.9	4.4	45	29	0.5	0.15
JBTR07340015-D050	●	5	7	0.9	4.4	50	34	0.5	0.15
JBTR/L07140015-D060	●	6	7	1.8	5.3	30	14	0.5	0.15
JBTR/L07210015-D060	●	6	7	1.8	5.3	37	21	0.5	0.15
JBTR/L07240015-D060	●	6	7	1.8	5.3	40	24	0.5	0.15
JBTR/L07290015-D060	●	6	7	1.8	5.3	45	29	0.5	0.15
JBTR07340015-D060	●	6	7	1.8	5.3	50	34	0.5	0.15
JBTR07410015-D060	●	6	7	1.8	5.3	57	41	0.5	0.15
JBTR/L07190015-D068	●	6.8	7	2.8	6.3	35	19	0.6	0.15
JBTR07240015-D068	●	6.8	7	2.8	6.3	40	24	0.6	0.15
JBTR/L07290015-D068	●	6.8	7	2.8	6.3	45	29	0.6	0.15
JBTR/L07340015-D070	●	7	7	2.8	6.3	50	34	0.6	0.15
JBTR07390015-D070	●	7	7	2.8	6.3	55	39	0.6	0.15
JBTR07440015-D070	●	7	7	2.8	6.3	60	44	0.6	0.15
JBTR07490015-D070	●	7	7	2.8	6.3	65	49	0.6	0.15

● : Line up

JBP R

Solid boring bars for boring & chamfering



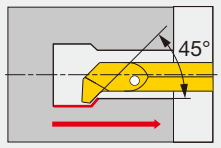


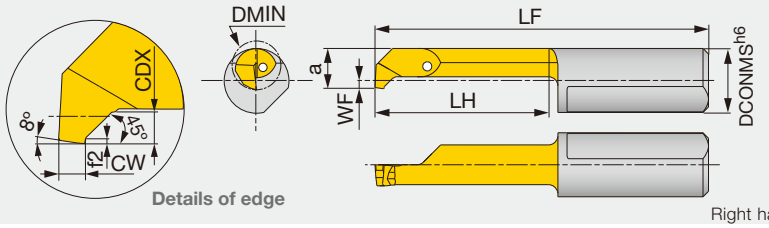
Designation	SH730	DMIN	DCONMS	WF	a	LF	LH	CDX	RE $^{+0.05}_{0}$
JBPR04090010-D028	●	2.8	4	0.9	2.6	25.5	9	0.2	0.1
JBPR04150010-D028	●	2.8	4	0.9	2.6	31.5	15	0.2	0.1
JBPR04090010-D040	●	4	4	1.5	3.5	25.5	9	0.3	0.1
JBPR04150010-D040	●	4	4	1.5	3.5	31.5	15	0.3	0.1
JBPR07140015-D050	●	5	7	0.9	4.4	30	14	0.5	0.15
JBPR07190015-D050	●	5	7	0.9	4.4	35	19	0.5	0.15

● : Line up

JBU R

Solid boring bars for back boring & chamfering



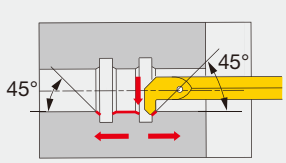


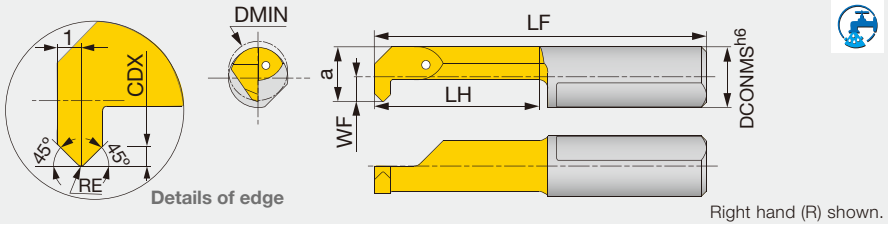
Designation	SH730	DMIN	DCONMS	WF	a	LF	LH	f2	CDX	CW $^{+0.05}_{0}$
JBUR07140010-D050	●	5	7	0.9	4.4	30	14	0.2	1	1
JBUR07190010-D050	●	5	7	0.9	4.4	35	19	0.2	1	1

● : Line up

JBC R

Solid boring bars for boring & 45° chamfering



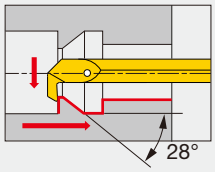


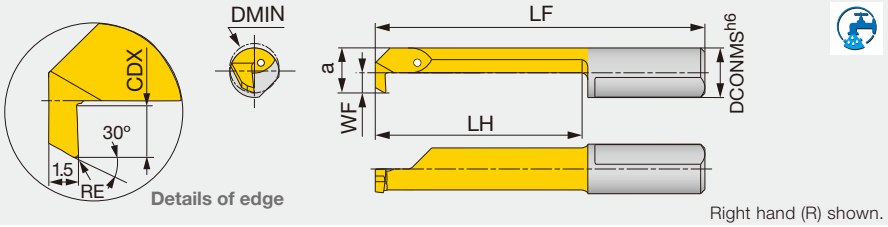
Designation	SH730	DMIN	DCONMS	WF	a	LF	LH	CDX	RE ±0.05
JBCR07140020-D050	●	5	7	0.9	4.4	30	14	0.7	0.2
JBCR07190020-D050	●	5	7	0.9	4.4	35	19	0.7	0.2
JBCR07190020-D068	●	6.8	7	2.8	6.3	35	19	0.7	0.2

● : Line up

JBB R

Solid boring bars for back boring



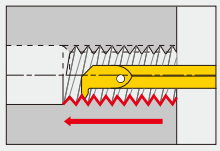


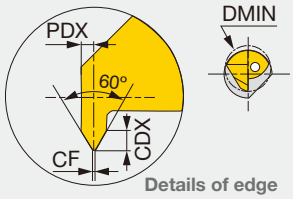
Designation	SH730	DMIN	DCONMS	WF	a	LF	LH	CDX	RE ±0.05
JBBR04140020-D030	●	3	4	0.6	2.6	30	14	0.5	0.2
JBBR04190020-D030	●	3	4	0.6	2.6	35	19	0.5	0.2
JBBR04140015-D040	●	4	4	1.5	3.5	30	14	0.8	0.15
JBBR04240015-D040	●	4	4	1.5	3.5	40	24	0.8	0.15
JBBR07190020-D050	●	5	7	0.9	4.4	35	19	1	0.2
JBBR07290020-D050	●	5	7	0.9	4.4	45	29	1	0.2
JBBR07190020-D060	●	6	7	1.8	5.3	35	19	1.8	0.2
JBBR07290020-D060	●	6	7	1.8	5.3	45	29	1.8	0.2
JBBR07190020-D070	●	7	7	2.8	6.3	35	19	2.5	0.2
JBBR07290020-D070	●	7	7	2.8	6.3	45	29	2.5	0.2

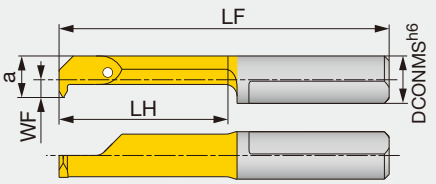
● : Line up

JBI R

Solid boring bars for threading (metric)







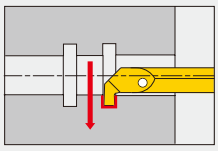
Right hand (R) shown.

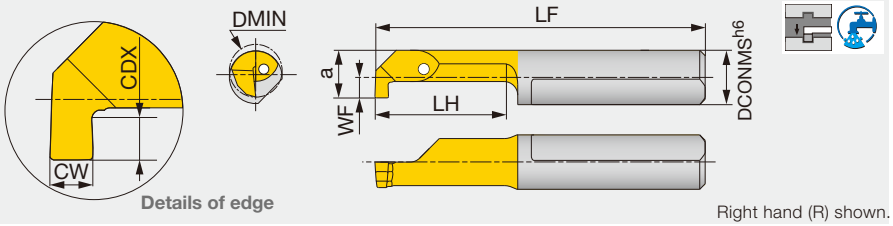
Designation	SH730	Pitch	DMIN	CF $^{0}_{-0.02}$	DCONMS	WF	a	LF	LH	CDX	PDX
JBIR04140050-D040	●	0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
JBIR07140050-D050	●	0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
JBIR07140075-D050	●	0.75	5	0.09	7	0.9	4.4	30	14	0.4	0.45
JBIR07140100-D048	●	1	4.8	0.12	7	0.9	4.4	30	14	0.6	0.55
JBIR07140100-D060	●	1	6	0.12	7	1.8	5.3	30	14	0.6	0.55
JBIR07140125-D060	●	1.25	6	0.15	7	1.8	5.3	30	14	0.7	0.65
JBIR07140150-D060	●	1.5	6	0.18	7	1.8	5.3	30	14	0.8	0.75
JBIR07140150-D070	●	1.5	7	0.18	7	2.8	6.3	30	14	0.8	0.75

● : Line up

JBG R/L

Solid boring bars for internal grooving





Details of edge

Right hand (R) shown.

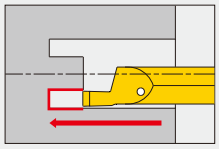
Designation	SH730	Cw $^{+0.05}_{0}$	DMIN	DCONMS	WF	a	LF	LH	CDX
JBGR04050050-D020	●	0.5	2	4	0.2	1.8	21	5	0.4
JBGR04100050-D020	●	0.5	2	4	0.2	1.8	26	10	0.4
JBGR04050070-D030	●	0.7	3	4	0.7	2.7	21	5	0.6
JBGR04100070-D030	●	0.7	3	4	0.7	2.7	26	10	0.6
JBGR04090100-D040	●	1	4	4	1.5	3.5	25.5	9	0.8
JBGR04150100-D040	●	1	4	4	1.5	3.5	31.5	15	0.8
JBGR07090100-D050	●	1	5	7	0.9	4.4	25	9	1
JBGR07140100-D050	●	1	5	7	0.9	4.4	30	14	1
JBGR07090150-D050	●	1.5	5	7	0.9	4.4	25	9	1
JBGR07140150-D050	●	1.5	5	7	0.9	4.4	30	14	1
JBGR07090200-D050	●	2	5	7	0.9	4.4	25	9	1
JBGR07190200-D050	●	2	5	7	0.9	4.4	35	19	1
JBGR/L07090100-D060	●	1	6	7	1.8	5.3	25	9	1.8
JBGR07140100-D060	●	1	6	7	1.8	5.3	30	14	1.8
JBGR07210100-D060	●	1	6	7	1.8	5.3	37	21	1.8
JBGR07290100-D060	●	1	6	7	1.8	5.3	45	29	1.8
JBGR/L07090150-D060	●	1.5	6	7	1.8	5.3	25	9	1.8
JBGR07140150-D060	●	1.5	6	7	1.8	5.3	30	14	1.8
JBGR07210150-D060	●	1.5	6	7	1.8	5.3	37	21	1.8
JBGR07240150-D060	●	1.5	6	7	1.8	5.3	40	24	1.8
JBGR07290150-D060	●	1.5	6	7	1.8	5.3	45	29	1.8
JBGR07090200-D060	●	2	6	7	1.8	5.3	25	9	1.8
JBGR07140200-D060	●	2	6	7	1.8	5.3	30	14	1.8
JBGR07210200-D060	●	2	6	7	1.8	5.3	37	21	1.8
JBGR07240200-D060	●	2	6	7	1.8	5.3	40	24	1.8
JBGR07290200-D060	●	2	6	7	1.8	5.3	45	29	1.8
JBGR07090100-D068	●	1	6.8	7	2.7	6.2	25	9	2.5
JBGR07140100-D068	●	1	6.8	7	2.7	6.2	30	14	2.5
JBGR07210100-D068	●	1	6.8	7	2.7	6.2	37	21	2.5
JBGR07090150-D068	●	1.5	6.8	7	2.7	6.2	25	9	2.5
JBGR07140150-D068	●	1.5	6.8	7	2.7	6.2	30	14	2.5
JBGR07210150-D068	●	1.5	6.8	7	2.7	6.2	37	21	2.5
JBGR07290150-D068	●	1.5	6.8	7	2.7	6.2	45	29	2.5
JBGR07090200-D068	●	2	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140200-D068	●	2	6.8	7	2.7	6.2	30	14	2.5
JBGR07210200-D068	●	2	6.8	7	2.7	6.2	37	21	2.5
JBGR07250200-D068	●	2	6.8	7	2.7	6.2	40	25	2.5
JBGR07290200-D068	●	2	6.8	7	2.7	6.2	45	29	2.5

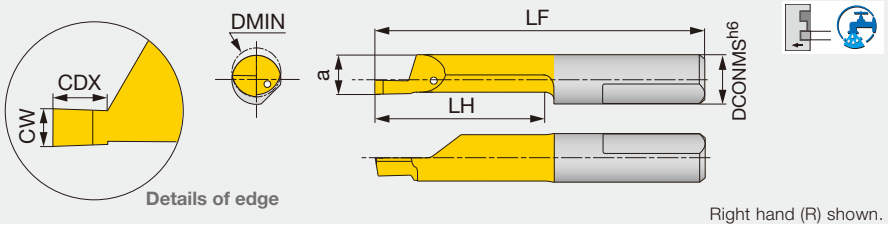
* Corner radius : less than 0.1 mm.

● : Line up

JBF R/L

Solid boring bars for face grooving





Right hand (R) shown.

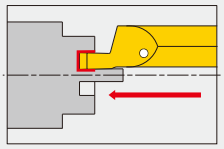
Designation	SH730	Cw $^{+0.05}_{0}$	DMIN	DCONMS	a	LF	LH	CDX
JBFR07110100-D060	●	1	6	7	5.2	26	10	1.5
JBFR07110150-D060	●	1.5	6	7	5.2	26	10	2
JBFR07110200-D060	●	2	6	7	5.2	26	10	3
JBFR07110100-D080	●	1	8	7	5.9	27	11	1.5
JBFR07110150-D080	●	1.5	8	7	5.9	27	11	2.5
JBFR07110200-D080	●	2	8	7	5.9	27	11	3
JBFR07110250-D080	●	2.5	8	7	5.9	27	11	3.5
JBFR07110300-D080	●	3	8	7	5.9	27	11	3.5
JBFR/L07210150-D080	●	1.5	8	7	5.9	36	21	2.5
JBFR07210200-D080	●	2	8	7	5.9	36	21	3
JBFR07210250-D080	●	2.5	8	7	5.9	36	21	3.5
JBFR07210300-D080	●	3	8	7	5.9	36	21	3.5
JBFR/L07300200-D080	●	2	8	7	5.9	46	30	3
JBFR07300300-D080	●	3	8	7	5.9	46	30	3.5
JBFR07200200-D080	●	2	8	7	5.9	36	20	3
JBFR07200250-D150	●	2.5	15	7	5.9	36	20	20
JBFR07200300-D150	●	3	15	7	5.9	36	20	20
JBFR07300300-D150	●	3	15	7	5.9	46	30	30

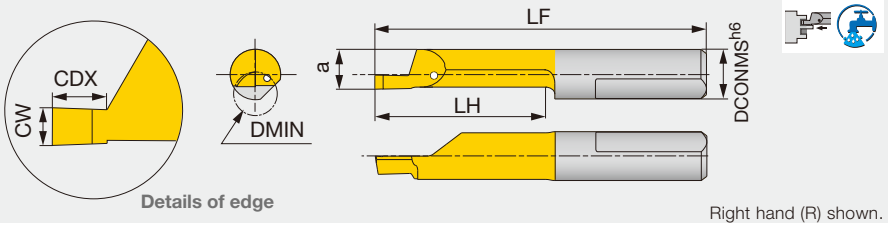
* Corner radius : less than 0.1 mm.

● : Line up

JBS R

Solid boring bars for face grooving (for shaft machining)





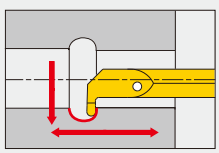
Designation	SH730	Cw $^{+0.05}_{0}$	DMIN	DCONMS	a	LF	LH	CDX
JBSR07200200-D060	●	2	6	7	5.2	36	20	4

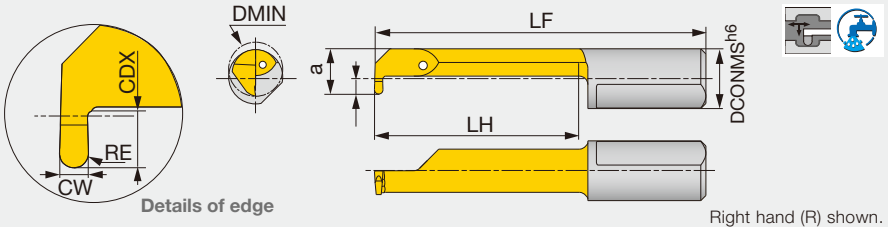
* Corner radius : less than 0.1 mm.

● : Line up

JBR R

Solid boring bars for Boring & profiling (full radius type)





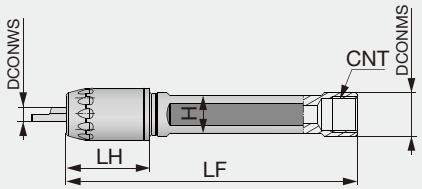
Designation	SH730	Cw $^{+0.05}_{0}$	DMIN	DCONMS	WF	a	LF	LH	CDX	RE
JBRR07190050-D050	●	1	5	7	0.9	4.4	35	19	1	0.5
JBRR07240050-D060	●	1	6	7	1.8	5.3	40	24	1.8	0.5
JBRR07290050-D068	●	1	6.8	7	2.8	6.3	45	29	2.5	0.5

● : Line up

JBBSA-C

Collet chuck sleeve for solid carbide bars

New



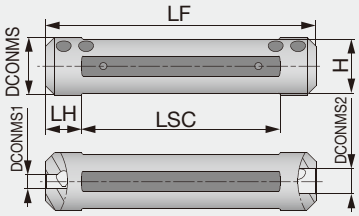
Designation	DCONMS	DCONWS	LF	LH	H	CNT
JBBSA16-4-L100C	16	4	100	23	14	Rc1/8
JBBSA16-7-L100C	16	7	100	23	14	Rc1/8
JBBSA20-4-L120C	20	4	120	23	18	Rc1/8
JBBSA20-7-L120C	20	7	120	23	18	Rc1/8

SPARE PARTS

Designation	Cap	Wrench
JBBSA**-4-L100C	CAP-A-4	WRENCH-A-4
JBBSA**-7-L100C	CAP-A-7	WRENCH-A-7

JBBS

Sleeve for external coolant supply



Designation	DCONMS	DCONWS1	DCONWS2	LF	LH	LSC	H
JBBS12-4-4	12	4	4	75	10	55	10.3
JBBS127-4-4	12.7	4	4	76.2	10	56.2	11.6
JBBS14-4-4	14	4	4	75	10	55	12
JBBS159-4-7	15.875	4	7	76.2	10	56.2	14
JBBS16-4-7	16	4	7	75	10	55	15
JBBS19-4-7	19.05	4	7	89	10	69	17.2
JBBS20-4-7	20	4	7	90	10	70	18
JBBS22-4-7	22	4	7	90	10	70	20
JBBS25-4-7	25	4	7	100	10	80	23
JBBS254-4-7	25.4	4	7	90	10	70	23.4

SPARE PARTS


Designation	Clamping screw	Wrench
JBBS12-4-4	SSHM5-4PF-S	P-2.5
JBBS127-4-4	SSHM5-6PF-S	P-2.5
JBBS14-4-4	SSHM5-4PF-S	P-2.5
JBBS**-4-7	SSHM5-6PF-S	P-2.5

JBBS-C

Sleeve for internal coolant supply

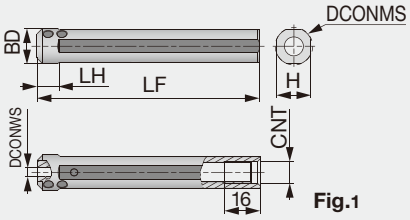


Fig.1

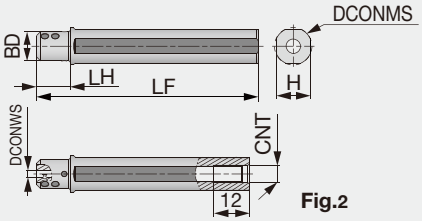


Fig.2

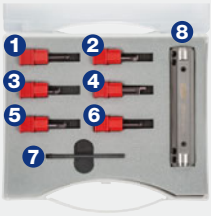
Designation	DCONMS	BD	DCONWS	LF	LH	H	CNT	Fig
JBBS159-4-L100C	15.875	15.875	4	100	10	14.58	Rc1/8	1
JBBS159-7-L100C	15.875	15.875	7	100	10	14.58	Rc1/8	1
JBBS16-4-L100C	16	16	4	100	10	15	Rc1/8	1
JBBS16-7-L100C	16	16	7	100	10	15	Rc1/8	1
JBBS19-4-L100C	19.05	17.5	4	100	20	17.2	Rc1/8	2
JBBS19-7-L100C	19.05	17.5	7	100	20	17.2	Rc1/8	2
JBBS20-4-L100C	20	17.5	4	100	20	18	Rc1/8	2
JBBS20-7-L100C	20	17.5	7	100	20	18	Rc1/8	2
JBBS22-4-L100C	22	17.5	4	100	20	20	Rc1/8	2
JBBS22-7-L100C	22	17.5	7	100	20	20	Rc1/8	2
JBBS25-4-L100C	25	18	4	100	23	23	Rc1/8	2
JBBS25-7-L100C	25	18	7	100	23	23	Rc1/8	2
JBBS254-4-L100C	25.4	18	4	100	23	23.4	Rc1/8	2
JBBS254-7-L100C	25.4	18	7	100	23	23.4	Rc1/8	2

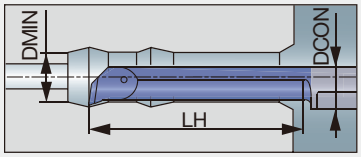
SPARE PARTS

Designation	Clamping screw	Wrench
JBBS**-4-L100C	SSHM5-6PF-S	P-2.5
JBBS**-7-L100C	SSHM5-4PF-S	P-2.5

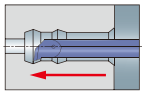
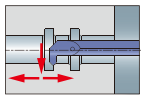
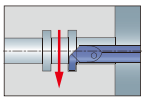
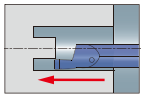
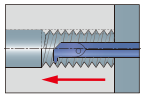
KIT-TINYTURN-GENERAL

General kit





Cat. No.	Kit
KIT-TINYTURN-GENERAL	General

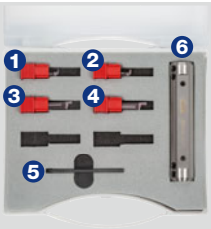
Applications		Cat. No.	DMIN	DCON	LH	RE	CW	Pitch
	Boring	❶ JBTR04150010-D040	4.0	4.0	15.0	0.1	-	-
		❷ JBTR07140015-D060	6.0	7.0	14.0	0.15	-	-
	Boring 45° Chamfering	❺ JBCR07140020-D050	5.0	7.0	14.0	0.2	-	-
	Internal Grooving	❸ JBGR07090100-D060	6.0	7.0	9.0	-	1.0	-
	Face Grooving	❹ JBFR07110200-D060	6.0	7.0	11.0	-	2.0	-
	Threading	❻ JBIR07140125-D060	6.0	7.0	14.0	-	1.25	1.25

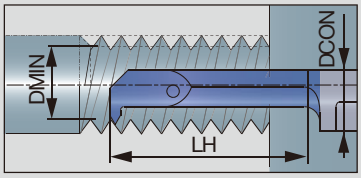
Parts	Cat. No.
Wrench	❼ P-2.5

Parts	Cat. No.
Sleeve	❽ JBBS20-4-7

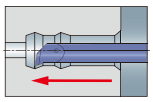
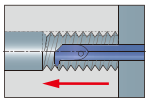
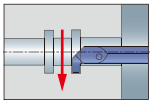
KIT-TINYTURN-THREADING

Boring, Threading and Grooving kit





Cat. No.	Kit
KIT-TINYTURN-THREADING	Boring, Threading and Grooving

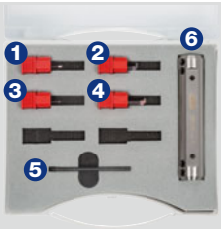
Applications		Cat. No.		DMIN	DCON	LH	RE	CW	Pitch
	Boring	❶	JBTR04150010-D040	4.0	4.0	15.0	0.1	-	-
	Threading	❸	JBIR04140050-D040	4.0	4.0	14.0	-	-	0.5
		❹	JBIR07140075-D050	5.0	7.0	14.0	-	-	0.75
	Internal Grooving	❷	JBGR04150100-D040	4.0	4.0	15.0	-	1.0	-

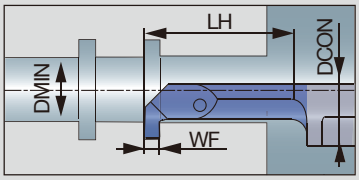
Parts	Cat. No.	
Wrench	❺	P-2.5

Parts	Cat. No.	
Sleeve	❻	JBBS20-4-7

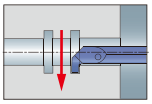
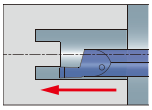
KIT-TINYTURN-GROOVING

Grooving kit





Cat. No.	Kit
KIT-TINYTURN-GROOVING	Grooving

Applications		Cat. No.	DMIN	DCON	LH	RE
	Internal Grooving	❶ JBGR07090100-D060	6.0	7.0	9.0	1.0
		❷ JBGR07140200-D068	6.8	7.0	14.0	2.0
	Face Grooving	❸ JBFR07110150-D060	6.0	7.0	15.0	1.5
		❹ JBFR07110200-D060	6.0	7.0	11.0	2.0

Parts	Cat. No.
Wrench	❺ P-2.5

Parts	Cat. No.
Sleeve	❻ JBBS20-4-7

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