

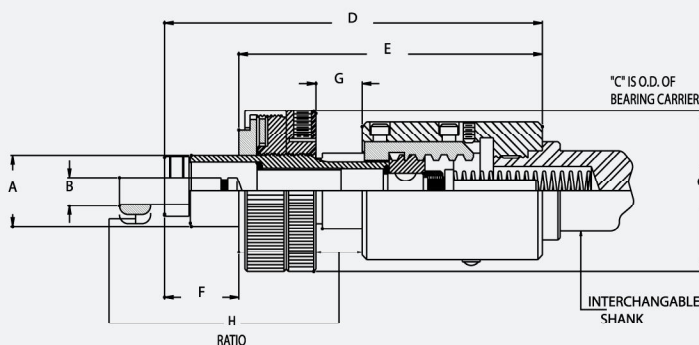
MODEL "JF" HOLDER AND TOOL

The "JF" holder is designed to be used in conjunction with standard or special jigs or fixtures, with either fixed or rotary bushings. They are easily set up and the changeover from one job to another usually requires only a new form cutter. The high ratio of axial motion provides a fine finish with close tolerances.

The model "JF" Recess Tool is ideal for dedicated, transfer line, rotary or index types of set-ups, where fixturing is most commonly used. However, these tools can be used to pilot directly in the workpiece. They are ideal for deep hole grooving, backfacing and back chamfering operations.

The toolholder nose (see drawing below) pilots into the drill bushing and stops on the head of the bushing. The Stop Bearing permits free rotation of the tool and prevents scoring or wear.

For hand feed operations, the diameter of the groove is controlled by the adjusting collars on the toolholder. For automatic feed operations, machine stops may be utilized. Groove location is governed by the adjustable stop bearing.

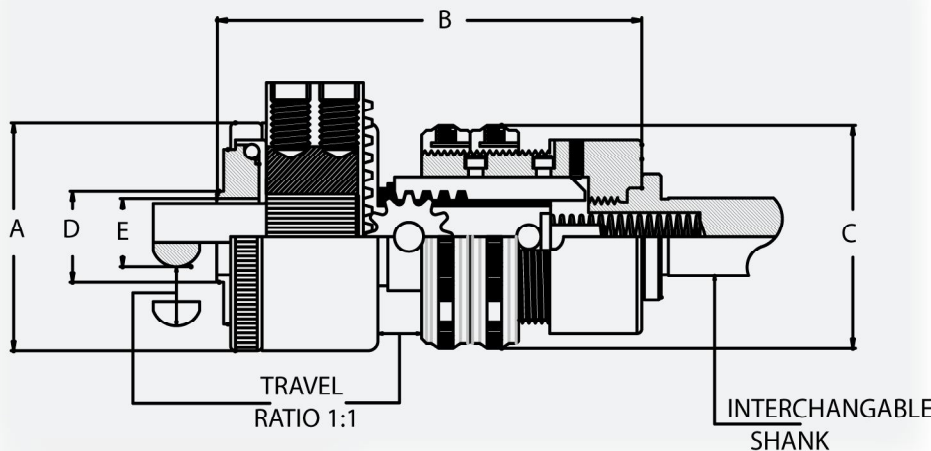


DIMENSIONS

TOOL MODEL	A	B	C	D	E	F	G MIN.	H MAX.	RATIO	WT.
O JF	1	3/8	2 1/4	6 1/2	5 1/16	1 7/16	3/4	.083	8.885	3
1 JF	1 1/4	1/2	2 1/2	6 53/64	4 61/64	1 7/8	57/64	.125	7.089	4
1 1/2 JF	1 1/2	5/8	2 3/4	8 5/16	6 3/16	2 1/8	1 1/8	.166	6.666	6
2 JF	1 3/4	3/4	3 1/4	8 5/8	6 3/8	2 1/4	1 11/32	.166	7.996	8
2 1/4 JF	2 1/4	1	3 5/8	11 13/16	8 15/16	2 7/8	1 5/8	.250	6.516	15

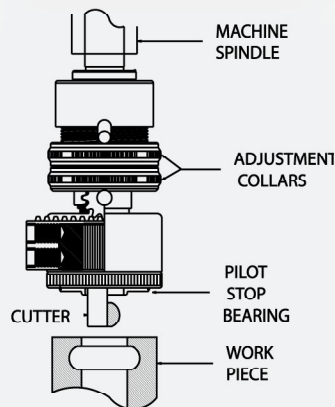
DIMENSIONS ARE IN INCHES - WEIGHTS ARE IN POUNDS

MODEL "R" HOLDER AND TOOL



The Model "R" holder is probably the most versatile and extensively used recess toolholder on the market. It is used for such a great variety of work because it has the greatest range and the longest travel of any available holder. These features, along with its simplicity of design, contribute to fast set-up and low cost operation.

The Model "R" recess tool pilots directly into and stops on the workpiece by means of a ballbearing pilot and is usable on most any machine from small manual machines to fully automatic equipment. It is particularly adaptable to program-controlled and full NC machines - whether in a dedicated transfer line, part of a Flexible Machining System (FMS), or a stand alone machine tool.



DIMENSIONS

TOOL MODEL	A	B MIN.	B MAX.	C	D MAX.	E	WT.	RANGE	THROW
1 R	2 1/4	4 3/4	5 3/16	2 3/8	1	1/2	3	3/8 - 1	7/16
2 R	3 1/4	4 3/4	5 5/16	2 7/8	2	3/4	4	1 - 2	7/16
3 R	4 1/4	5 23/32	6 15/32	3 9/16	3	1	11	2 - 3	3/4
4 R	5 5/16	5 23/32	6 15/32	3 9/16	4	1 1/4	15	3 - 4	3/4

DIMENSIONS ARE IN INCHES - WEIGHTS ARE IN POUNDS