



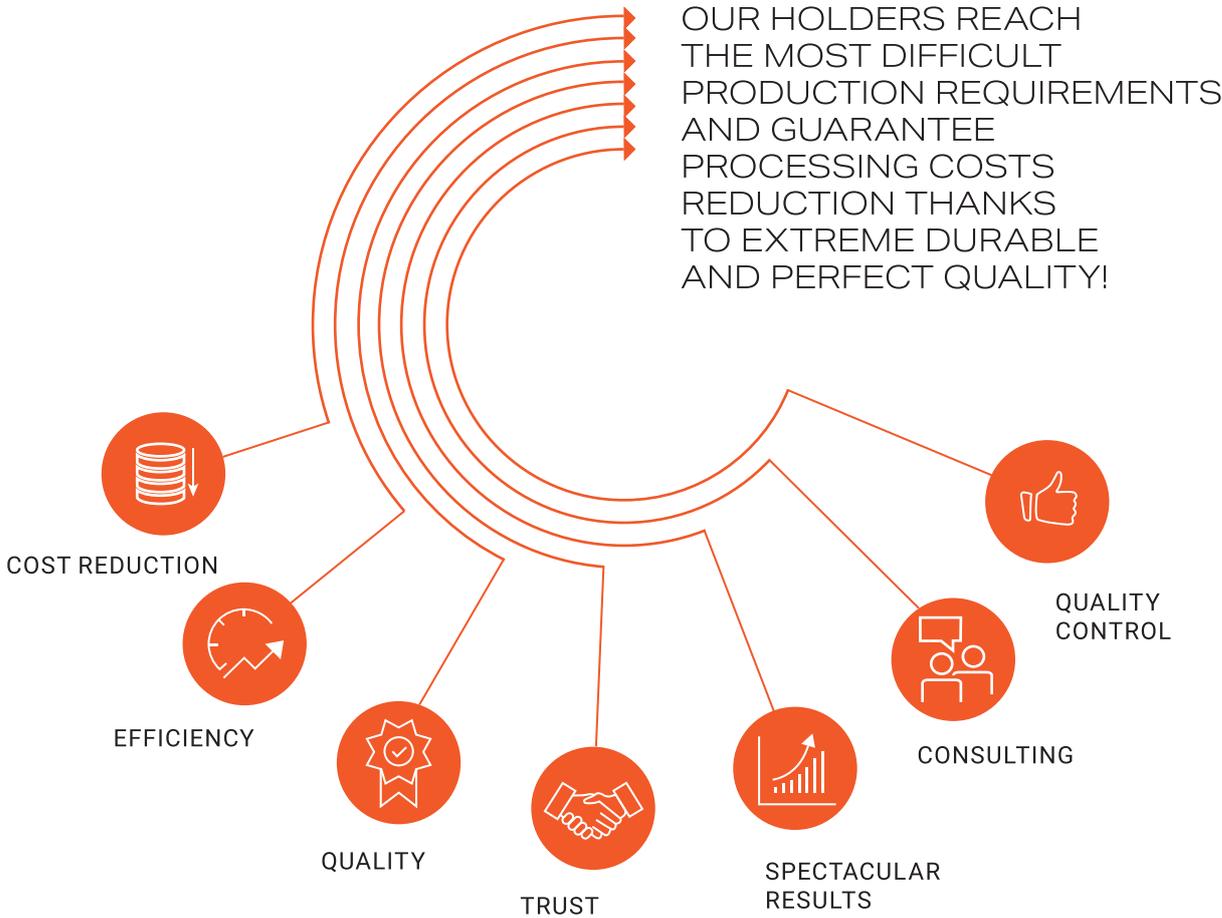
THE PRECISION
OF THE TOOL
IS THE PRECISION
OF DETAIL

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WHAT DISTINGUISHES OUR TURNING TOOL HOLDERS:

- 1 very high quality of used materials
- 2 patented quick and repeatable head replacement system
- 3 precise coolant supply system with max. 10 bar pressure
- 4 increased insert life due to precise cooling and optimized tool head shape
- 5 very simple assembly and disassembly of the tool



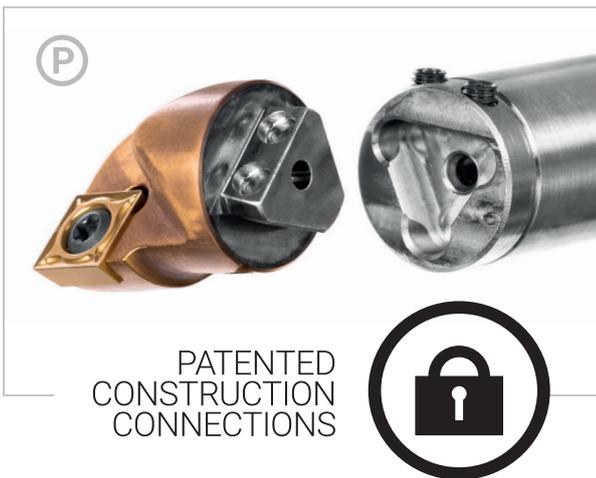
HUMM BORING BARS



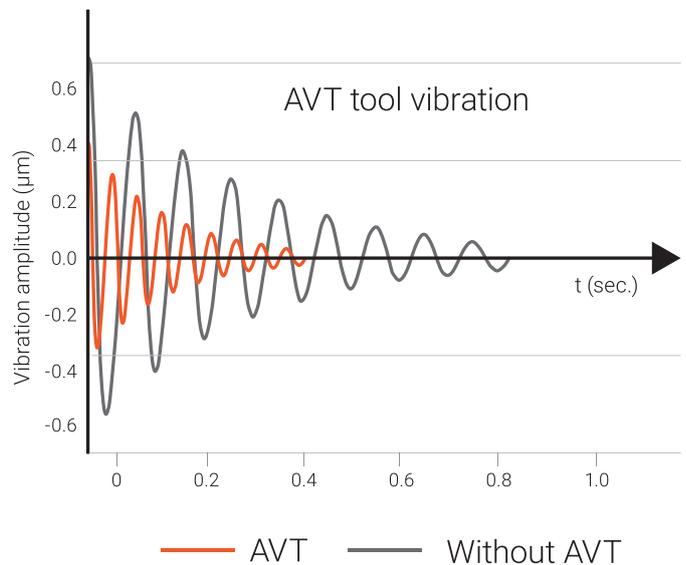
quick head change while maintaining repeatability

optimized chip evacuation

direct cooling of the cutting zone



PATENTED CONSTRUCTION CONNECTIONS



Unique anti-vibration mechanism in the tool body reduces vibration during deep hole boring

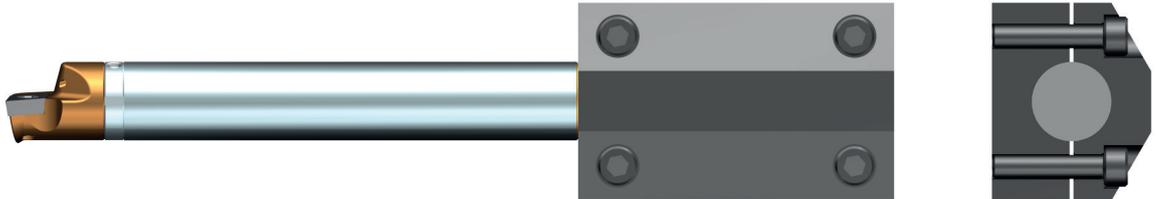
L/D=10



VERY GOOD

Two-piece fixing collar

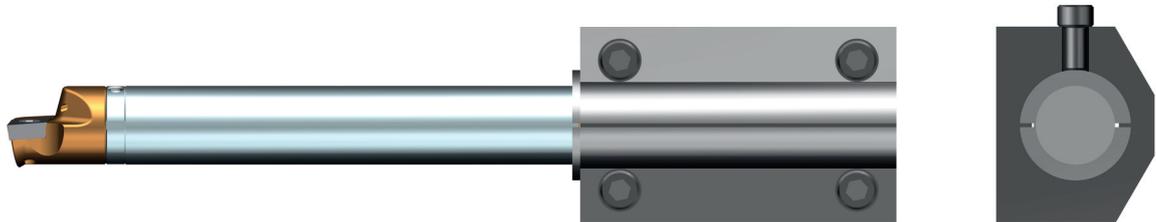
Tighten the screws so that the entire bar is in contact with the periphery fastening element. This will ensure perfect working precision and no damage to the grip surface.



GOOD

Two-piece clamping sleeve

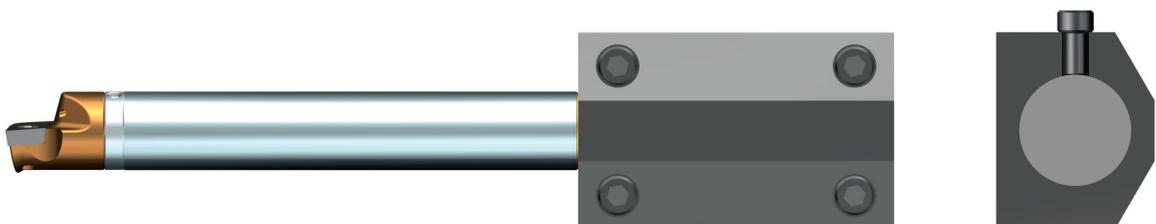
The split sleeve presses the bar all over its perimeter. The screw tightens the bushings around the handle. It will ensure the perfect precision of work and will not damage the surface of the handle.



VERY WRONG - do not use!

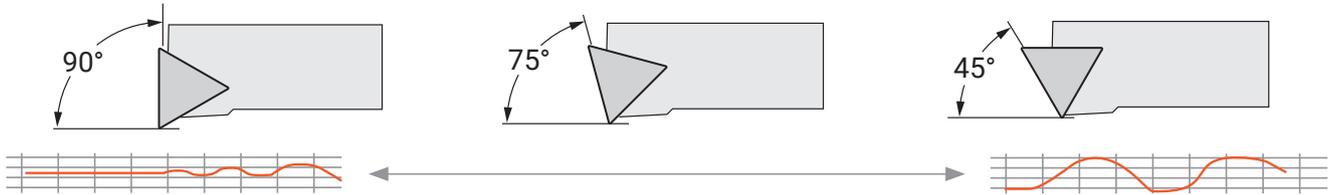
Strong boring bar holder, without collet

Never drive screws directly into the boring bar holder. Such mounting gives only point contact with the handle and does not provide stiffness. In addition, the screws will damage the handle surfaces and make it difficult to set the tool correctly.

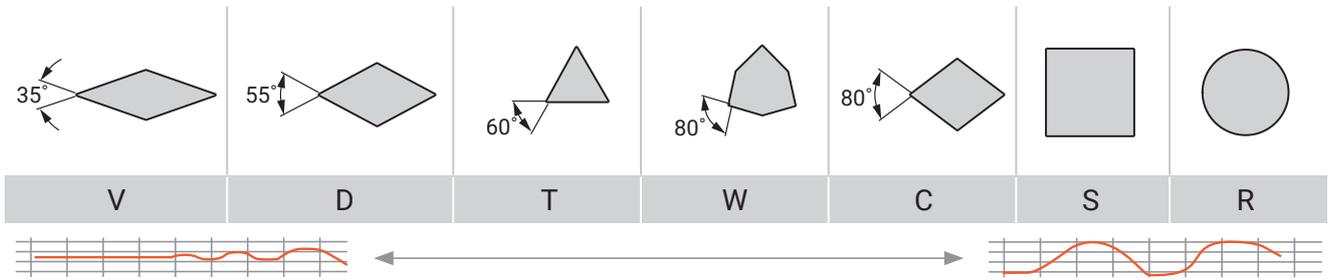


SELECTION OF THE RIGHT INSERT

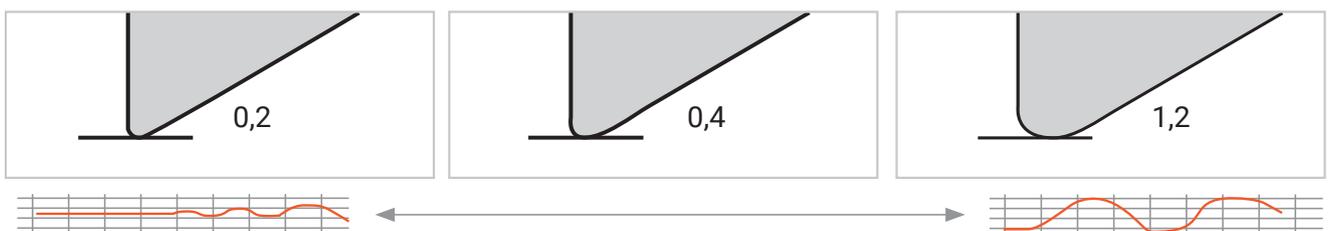
Choosing the right insert can make a significant difference to the overall success of vibration damping by minimizing cutting forces. Following the directions below should be the first step to eliminate vibrations:



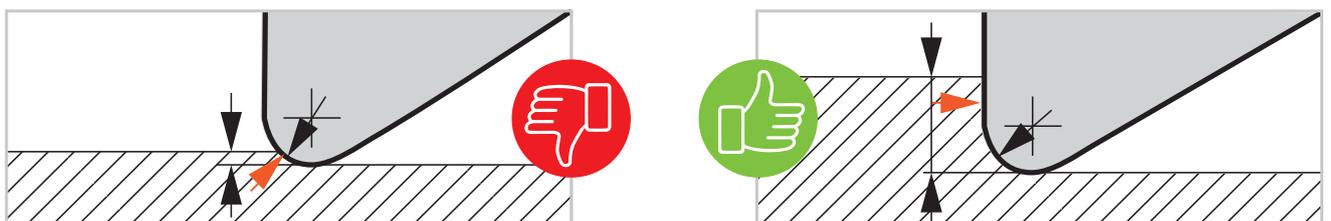
Use inserts with as **largest angle** as possible.



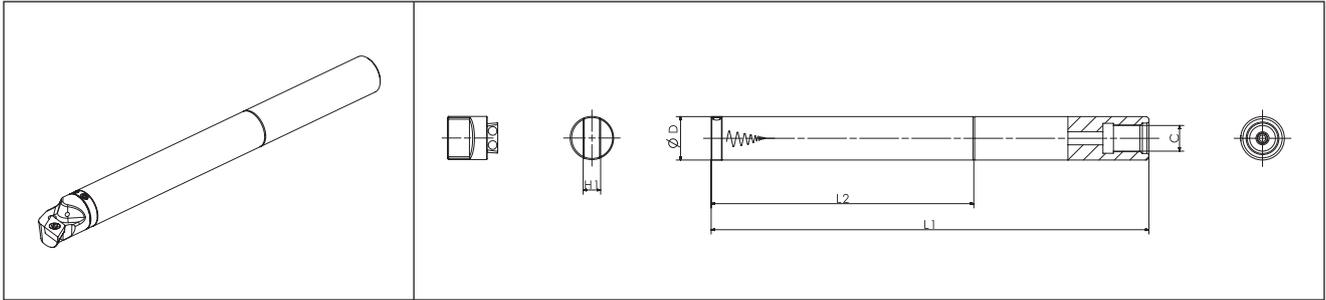
Choose a **small radius**, to reduce cutting forces and allow smaller cutting depth.



The depth of cut (a_p) should be greater than the radius.

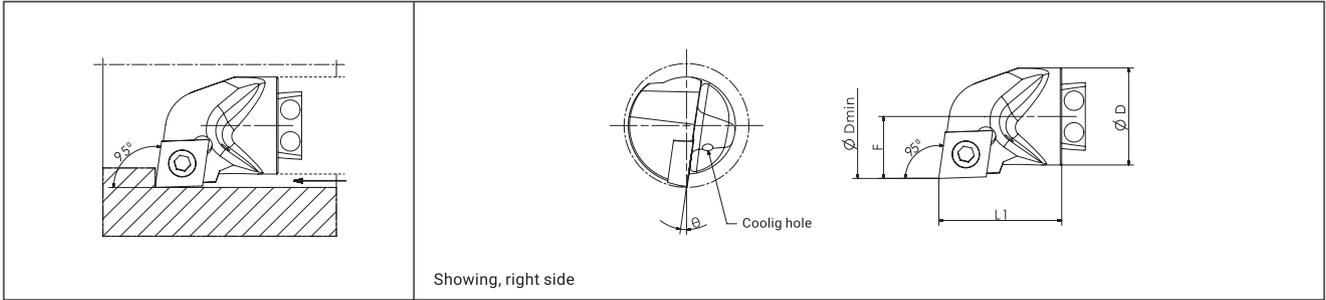


Dimensions of the bar



Item	Material	Dimensions				Spare parts		
						Screw	Wrench	Setting screw
		$\varnothing D$	L1	L2	C			
AV20-L200-7D-S	steel	20	200	120	G1/4	SK45	KA20	SAV-20
AV20-L260-10D-SC	steel/carbide	20	260	180	G1/4-			
AV25-L255-7D-S	steel	25	255	155	G1/4	SK56	KA25	SAV-25
AV25-L330-10D-S	steel	25	330	230	G1/4			
AV32-L325-7D-S	steel	32	325	195	G3/8	SK68	KA32	SAV-32
AV32-L420-10D-S	steel	32	420	290	G3/8			
AV40-L420-7D-S	steel	40	420	250	G1/2	SK810	KA40	SAV-40

SCLC

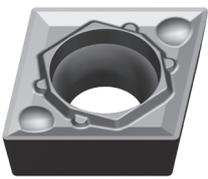


Showing, right side

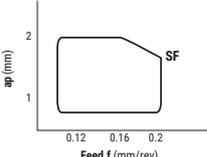
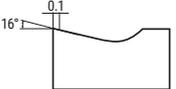
Tool dimension

Coolant pressure: up to 10 bar

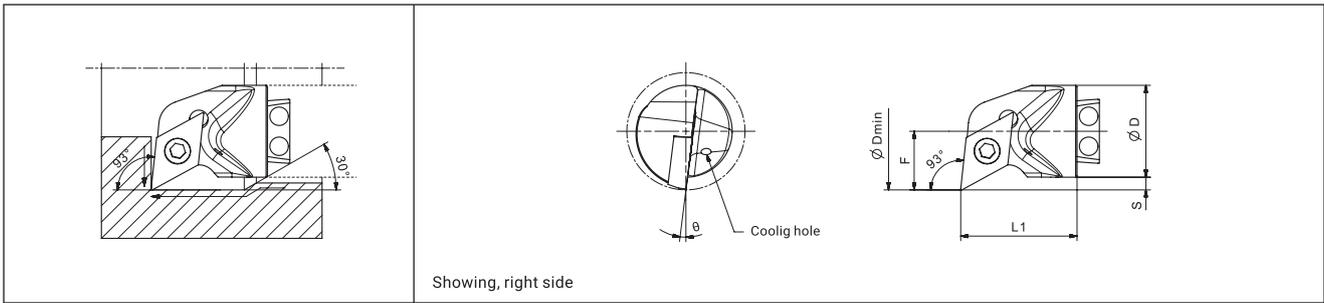
Item	Stock		Dimensions				Bar dimensions	Spare parts		
	R	L	ØD min	ØD	F	L1		Screw	Wrench	Insert
										
20-SCLCR/L09	●	●	25	20	13	25	20	S07	FT15	CC..09T3..
25-SCLCR/L09	●	●	32	25	17	27	25			CC..09T3..
32-SCLCR/L09	●	●	40	32	22	32	32			CC..09T3..
40-SCLCR/L12	●	●	50	40	27	38	40	S25	FT20	CC..1204..

CERMETAL INSERTS						
	Type	Dimensions [mm]			Sort	
		I.C.	S	R	JG135	JG130
	CCMT 09T304-SF	9,525	3,97	0,4	●	□
	CCMT 09T308-SF	9,525	3,97	0,8	●	□
	CCMT 120404-SF	12,7	4,76	0,4	●	□
CCMT 120408-SF	12,7	4,76	0,8	●	□	

Speed Vc (m/min)

Grade	Low alloy steel carbon >150 HB	Low carbon steel >250 HB	Carbon steel >300 HB	Working range	Breaker shape
JG 130	150 – 250 – 350		140 – 240 – 300		
JG 135	100 – 220 – 320		120 – 180 – 240		

□ – product available on request

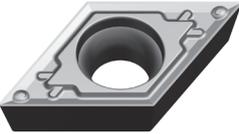


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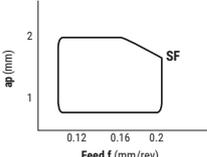
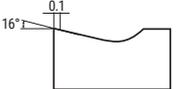
Wymiary noża

Coolant pressure: up to 10 bar

Item	Stock		Dimensions				Bar dimensions	Spare parts		
	R	L	φD min	φD	F	L1		Screw	Wrench	Insert
										
20-SDUCR/L11T	●	●	25	20	13	25	S07	FT15	DC..11T3..	
25-SDUCR/L11T	●	●	32	25	17	27			DC..11T3..	
32-SDUCR/L11T	●	●	40	32	22	32			DC..11T3..	
40-SDUCR/L11T	●	●	50	40	27	38			DC..11T3..	

CERMETAL INSERTS						
	Type	Dimensions [mm]			Sort	
		I.C.	S	R	JG135	JG130
	DCMT 11T304-SF	9,525	3,97	0,4	●	□
DCMT 11T308-SF	9,525	3,97	0,8	●	□	

Speed Vc (m/min)

Grade	Low alloy steel carbon >150 HB	Low carbon steel >250 HB	Carbon steel >300 HB	Working range	Breaker shape
JG 130	150 – 250 – 350		140 – 240 – 300		
JG 135	100 – 220 – 320		120 – 180 – 240		

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 www.jg-group.pl

 JG Group Sp. z o.o.
Headquarters and Production Plant
ul. Braci Krausse 4, 20-270 Lublin

 Office: +48 81 468 00 30
Fax: +48 81 746 57 88

 biuro@jg-group.pl
info@jg-group.pl

NIP: 9462678267 | KRS: 0000717020 | REGON: 369388478



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