

*Sharp tools. sharp ideas*



DEFORMATION



95 route de Marienthal - ZI de l'Aérodrome  
BP 10062 - 67502 HAGUENAU Cedex FRANCE

Tél. +33 (0)3 88 93 08 41

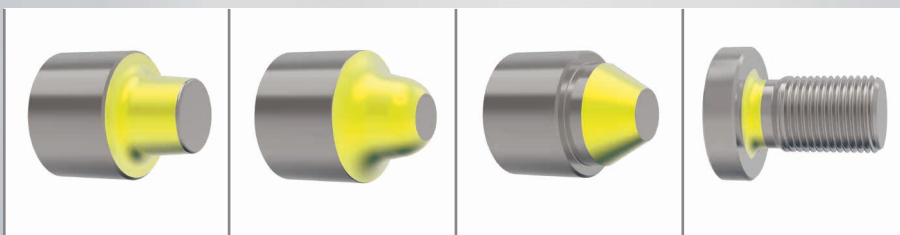
Fax +33 (0)3 88 93 43 73

[infos@joneprecision.com](mailto:infos@joneprecision.com)

[www.joneprecision.com](http://www.joneprecision.com)

***Sharp tools. sharp ideas***





## TAILOR MADE TOOL

For external contours / radii



## TAILOR MADE TOOLS FOR SPECIAL TASKS

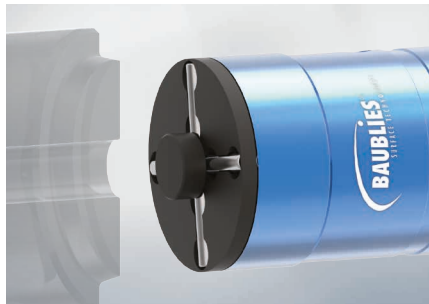
With our broad product range of standard tools we cover almost all applications. Nevertheless, there will always be special requirements.

Your individual machining task is our motivation to develop the special solution you need.

Trust our extensive know-how and the experience of our specialists. Sometimes it is already enough to modify existing components.



**BALL-BURNISHING**



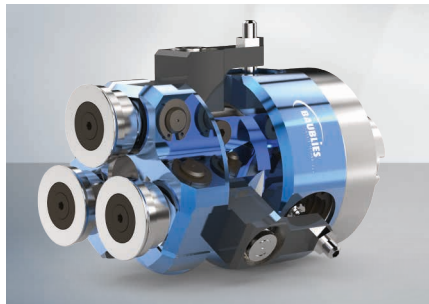
**BURNISHING PLANE SURFACES**



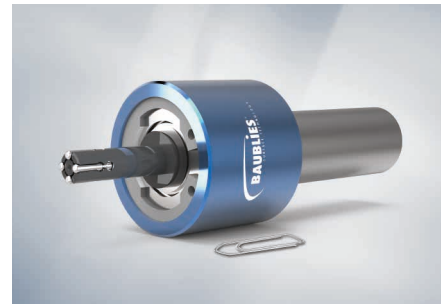
**BURNISHING STEPPED HOLES**



**BURNISHING THREADS**



**BURNISHING CONTOURS**



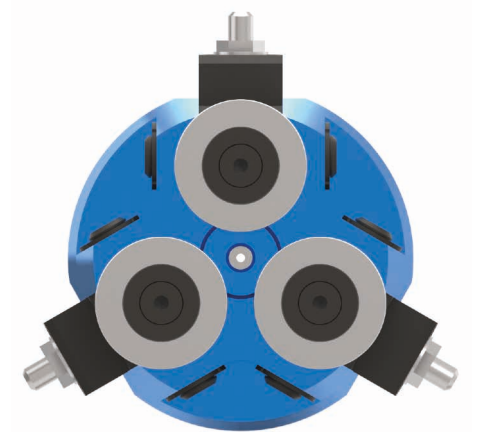
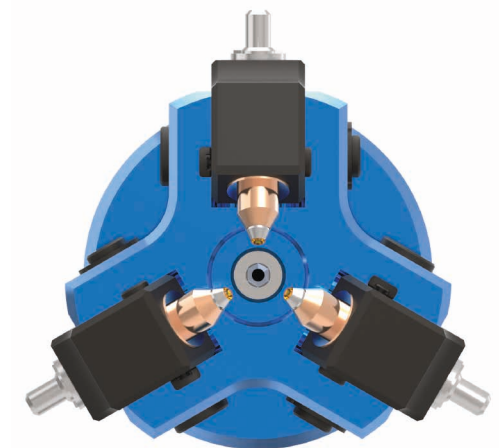
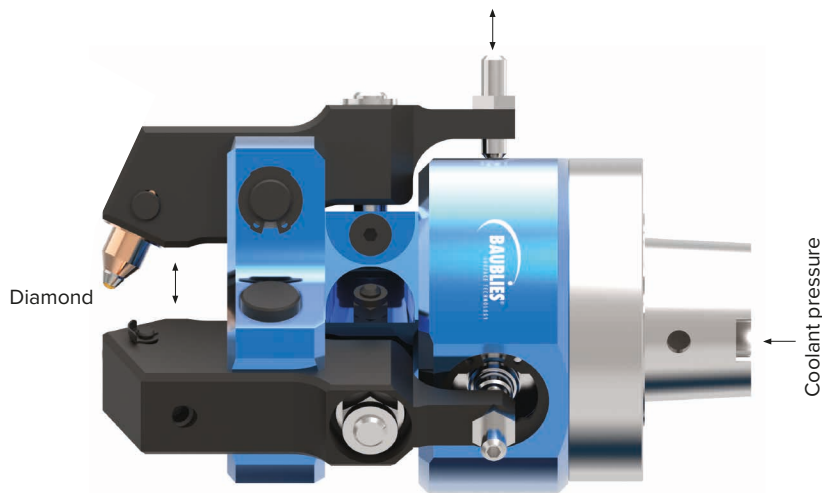
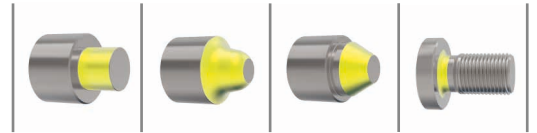
**MULTI-ROLLER BURNISHING  
TOOL PICCOLINO**



**BURNISHING TAPERS**



## Tailor made tool for external contours/radii



### Technical details

Application	external contours/radii
Dimensions	tailor made tool as required
Fixture	as required

Smoothering and work hardening of external contours (e.g. radii, tapers, etc.). The tool is rotating and the required rolling force is applied hydraulically (by coolant pressure) or mechanically (by connecting rod). During the rolling process the burnishing elements follow the given workpiece contour.

### ADVANTAGES

- Very short machining time
- High productivity
- Fast return of investment
- Easy to maintain
- Slim design
- Low machining forces



## FLANGING TOOLS

For flanging of tube  
shaped parts

## FORMING IN CONVINCING QUALITY

Forming tools from Baublies are used in a wide variety of applications including expanding, flanging and beading. Baublies forming tools are versatile, robust and durable. They enable the machining of small series on standard

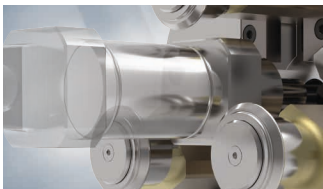
machines as well as the machining of large series on specialized machines. Baublies solutions are used for joining and assembly operations in various industries.

## ADVANTAGES

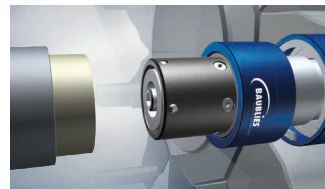
- High process reliability
- Quick processing and short cycle times
- High quality

## BEADING AND JOINING

With Baublies forming tools, beads in cylinders and tubes can be produced reliably in the shortest possible time and components can be connected in a form-fit manner. These tools can be used for both internal and external machining.



External beading

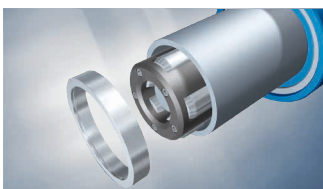


Internal beading

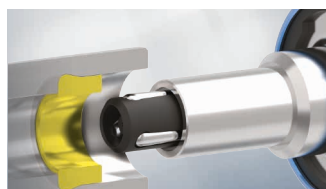


## EXPANDING AND ROLLING-IN

Baublies rolling tools for expanding and rolling-in join different components together in a force-locking or form-fit manner.



Rolling-in

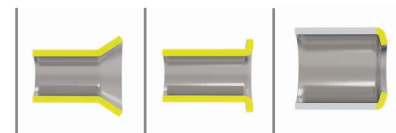


External flanging

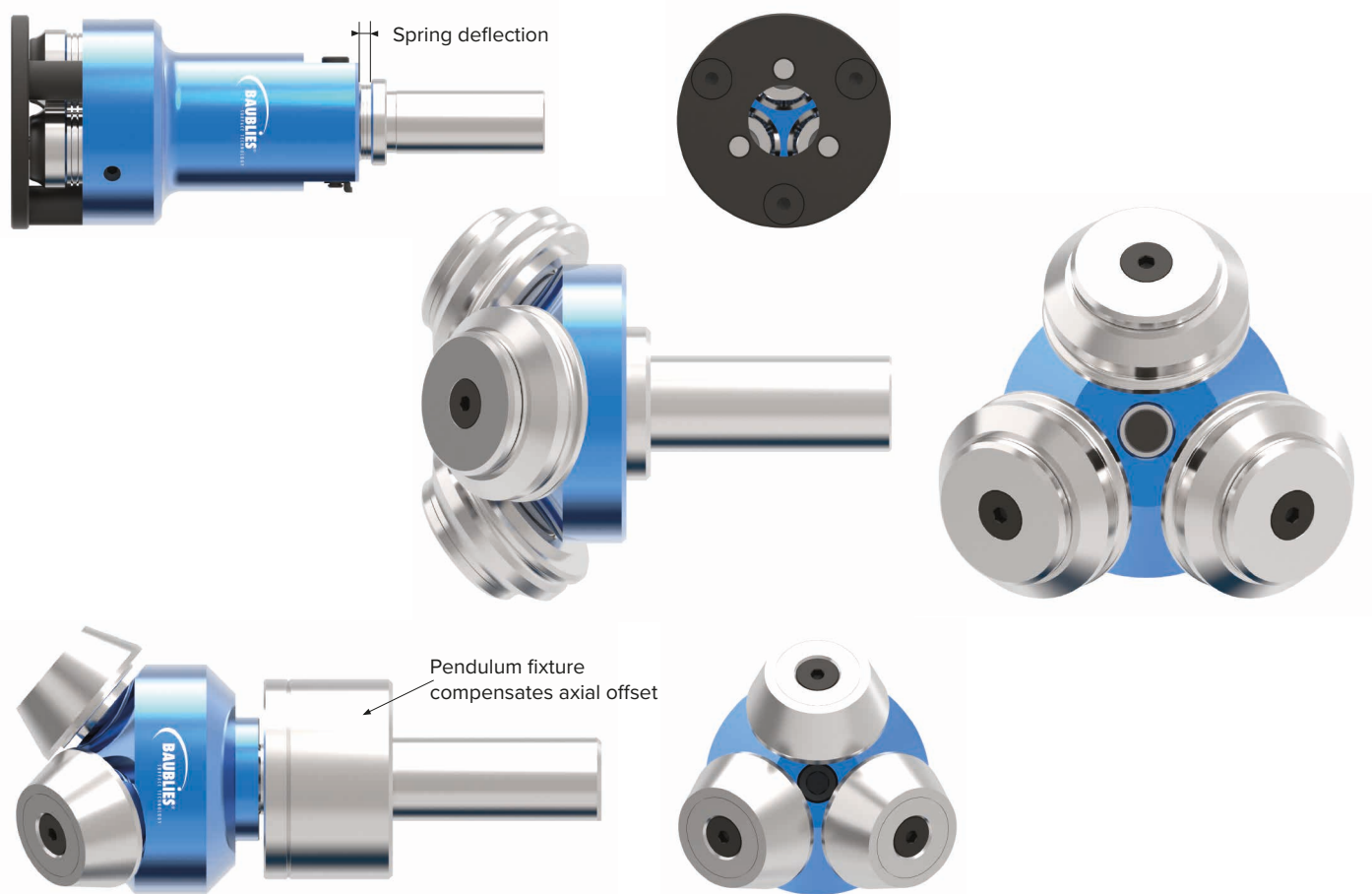


Internal flanging





## Flanging tools



### Technical details

Application	flanging of tube shaped parts
Dimensions	as required
Fixture	as required

### Application parameters

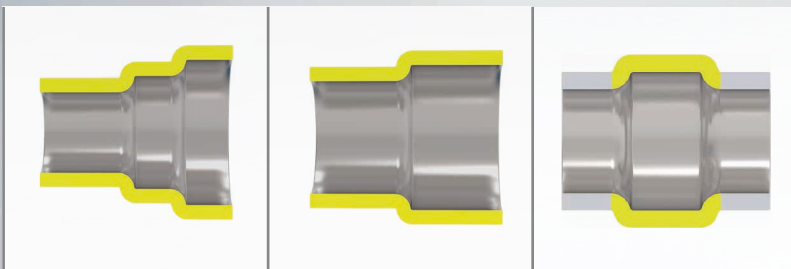
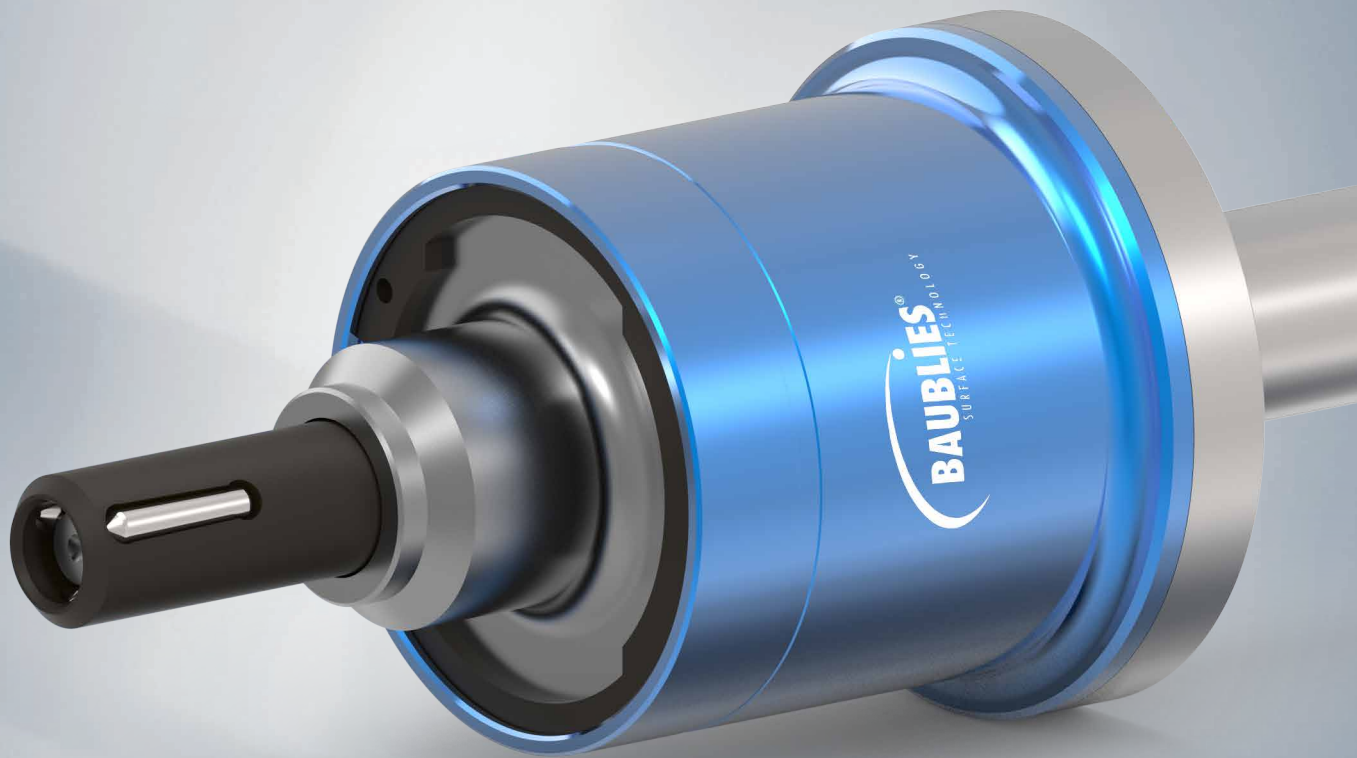
**Please note that this information represents standard values which must be adapted to the individual cases.**

Speed	up to 30 m/min
Feed rate	up to 0.5 mm/rev
Lubrication	emulsion or oil

Flanging tools create various contours in thin walled parts (e.g. tubes).

### ADVANTAGES

- Very short machining time
- Both tool or workpiece can rotate
- Slim design
- Low investment costs
- Easy to maintain
- Useable on common machine types



## EXPANDING TOOL

For expansion of tubular parts

## FORMING IN CONVINCING QUALITY

Forming tools from Baublies are used in a wide variety of applications including expanding, flanging and beading. Baublies forming tools are versatile, robust and durable. They enable the machining of small series on standard

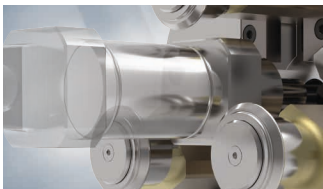
machines as well as the machining of large series on specialized machines. Baublies solutions are used for joining and assembly operations in various industries.

## ADVANTAGES

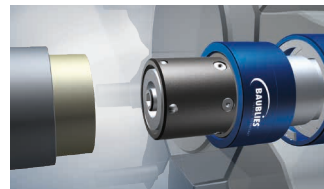
- High process reliability
- Quick processing and short cycle times
- High quality

## BEADING AND JOINING

With Baublies forming tools, beads in cylinders and tubes can be produced reliably in the shortest possible time and components can be connected in a form-fit manner. These tools can be used for both internal and external machining.



External beading

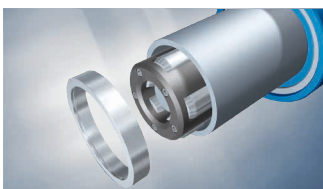


Internal beading

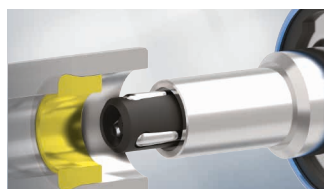


## EXPANDING AND ROLLING-IN

Baublies rolling tools for expanding and rolling-in join different components together in a force-locking or form-fit manner.



Rolling-in



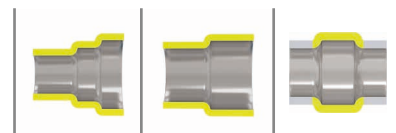
External flanging



Internal flanging



## Expanding tool



### Technical details

Application	expansion of tubular parts
Dimensions	as required
Fixture	as required
Internal coolant	optional as required

### Application parameters

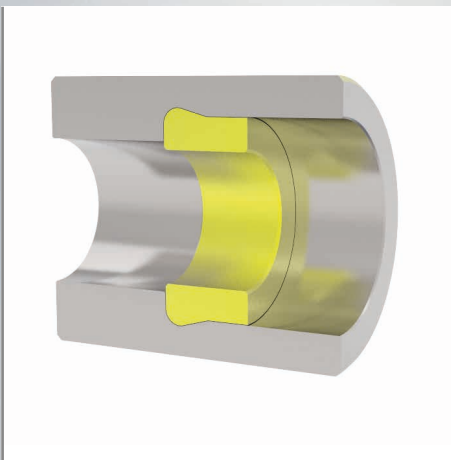
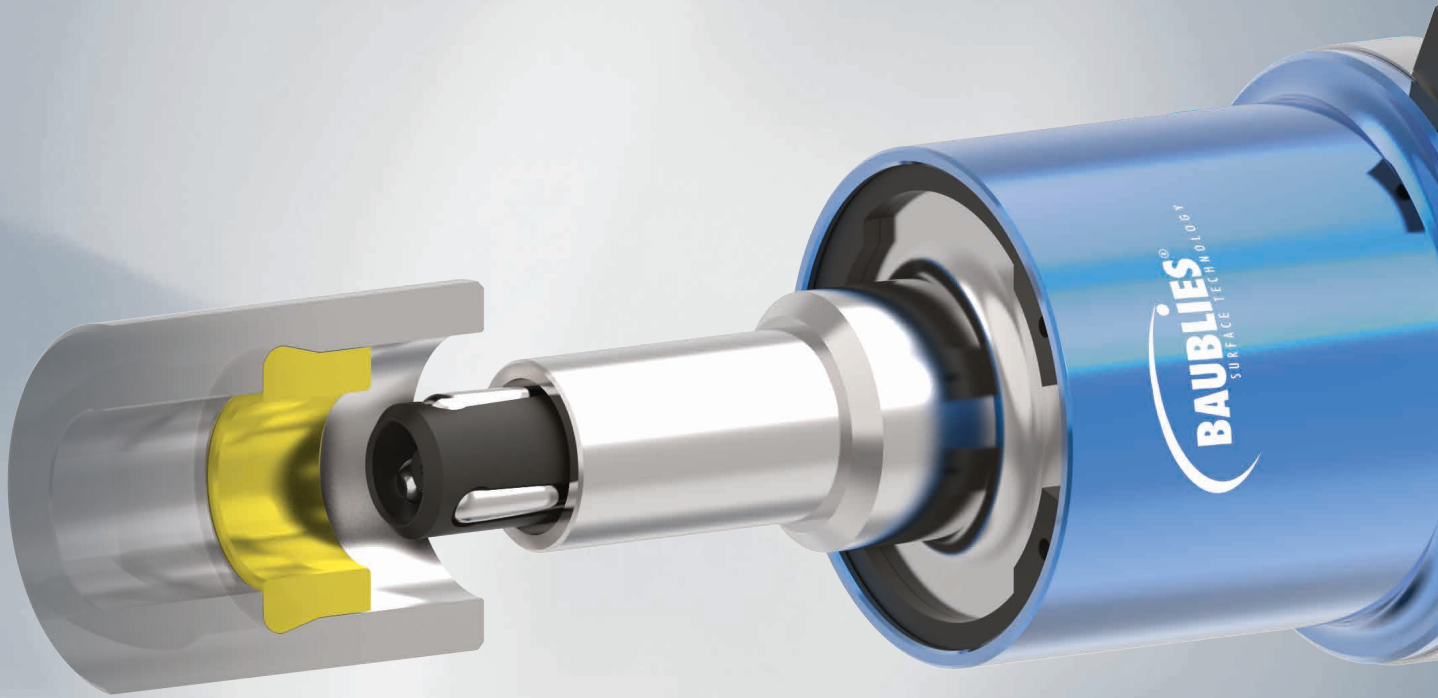
**Please note that this information represents standard values which must be adapted to the individual cases.**

Speed	up to 30 m/min
Feed rate	up to 0.5 mm/rev
Lubrication	emulsion or oil

Useable for connecting parts. The connection is form closed or force locked. These expanding tools can also create internal contours.

### ADVANTAGES

- Very short machining time
- Both tool or workpiece can rotate
- Slim design
- Low investment costs
- Easy to maintain
- Useable on common machine types



## EXPANDING TOOLS

For formclosed connections

## FORMING IN CONVINCING QUALITY

Forming tools from Baublies are used in a wide variety of applications including expanding, flanging and beading. Baublies forming tools are versatile, robust and durable. They enable the machining of small series on standard

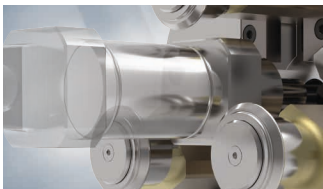
machines as well as the machining of large series on specialized machines. Baublies solutions are used for joining and assembly operations in various industries.

## ADVANTAGES

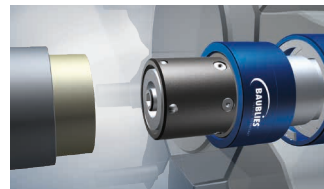
- High process reliability
- Quick processing and short cycle times
- High quality

## BEADING AND JOINING

With Baublies forming tools, beads in cylinders and tubes can be produced reliably in the shortest possible time and components can be connected in a form-fit manner. These tools can be used for both internal and external machining.



External beading

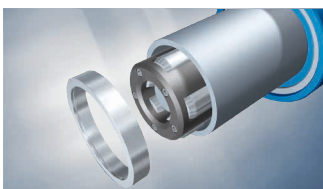


Internal beading

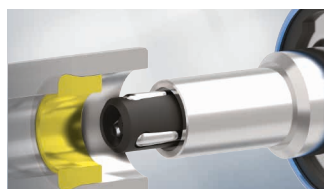


## EXPANDING AND ROLLING-IN

Baublies rolling tools for expanding and rolling-in join different components together in a force-locking or form-fit manner.



Rolling-in



External flanging

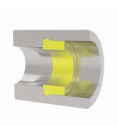


Internal flanging

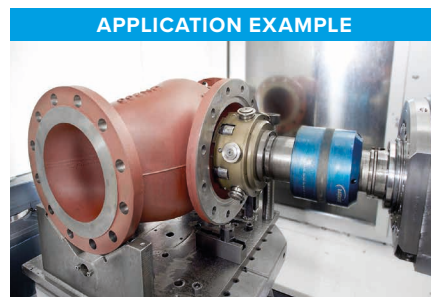


## Expanding tool

from DN 15



### APPLICATION EXAMPLE



#### Technical details

Application	form closed connection of seat rings into valve housings
Dimensions	as required
Fixture	as required
Internal coolant	optional as required

#### Application parameters

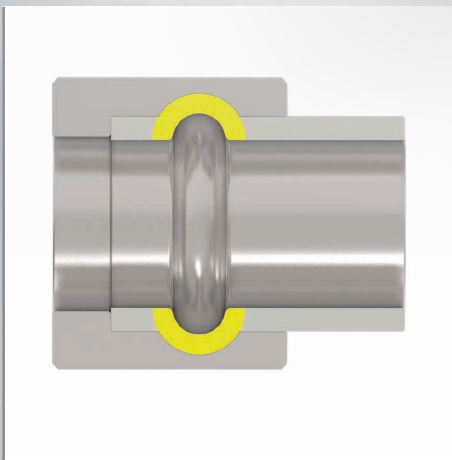
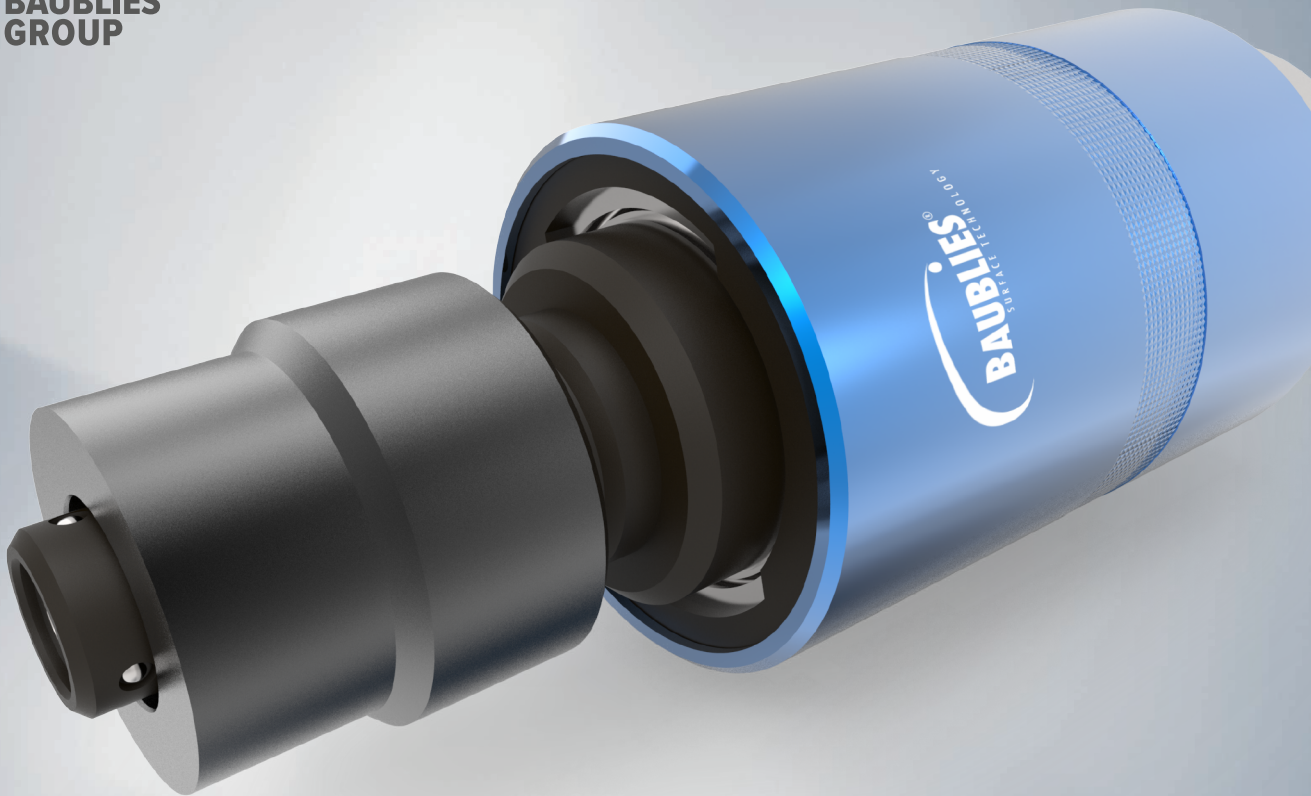
**Please note that this information represents standard values which must be adapted to the individual cases.**

Speed	up to 70 m/min
Feed rate	up to 0.5 mm/rev
Lubrication	emulsion or oil
Special features	The seat ring is held by the tool so that automatic loading can take place before machining.

Useable to connect valve seat rings into valve housings. The connection is form closed.

#### ADVANTAGES

- Automatic processing is possible
- The valve seat ring is fixed, guided and positioned by the tool
- Diameter range from DN 15 to DN 400 available



## INTERNAL BEADING TOOLS

For formfit connection of  
tube shaped parts

## FORMING IN CONVINCING QUALITY

Forming tools from Baublies are used in a wide variety of applications including expanding, flanging and beading. Baublies forming tools are versatile, robust and durable. They enable the machining of small series on standard

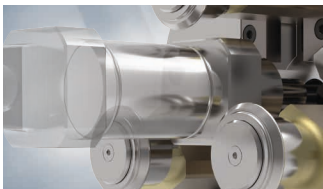
machines as well as the machining of large series on specialized machines. Baublies solutions are used for joining and assembly operations in various industries.

## ADVANTAGES

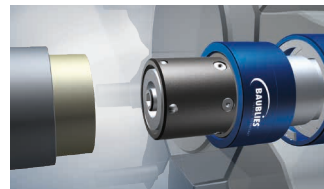
- High process reliability
- Quick processing and short cycle times
- High quality

## BEADING AND JOINING

With Baublies forming tools, beads in cylinders and tubes can be produced reliably in the shortest possible time and components can be connected in a form-fit manner. These tools can be used for both internal and external machining.



External beading

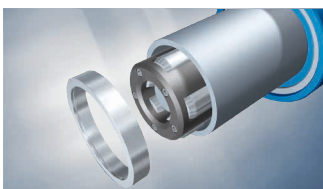


Internal beading

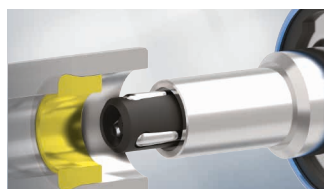


## EXPANDING AND ROLLING-IN

Baublies rolling tools for expanding and rolling-in join different components together in a force-locking or form-fit manner.



Rolling-in

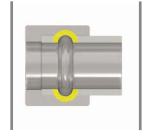


External flanging

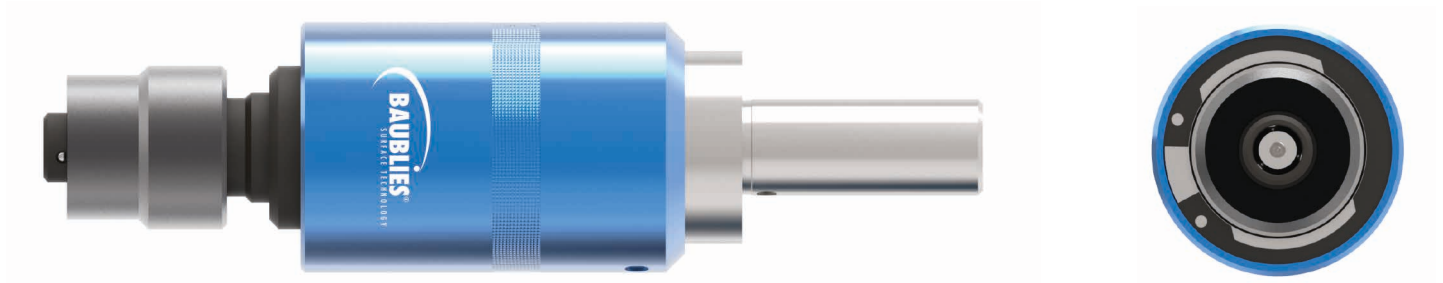


Internal flanging





## Internal beading tool



### Technical details

Application	formfit connection of tube shaped parts
Dimensions	as required
Fixture	as required

### Application parameters

**Please note that this information represents standard values which must be adapted to the individual cases.**

Speed	up to 50 m/min
Feed rate	up to 0.5 mm/rev
Lubrication	emulsion or oil

### ADVANTAGES

- Short machining time
- Drive possible on tool or on workpiece side
- Compact dimensions
- Low investment costs
- Simple replacement of wear parts
- Useable on common machine types

