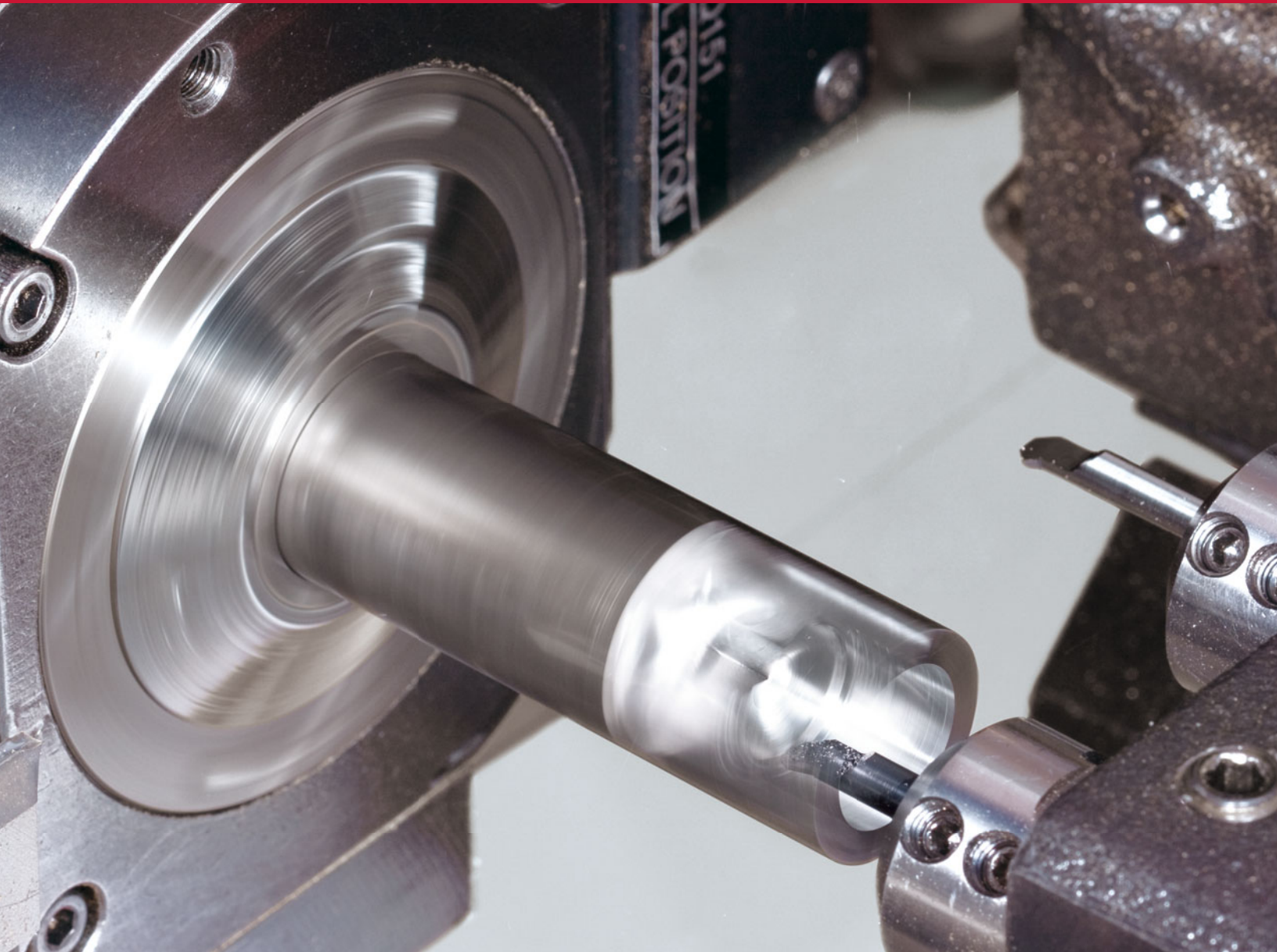
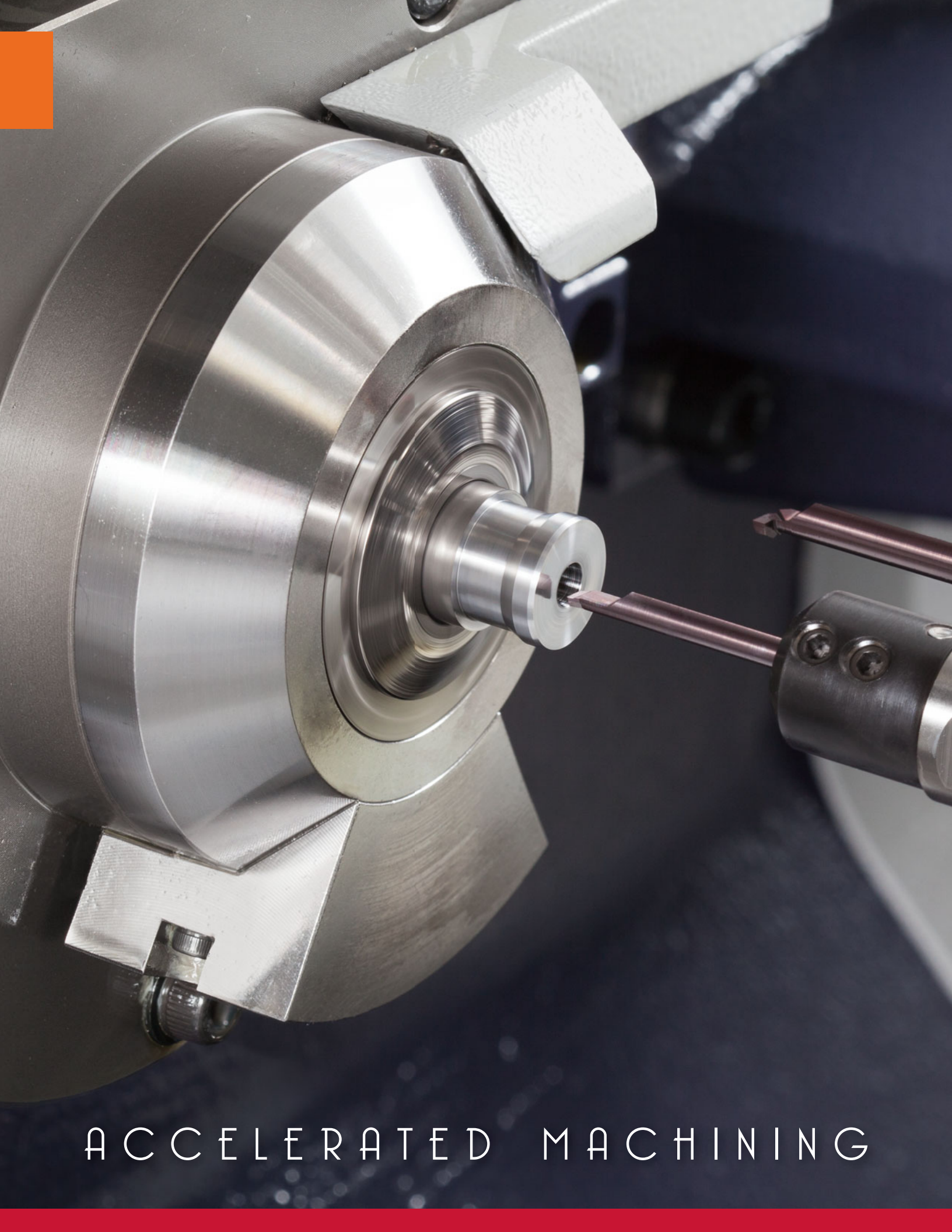


Solid boring bars with minimum bore as small as $\varnothing 0.6\text{mm}$ diameter.



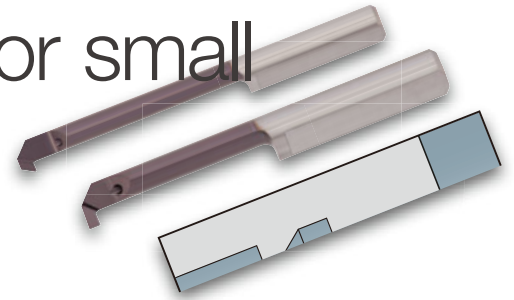


ACCELERATED MACHINING



Sharp and precise cutting edge offers highly accurate machining for a wide range of internal applications!

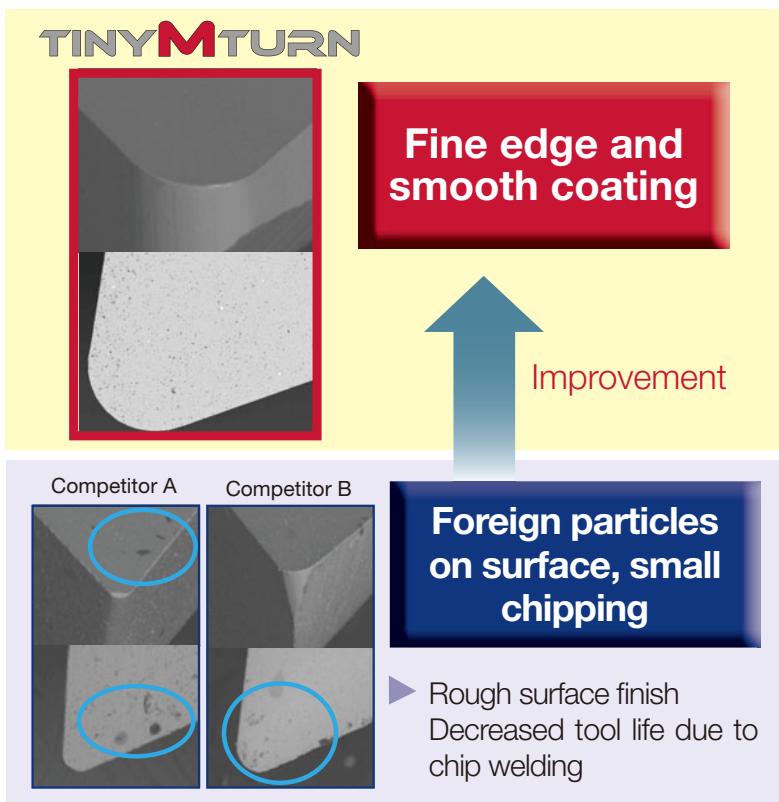
Stable machining and excellent surface finish for small diameter internal turning!



Well-designed edge provides highly accurate machining

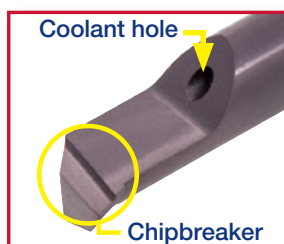
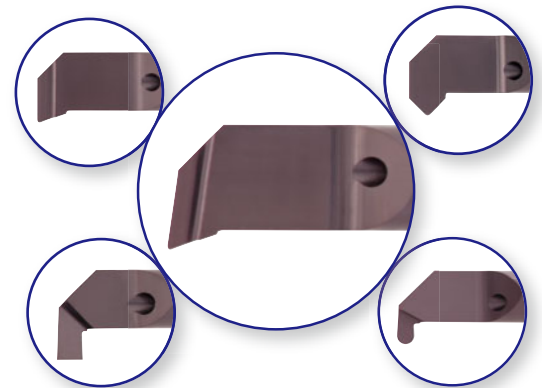
Super fine cutting edges

Comparison of tool surface and cutting edge



Cutting edge is extremely fine compared to competitors!!

- Generates fine surface finishes and prevents edge chipping.
- Smooth cutting edge leads to high precision products.



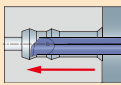
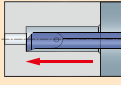
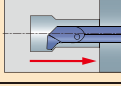
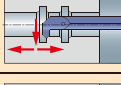
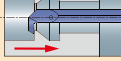
Coolant hole

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

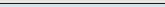
Wide range of items can be applied to a variety of internal operations.

- 146 solid bar items in a wide range of geometries
- Minimum boring diameter: $\varnothing Dm = 0.6 \text{ mm}$

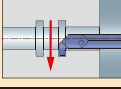
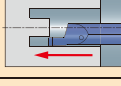
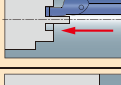
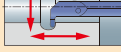
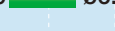
Boring, profiling, chamfering

Type	Application		Shank diameter øDs (mm)	Min. bore dia. øDm (mm)						
				0	2	4	6	8	10	
JBT (P. 10)		Boring, profiling, chamfering	ø4, ø7	ø0.6					ø7.0	
JBP (P. 12)		Boring, chamfering	ø4, ø7		ø2.8				ø5.0	
JBU (P. 12)		Back boring, chamfering	ø7			ø5.0				
JBC (P. 13)		Boring, 45° chamfering	ø7			ø5.0				ø6.8
JBB (P. 14)		Back boring	ø4, ø7		ø3.0					ø7.0

Threading

Type	Application	Shank diameter øDs (mm)	Min. bore dia. øDm (mm)					
			0	2	4	6	8	10
JB1 (P. 15)	 Threading (Metric thread)	ø4, ø7			ø4.0		ø7.0	

Grooving

Type	Application		Shank diameter øDs (mm)	Groove width W (mm)	Min. bore dia. øDm (mm)									
					0	2	4	6	8	10	12	14	15	
JBG (P. 16)		Grooving	ø4, ø7	0.5 - 2.0	ø2.0  ø6.8									
JBF (P. 19)		Face grooving	ø7	1.0 - 3.0	ø6.0  ø15.0									
JBS (P. 20)		Face grooving (for shaft)	ø7	2.0	ø6.0 									
JBR (P.18)		Boring, profiling (full radius type)	ø7	1.0	ø5.0  ø6.8									

Well-designed edges with a wide range of items to generate high productivity for small parts machining!

Precision sleeve with easy operation

Excellent repeatability of solid bars

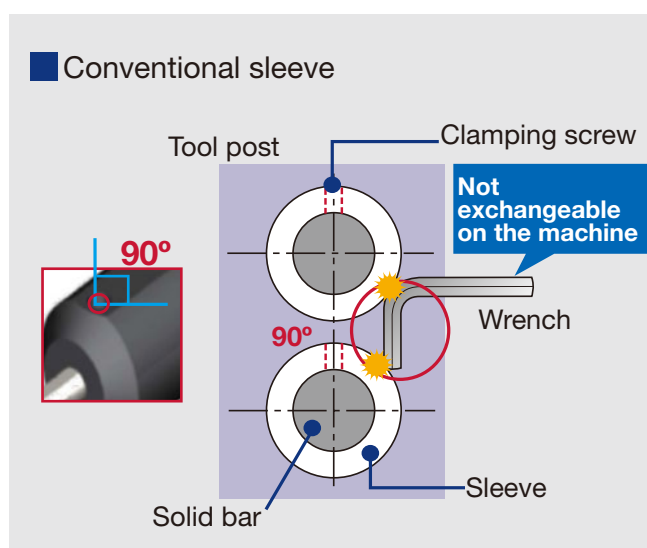
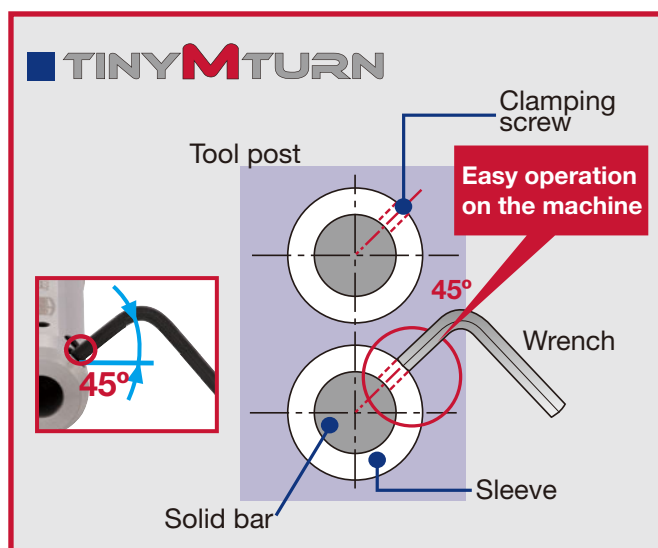
Exact positioning provides exceptional stability and reliability in tool changeovers

Double ported

ø4 mm and ø7 mm shank can be set on ONE sleeve

Easy tool changeovers

Solid bar can be precisely changed to any style tool on the machine with minimum set up time. The clamping screws are oriented at 45° to the cutting edge for easy access and the solid bar positioner assures the best repeatability.



Precisional sleeve creates extremely stable machining!

Special sleeve with internal coolant supply

Easy connection with coolant hose

Connection screw R1/8 at the end of the sleeve

Enhanced range of overhang lengths

Perfect lengths of sleeve and cotter flat for adjustable overhang lengths

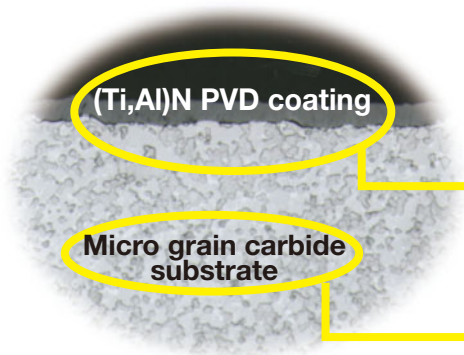
Excellent repeatability of solid bars and easy tool changeover

Solid bar positioner provides exact positioning of solid bars and tools can be changed easily on the machine



Grade

SH730 PVD coated grade



Delivers a stable performance with the combination of exclusive (Ti,Al)N coating and extremely tough substrate

Excellent chipping & welding resistance

Thin (Ti,Al)N coated layers are tightly adhered to create a sharp cutting edge

Improved plastic deformation resistance and toughness

Application	Application 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

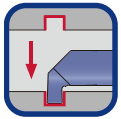
ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)	Cutting speed (SFM)	Feed f (mm/rev)	Feed f (in/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.08 *	0.0004 - 0.003
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.08 *	0.0004 - 0.003
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.08 *	0.0004 - 0.003
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	130 - 460	0.01 - 0.08 *	0.0004 - 0.003
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	100 - 328	0.01 - 0.08 *	0.0004 - 0.003
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	100 - 328	0.01 - 0.08 *	0.0004 - 0.003
N	Aluminum alloys, copper alloys Si < 12%	SH730	90 - 200	265 - 656	0.01 - 0.08 *	0.0004 - 0.003
S	Titanium alloys (Ti-6Al-4V, etc.)	SH730	30 - 100	100 - 328	0.01 - 0.08 *	0.0004 - 0.003
	Superalloys (Inconel718, etc.)	SH730	30 - 100	100 - 328	0.01 - 0.08 *	0.0004 - 0.003

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



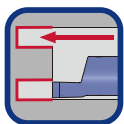
Threading (metric thread)

ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)	Cutting speed (SFM)	Number of passes Pitch mm/(in)				
					0.5/(0.020)	0.75/(0.029)	1/(0.039)	1.25/(0.049)	1.5/(0.059)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	130 - 460	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	130 - 460	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	130 - 460	6 - 8	8 - 10	10 - 12	12 - 15	15 - 18
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc)	SH730	40 - 140	130 - 460	8	10	12	15	18
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	100-328	7	9	12	14	17
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	100-328	7	9	12	14	17
N	Aluminum alloys, copper alloys Si < 12%	SH730	90 - 200	295-656	6	8	10	12	15



Internal grooving

ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)		Feed f (mm/rev)	Feed f (in/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.03 *	0.0004 - 0.001
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.03 *	0.0004 - 0.001
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.03 *	0.0004 - 0.001
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.03 *	0.0004 - 0.001
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	100 - 328	0.01 - 0.03 *	0.0004 - 0.001
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	100 - 328	0.01 - 0.03 *	0.0004 - 0.001
N	Aluminum alloys, copper alloys Si < 12%	SH730	90 - 200	265 - 656	0.01 - 0.03 *	0.0004 - 0.001
S	Titanium alloys Ti-6Al-4V etc.	SH730	30 - 100	100 - 328	0.01 - 0.03 *	0.0004 - 0.001
	Superalloys (Inconel718, etc.)	SH730	30 - 100	100 - 328	0.01 - 0.03 *	0.0004 - 0.001



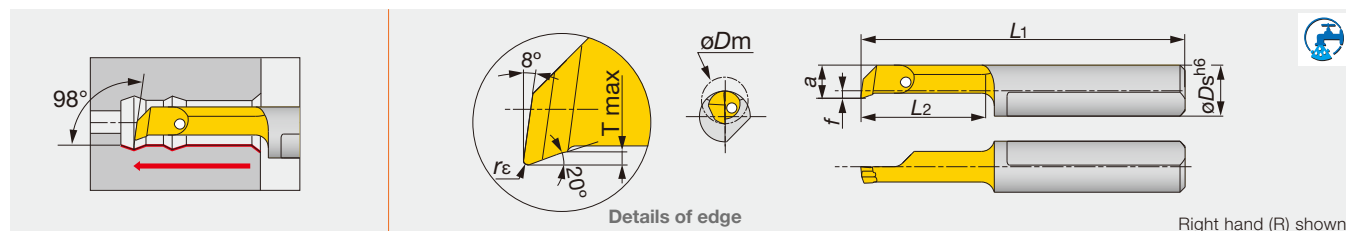
Face grooving

ISO	Workpiece materials	Grade	Cutting speed Vc (m/min)	Cutting speed (SFM)	Feed f (mm/rev)	Feed f (in/rev)
P	Low carbon steels (C15, C20 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.05 *	0.0004 - 0.002
	Carbon steels, Alloy steels (C55, 42CrMoS4 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.05 *	0.0004 - 0.002
	Prehardened steels (NAK80, PX5 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.05 *	0.0004 - 0.002
M	Stainless steels (X5CrNi18-9, X5CrNiMo17-12-2 etc.)	SH730	40 - 140	130 - 460	0.01 - 0.05 *	0.0004 - 0.002
K	Grey cast irons (250, 300 etc.)	SH730	30 - 100	100 - 328	0.01 - 0.05 *	0.0004 - 0.002
	Ductile cast irons (400-15, 600-3 etc.)	SH730	30 - 100	100 - 328	0.01 - 0.05 *	0.0004 - 0.002
N	Aluminum alloys, copper alloys Si < 12%	SH730	90 - 200	265 - 656	0.01 - 0.05 *	0.0004 - 0.002
S	Titanium alloys Ti-6Al-4V etc.	SH730	30 - 100	100 - 328	0.01 - 0.05 *	0.0004 - 0.002
	Superalloys (Inconel718, etc.)	SH730	30 - 100	100 - 328	0.01 - 0.05 *	0.0004 - 0.002

Solid boring bars for boring, profiling & chamfering

BORING, PROFILING, CHAMFERING

TinyMini-Turn JBTR/L



Designation Metric	Grade SH730		ϕD_m	ϕD_s	f	a	L_1	L_2	T max	$r_\epsilon + 0.05_0$
	R	L								
JBTR/L04020004-D006	✓		0.6	4	-	0.5	18.5	2	0.08	0.04
JBTR/L04030004-D006	✓		0.6	4	-	0.5	19.5	3	0.08	0.04
JBTR/L04045005-D010	✓		1	4	-	0.9	21	4.5	0.1	0.05
JBTR/L04065005-D010	✓		1	4	-	0.9	23	6.5	0.1	0.05
JBTR/L04040005-D020	✓		2	4	-	1.7	20.5	4	0.1	0.05
JBTR/L04090005-D020	✓		2	4	-	1.7	25.5	9	0.1	0.05
JBTR/L04140005-D020	✓		2	4	-	1.7	30.5	14	0.1	0.05
JBTR/L04090010-D028	✓	✓	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBTR/L04150010-D028	✓	✓	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBTR/L04190010-D028	✓	✓	2.8	4	0.6	2.6	35.5	19	0.2	0.10
JBTR/L04090010-D040	✓	✓	4	4	1.5	3.5	25.5	9	0.3	0.10
JBTR/L04150010-D040	✓	✓	4	4	1.5	3.5	31.5	15	0.3	0.10
JBTR/L04190010-D040	✓	✓	4	4	1.5	3.5	35.5	19	0.3	0.10
JBTR/L04230010-D040	✓		4	4	1.5	3.5	39.5	23	0.3	0.10
JBTR/L04270010-D040	✓		4	4	1.5	3.5	43.5	27	0.3	0.10
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
JBTR/L07340015-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
JBTR/L07340015-D060	✓		6	7	1.8	5.3	50	34	0.5	0.15
JBTR/L07410015-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
JBTR/L07240015-D068	✓		6.8	7	2.8	6.3	40	24	0.6	0.15

(Unit: mm)
✓ : Stocked items

Designation Metric	Grade SH730		ϕD_m	ϕD_s	f	a	L_1	L_2	T max	r_e
	R	L								
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
JBTR/L07390015-D070	✓		7	7	2.8	6.3	55	39	0.6	0.15
JBTR/L07440015-D070	✓		7	7	2.8	6.3	60	44	0.6	0.15
JBTR/L07490015-D070	✓		7	7	2.8	6.3	65	49	0.6	0.15

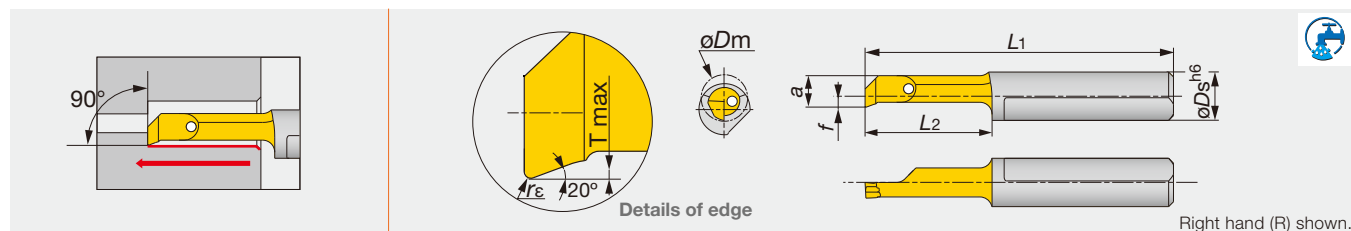
(Unit: mm)

✓ : Stocked items

Solid boring bars for boring & chamfering

BORING, CHAMFERING

TinyMini-Turn JBPR



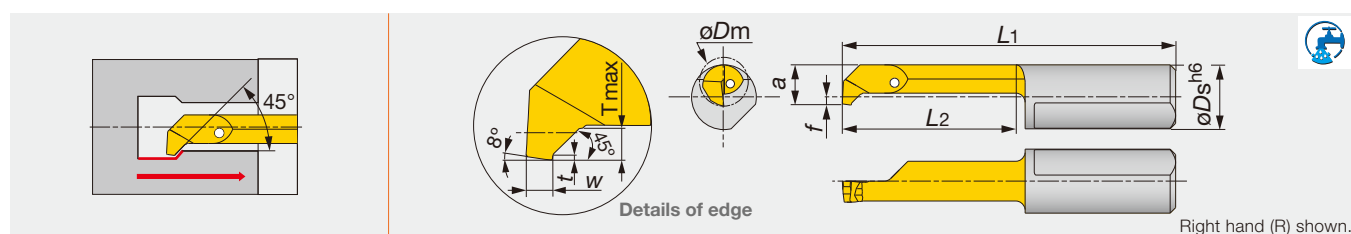
Designation Metric	Grade SH730	ϕD_m	ϕD_s	f	a	L_1	L_2	T max	$r_E + 0.05_0$
JBPR04090010-D028	✓	2.8	4	0.6	2.6	25.5	9	0.2	0.10
JBPR04150010-D028	✓	2.8	4	0.6	2.6	31.5	15	0.2	0.10
JBPR04090010-D040	✓	4	4	1.5	3.5	25.5	9	0.3	0.10
JBPR04150010-D040	✓	4	4	1.5	3.5	31.5	15	0.3	0.10
JBPR07140015-D050	✓	5	7	0.9	4.4	30	14	0.5	0.15
JBPR07190015-D050	✓	5	7	0.9	4.4	35	19	0.5	0.15

(Unit: mm)
✓ : Stocked items

Solid boring bars for back boring & chamfering

BACK BORING, CHAMFERING

TinyMini-Turn JBUR



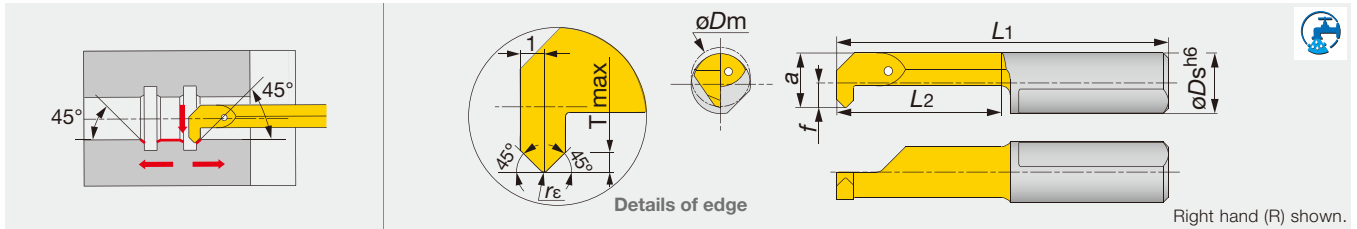
Designation Metric	Grade SH730	ϕD_m	ϕD_s	f	a	L_1	L_2	t	T max	$W + 0.05_0$
JBUR07140010-D050	✓	5	7	0.9	4.4	30	14	0.2	1	1
JBUR07190010-D050	✓	5	7	0.9	4.4	35	19	0.2	1	1

(Unit: mm)
✓ : Stocked items

Solid boring bars for 45deg chamfering

45° CHAMFERING

TinyMini-Turn JB CR



Designation Metric	Grade SH730	ϕD_m	ϕD_s	f	a	L_1	L_2	T max	$r_{\epsilon} + 0.05_0$
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

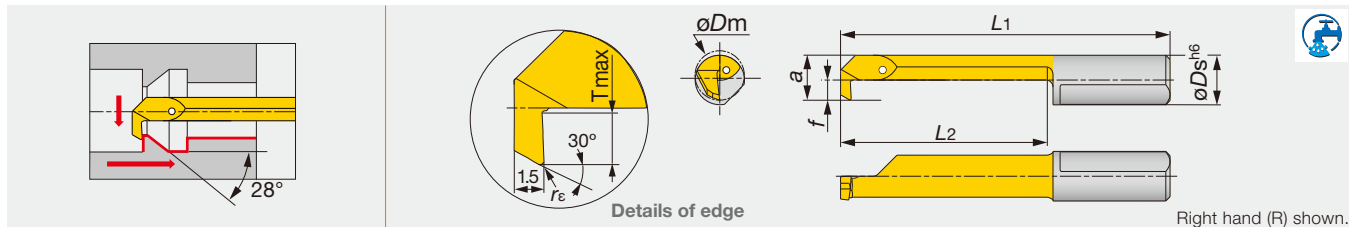
(Unit: mm)

✓ : Stocked items

Solid boring bars for back boring

BACK BORING

TinyMini-Turn JBRR



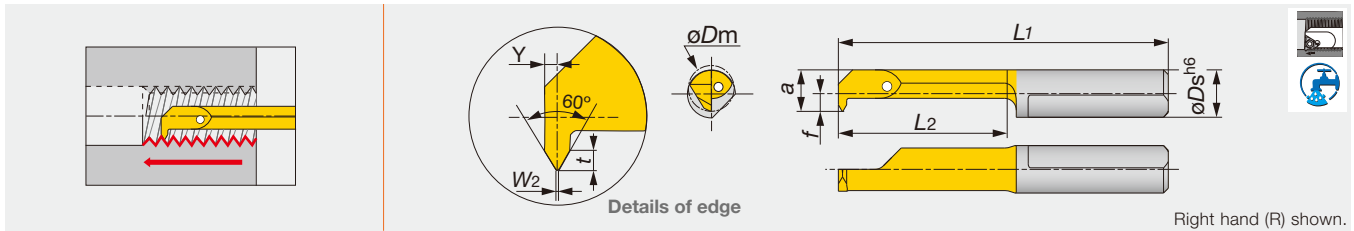
Designation	Grade SH730	ϕD_m	ϕD_s	f	a	L_1	L_2	T max	$r_e^{+0.05}_0$
JBBR04140020-D030	✓	3	4	0.6	2.6	30	14	0.5	0.2
JBBR04190020-D030	✓	3	4	0.6	2.6	35	19	0.5	0.2
JBBR04140015-D040	✓	4	4	1.5	3.5	30	14	0.8	0.15
JBBR04240015-D040	✓	4	4	1.5	3.5	40	24	0.8	0.15
JBBR07190020-D050	✓	5	7	0.9	4.4	35	19	1	0.2
JBBR07290020-D050	✓	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

(Unit: mm)
✓ : Stocked items

Solid boring bars for threading, metric thread

THREADING (METRIC THREAD)

TinyMini-Turn JBIR



Designation	Grade SH730	Pitch	ϕD_m	$W_2 \begin{smallmatrix} 0 \\ -0.02 \end{smallmatrix}$	ϕD_s	f	a	L_1	L_2	t	Y
JBIR04140050-D040	✓	0.8 - 0.5	4	0.06	4	1.5	3.5	30	14	0.3	0.35
JBIR07140050-D050	✓	1.0 - 0.5	5	0.06	7	0.9	4.4	30	14	0.3	0.35
JBIR07140075-D050	✓	1.0 - 0.75	5	0.09	7	0.9	4.4	30	14	0.4	0.45
JBIR07140100-D048	✓	1.0	4.8	0.12	7	0.9	4.4	30	14	0.6	0.55
JBIR07140100-D060	✓	1.5 - 1.0	6	0.12	7	1.8	5.3	30	14	0.6	0.55
JBIR07140125-D060	✓	1.5 - 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 - 1.0	7	0.18	7	2.8	6.3	30	14	0.8	0.75

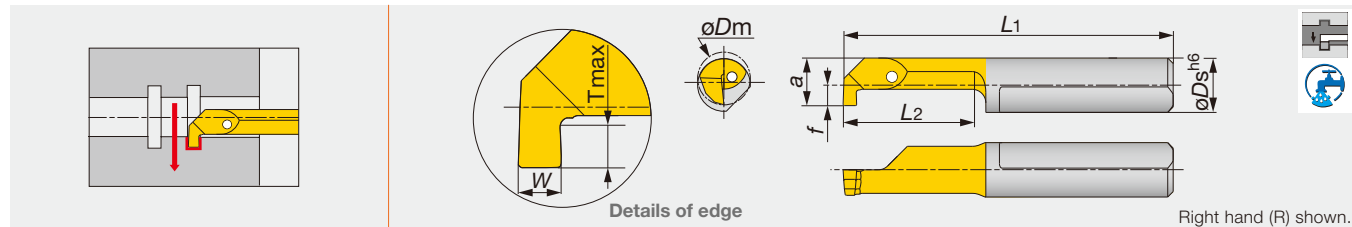
(Unit: mm)

✓ : Stocked items

Solid boring bars for internal grooving

GROOVING

TinyMini-Turn JBGR/L



Designation	Grade		$W + {}^{0.05}_0$	ϕD_m	ϕD_s	f	a	L_1	L_2	T max
	R	L								
JBGR/L04050050-D020	✓		0.5	2	4	0.2	1.8	21	5	0.4
JBGR/L04100050-D020	✓		0.5	2	4	0.2	1.8	26	10	0.4
JBGR/L04050070-D030	✓		0.7	3	4	0.7	2.7	21	5	0.6
JBGR/L04100070-D030	✓		0.7	3	4	0.7	2.7	26	10	0.6
JBGR/L04090100-D040	✓		1	4	4	1.5	3.5	25.5	9	0.8
JBGR/L04150100-D040	✓		1	4	4	1.5	3.5	31.5	15	0.8
JBGR/L07090100-D050	✓		1	5	7	0.9	4.4	25	9	1
JBGR/L07140100-D050	✓		1	5	7	0.9	4.4	30	14	1
JBGR/L07090150-D050	✓		1.5	5	7	0.9	4.4	25	9	1
JBGR/L07140150-D050	✓		1.5	5	7	0.9	4.4	30	14	1
JBGR/L07090200-D050	✓		2	5	7	0.9	4.4	25	9	1
JBGR/L07190200-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
JBGR/L07140100-D060	✓		1	6	7	1.8	5.3	30	14	1.8
JBGR/L07210100-D060	✓		1	6	7	1.8	5.3	37	21	1.8
JBGR/L07290100-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
JBGR/L07140150-D060	✓		1.5	6	7	1.8	5.3	30	14	1.8
JBGR/L07210150-D060	✓		1.5	6	7	1.8	5.3	37	21	1.8
JBGR/L07240150-D060	✓		1.5	6	7	1.8	5.3	40	24	1.8
JBGR/L07290150-D060	✓		1.5	6	7	1.8	5.3	45	29	1.8
JBGR/L07090200-D060	✓		2	6	7	1.8	5.3	25	9	1.8
JBGR/L07140200-D060	✓		2	6	7	1.8	5.3	30	14	1.8
JBGR/L07210200-D060	✓		2	6	7	1.8	5.3	37	21	1.8
JBGR/L07240200-D060	✓		2	6	7	1.8	5.3	40	24	1.8
JBGR/L07290200-D060	✓		2	6	7	1.8	5.3	45	29	1.8
JBGR/L07090100-D068	✓		1	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140100-D068	✓		1	6.8	7	2.7	6.2	30	14	2.5

(Unit: mm)
✓ : Stocked items

Designation	Grade		$W^{+0.05}_0$	ϕD_m	ϕD_s	f	a	L_1	L_2	T max
	R	L								
JBGR/L07210100-D068	✓		1	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07090150-D068	✓		1.5	6.8	7	2.7	6.2	25	9	2.5
JBGR/L07140150-D068	✓		1.5	6.8	7	2.7	6.2	30	14	2.5
JBGR/L07210150-D068	✓		1.5	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07290150-D068	✓		1.5	6.8	7	2.7	6.2	45	29	2.5
JBGR/L07090200-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
JBGR/L07210200-D068	✓		2	6.8	7	2.7	6.2	37	21	2.5
JBGR/L07250200-D068	✓		2	6.8	7	2.7	6.2	40	25	2.5
JBGR/L07290200-D068	✓		2	6.8	7	2.7	6.2	45	29	2.5

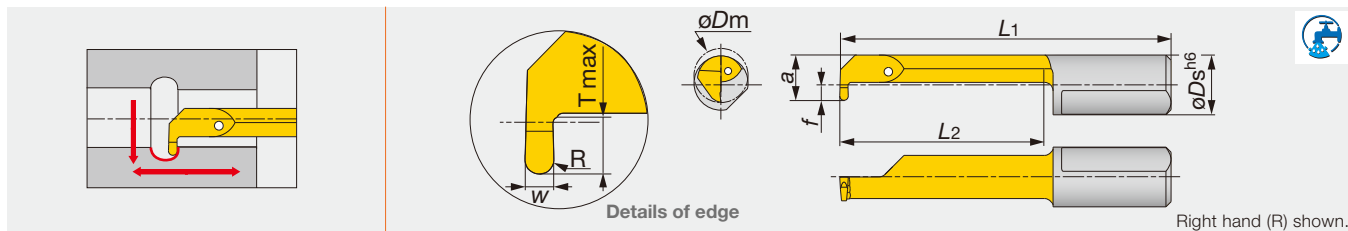
- Corner radius : less than 0.01 mm.

(Unit: mm)
✓ : Stocked items

Solid boring bars for grooving & profiling full radius type

GROOVING, PROFILING (FULL RADIUS TYPE)

TinyMini-Turn JBRR



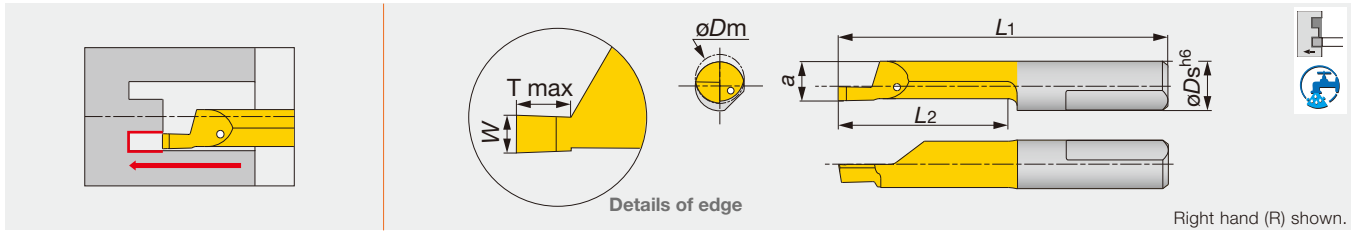
Designation	Grade	$W^{+0.05}_0$	ϕD_m	ϕD_s	f	a	L_1	L_2	T max	R
	SH730									
JBRR07190050-D050	✓	1	5	7	0.9	4.4	35	19	1	0.5
JBRR07240050-D060	✓	1	6	7	1.8	5.3	40	24	1.8	0.5
JBRR07290050-D068	✓	1	6.8	7	2.8	6.3	45	29	2.5	0.5

(Unit: mm)
✓ : Stocked items

Solid boring bars for face grooving along bore

FACE GROOVING

TinyMini-Turn JBFR/L



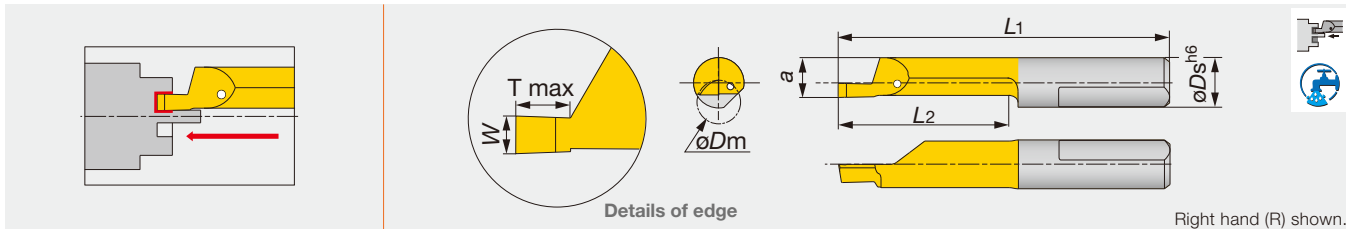
Designation	Grade		$W^{+0.05}_0$	ϕD_m	ϕD_s	a	L_1	L_2	T max
	R	L							
JBFR/L07110100-D060	✓		1	6	7	5.2	26	10	1.5
JBFR/L07110150-D060	✓		1.5	6	7	5.2	26	10	2
JBFR/L07110200-D060	✓		2	6	7	5.2	26	10	3
JBFR/L07110100-D080	✓		1	8	7	5.9	27	11	1.5
JBFR/L07110150-D080	✓		1.5	8	7	5.9	27	11	2.5
JBFR/L07110200-D080	✓		2	8	7	5.9	27	11	3
JBFR/L07110250-D080	✓		2.5	8	7	5.9	27	11	3.5
JBFR/L07110300-D080	✓		3	8	7	5.9	27	11	3.5
JBFR/L07200200-D080	✓		2	8	7	5.9	36	20	3
JBFR/L07210150-D080	✓	✓	1.5	8	7	5.9	36	21	2.5
JBFR/L07210200-D080	✓		2	8	7	5.9	36	21	3
JBFR/L07210250-D080	✓		2.5	8	7	5.9	36	21	3.5
JBFR/L07210300-D080	✓		3	8	7	5.9	36	21	3.5
JBFR/L07300200-D080	✓	✓	2	8	7	5.9	46	30	3
JBFR/L07300300-D080	✓		3	8	7	5.9	46	30	3.5
JBFR/L07200250-D150	✓		2.5	15	7	5.9	36	20	20
JBFR/L07200300-D150	✓		3	15	7	5.9	36	20	20
JBFR/L07300300-D150	✓		3	15	7	5.9	46	30	30

(Unit: mm)
✓ : Stocked items

Solid boring bars for face grooving, along shaft

FACE GROOVING (FOR MACHINING SHAFT)

TinyMini-Turn JBSR



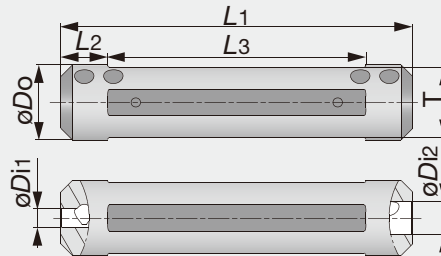
Designation	Grade	$W^{+0.05}_0$	ϕD_m	ϕD_s	a	L_1	L_2	T max
JBSR07200200-D060	SH730 ✓	2	6	7	5.2	36	20	4

(Unit: mm)
✓ : Stocked items

Sleeve with double and clamping two different size carbide shank with coolant supply

SLEEVE FOR CLAMPING TWO DIFFERENT SHANK SIZE

TinyMini-Turn JBBS



Designation	ϕD_o	ϕD_{i1}	ϕD_{i2}	L_1	L_2	L_3	T
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

(Unit: mm)

SPARE PARTS

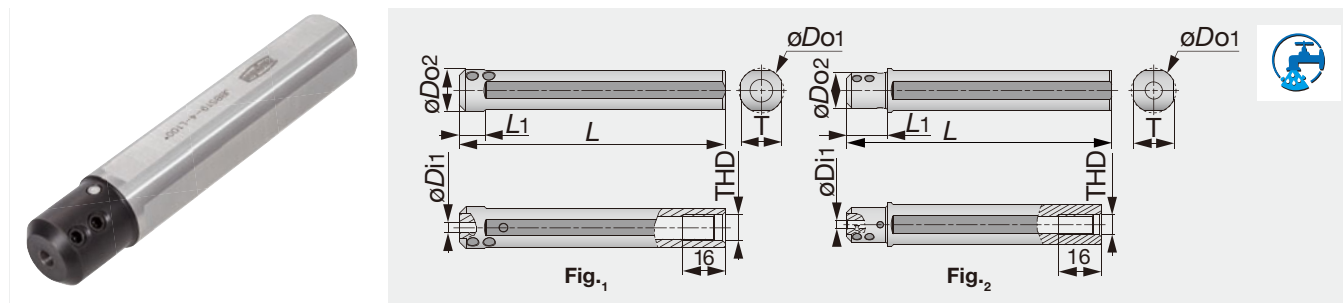


Designation	Clamping screw	Wrench
JBBS12-4-4	SSHM5-4PF-S	P-2.5
JBBS14-4-4	SSHM5-4PF-S	P-2.5
JBBS127-4-4	SSHM5-6PF-S	P-2.5
JBBS...-4-7	SSHM5-6PF-S	P-2.5

Single and sleeve with external coolant insert

SLEEVE WITH EXTERNAL COOLANT INLET

TinyMini-Turn JBBS-C



Designation	ϕD_{o1}	ϕD_{o2}	ϕD_{i1}	L	L_1	T	THD	Fig
JBBS159-4-L100C	15.875	15.875	4	100	10	14.58	8/R1	1
JBBS159-7-L100C	15.875	15.875	7	100	10	14.58	8/R1	1
JBBS16-4-L100C	16	16	4	100	10	15	8/R1	1
JBBS16-7-L100C	16	16	7	100	10	15	8/R1	1
JBBS19-4-L100C	19.05	17.5	4	100	20	17.2	8/R1	2
JBBS19-7-L100C	19.05	17.5	7	100	20	17.2	8/R1	2
JBBS20-4-L100C	20	17.5	4	100	20	18	8/R1	2
JBBS20-7-L100C	20	17.5	7	100	20	18	8/R1	2
JBBS22-4-L100C	22	17.5	4	100	20	20	8/R1	2
JBBS22-7-L100C	22	17.5	7	100	20	20	8/R1	2
JBBS25-4-L100C	25	18	4	100	23	23	8/R1	2
JBBS25-7-L100C	25	18	7	100	23	23	8/R1	2
JBBS254-4-L100C	25.4	18	4	100	23	23.4	8/R1	2
JBBS254-7-L100C	25.4	18	7	100	23	23.4	8/R1	2

(Unit: mm)

SPARE PARTS



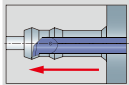
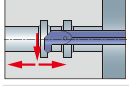
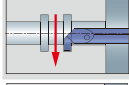
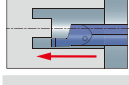
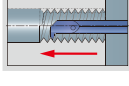
Designation	Clamping screw	Wrench
JBBS...-4-L100C	SSHM5-6PF-S	P-2.5
JBBS...-7-L100C	SSHM5-4PF-S	P-2.5

General kit

KIT-TINYTURN-GENERAL



Designation	Stock	Kit
KIT-TINYTURN-GENERAL	○	General

Applications	Designation	ϕD_m (mm)	ϕD_s (mm)	L_2 (mm)	$r\epsilon$ (mm)	W (mm)	Pitch
 Boring	① JBTR04150010-D040	4.0	4.0	15.0	0.1	-	-
	② JBTR07140015-D060	6.0	7.0	14.0	0.15	-	-
 Boring 45° Chamfering	⑤ JBGR07140020-D050	5.0	7.0	14.0	0.2	-	-
 Internal Grooving	③ JBGR07090100-D060	6.0	7.0	9.0	-	1.0	-
 Face Grooving	④ JBFR07110200-D060	6.0	7.0	11.0	-	2.0	-
 Threading	⑥ JBIR07140125-D060	6.0	7.0	14.0	-	1.25	1.25

PARTS

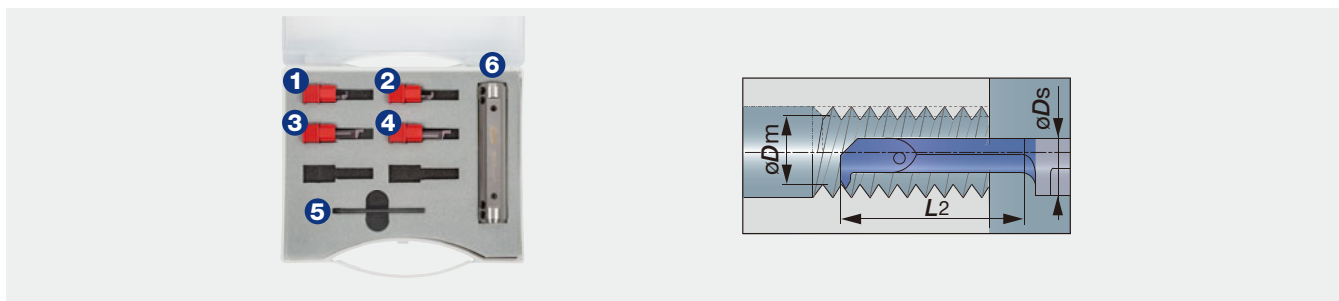
Parts		
Wrench	⑦	P-2.5
Sleeve	⑧	JBBS20-4-7



● : Stocked items
○ : Japan stocked

Boring, Threading and Grooving kit

KIT-TINYTURN-THREADING



Designation	Stock	Kit
KIT-TINYTURN-THREADING	●	Boring, Threading and Grooving

Applications	Designation	ϕD_m (mm)	ϕD_s (mm)	L_2 (mm)	$r\epsilon$ (mm)	W (mm)	Pitch
Boring	1 JBTR04150010-D040	4.0	4.0	15.0	0.1	-	-
Threading	3 JBIR04140050-D040	4.0	4.0	14.0	-	-	0.5
Threading	4 JBIR07140075-D050	5.0	7.0	14.0	-	-	0.75
Internal Grooving	2 JBGR04150100-D040	4.0	4.0	15.0	-	1.0	-

PARTS

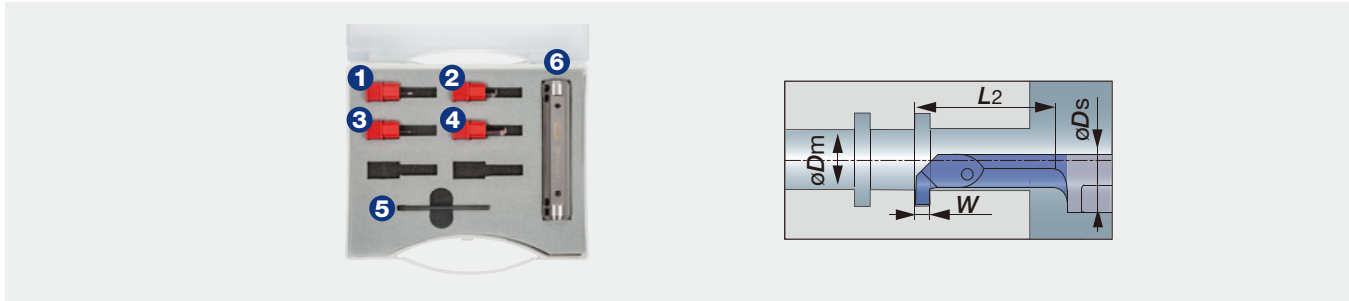
Parts		
Wrench	5	P-2.5
Sleeve	6	JBBS20-4-7



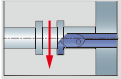
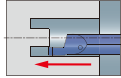
● : Stocked items
○ : Japan stocked

Grooving kit

KIT-TINYTURN-GROOVING



Designation	Stock	Kit
KIT-TINYTURN-GROOVING	●	Grooving

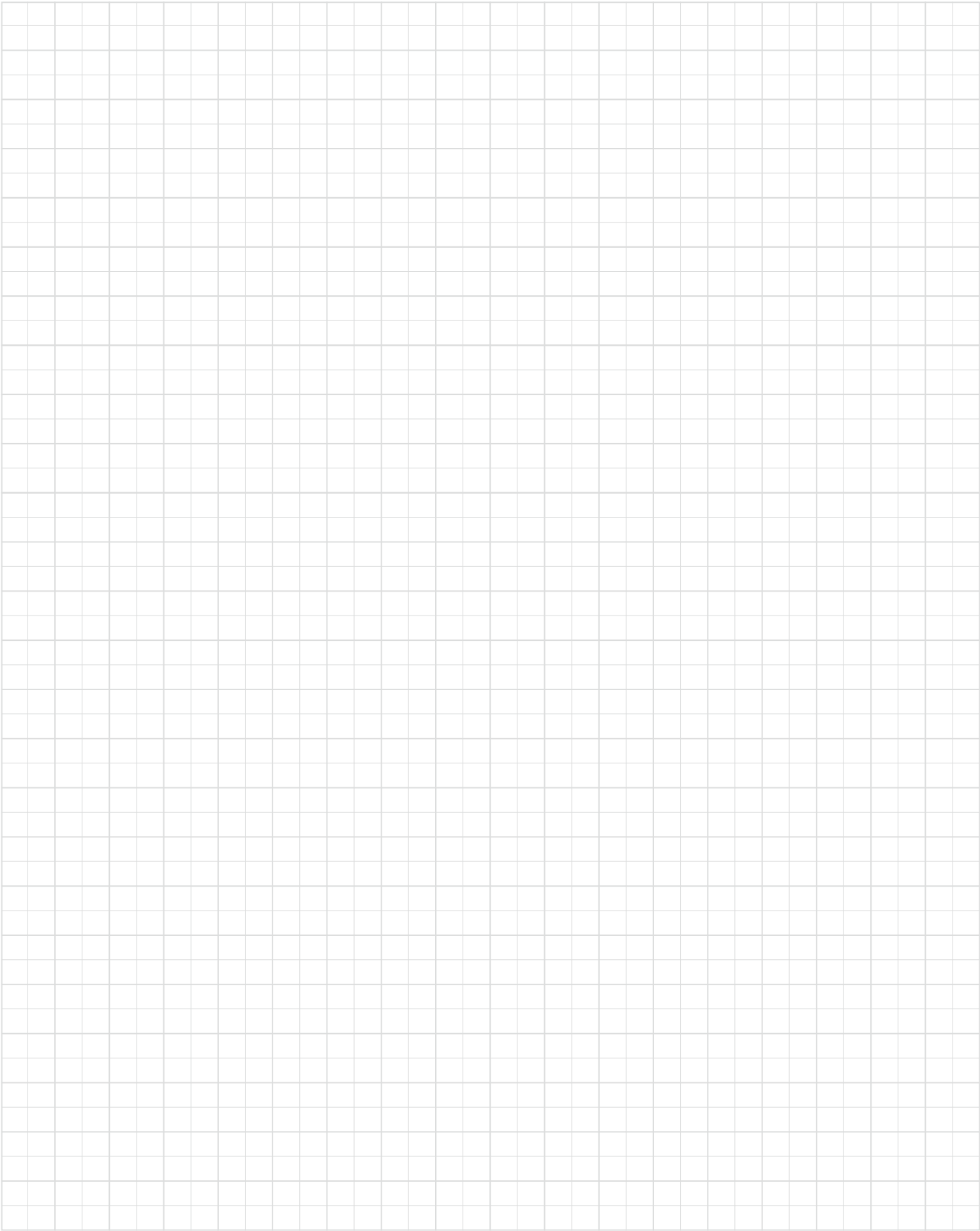
Applications	Cat. No.	ϕD_m (mm)	ϕD_s (mm)	L_2 (mm)	$r\epsilon$ (mm)
 Internal Grooving	① JBGR07090100-D060	6.0	7.0	9.0	1.0
	② JBGR07140200-D068	6.8	7.0	14.0	2.0
 Face Grooving	③ JBFR07110150-D060	6.0	7.0	15.0	1.5
	④ JBFR07110200-D060	6.0	7.0	11.0	2.0

PARTS

Parts		
Wrench	⑤	P-2.5
Sleeve	⑥	JBBS20-4-7



● : Stocked items
○ : Japan stocked



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Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779 Fax: +1-519-758-5791
www.tungaloy.co.jp/ca

Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
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