Clamping

Guiding

Pick Up
„We start there, where others have to give up.“

Here at JBS System GmbH, we act according to this principle and we are committed to looking at difficult problems and providing a solution.

Founded in 1982, the company has become one of the leading providers of flexible guide bush units for long automatic lathes over the last 30 years.

The JBS Flexible Guide Bushing for double-cone collets and pull-collets was developed in order to guide and/or clamp work material rods with a varying external diameter in a rotating as well as a stationary condition in Swiss type automatic lathes.

The drive for the flexible guide bushing is via a drive belt, a gearwheel or a driving dog or synchronous drive.

Opening, closing and clamping of the guide collets is by means of a pneumatic system with an adjustable pressure piece.

The pressure piece presses the guide collet against the fixed spindle cap, the guide collet begins to close and thus surrounds the work material rod.

Controlling of the JBS guide bushing is via 4 freely programmable M commands in the machine.
This is what speaks in favour of the JBS System

- no seizing any more
- collet guide runs synchronized to spindle and during the processing adjusts to material
- range of adjustment of the flexible guide collet system max. ±0,3 mm
- quick change from collet to collet: maximum 3 minute!
- No more the titherto time-consuming and complicated adjustment of the guide collet
- easy handling with loading magazine
- thanks to this novel system, for the first time ever, the necessary high metal removal rate in form cutting is made possible
- suitable for all materials: from plastics to highalloyed chrome steels in the version from ground to rolled material according to DIN standard 1013

Technical data:
Material diameter 1,0 mm to 40,0 mm
CNC- or CAM-controlling with serveral functions: opening - closing - clamping - gliding

Special sizes are possible

The JBS System can be applied to the following CNC Swiss bush-type automatic lathes:
Star, Citizen, Maier, HANWHA, Gildemeister, Manurhin/KMX, Tornos, Traub, Tsugami, Nomura, Strohm etc.
### JBS overview Pull-System for Star CNC Swiss Automatic

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Collet Typ</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>344</td>
<td>SV-32-JII-Z, Flexible Guide Bush Unit</td>
<td>342/53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>345</td>
<td>SR-32 J-Z, Flexible Guide Bush Unit</td>
<td>342/53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>395</td>
<td>SR-10 J-Z, Flexible Guide Bush Unit</td>
<td>322/26x35</td>
<td>Pull-System, up to Ø 10mm</td>
</tr>
<tr>
<td>396</td>
<td>SV-20 Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>325</td>
<td>SR-20 RIII-Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>398</td>
<td>ECAS 20 T-Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>410</td>
<td>SR-20 J-Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>420</td>
<td>SV-20/25-Z, Flexible Guide Bush Unit</td>
<td>378/44x40</td>
<td>Pull-System, up to Ø 23mm</td>
</tr>
<tr>
<td>423</td>
<td>SB-20 Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>427</td>
<td>SB 16-Z, Flexible Guide Bush Unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
<tr>
<td>438</td>
<td>SW-20 Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>452</td>
<td>SR-20 RIV-Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>479</td>
<td>SA 16-Z, Flexible Guide Bush Unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
<tr>
<td>489</td>
<td>SV-38 R-Z, Flexible Guide Bush Unit</td>
<td>485/59x60</td>
<td>Pull-System, up to Ø 38mm</td>
</tr>
<tr>
<td>522</td>
<td>SB-20 RG-Z, Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>524</td>
<td>SW-20/25Z, Flexible Guide Bush Unit</td>
<td>378/36x40</td>
<td>Pull-System, up to Ø 23mm</td>
</tr>
<tr>
<td>528</td>
<td>ST-20 , Flexible Guide Bush Unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>531</td>
<td>SB-12 RG-Z, Flexible Guide Bush Unit</td>
<td>322/26x35</td>
<td>Pull-System, up to Ø 10mm</td>
</tr>
<tr>
<td>532</td>
<td>SW-12 RII-Z, Flexible Guide Bush Unit</td>
<td>322/26x35</td>
<td>Pull-System, up to Ø 10mm</td>
</tr>
<tr>
<td>544</td>
<td>SR-38 A/B-Z, Flexible Guide Bush Unit</td>
<td>485/59x60</td>
<td>Pull-System, up to Ø 38mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice
### JBS Chuck Systems for Star CNC Swiss Automatic

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Collet Typ</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>183</td>
<td>SR-32 DKZ, Chuck</td>
<td>3/42x50</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>197</td>
<td>SV-32 J DKZ, Chuck</td>
<td>3/42x50</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>280</td>
<td>SR-20/25 RII DKZ, Chuck</td>
<td>2/33x40</td>
<td>up to Ø 23mm</td>
</tr>
<tr>
<td>281</td>
<td>SR-20 RII DKZ, Chuck</td>
<td>1/28x40</td>
<td>up to Ø 20mm</td>
</tr>
<tr>
<td>362</td>
<td>SR-32 J DKZ, Chuck</td>
<td>3/42x50</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>364</td>
<td>SR-32 JN DKZ, Chuck</td>
<td>3/42x50</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>374</td>
<td>SR-20 JN DKZ, Chuck</td>
<td>1/28x40</td>
<td>up to Ø 20mm</td>
</tr>
<tr>
<td>403</td>
<td>SV-32/36 J DKZ, Chuck</td>
<td>3/42x50</td>
<td>up to Ø 35mm</td>
</tr>
<tr>
<td>415</td>
<td>SV-32 J, Over grip chusk</td>
<td>J37</td>
<td>Ø on request</td>
</tr>
<tr>
<td>434</td>
<td>ECAS 20 T, Over grip chuck</td>
<td>J25</td>
<td>Ø on request</td>
</tr>
<tr>
<td>442</td>
<td>SR-32 J DKZ, Pick up chuck</td>
<td>3/42x50</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>448</td>
<td>SR-32 JN XL DKZ, Chuck</td>
<td>3/42x90</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>449</td>
<td>SR-32 J, Over grip chuck</td>
<td>J37</td>
<td>Ø on request</td>
</tr>
<tr>
<td>457</td>
<td>SR-20 RII, Over grip chuck</td>
<td>J25</td>
<td>Ø on request</td>
</tr>
<tr>
<td>460</td>
<td>SV-32 J DKZ, Pick up chuck</td>
<td>3/42x50</td>
<td>up to Ø 32mm</td>
</tr>
<tr>
<td>469</td>
<td>SB-16 EII DKZ, Chuck</td>
<td>1/28x40</td>
<td>up to Ø 32mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice.
### JBS overview Pull-System for Citizen CNC Swiss Automatic

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Guide collet</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>287</td>
<td>R 07-Z, Flexible guide bush unit</td>
<td>322/26x35</td>
<td>With synchronous drive up to max. 6.000 rpm</td>
</tr>
<tr>
<td>306</td>
<td>M 16-Z, Flexible guide bush unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
<tr>
<td>316</td>
<td>L 720-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>355</td>
<td>C 16, Flexible guide bush unit (insert)</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
<tr>
<td>394</td>
<td>A 20 VII-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>399</td>
<td>A 32-Z, Flexible guide bush unit</td>
<td>342/53x40</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>400</td>
<td>K12-Z/K-16-Z, Flexible guide bush unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
<tr>
<td>402</td>
<td>M32-Z, Flexible guide bush unit</td>
<td>342/53x40</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>413</td>
<td>L 20 E VIII-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>441</td>
<td>M432-Z VIII, Flexible guide bush unit</td>
<td>342/53x40</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>446</td>
<td>L 20 X-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>484</td>
<td>L 12-Z, Flexible guide bush unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 12mm</td>
</tr>
<tr>
<td>493</td>
<td>A 232-Z, Flexible guide bush unit</td>
<td>342/53x40</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>510</td>
<td>M 416, Flexible guide bush unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
<tr>
<td>512</td>
<td>L 220 XII-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>550</td>
<td>A320-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice.
**JBS overview Pull-System for Hanwha CNC Swiss Automatic**

![Image of a CNC machine with a pull system](image)

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Guide collet</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>326</td>
<td>XD 20 H-Z, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>431</td>
<td>STL 32-Z H, Flexible guide bush unit</td>
<td>342/53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>454</td>
<td>XD 20 V, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>486</td>
<td>STL 38 H-Z, Flexible guide bush unit</td>
<td>485/59x60</td>
<td>Pull-System, up to Ø 38mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice.
**JBS overview Pull-System for Maier CNC Swiss Automatic**

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Guide collet</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>338</td>
<td>ML 32-Z Serie A-F, Flexible guide bush unit</td>
<td>342/ 53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>333</td>
<td>ML 26-Z Serie A-F, Flexible guide bush unit</td>
<td>342/ 53x50</td>
<td>Pull-System, up to Ø 26mm</td>
</tr>
<tr>
<td>379</td>
<td>ML 20-Z Serie A-F, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
<tr>
<td>475</td>
<td>ML 32-Z Serie A-F/56, Flexible guide bush unit</td>
<td>342/ 53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>474</td>
<td>ML 26-Z Serie A-F/56, Flexible guide bush unit</td>
<td>342/ 53x50</td>
<td>Pull-System, up to Ø 26mm</td>
</tr>
<tr>
<td>476</td>
<td>ML 20-Z Serie A-F/56, Flexible guide bush unit</td>
<td>317/36x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice.
JBS overview Pull-System for Tornos CNC Swiss Automatic

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Guide collet</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>371</td>
<td>Deco 10 Z, Flexible guide bush unit</td>
<td>322/26x35</td>
<td>Pull-System, up to Ø 10mm</td>
</tr>
<tr>
<td>436</td>
<td>Deco 2000/25-Z, Flexible guide bush unit</td>
<td>378/44x40</td>
<td>Pull-System, up to Ø 25mm</td>
</tr>
<tr>
<td>535</td>
<td>ST 26-Z, Flexible guide bush unit</td>
<td>378/44x40</td>
<td>Pull-System, up to Ø 25mm</td>
</tr>
<tr>
<td>537</td>
<td>EvoDeco 16-Z, Flexible guide bush unit</td>
<td>346/32x40</td>
<td>Pull-System, up to Ø 16mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice
JBS overview Pull-System for Nomura CNC Swiss Automatic

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Guide collet</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>377</td>
<td>NN 25-Z YB, Flexible guide bush unit</td>
<td>378/44x40</td>
<td>Pull-System, up to Ø 26mm</td>
</tr>
<tr>
<td>388</td>
<td>NN 32-Z YB, Flexible guide bush unit</td>
<td>342/53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>456</td>
<td>NN 20-Z YB, Flexible guide bush unit</td>
<td>378/44x40</td>
<td>Pull-System, up to Ø 20mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice.
JBS overview Pull-System for Tsugami CNC Swiss Automatic

<table>
<thead>
<tr>
<th>Ident.-Nr</th>
<th>Item description</th>
<th>Guide collet</th>
<th>Info</th>
</tr>
</thead>
<tbody>
<tr>
<td>492</td>
<td>BO 266-II-Z, Flexible guide bush unit (insert)</td>
<td>378/44x40</td>
<td>Pull-System, up to Ø 26mm</td>
</tr>
<tr>
<td>497</td>
<td>BO 326-II-Z, Flexible guide bush unit (insert)</td>
<td>342/53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
<tr>
<td>505</td>
<td>HS 327-Z, Flexible guide bush unit (insert)</td>
<td>342/53x50</td>
<td>Pull-System, up to Ø 32mm</td>
</tr>
</tbody>
</table>

More model on request. Technical execution are subject to change without prior notice.
Collets Article-Number Key
Pinces de guidage article-nom.-clé

inner diameter / diamètre intérieur

form / forme
1 = round / rond
2 = square / carré
3 = hexagon / hexagone

material / matériaux
1 = CLASSIC nitrided / CLASSIC nitruré
3 = SIMPLEX Standard
4 = CLASSIC-AMPCO
5 = CLASSIC grey iron / CLASSIC fonte grise
6 = SIMPLEX-AMPCO
8 = CLASSIC plastic / CLASSIC matière plastique
9 = SIMPLEX nitrided / SIMPLEX nitruré

outer diameter / diamètre extérieur
1 = 28 x 40
2 = 33 x 40
3 = 42 x 50
6 = 48 x 60
7 = 24 x 35

7 = special length / longueur spéciale
8 = extended nose
9 = profile + special collets

0 0 0 0 0 0
Pull Collets Article-Number Key

inner diameter / diamètre intérieur

form / forme
1 = round / rond
2 = square** / carré**
3 = hexagon** / hexagone**

material / matériaux
1 = CLASSIC-nitrided / CLASSIC-nitruré
4 = CLASSIC-AMPCO
6 = SIMPLEX-AMPCO
9 = SIMPLEX-nitrided / SIMPLEX-nitruré

outer diameter / diamètre extérieur
317/36x40
322/26x35
342/53x50
378/44x40
485/59x60
Air Control for JBS Flexible Guide Bush Unit
WhizCut America

101 East Pier Street PO Box 345
Port Washington WI
53074-0345

Phone 262-284-3830
Fax 262-247-0622
Email sales.america@whizcut.com