

Cutting parameter

Workpiece: Bolt

Material: X5 CrNiMo 17 13 3

Application: M22x1.5

Tool: GFGW Pitch M1.5F-HSK40C

Cutting data:

$V_c = 100$ m/min

$f_z = 0.1$ mm

Application time = 4.5 s

**Machine: Hydromat revolving
transfer machine**



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Produktionstechnik



Cutting parameter

Workpiece: Rail

Material: 38 Mn Si 17

Application:

4 pc M14x1.5 -A

1 pc M12x1.5

2 pc M22x1.5

Tool:

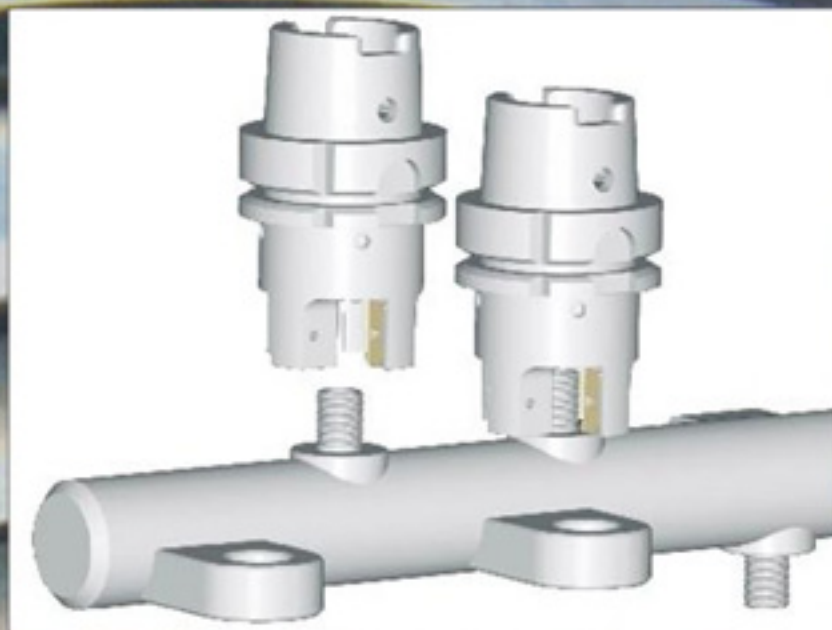
GFGW M14x1.5 F

Vc = 140 m/min

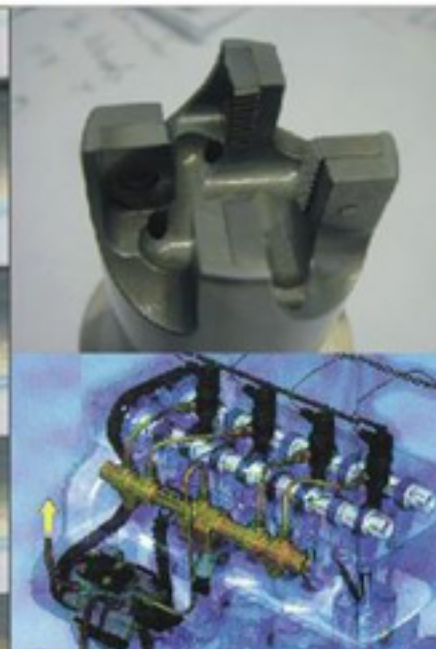
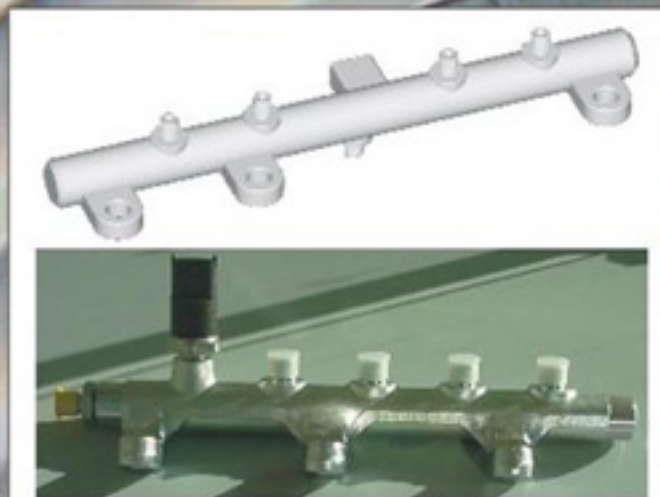
fz = 0.1 mm

Application time = 4.5 s

Machine: Grob transfer machine



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Produttore di utensili





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Průmyslové závody

Cutting parameter

Workpiece: Fitting

Material: Ms 58

Application: 30x1,5-A

*Tool: GFG M30x1,5 F - HSK 50
with soldering inserts*

Cutting data:

Vc = 200 m/min

fz = 0,15 mm

Application time = 4,2s

Machine: W&F revolving transfer machine



Cutting parameter

Workpiece: Pump part

Material: Ms 58

Application: 58x1

Tool: GFG M58x1
with soldering inserts

Cutting data:

$V_c = 300 \text{ m/min}$

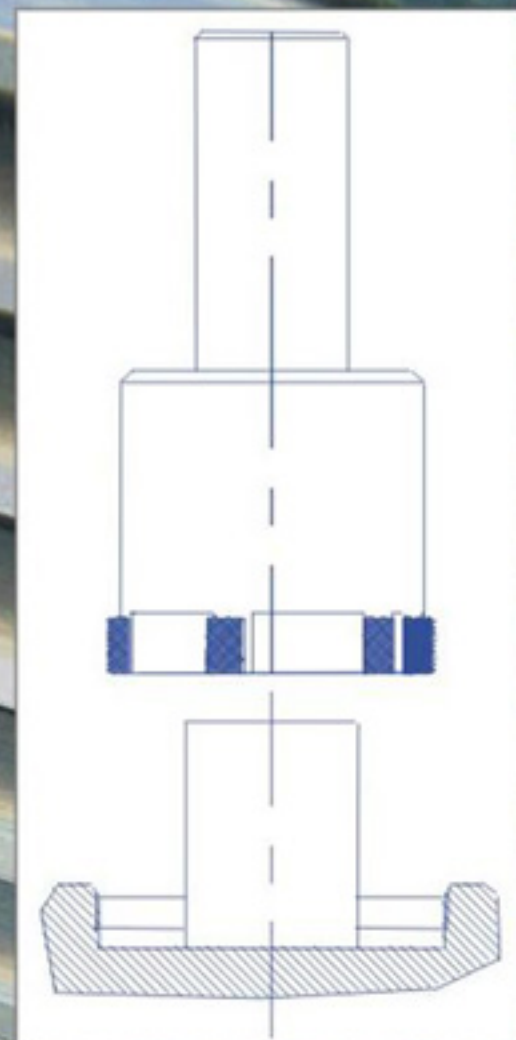
$f_z = 0,2 \text{ mm}$

Application time = 6.2s

Machine: Grob



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Produktionstechnik aus Fabrik



Cutting parameter

Workpiece: Fitting

Material: 1.4301

Application: 30x1.5

Tool: GFGW M1,5 F -SK40

Cutting data:

Vc = 150 m/min

fz = 0,15 mm

Application time = 10,4s

*Machine: IMAS revolving
transfer machine*



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Produktionswerkzeugfabrik



Cutting parameter

Workpiece: Fitting

Material: C 45

Application: 24x1

Tool: GFG M1 F-SK40

Cutting data:

$V_c = 130$ m/min

$f_z = 0,15$ mm

Application time = 9,6 s

Machine: Huron



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



Cutting parameter

Workpiece: Fitting

Material: 16 MnCr5

Application: 14x1.5

Tool: GFG M1.5 F -SK40

Cutting data:

Vc = 150 m/min

fz = 0,06 mm

Application time = 4,9 s

Machine: DMG



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Produttore di utensili



Cutting parameter

Workpiece: Fitting

Material: Ms58

Application: 1/2-14 NPT

Tool: GFG NPT14 F

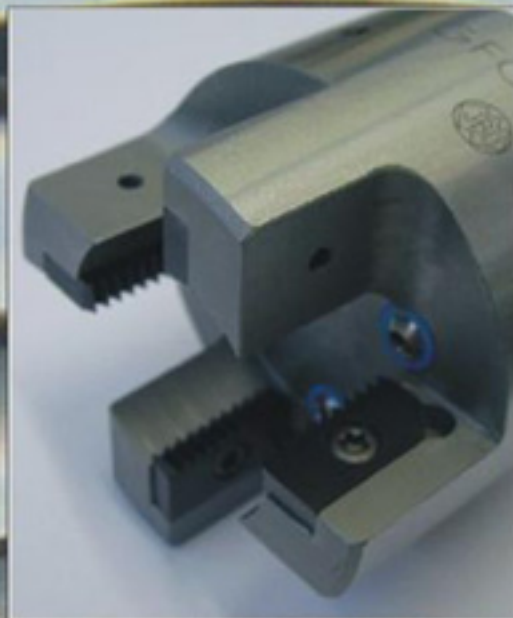
Cutting data:

Vc = 200 m/min

fz = 0,15 mm

Application time = 3,6 s

Machine: DMG lathe



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