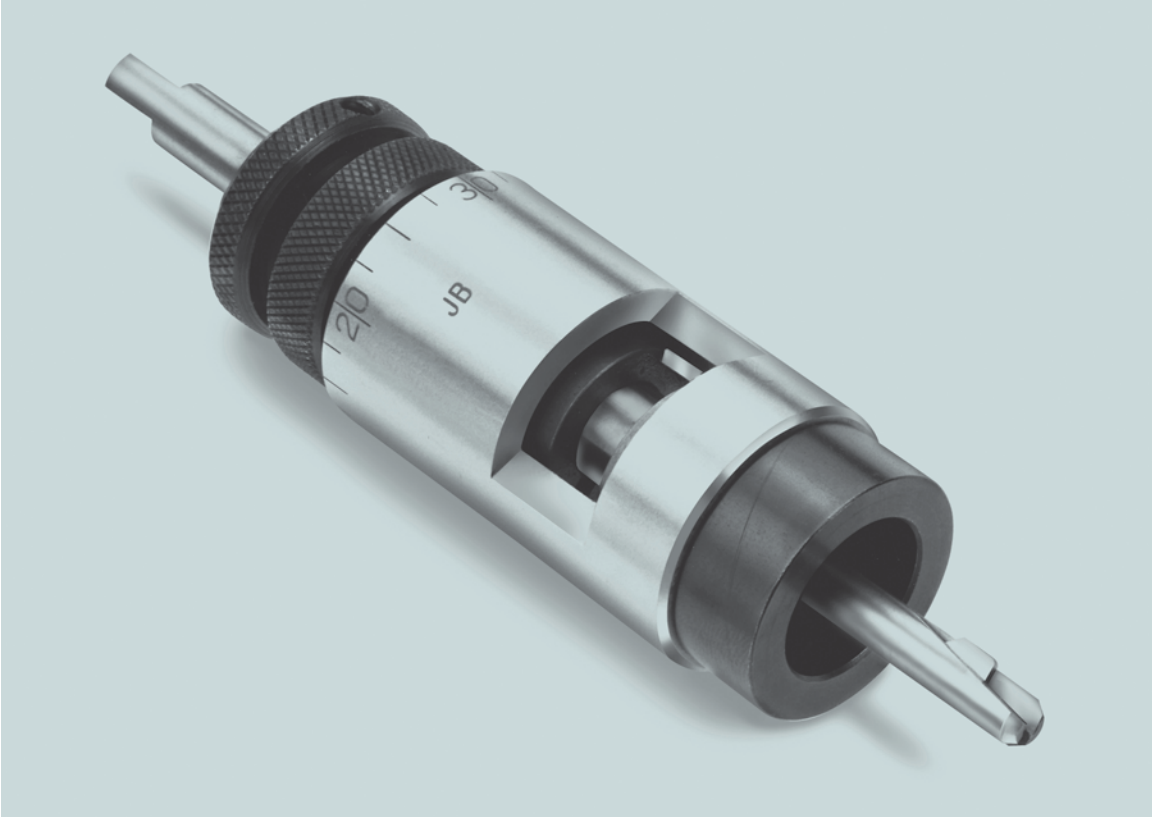
Precision Chamfering

Nobur® JB Automatic Back-Chamfering Tool

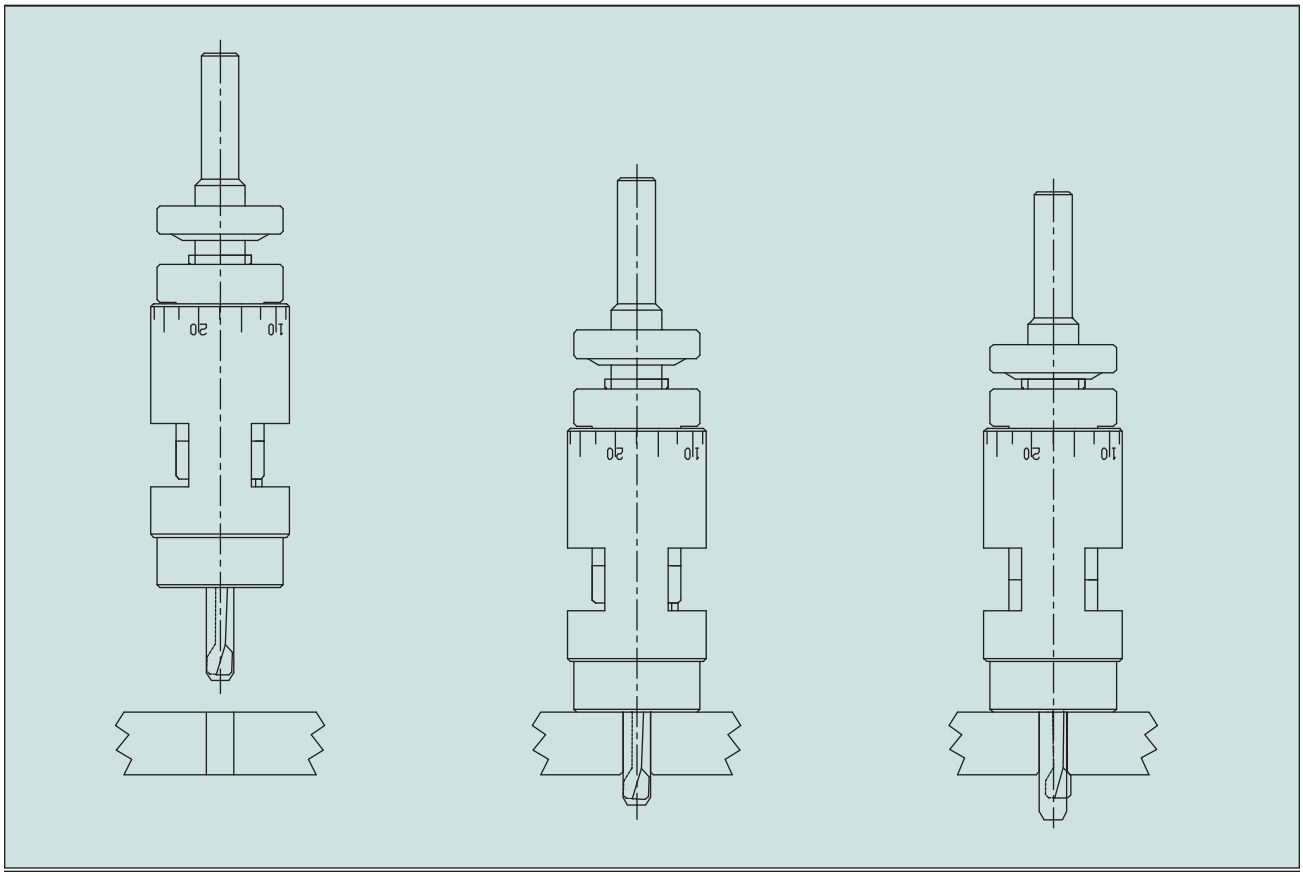
For back-chamfering or deburring on drill presses, CNC machines, tool or turret lathes, multi-spindle machines and jig boring machines.



- **Consistently accurate back-chamfering, deburring, and back-countersinking operations**
- **Pilots in hole for precise concentricity**
- **Rigid support of the cutter virtually eliminates deflection**
- **Micrometer-stop adjustment**
- **Standard pilots and cutters for hole sizes from 3/16 to 3/4” (4.75 to 19.05mm)**
- **Special pilots and cutters available upon request**

Operating Principle

Illustrated below is the basic operating principle for the Nobur® JB Automatic Back-Chamfering tool.



1 Approach Stroke

The Nobur® JB tool is rotating in a machine spindle. The spindle is lowered to bring the tool into position to enter the bore.

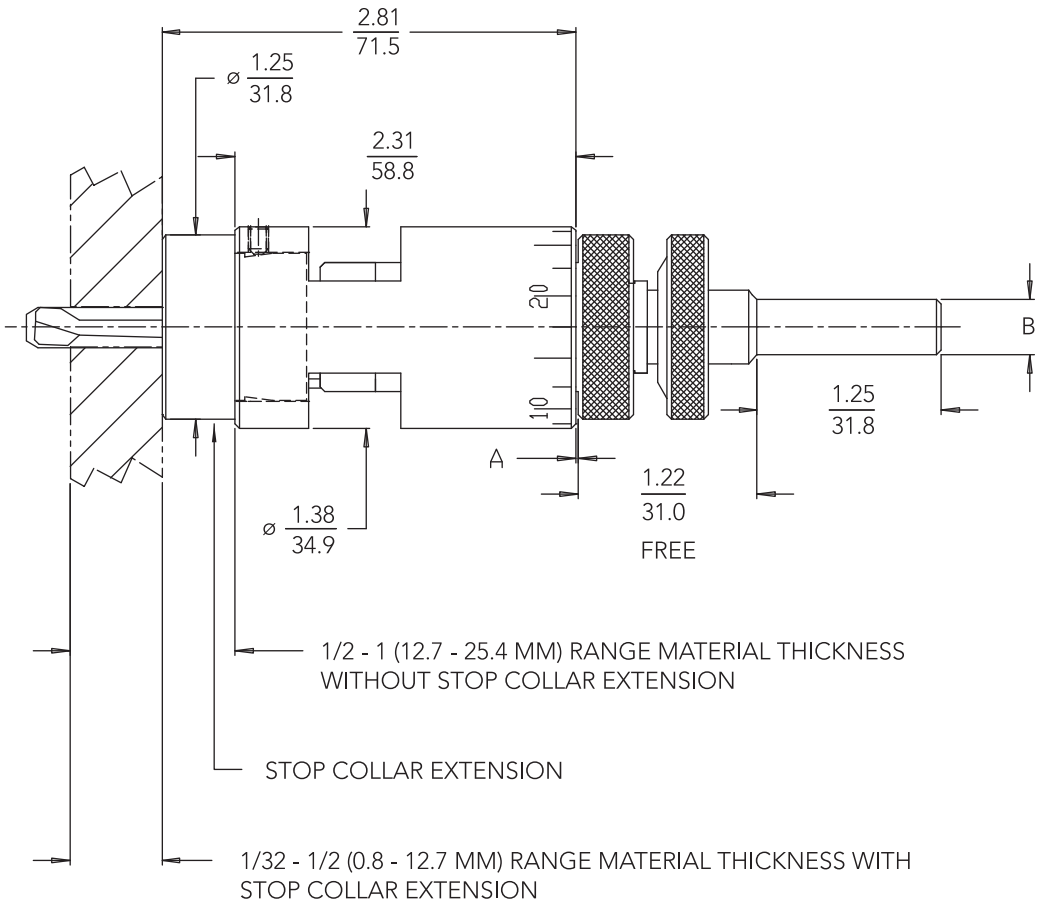
2 Feed Stroke

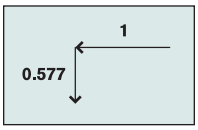
The pilot locates in the bore, stopping against the face of the workpiece. As the spindle continues to travel, the tool is compressed so that the cutter feeds out radially into the work. The cutter is rigidly supported in the bore by the pilot to eliminate deflection and ensure concentricity.

3 End of Feed Stroke

Radial depth of cut is obtained when the micrometer-stop nut bottoms out. Chamfer location is controlled by rotation of the stop collar, which moves the stop collar extension up or down to position the cutter for accurate chamfer location.

Specifications





The ***Feed Ratio*** is the ratio of vertical to horizontal movement. The ***Maximum Feed Stroke*** is 0.38 in. (9.4mm)

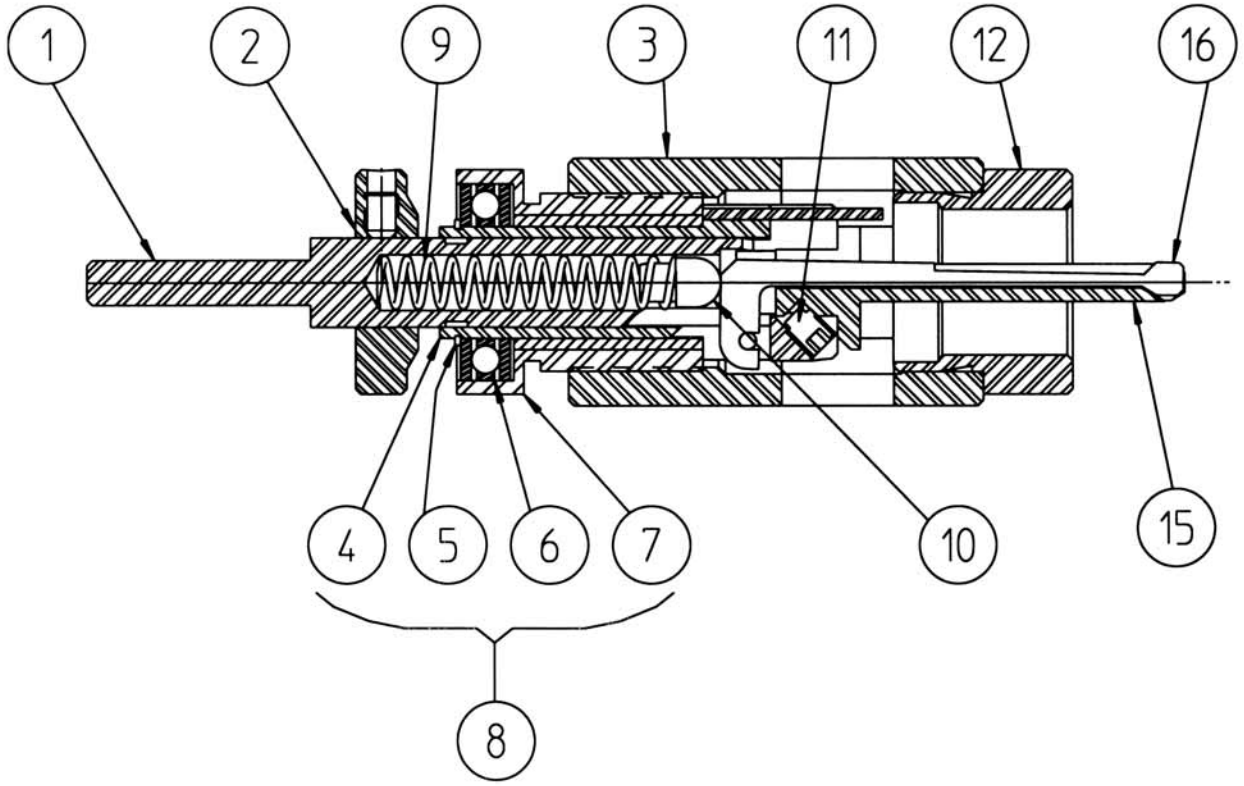
INCH [METRIC]

CAPACITY *		(A) MAX.		(B) SHANKS **
IN	MM	IN	MM	STRAIGHT SHANKS
0.88	22.4	0.78	19.8	1/4 3/8 w/tang

* Capacity means the suggested maximum chamfer diameter. Dependent upon cutting forces and bore diameter. Stated capacity is for steel.

** Shank is included with head. Shanks other than shown can be supplied upon request.

Bill of Materials



1 Body Holder

2 Stop Nut

3 Stop Collar

4 Keyed Transport Sleeve

5 Retaining Ring

6 Ball Thrust Bearing

7 Bearing Cage

8 Transport Assembly

9 Compression Spring

10 Ball (19/64) diameter

11 Pilot Retaining Screw

12 Stop Collar Extension

15 Pilot

16 Blade