

Cutting parameter

Workpiece: sump
Material: Al Cu Si9

Application: M14x1.5 1.5xD
with spot face and chamfering

Tool: KW with spot face, chamfering
inserts and BGF M14x1.5 1.5xD

Cutting data:

$V_c = 175$ m/min

$n = 5000$ rpm

$f_b = 0.2$ mm/U

$V_b = 1300$ mm/min

$f_z = 0.2$ mm

$V_f = 380$ mm/min

Application time = 4.5 s

Machine: Stama



JBO, s.r.o. s. r. o.
Průmyslová zóna, s. r. o.



Cutting parameter
Workpiece: CTI-Motorcover
Material: AISI12

Application: M6 2,5xD
with spot face and chamfering

Tool: KW with spot face, chamfering
inserts and BGFZ M6 2,5xD 4 flutes

Vc = 200 m/min
fb = 0,1 mm/U
fz = 0,05 mm

Application time = 2,9 s

Machine: Chiron Fz12



JBO, Bress, GmbH & Co. KG
Produktionstechnik aus Gießen



Cutting parameter

Workpiece: Sump

Material: Al Si 12 (Cu1)

Application: M14x1,5 with spot face and chamfering for the waste oil screw

Tool: KW with form inserts and BGFZ M14x1,5 2xD 3 flutes

Cutting data:

$V_c = 200 \text{ m/min}$

$f_b = 0,2 \text{ mm/U}$

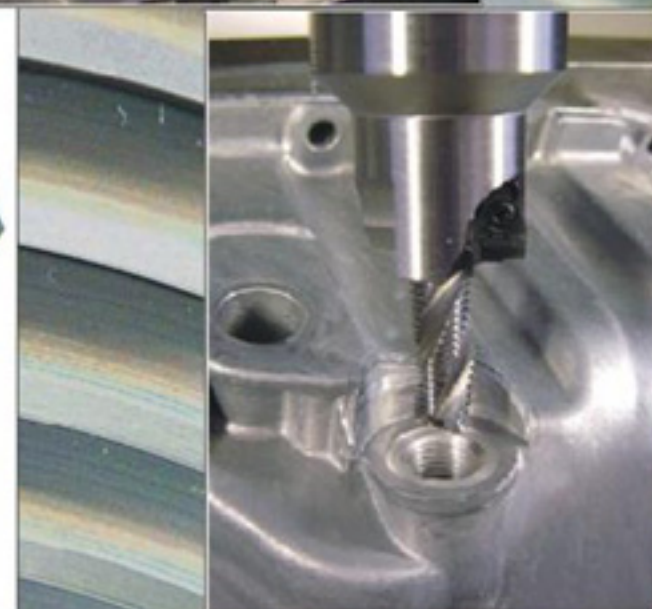
$f_z = 0,2 \text{ mm}$

Application time = 3,7s

Machine: Chiron Fz 12 /2 spindles



JBO Group GmbH & Co. KG
Produktionstechnik-Experten





JBO, s.p.a. - Ombra & C. s.p.a.
Produttori di utensili e macchine

Cutting parameter

Workpiece: *Hydraulicblock*
Material: *Al Mg Cu 1*

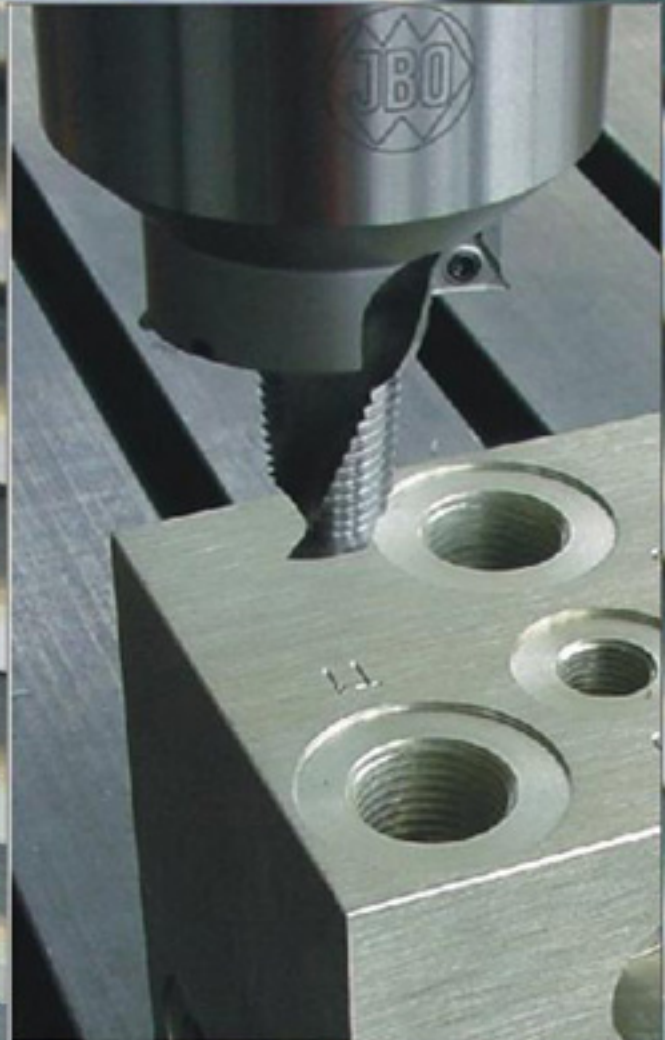
Application: *1 7/8" - 16 UN*
with *spot face and chamfering*

Tool: *KW* with *2 spot face inserts*
and *BGFZ 1 7/8" - 16 UN* with *chamfer*

Cutting data:
 $V_c = 200 \text{ m/min}$
 $f_b = 0.1 \text{ mm/U}$
 $f_z = 0.08 \text{ mm}$

Application time = *6.9s*

Machine: *Grob*



Cutting parameter

Workpiece: Compressor case

Material: Al Cu Si9

Application: 3/8"-24 UNF 1,5xD
with spot face, recess for an O-ring
and chamfering

Tool: KW with spot face, recess, chamf.
inserts and BGF 3/8"-24 UNF 1,5xD

Cutting data:

$V_c = 150$ m/min

$n = 5000$ rpm

$f_b = 0.2$ mm/U

$V_b = 1300$ mm/min

$f_z = 0.2$ mm

$V_f = 380$ mm/min

Application time = 2.5 s

Machine: Heller MC16



JBO, s.r.o. - Osmička Co.IG
Průmyslová výroba a výzkum





JBO, s.p.a. - Orbassano (TV) - Italy
Produttore di utensili

Cutting parameter

Workpiece: Motor cover
Material: Al Si9 Cu3 Fe

Application:

Kw1086 M20x1,5 with contour
Kw1087 M20x1,5 with contour
Kw1088 M22x1,5 with contour

Tool: 3 different KW's
with form inserts
and BGFZ M20x1,5 I, -33,5 mm

Cutting data:

$V_c = 150 \text{ m/min}$ $n = 5000 \text{ rpm}$
 $f_b = 0.2 \text{ mm/U}$ $V_b = 1300 \text{ mm/min}$
 $f_z = 0.2 \text{ mm}$ $V_f = 380 \text{ mm/min}$
Application time = about 8-12 s per each

Machine: Chiron Fz12
Hitachi HG400II





JBO, s.r.o. - OmbH & Co. KG
Průmyslová výroba a obchod

Cutting parameter

Workpiece: Connecting piece
Material: Al Cu Si7

Application: 1/8"-27 NPSF $t=10\text{mm}$
with spot face and chamfering

Tool: KW with spot face, chamfering
inserts and BGFZ 1/8"-27 NPSF

Cutting data:

$V_{cb} = 100\text{ m/min}$ $n = 3800\text{ rpm}$

$f_b = 0,12\text{ mm/U}$

$V_{cf} = 200\text{ m/min}$ $n = 7800\text{ rpm}$

$f_z = 0,08\text{ mm}$

Application time = 3,4 s

Machine: Chiron Fz12



Cutting parameter

Workpiece: Turbo-supercharger

Material: GG25

Application:

1 pc M10x1 with spot face an chamfering

2 pc M6 2xD

4 pc M5 2xD

Tool:

KW with spot face, chamfering inserts

and BGF M10x1 2xD

BGF M6 2xD IK 3 flutes

BGF M5 2xD 3 flutes

Cutting data:

$V_c = 100 \text{ m/min}$

$f_b = 0,12 \text{ mm/U}$

$f_z = 0,08 \text{ mm}$

Application time = 29 s

Machine: Okuma OSP-U100M



JBO, s.r.o. - Osmička Co.IG
Přesná výroba s.r.l. a.s.



Cutting parameter

Workpiece: Pumpcase
Material: Al Si 12

Application:
M10x1 2xD1= 14 mm
with spot face and chamfering

Tool:
KW with spot face, chamfering
inserts and BGFZ M10x1 2xD1K

Vb= 125 m/min fb= 0,16 mm
Vc= 200 m/min fz= 0,1 mm

Application time = 3 s

Machine: Chiron Fz12



JBO, s.r.o. - OmbH& Co.KG
Průmyslové závody



Cutting parameter

Workpiece: Cylinder head cover
Material: Al Si 7

Application:
1 7/8"-16 UN
with spot face

Tool:
KW with 2 spot face inserts
GFZ 1 7/8"-16 UN

Vc = 200 m/min
fz = 0,15 mm

Application time = 6,3 s

Machine: Grob



JBO, Dörsch, GmbH & Co. KG
Produktionstechnik und Fabrik



JBO, Dées, GmbH & Co. KG
Průmyslová výroba a údržba

Cutting parameter

Workpiece: Gear box case

Material: Al Cu Mg 1

Application:

M10x1 2xD

with spot face and chamfering

Tool:

*KW with spot face, chamfering
inserts and BGFZ M10x1 2xD IK*

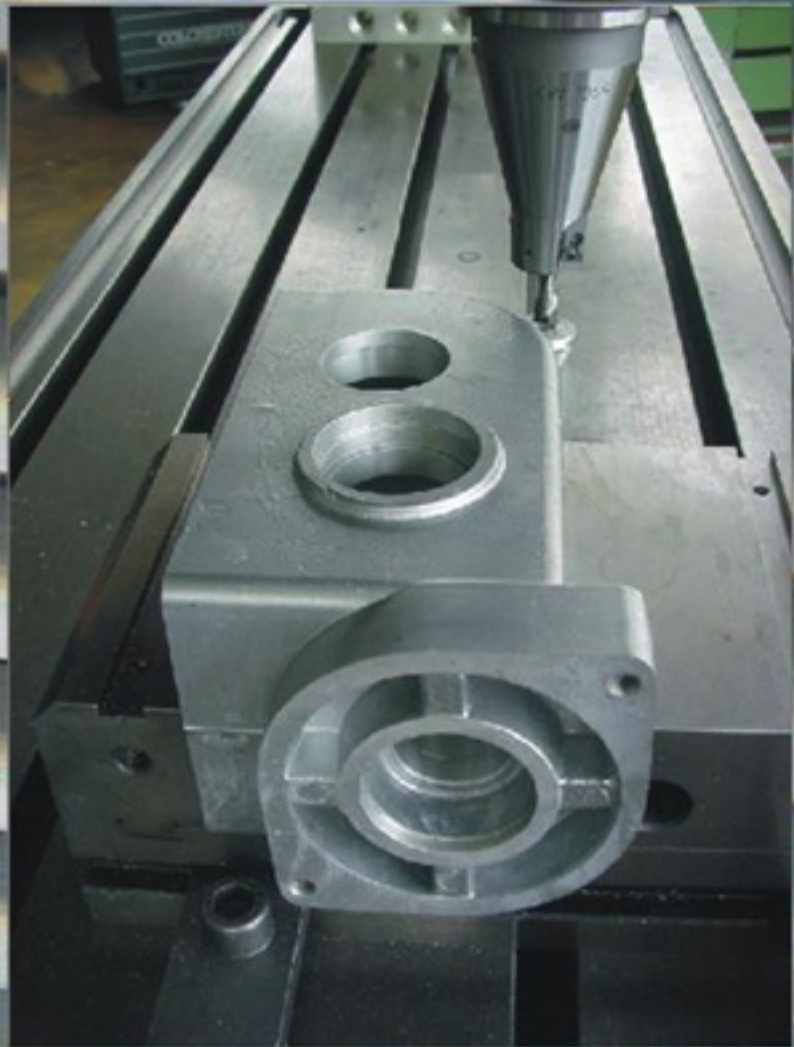
Vc = 200 m/min

fb = 0,12 mm/U

fz = 0,1 mm

Application time = 3,6 s

Machine: Hitachi



Cutting parameter
Workpiece: Motorcase
Material: Al Mg Si 0.5

Application:
6 pc drill holes D 6.0
with spot face and chamfering
Tool:
KW with spot face, chamfering
inserts and solid carbide drill D6.0

Vc = 200 m/min
fb = 0.2 mm/U

Application time = 1.5 s

Machine: Heller Mc16



JBO, s.r.o. DrbH&Co.IG
Průmyslová zóna, Písek

