



# THREAD CUTTING MACHINE

## TYPE GM 07

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**Manual, hydraulic or  
semi-automatic  
operation.**

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**Manual model  
GM 07-50 M**

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**Hydraulic models  
GM 07-100 H (Hydraulic)  
GM 07-50 H (Hydraulic)**

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**Semi-automatic models  
GM 07-100 SA  
GM 07-50 SA**

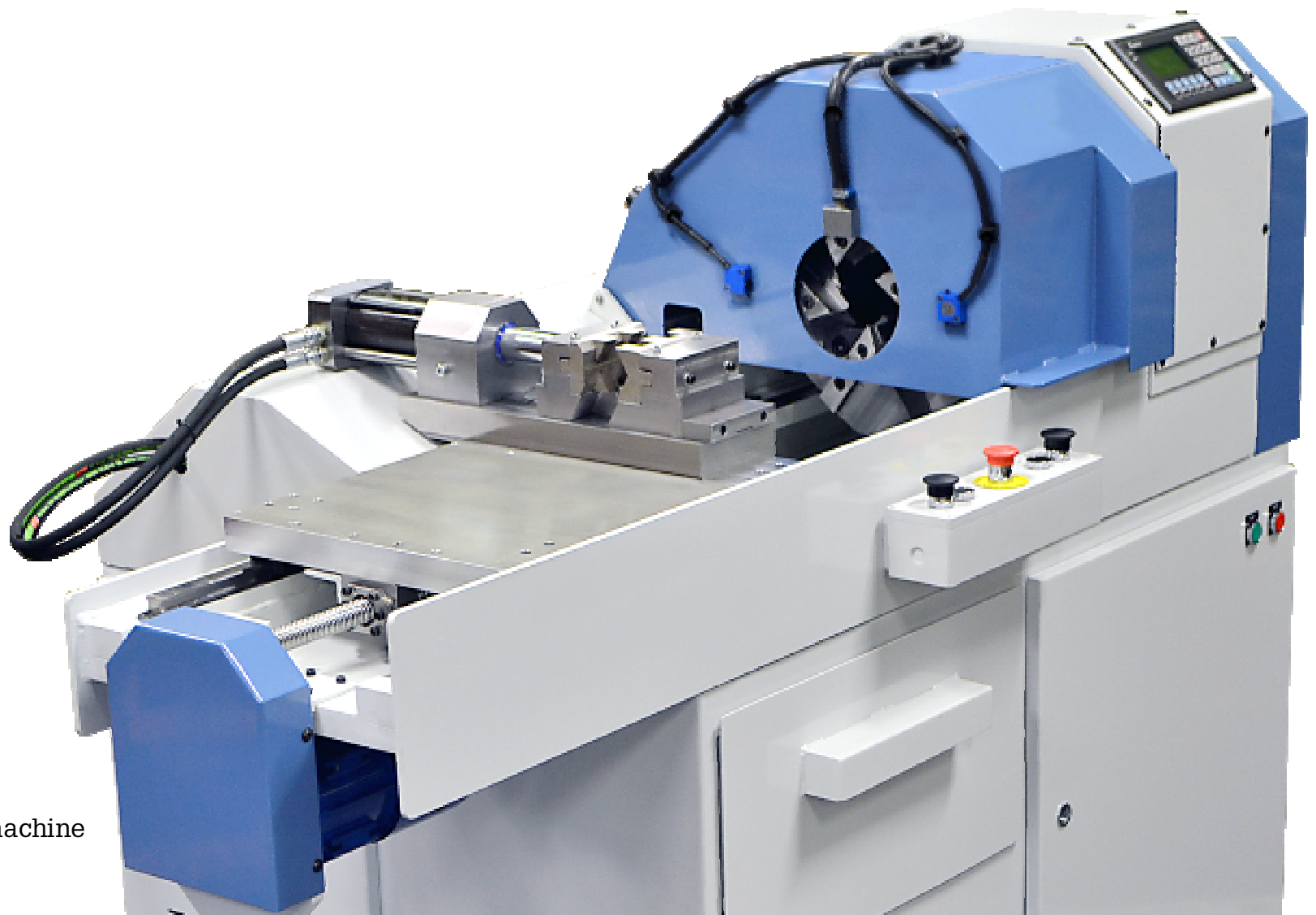
Replaces our discontinued  
models OK-3 and OK-5



Pictured:  
Semi-automatic  
Thread cutting machine  
GM 07-100 SA

# THREAD CUTTING MACHINE

## TYPE GM 07



Pictured:  
Semi-automatic  
Thread cutting machine  
GM 07-100 SA

### **The GM 07 machines are specifically designed for thread cutting.**

The operating time per thread length is considerably shorter than what can be achieved, for example, on a lathe. The finished thread is produced in a single cutting operation, irrespective of thread pitch or the initial diameter of the material. The work piece is fixed in the clamp and fed towards the rotating die head that guides the thread. The machines feature simple and robust design and are easy to operate, even by low-skilled staff.

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The GM 07 machine series offers a manual (M), hydraulic (H) and semi-automatic (SA) version.


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All versions are available with a standard die head for medium thread cutting (07-50). The hydraulic and semi-automatic versions are available with a large die head for larger and coarser work pieces (07-100).


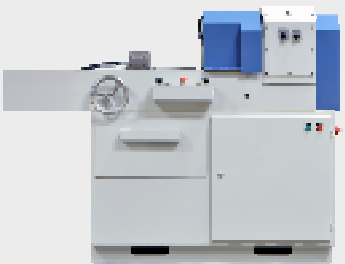



**High operating efficiency**  
**High precision operation**  
**Heavy duty capacity**  
**High build quality**  
**High safety**  
**Easy to operate**

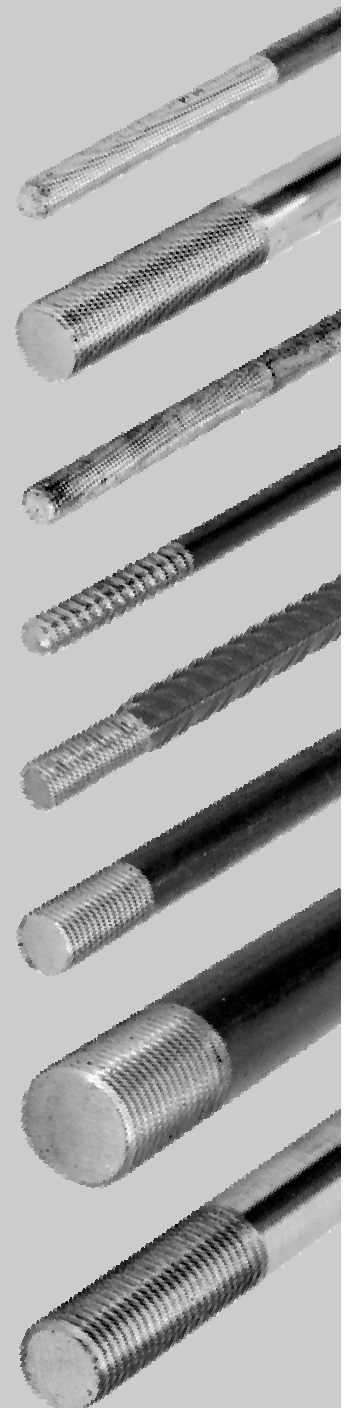
- Rods
- Pipes
- Rebar
  
- Metric threads
- Straight pipe threads
- Tapered pipe threads

**For piece and series production.**

 Quality product  
 Made in Sweden

**For industry, metalworking, installation.**

<b>Manual</b>	<b>Hydraulic</b>	<b>Semi-auto</b>
 GM 07-50 M	 GM 07-50 H	 GM 07-50 SA
	 GM 07-100 H	 GM 07-100 SA





# H M V G M 0 7

## Features

Applies to all models

### Design

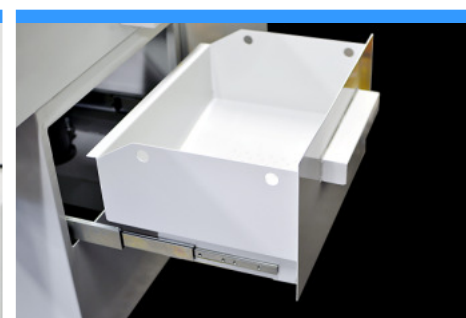
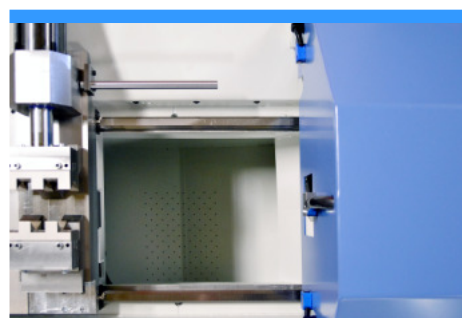
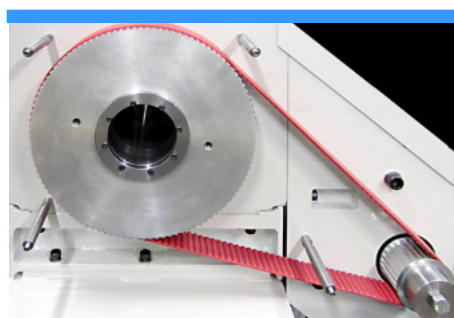
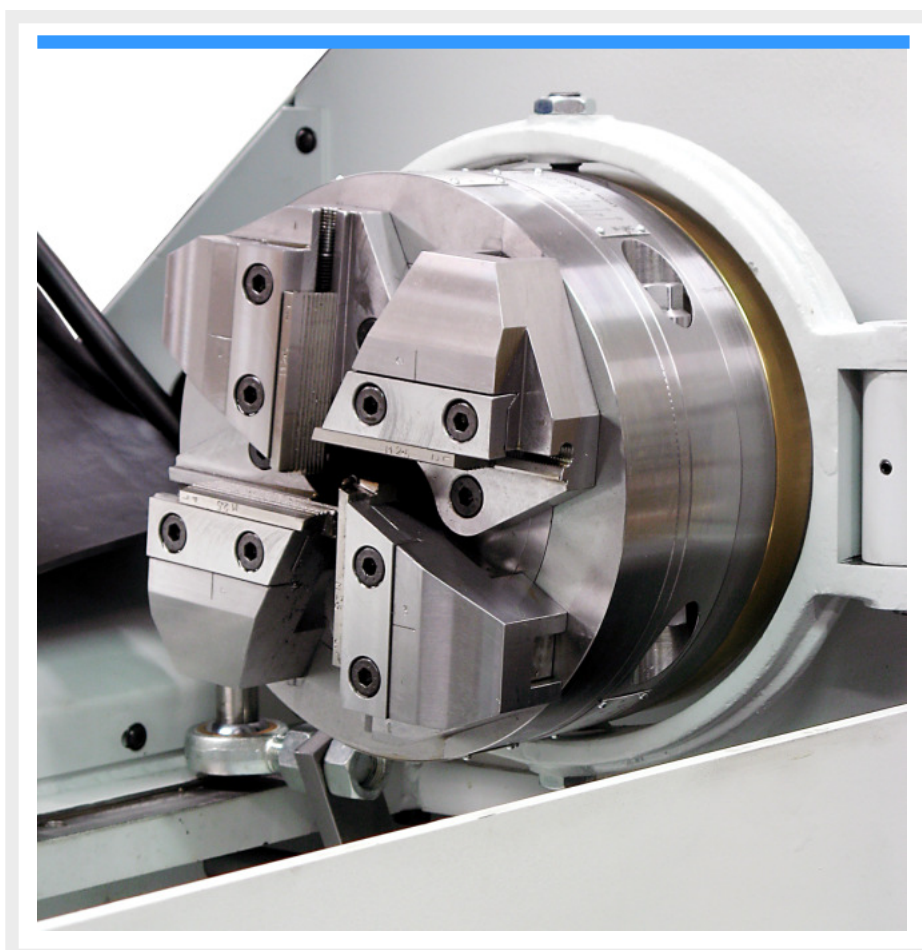
Robust construction for continuous operation. Die head with regrindable tangential HSS threading dies. Strong welded machine stand with integrated coolant pump, 40 liter coolant tank and 50 liter removable chip drawer on telescopic rails with ball bearings designed for traverse crane attachment. Die head protection cover with built-in cooling spray nozzle. Relocating the machine is easy thanks to the fork lift channels in the bottom of the machine stand.

### Drive

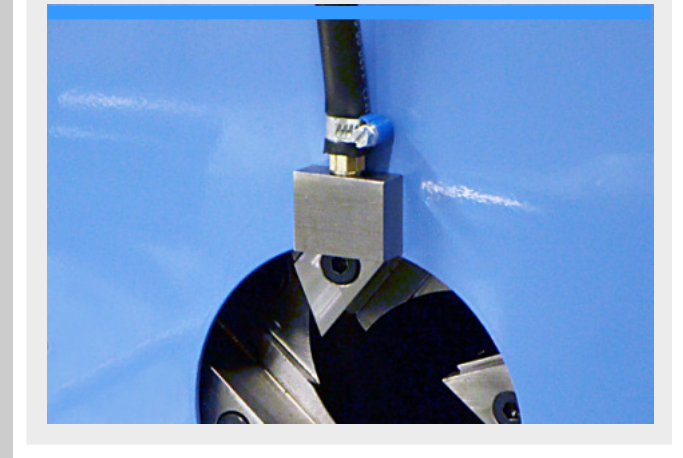
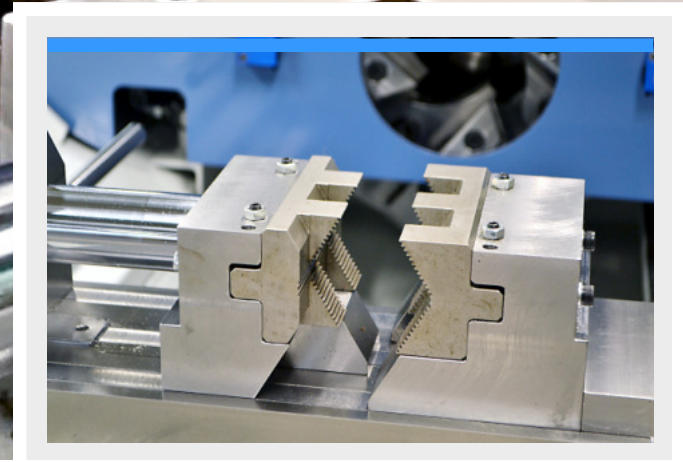
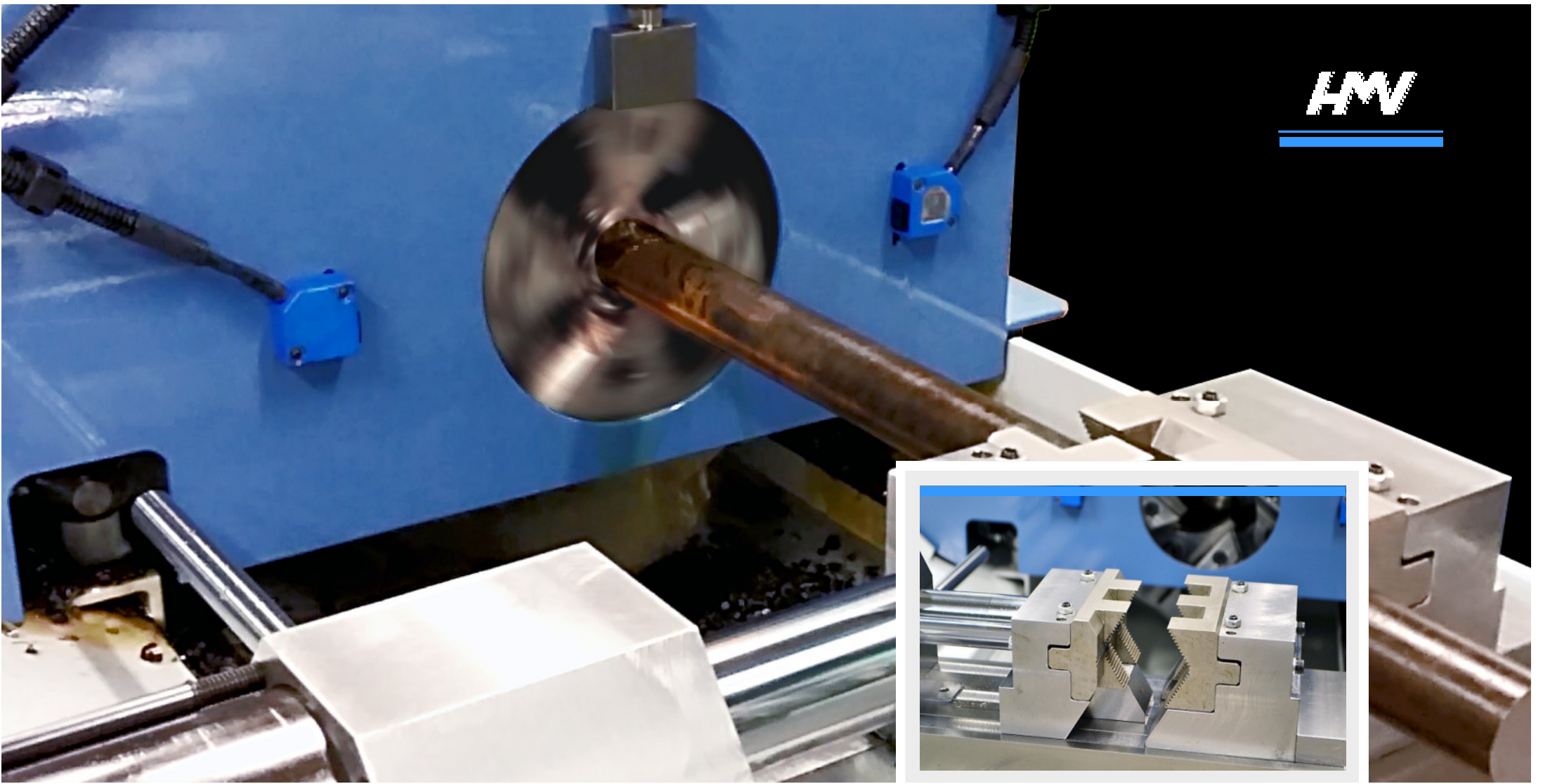
Cog belt drive eliminates the need for a gearbox and gives way for a low noise level. The cog belt is made out of extra durable polyurethane that is pre-stressed with a stretch stable steel cord. Seamless adjustment of die head speed from 3 to 350 rpm. Max. cutting speed standard dies up to 15 m/min. Max. cutting speed coated dies up to 20 m/min. The carriage runs on ball screw and linear guides to ensure a reliable and smooth movement.

### Die head

The die head comes equipped with die holders for right-hand threads but can also be equipped for left-hand threads if needed. The same die holder is used for all threading dies within respective diameter interval. The entire working range can be covered with a single set of die holders. The tangential cutting system makes for good chip clearance, coupled with high cutting and production capacity. Graduated spindle for precision adjustment of thread diameter.





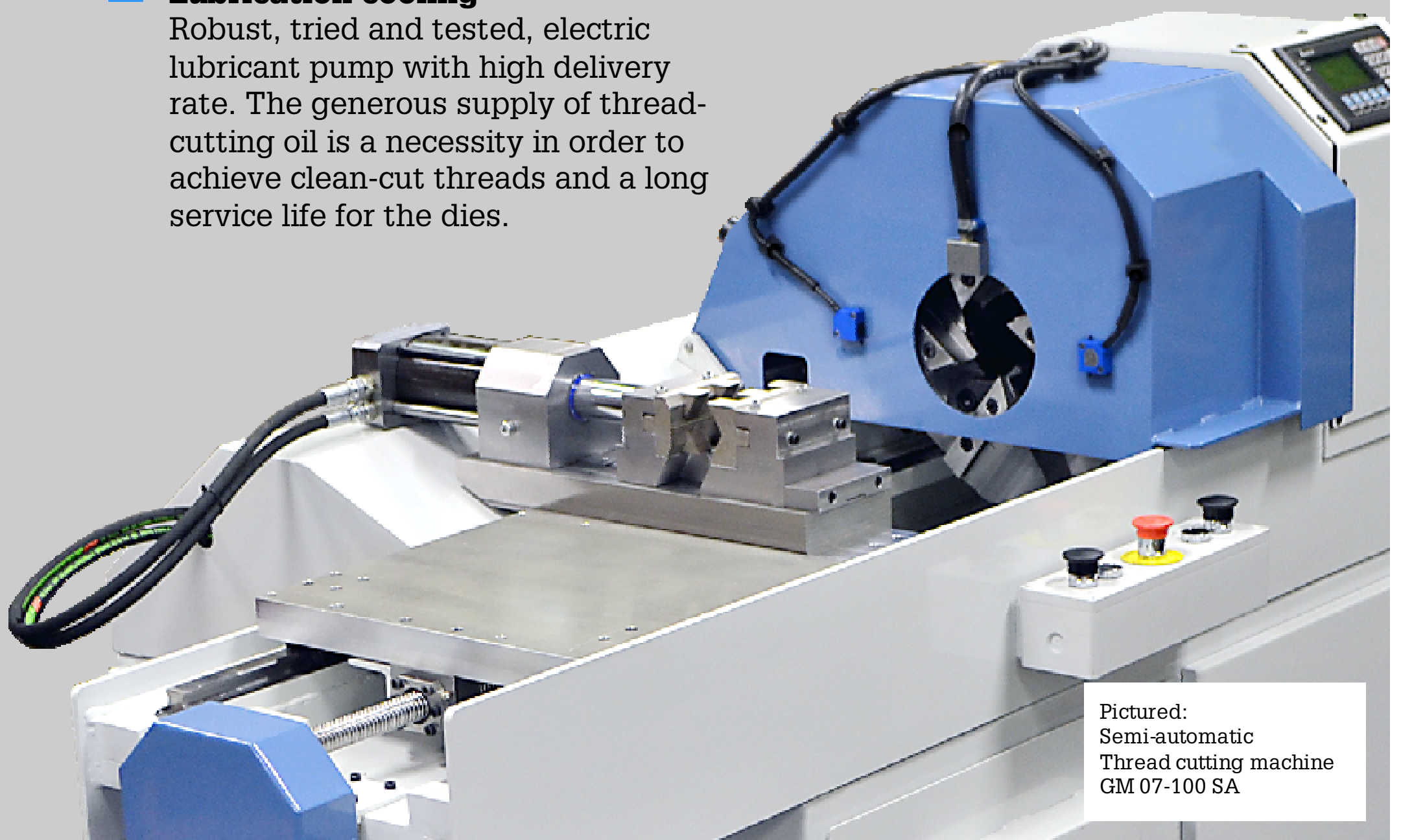


### **Clamping fixture**

Strong, distortion-resistant vice with specially hardened jaws that are easily replaced. The jaw vice is symmetrical meaning the work piece self centers when clamping to ensure a correct grip.

### **Lubrication cooling**

Robust, tried and tested, electric lubricant pump with high delivery rate. The generous supply of thread-cutting oil is a necessity in order to achieve clean-cut threads and a long service life for the dies.

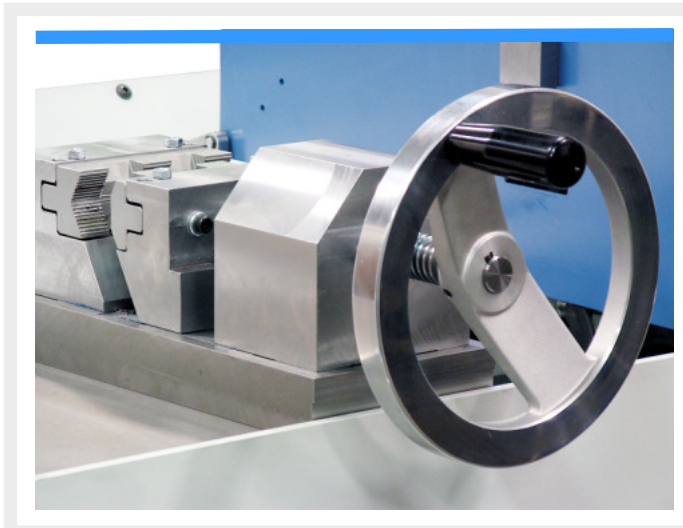
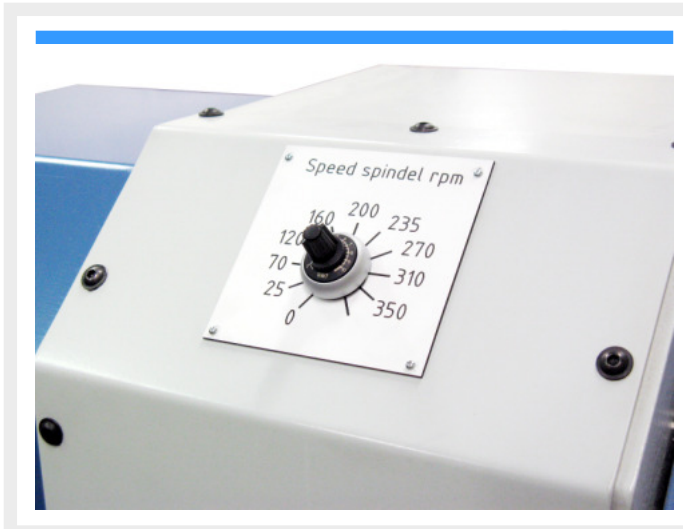


Pictured:  
Semi-automatic  
Thread cutting machine  
GM 07-100 SA



# HMV GM 07-50 M

## Manual medium duty Thread cutting machine



Motor output 5,5 Kw.  
 Max torque 500 Nm.  
 Max. thread length 475 mm.  
 Clamping grip range 8-50 mm.  
 Thread diameter range 10– 50 mm.

### Operation

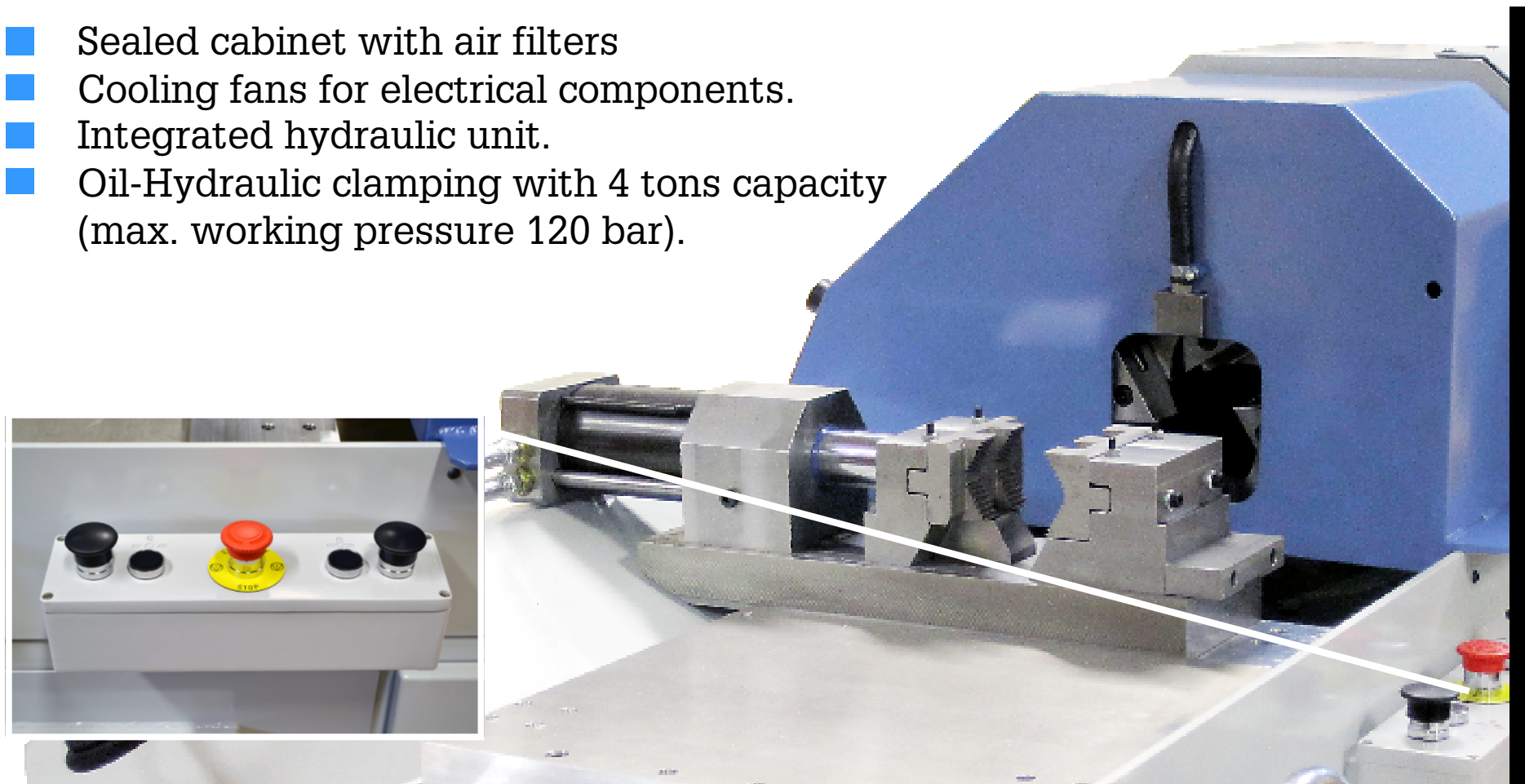
Lever opens/closes die head. Start/stop and emergency stop buttons are located on the front side of the machine. Lockable main switch on right-hand short side of machine. Handwheel operated carriage and jaw vice. Thread length is set manually with a stop on a metric scale. Switches for spindle on/off and cooling on/off is located on the spindle cover. Seamless adjustment of cutting speed by the means of a knob on the spindle cover.

# HMV GM 07-50 H/100 H

## Manual hydraulic powered Medium to heavy duty Thread cutting machines

### Hydraulics save labour and enhance capacity

- Sealed cabinet with air filters
- Cooling fans for electrical components.
- Integrated hydraulic unit.
- Oil-Hydraulic clamping with 4 tons capacity (max. working pressure 120 bar).



Motor output 5,5 kW.

Max torque 500 Nm.

Max. thread length 475 mm.

Clamping grip range 8-50 mm

Thread diameter range 10– 50 mm

**50 H**

Motor output 11 kW.

Max torque 1000 Nm.

Max. thread length 425 mm.

Clamping grip range 16-95 mm

Thread diameter range 16—95 mm

**100 H**

The hydraulic equipment provides operators with a pair of strong extra hands for heavier operations. The equipment ensures higher production capacity and less muscular effort, while also allowing one operator to mind two machines at the same time, thereby enhancing earnings capacity. The jaw vice is operated by a hydraulic piston that effectively holds the work piece in place during thread cutting.

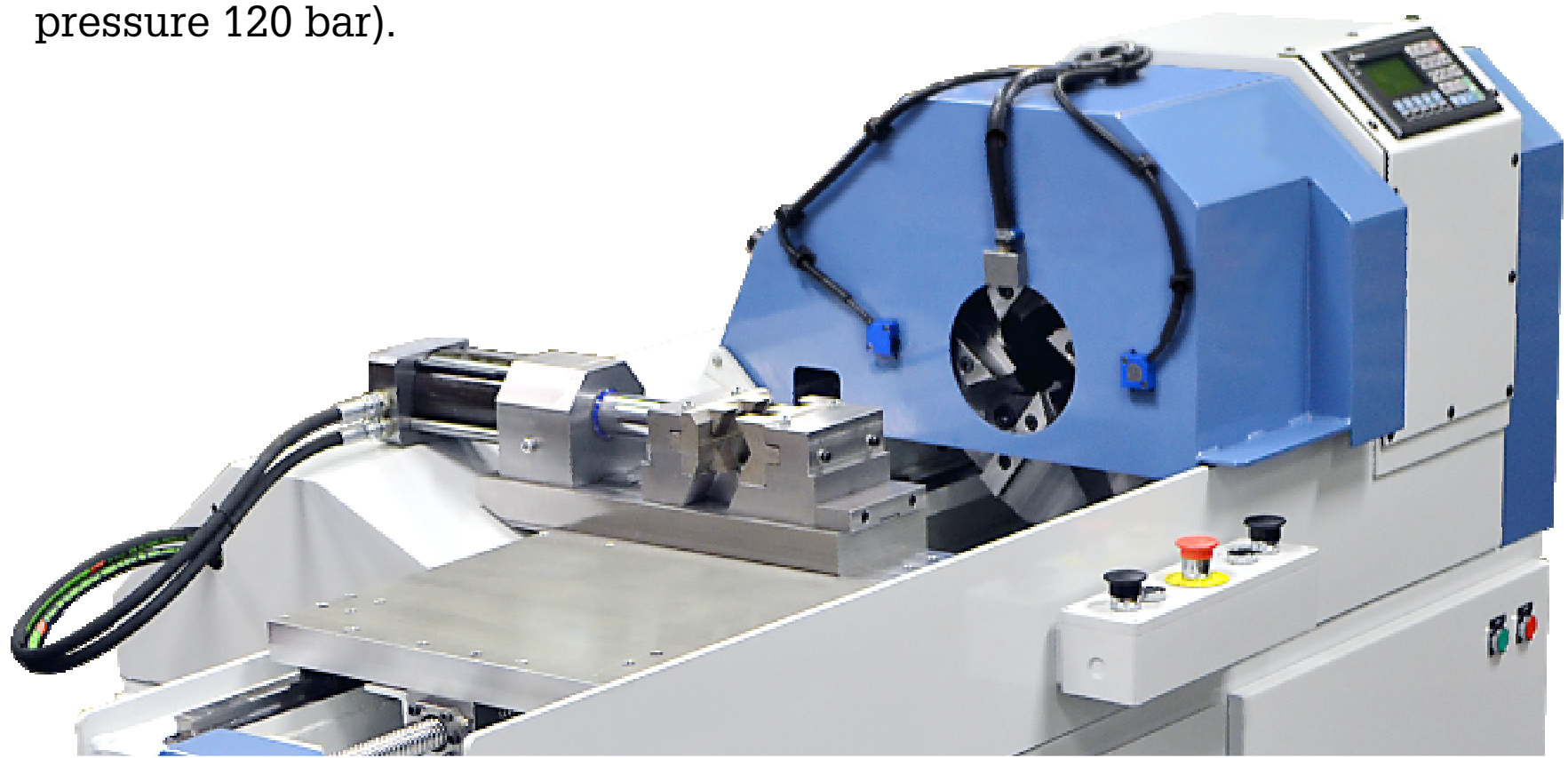
### Operation

Push-button control box opens/closes vice and die head. Emergency stop is also located on the control box. Start/stop buttons on front side of machine. Lockable main switch on right-hand short side of machine. Handwheel operated carriage. Thread length is set manually with a stop on a metric scale. Switches for spindle on/off and cooling on/off is located on the spindle cover. Seamless adjustment of cutting speed by the means of a knob on the spindle cover.

# HMV GM 07-50 SA/100 SA

## Semi-automatic Medium to heavy duty Thread cutting machines

- Sealed cabinet with air filters
- Cooling fans for electrical components.
- Integrated hydraulic unit.
- Oil-Hydraulic clamping with 4 tons capacity (max. working pressure 120 bar).
- Frequency controlled motor
- PLC-controlled carriage feed synchronized to pitch and spindle speed.
- Manual loading – automatic thread sequence.
- Standard threads pre-programmed.



Motor output 5,5 kW.  
Max torque 500 Nm.  
Max. thread length 470 mm.  
Clamping grip range 8-50 mm  
Thread diameter range 10– 50 mm

**50 SA**

Motor output 11 kW.  
Max torque 1000 Nm.  
Max. thread length 420 mm.  
Clamping grip range 16-95 mm  
Thread diameter range 16—95 mm

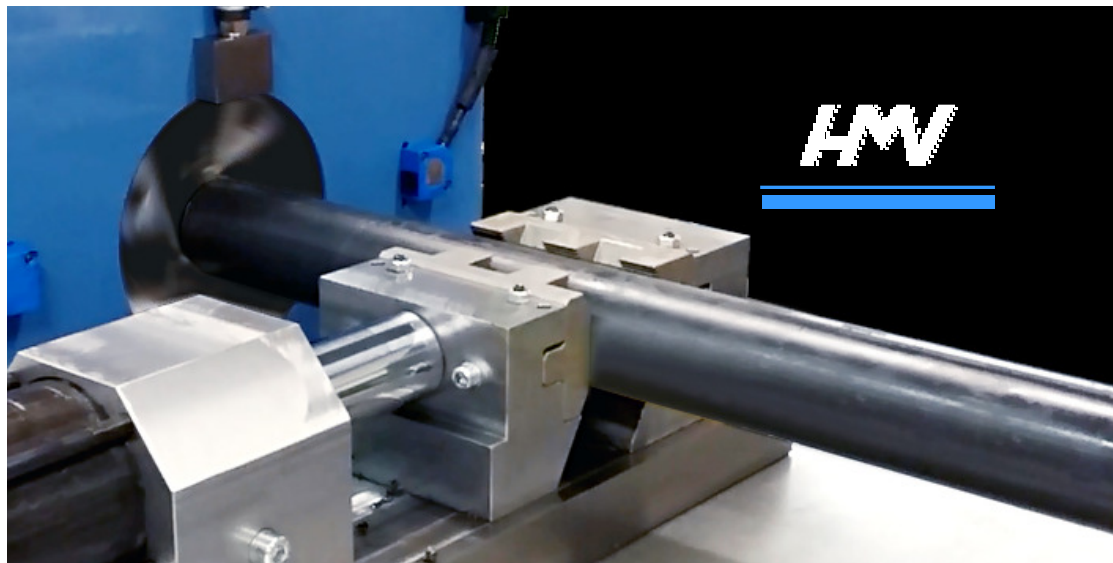
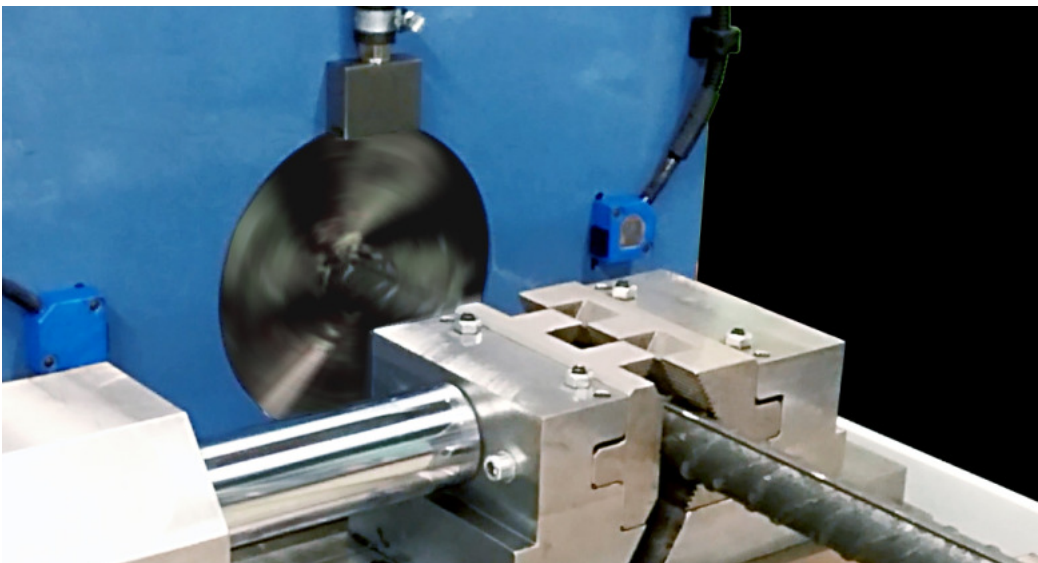
**100 SA**

### Operation

Push-button control box opens/closes vice and die head. Emergency stop is also located on the control panel. Start/stop buttons on front side of machine. Lockable main switch on right-hand short side of machine. The operator panel controls all other functions such as:

	■ Thread diameter	■ Thread pitch
	■ Thread length	■ Cutting speed
	■ Start position of carriage	■ Coolant on/off
Controlled from Jog menu. (Manual adjustment of dies)	■ Manually work the die head	■ Manually work the carriage
	■ Manually work the jaw vice	■ Length from optosensors to dies
	■ Switch to reverse direction of rotation for left-hand threads	





### **i** How it works

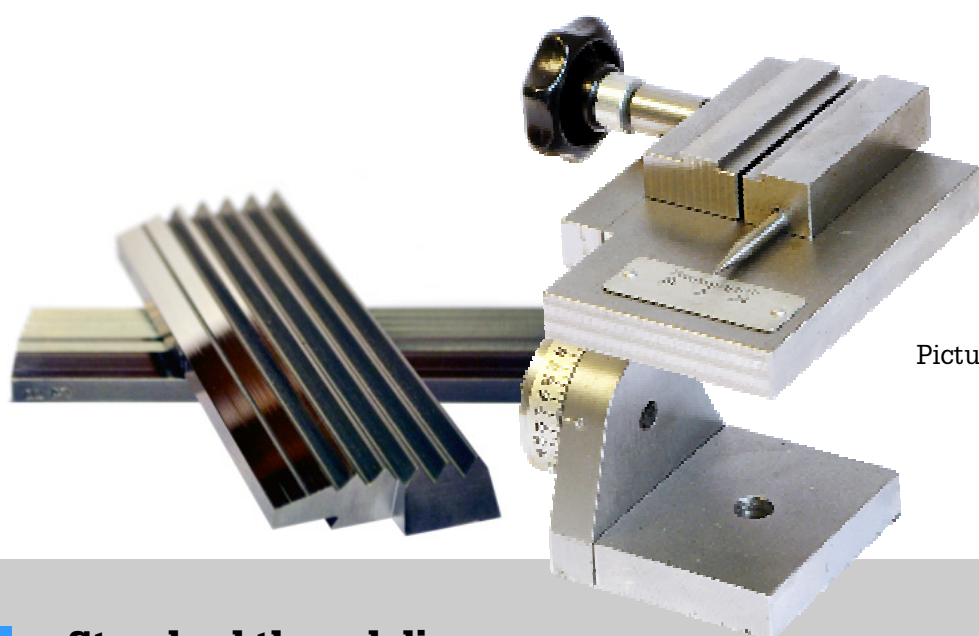
The driving motor of the die head sends RPM data to the PLC computer to calculate the correct RPM for the motor powering the ball screw for the selected thread pitch. The PLC computer monitors and corrects the RPM of the ball screw during operation if necessary. The material thereby exhibit significantly more accurate thread pitch than material that has been threaded in a manual machine or with a threading chaser. The optosensors on the die head protection cover signals when the material reaches the dies in order to achieve the exact thread length. Cooling fluid is sprayed on cutting surfaces during threading. When the thread length is reached, the cooling spray ceases, the die head opens and the carriage is fed back to the loading position. If the carriage unintentionally moves to close to the die head, the die head opens automatically.





# Accessories HMV GM 07

- **GM-MU Material dispenser**  
The material dispenser is mounted on the carriage of the thread cutting machine. The dispenser moves the threaded bar from the vice to a pallet or to a post machining process. The only manual labour required is to load the material and start the threading sequence.
- **FE-07 Chamfering unit**  
The chamfering unit chamfers the bar before thread cutting in order to obtain the correct thread entrance. The unit can also be used to sharpen bars with a diameter of up to 20 mm (e.g. wooden screw). It has a separate coolant tank, pump and chip container.
- **SL-07 Extra removable chip drawer**  
To minimize stoppage while emptying chips.
- **SV-07 Trolley for chip drawer**  
For transporting chip drawer to other location.
- **Relocation of jaw vice for threading of long bars (Semi-auto only)**  
With detachable pneumatic rod support on the carriage. Number of relocations and length is programmed in the PLC. Rod support before and after machine not included.
- **Laser guide**  
Helps the operator to place the material in the right position to achieve correct thread length. To be installed onto the die head protection cover.
- **Die head with extended diameter**  
equipped with specially fitted die holders for pitch diameter 100 – 115 mm (GM 07-100 SA).
- **Die holders for extreme pitch angles**
- **Die holders for left-hand threads**
- **Thread cutting oil**



Pictured: Grinding fixture for dies,  
Standard thread dies

- **Standard thread dies**  
The tried and tested re-grindable HMV tangential thread-cutting dies are optimized for extremely easy starting action, easy thread cutting and clean-cut threads. The dies are made of high-speed steel, permitting high cutting speeds, high quality threads and long tool life. The dies can be used for thread-cutting at cutting speeds of up to 12m/min (appropriate coolant must be used).
- **Special thread dies**  
We will upon request manufacture dies for any threads, standard or per your specification, for diameter 16 - 100mm, 1/4" - 2".
- **Dies with two-step chamfering**  
Optimized for threading reinforcement bars.
- **Special anti-stick coating**  
Optional for all dies. Prolongs the life span and better performance. With the coating, the dies can be used for thread-cutting at cutting speeds of up to 20m/min (appropriate coolant must be used). Some materials have a tendency to stick to the cutting teeth. The coating minimizes this problem.
- **Grinding fixture for dies**  
For standard tool- and surface grinders but can also be applied on ordinary grinding machines. It is essential to use the grinding fixture in order to achieve a precise sharpening.



Sale through specialist dealers



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