



Tool Post & Tool Holders

& High Performance Carbide Boring Bars



Tool Post and Toolholders For CNC and Manual Lathes

Technical Support

| | |
|--|-----------|
| Manual Lathe Terminology | Page B-4 |
| CNC Toolroom Lathe Terminology | Page B-5 |
| Turning and Boring Applications | Page B-6 |
| Tool Post Tolerance and Crossover | Page B-7 |
| Tool Post Mounting Data Form | Page B-8 |
| Quadra® Indexing Quick Change Tool Post Locking and Indexing System | Page B-9 |
| Quadra® Indexing Quick Change Tool Post Mounting, Set-Up and Function Data | Page B-13 |
| Quadra® Indexing Quick Change Tool Post Applications | Page B-14 |
| Triple Action Wedge Style Locking System | Page B-25 |
| SUPER Quick Change Tool Post Mounting, Set-Up and Function Data | Page B-29 |
| SUPER Quick Change Tool Post System | Page B-30 |
| Victory™ Automatic Thru-Coolant Quick Change Tool Post Mounting | Page B-41 |
| Victory™ Automatic Thru-Coolant Quick Change Tool Post System | Page B-49 |
| Victory™ CNC Quick Change Gang Tool Installation and Set up | Page B-51 |

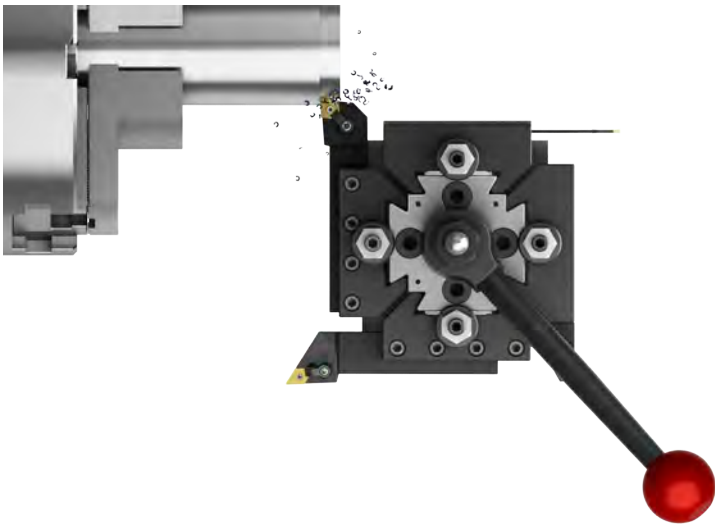
Quadra® Indexing Quick Change Tool Post & Toolholders

| | |
|--|----------------|
| Graphic Index | Page B-10, 11 |
| Quadra® Indexing Quick Change Tool Post Specifications | Page B-15 |
| Quadra® Indexing Quick Change Toolholders Specifications | Page B-16 - 19 |
| Quadra® Indexing Quick Change Tool Post & Toolholders SETS | Page B-23, 24 |

SUPER Quick Change Tool Post & Toolholders

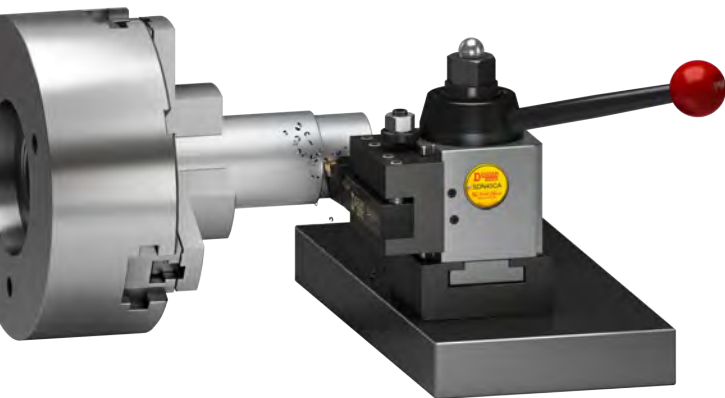
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|---|----------------|
| Graphic Index | Page B-26, 27 |
| SUPER Quick Change Tool Post Specifications | Page B-30 |
| SUPER Quick Change Toolholders Specifications | Page B-31 - 34 |
| SUPER Quick Change Tool Post & Toolholders SETS | Page B-39, 40 |

Quadra® Indexing Quick Change Tool Post with Advanced Indexing and Locking Technology

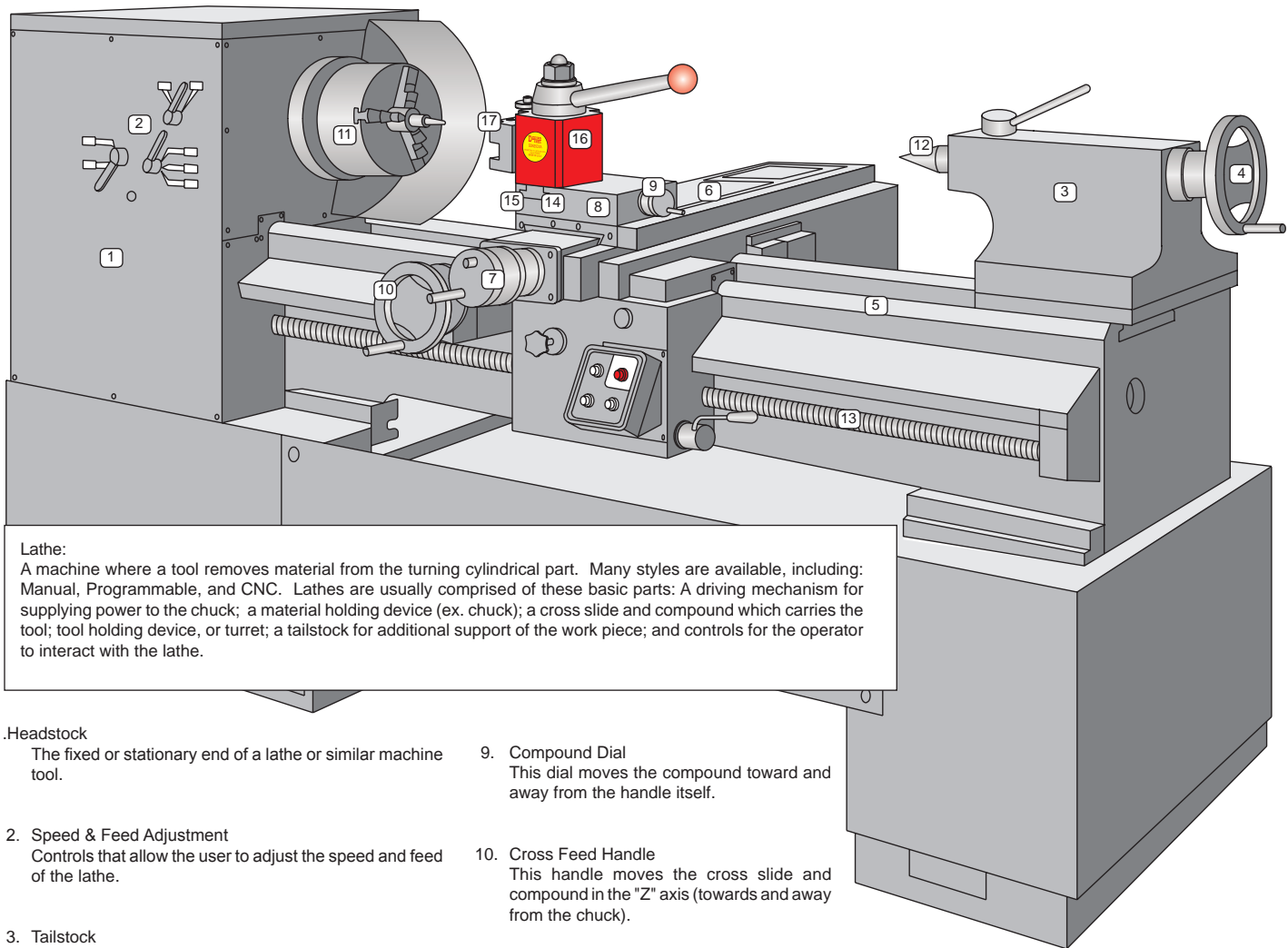


- Heavy duty construction
- Heat-treated alloy steel body
- Precision ground
- Four quick change tool holders locked independently
- Industry Standard holders
- Positive lock with absolute zero backlash
- One to four tools ready to be used
- Precise tool repeatability of .00005" / ,00127 mm
- Cam-Lock toolholder locking system for maximum rigidity
- Instant tool positioning
- Highest locking rigidity in the industry
- Indexing flexibility every 15°
- 24 positive positions
- Wide range of holders
- Maintenance-free
- "T"-nut for easy mounting
- Ready to install

Super Quick Change Tool Post with Triple Action Wedge-Locking System



- Triple Action Locking System
- Zero Backlash
- Precise Repeatability within .0001"
- 15° Locking Handle Position Adjustment
- Super Heavy Duty Locking Gear and Wedge Style Sliding Gibs
- Industry Standard Interchangeable Toolholders
- High Tensile Strength Chromium-Molybdenum Alloy Steel Body, Locking Gear, Sliding Gibs, Locking Gear Head, and Locking Handle
- Through-Hardened, Ion Nitrided, and Nickel-plated Body
- Through-Hardened, and Ion Nitrided and Precision Ground Locking Gear and Sliding Gibs for Wear Resistance and Repeatability
- CNC Precision Ground and Qualified for accuracy and super precise repeatability



Lathe:
A machine where a tool removes material from the turning cylindrical part. Many styles are available, including: Manual, Programmable, and CNC. Lathes are usually comprised of these basic parts: A driving mechanism for supplying power to the chuck; a material holding device (ex. chuck); a cross slide and compound which carries the tool; tool holding device, or turret; a tailstock for additional support of the work piece; and controls for the operator to interact with the lathe.

1. Headstock

The fixed or stationary end of a lathe or similar machine tool.

2. Speed & Feed Adjustment

Controls that allow the user to adjust the speed and feed of the lathe.

3. Tailstock

The part of a lathe that supports the end of a workpiece with a center. It may be positioned at any point along the way of the bed, and may be offset from center to machine tapers.

4. Tailstock Spindle Movement Handle

This handle moves the tail stock in the "Z" axis (towards and away from the chuck).

5. Bed

One of the principal parts of a machine tool with accurately machined ways or bearing surfaces to support and align other parts of the machine.

6. Cross-Slide

The part of the lathe that moves across the bed. It also holds the compound where the tool holding device is mounted.

7. Cross-Slide Dial

This dial moves the cross slide in the "X" axis (toward and away from the operator).

8. Compound

The part of a lathe set on the carriage that carries the tool post and holder. It is designed to swing in any direction and to provide feed for turning short angles or tapers.

9. Compound Dial

This dial moves the compound toward and away from the handle itself.

10. Cross Feed Handle

This handle moves the cross slide and compound in the "Z" axis (towards and away from the chuck).

11. Chuck

A device on a lathe to hold the workpiece.

12. Live Center

A tool that is inserted into the tailstock to support long workpieces where the cutting force would deflect the part excessively.

13. Lead Screw

The long, precision screw located in front of the lathe bed, geared to the spindle and used for cutting threads.

14. T-Slot

Inverted T-shaped slot on the compound of a lathe. Used for securing a toolpost onto the compound.

15. T-Nut

A T-shaped nut that is slid into the T-Slot of the compound. It is used to secure a tool holding device to the compound.

16. Quick Change Tool Post

A device for holding tooling on the compound of a lathe. It can be as simple as a fixed system for holding one tool or as complex as an indexing quick change system.

17. Quick Change Holder

A device to hold a cutting tool on a lathe that uses a system to allow for quick changing of tooling from one operation to the next. It is generally applied by using a dovetail slot that is slid over a male dovetail on a toolpost.

18. Center Height

The distance from the centerline of the chuck to the top of the compound.

19. Lathe Swing

The dimension of a lathe determined by the maximum diameter of the workpiece that can be rotated over the ways of the bed.

20. Shank System

The diameter of a round cutting tool or the height of a square shank cutting tool.

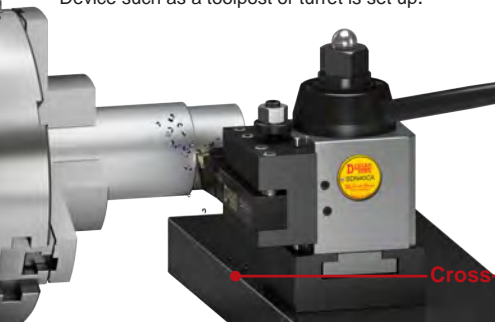
Lathe: A machine where a tool removes material from the turning cylindrical part. Many styles are available, such as: **Manual**, **Combination** and **CNC**. Lathes are usually comprised of these basic parts: A **Spindle** which is a driving mechanism for supplying power to the chuck (a material holding device) ; a **cross-slide** compound which carries the tool; tool holding device, or turret; a **tailstock** for additional support of the work piece; and **controls** for the operator to interact with the lathe.

Spindle: Driving mechanism that supplies power to the chuck. The chuck is the device that holds the workpiece.



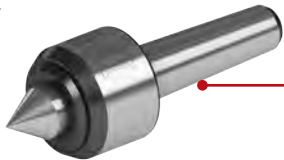
Chuck

Cross-Slide: Where the tooling Device such as a toolpost or turret is set up.



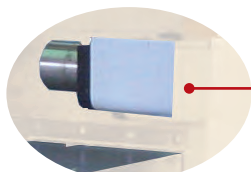
Cross-Slide

Live Center: A tool that is inserted into the tail-stock of the lathe to support longer workpieces where the cutting force would deflect the part excessively.



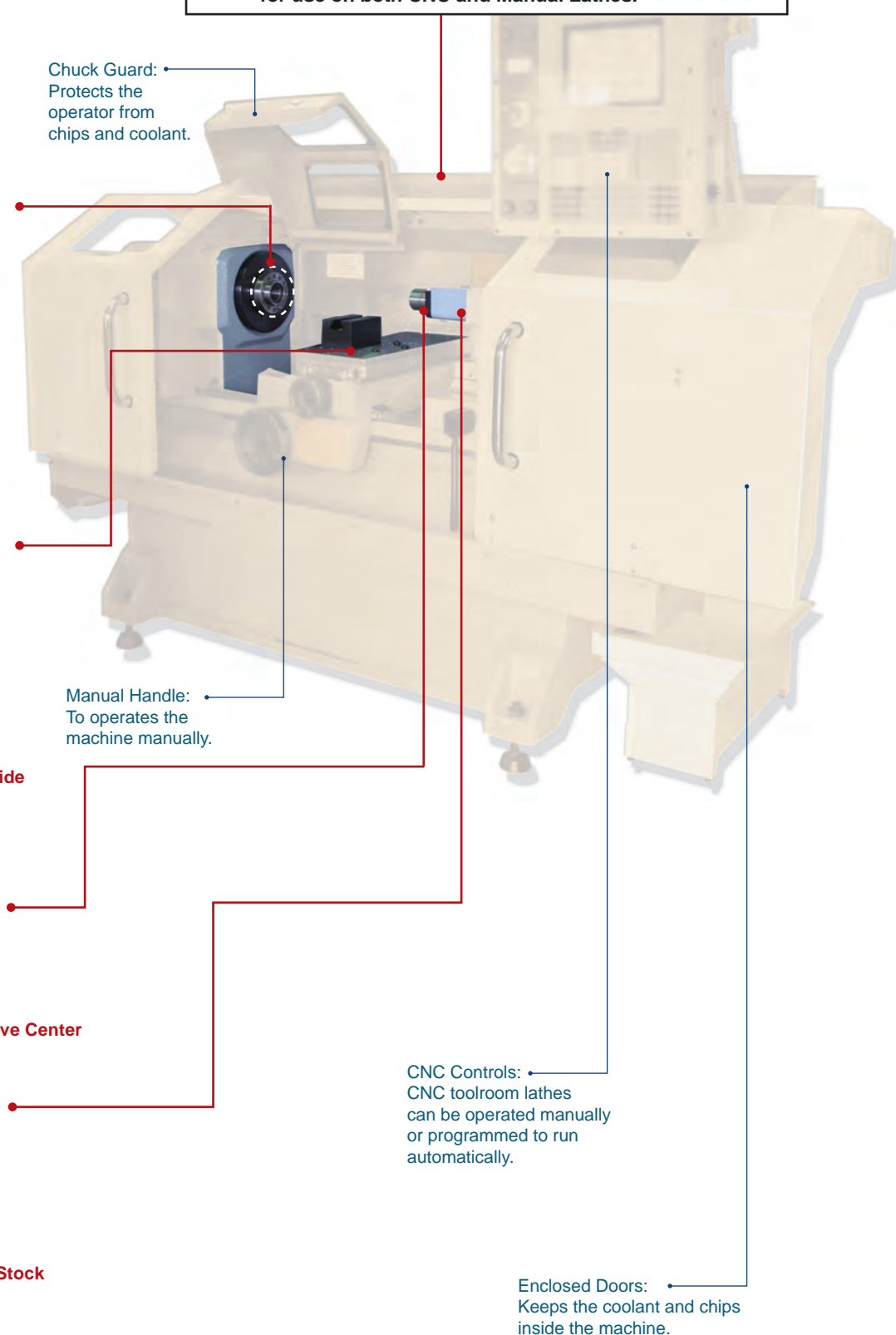
Live Center

Tail Stock: The part of a lathe that supports the end of a workpiece with a center. It may be positioned at any point along the way of the bed and may be offset from center to machine tapers.



Tail Stock

All Dorian Turning Toolholders, Boring Bars and Inserts offered in this catalog are engineered for use on both CNC and Manual Lathes.



Chuck Guard: Protects the operator from chips and coolant.

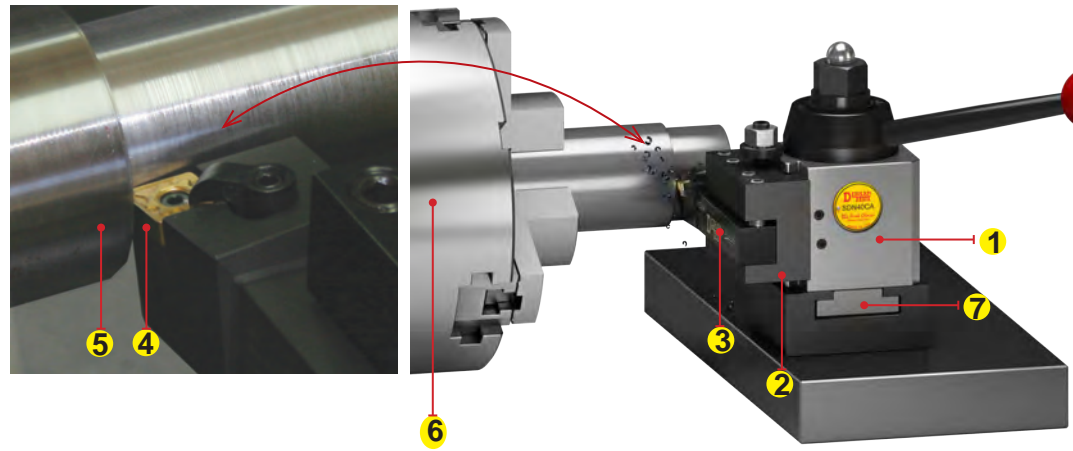
Manual Handle: To operates the machine manually.

CNC Controls: CNC toolroom lathes can be operated manually or programmed to run automatically.

Enclosed Doors: Keeps the coolant and chips inside the machine.

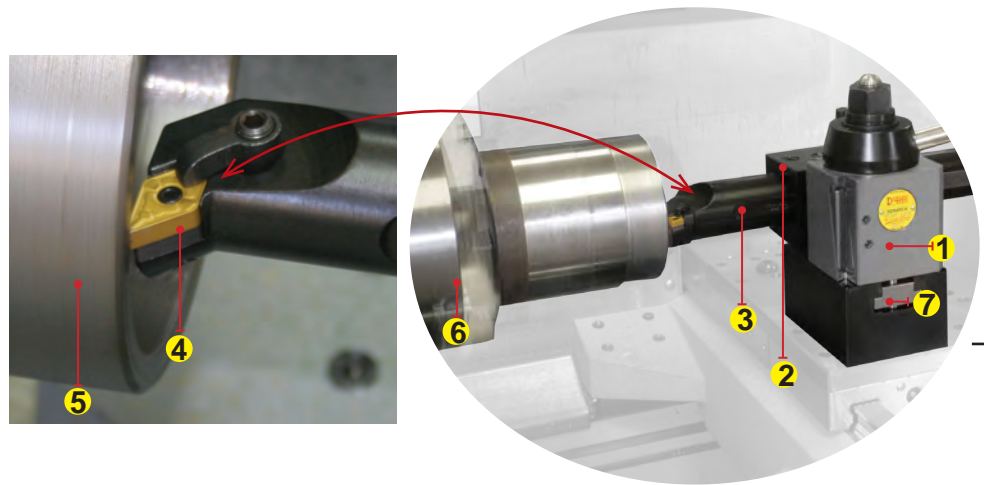
Turning Application with a Manual or CNC Toolroom Lathe

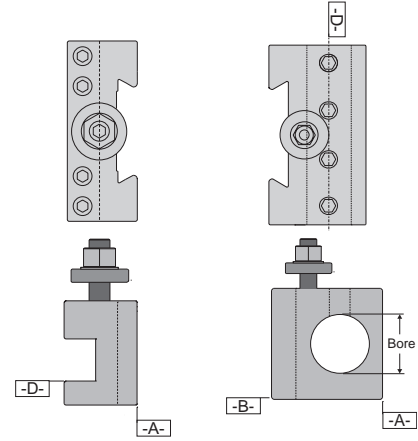
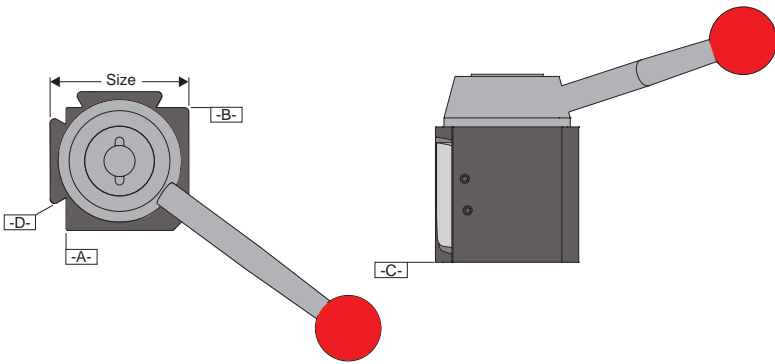
1. Quick Change Tool Post
2. Quick Change Turning and Facing Toolholder
3. Square Shank Toolholder
4. Insert
5. Workpiece
6. Chuck
7. Custom T-Nut



Boring Application with a Manual or CNC Toolroom Lathe

1. Quick Change Tool Post
2. Quick Change Boring Bar Holder
3. Boring Bar
4. Insert
5. Workpiece
6. Chuck
7. Custom T-Nut

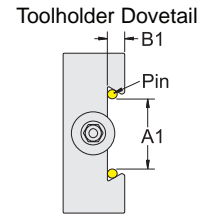
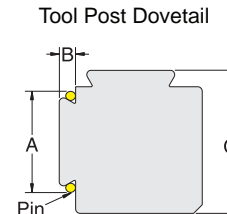




| Tool Post Series | System (Square) | |
|------------------------------------|-----------------|-----------|
| | in. | mm |
| 25 | 2.5 | 66 |
| 30 | 3.0 | 76 |
| 35 | 3.5 | 89 |
| 40 | 4.0 | 102 |
| 50 | 5.0 | 127 |
| 60 | 6.0 | 152 |
| Tolerance (* Per Inches) | | |
| Quick Change Repeatability | ± .0001 | ± 0,00254 |
| Face to Face Squareness A-B* | ± .0001 | ± 0,00254 |
| Bottom to Face Squareness A-C* | ± .0001 | ± 0,00254 |
| Bottom to Dovetail Squareness C-D* | ± .0001 | ± 0,00254 |

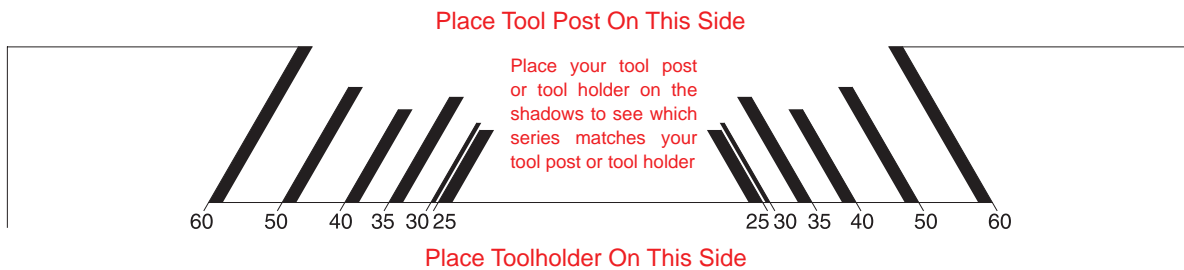
| Holder Tolerance (* Per Inches) | | in. | mm |
|--|------|---------|-----------|
| Quick Change Repeatability | | ± .0001 | ± 0,00254 |
| Face to Face Squareness | | ± .0005 | ± 0,0127 |
| Bottom to Face Squareness | | ± .0005 | ± 0,0127 |
| Bottom to Dovetail Squareness | | ± .0005 | ± 0,0127 |
| Square Shank Holder Tolerance (* Per Inches) | | | |
| Tool Slot Taper | D | ± .0001 | ± 0,00254 |
| Tool Slot Squareness | D-A | ± .0005 | ± 0,0127 |
| Boring Bar Holder Tolerance (* Per Inches) | | | |
| Bore Circularity | Bore | ± .0001 | ± 0,00254 |
| Bore Cylindricity | Bore | ± .0001 | ± 0,00254 |
| Boring Parallelism | D-A | ± .0002 | ± .00508 |
| | D-B | | |

| Tool Post Data for Measuring the Dovetail | | | | Tool Post Dovetail | | | Toolholder Dovetail | | | |
|---|-------------|-----|----------|--------------------|---|---|---------------------|----|----|----------|
| Tool Post Series | C (nominal) | | Pin Dia. | | A | B | Pin Dia. | A1 | B1 | Pin Dia. |
| | in. | mm | in. | mm | | | | | | |
| 25 | 2.5 | 66 | .1875 | 5 | | | | | | |
| 30 | 3.0 | 76 | .1875 | 5 | | | | | | |
| 35 | 3.5 | 89 | .2500 | 6 | | | | | | |
| 40 | 4.0 | 102 | .2500 | 6 | | | | | | |
| 50 | 5.0 | 127 | .3750 | 10 | | | | | | |
| 60 | 6.0 | 152 | .5000 | 12 | | | | | | |



1. Measure the nominal dimension "C" across the flats of the toolpost, as shown above.
2. Cross reference the measurement in the table above to find which pin diameter to use.
3. Place the two (2) dowel pins in the dovetail.
4. To ensure accuracy, write down the pin System in the table provided.

5. Measure the distance across the pins, denoted as "A" and "A1".
6. Record your measurement in the table provided.
7. Measure the dovetail depth, denoted as "B" and "B1".
8. Record your measurement in the table provided.



| Super Quick Change Tool Post Crossover Chart | | | | | | Quadra Index Tool Post Crossover | |
|--|---------------------|-----------------------|--------------|--------------|--------------|----------------------------------|----------|
| Manufacturer | Dorian Tool | | Aloris | DTM | Phasell | Dorian Tool | Aloris |
| Tool Post Type | Super Quick Change™ | Victory™ Thru-Coolant | Quick Change | Quick Change | Quick Change | Quadra Indexing | Indexing |
| Tool Post Size | SDN25AXA | - | AXA | TP65A | 250-100 | QITP25N | - |
| | SDN30BXA | - | BXA | TP75A | 250-200 | QITP30N | BXA-I |
| | SDN35CXA | V35tc | CXA | TP90A | 250-300 | QITP35N | - |
| | SDN40CA | V40tc | CA | TP100A | 250-400 | QITP40N | CA-I |
| | SDN50DA | - | DA | TP125A | - | QITP50N | DA-I |
| | SDN60EA | V60tc | EA | TP150A | - | QITP60N | - |

Tool Post Mounting Data Form

For help fill in the information shown below and fax to: (979) 282-2951

QUOTE # _____
PART # _____

Company _____

Phone () _____

Customer Name _____

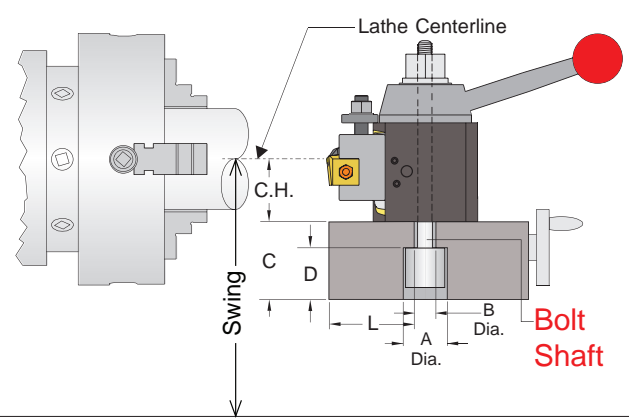
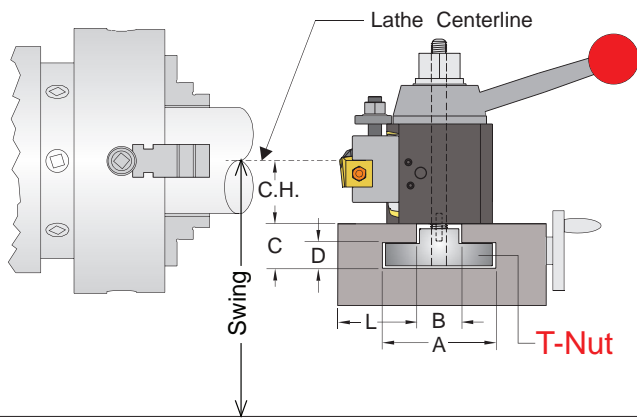
Email _____

Type of Machine _____

Please place an **X** for American or European mounting Style in the box below

American Style Mounting ("T-Nut")

European Style Mounting (Bolt Shaft)



Lathe Bed

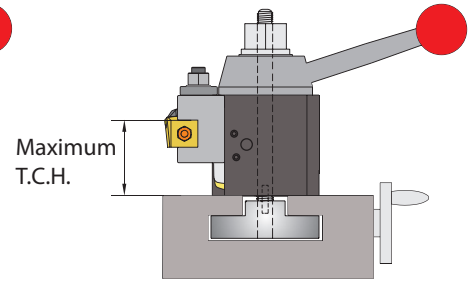
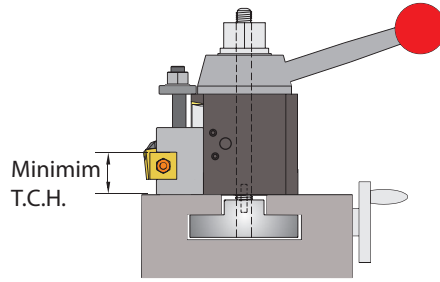
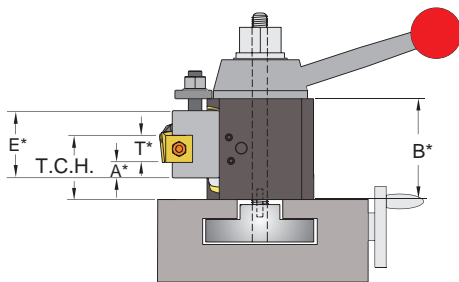
| Make & Model of Lathe | Lathe Swing Over Bed | | CH | | Tool Size | | A | | B | | C | | D | | L | | |
|-----------------------|----------------------|----|----|----|-----------|----|----|----|----|----|----|----|----|----|----|----|--|
| | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm | |
| System | | | | | | | | | | | | | | | | | |

Tool Post recommendation will be based on the accuracy of the information provided by the customer. Each Tool Post is supplied with a Blank T-Nut or Bolt Shaft that the customer machines to their required dimensions. For custom machined T-Nut or Bolt Shaft, please specify the dimensions A, B, C, and D precise within +/- .003in.

How to measure Tool Center Height "T.C.H."

"CH" = Center Height is measured from top of compound to lathe center line
"A" = Toolholder bottom lip

"T" = Shank System
"T.C.H." = Tool Center Height



*For specifications see tool post and toolholder No1 sections of this catalog. Formula applies to all three tool post styles.

Factors that determine the proper System tool post for a particular lathe:

1. Lathe swing
2. Center height
3. Tool Size
4. Mounting type
5. Horse power of motor
6. RPM of chuck
7. Type of machine
8. Type of work
9. Prototype or production
10. Roughing or finishing

Customer to complete with choice of tool post & toolholders

| Item | Qty | First Choice Tool Post & Toolholders | |
|------------------|-----|--------------------------------------|-------------|
| | | Part Number | Description |
| Tool Post | | | |
| Tool Post Set | | | |
| Machined "T" nut | | | |
| Toolholder | | | |
| Toolholder | | | |
| Toolholder | | | |
| Toolholder | | | |
| Toolholder | | | |
| Toolholder | | | |

Quadra® Indexing Quick Change Tool Post & Toolholders



Quick and Versatile for Any Operation!

Locking and Indexing System with 24 Super Precise Positioning Ball Bearings & Pre-Loaded Indexing Pins

4 Toolholders Held Simultaneously!

Style

Features

Application

QITPN Quadra Indexing Quick Change Tool Post

Page B-15



- Heavy duty construction
- Heat-treated alloy steel body
- Precision ground
- Four quick change tool holders locked independently
- Industry Standard holders
- Positive lock with absolute zero backlash
- One to four tools ready to be used
- Precise tool repeatability of .00005" / .00127 mm
- Cam-Lock toolholder locking system for maximum rigidity

- Instant tool positioning
- Highest locking rigidity in the industry
- Indexing flexibility every 15°
- 24 positive positions
- Wide range of holders
- Maintenance-free
- "T"-nut for easy mounting
- Ready to install

- CNC Toolroom Lathes
- Manual Toolroom Lathes
- Engine Lathes
- Heavy Duty Oil-Country Lathes
- Super Precision High Speed Finish Requiring Applications
- Deep Drilling and Boring
- Heavy Material Removal
- Multi Turning, Drilling, Boring, Threading Applications

No. QITPN-1 Turning & Facing Holder

Page B-16



- Quick Change Mounting
- High Tensile Strength Chromium-Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Holds Square Shank Tools
- Turning and Facing
- Threading and Grooving
- Cut-Off Applications

No. QITPN-2 Turning, Facing & Boring Holder

Page B-16



- Boring Bar "V" Seat
- Quick Change Mounting
- High Tensile Strength Chromium-Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Holds Square Shank Tools
- Holds Boring Bars
- Turning and Facing
- Light to Medium Boring
- Threading and Grooving
- Cut-Off Applications

No. QITPN-4,41,41S CNC Extra Heavy Duty Boring Bar Holder

Page B-17 -B-18



- Precision Ground and Honed Bore
- Qualified Bore for Precise Tool Alignment and Squareness
- Quick-Lock System Aligns Boring Bar Centerheight and Rake Angle Automatically.
- Four Special Flat Machined Locking Screws for High Rigidity Extended Overhangs without Scarring the Boring Bar
- Systems Up to 3" Capacity
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Precision Boring Applications
- Heavy Duty Boring Applications
- Heavy Duty Drilling Applications
- Deep Boring, Drilling and Threading Applications

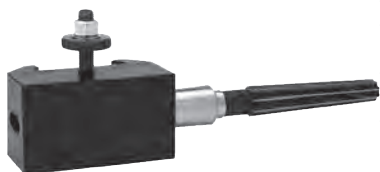
Style

Features

Application

No. QITPN-5 Morse Taper Holder

Page B-18



- Precision Ground Morse Taper
- Qualified for Precise Tool Alignment and Squareness
- Designed for Deep Drilling
- Heavy Duty Drilling
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Deep Drilling Applications
- Heavy Duty Drilling Applications
- Reaming and Tapping

No. QITPN-36 5C Collet Holder

Page B-19



- 5C Collet Holding System
- Supplied with Collet Closer
- Qualified for Precise Tool Alignment and Squareness
- Designed for Versatility
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Miniature to Medium System Tools
- For Special Tool System and Shapes
- Accepts Square, Round & Hex Collets
- Drilling Applications
- Boring Applications
- Reaming Applications
- Tapping
- From 1/16" to 1.0" Diameter Tools

No. QITPN-7-71C Reversible Cut-Off Blade Holder

Page B-19



- Qualified for Precise Tool Alignment and Squareness
- Quick Change Mounting
- High Tensile Strength Chromium-Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Cut-Off Applications
- Grooving Applications

No. QITPN-881 O.D. or I.D. Threading Holder

Page B-21



- On Edge and Laydown Threading Cartridge
- Quick Change Mounting
- High Tensile Strength Chromium-Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

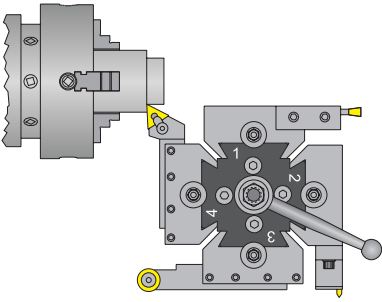
- O.D. and I.D. Threading

The Multi-Patented Tool Post with The Most Advanced Locking and Indexing and Locking Technology

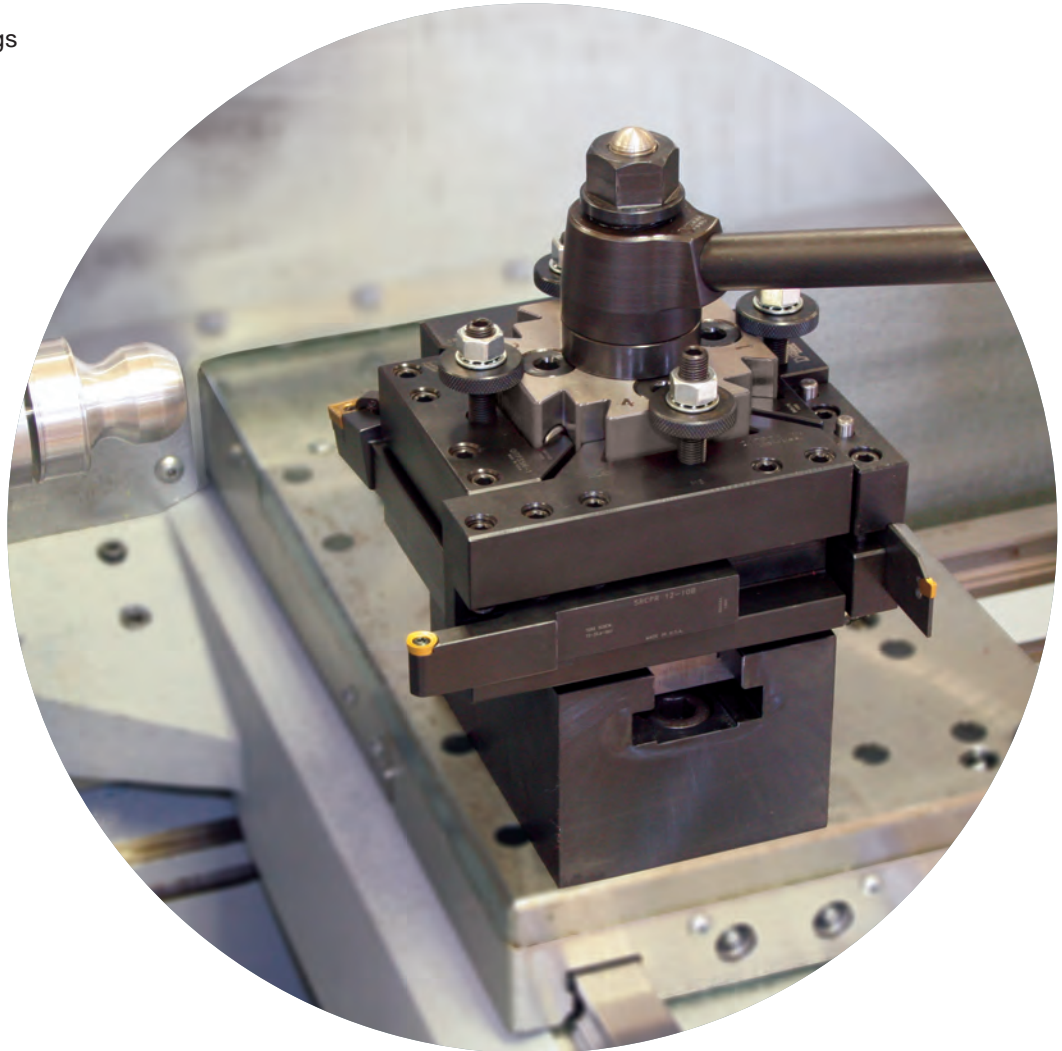
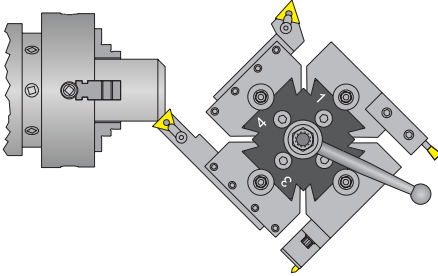
24 Super Precise Positioning Ball Bearings
& Pre-Loaded Indexing Pins

Strong - Rigid - Precise!

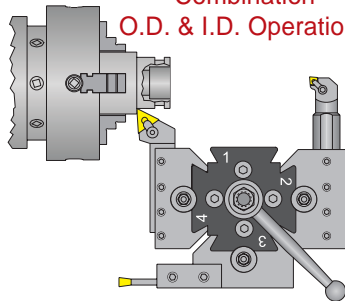
O.D. Turning Operations



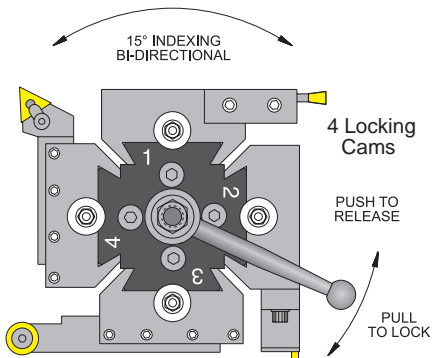
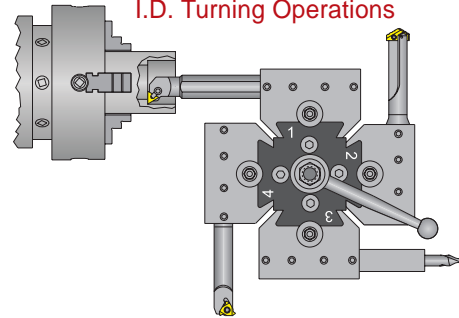
O.D. Chamfering Operations 15° Increments



Combination O.D. & I.D. Operations



I.D. Turning Operations

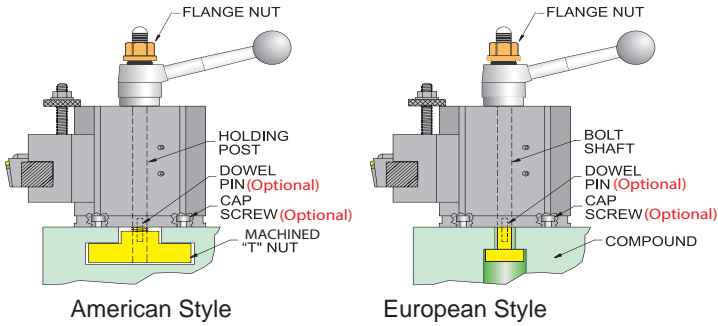


Easy To Operate: Push the handle away to release the indexing mechanism, rotate tool post to desired position and then pull the handle to lock the indexing mechanism.

Quick change toolholders are locked independently by individual locking cams. Locking wrench with handle is provided with the tool post.

Tool Post Mounting

Quick, Simple, & Rigid

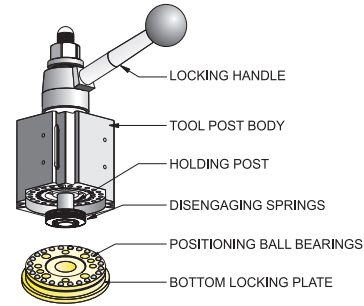


Tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flanged Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using the Bolt Shaft is the common mounting method on European lathes.

Optional cap screws and dowel pins may be used to secure the toolpost directly to the compound or the T-nut. This is advantageous if there is tool post shifting during heavy or interrupted cuts.

Indexing System

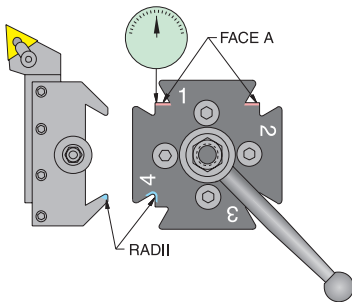
Repeatability within .00005"



With the locking handle in unlocked position, the disengaging spring set lifts the toolpost from the bottom locking plate. Two pre-loaded index pins allow the toolpost to be indexed to any of the preset positions in 15° increments. Pulling the locking handle to the locked position engages the locking mechanism of the tool post for superior rigidity and repeatability.

Indicating Position

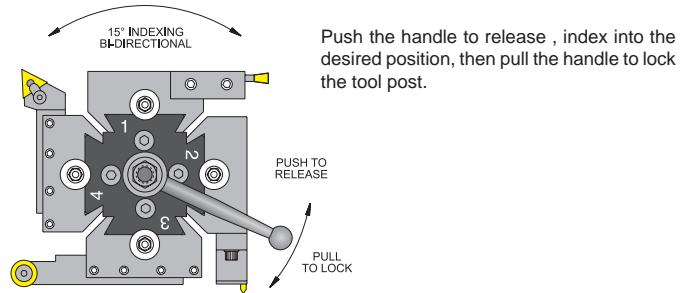
Squareness within .0005"



The four dovetails are machined at 90° square ($\pm .0005$ "). When mounting, it is necessary that the Face "A" be set parallel to the lathe axis with an indicator in order for drills to work properly. The dovetail surfaces must be kept clean and lubricated at all times to prevent misalignment of the tool holder when locked on the tool post.

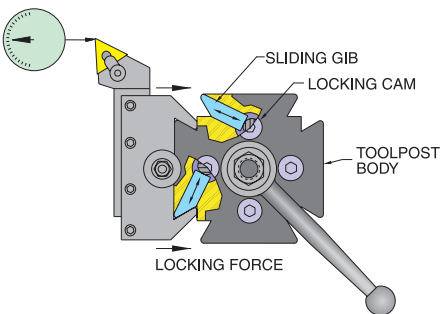
Operation

Index from Tool to Tool in Seconds



Holder Locking System

20,000 lbs Locking Force

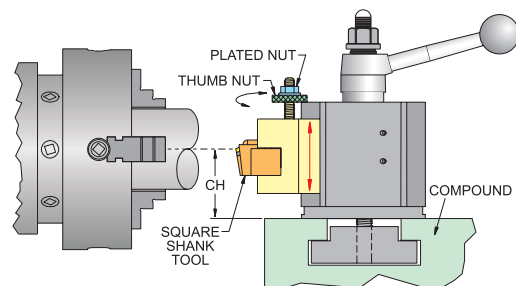


The holder locking system of the Quadra Indexing Tool Post is based on the four Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam style Locking Pin, locking it positively. The cam rotates from 0° (Release Position) to approximately 45° (Locking Position).

The repeatability of the tool holders is $\pm .0001$ " and can be checked with a dial indicator, fixed on the tool post body as shown above. Each tool is independently locked, giving it flexibility to use from one to four tools simultaneously.

Holder Center Height Adjustment

Positive Center Height Adjustment



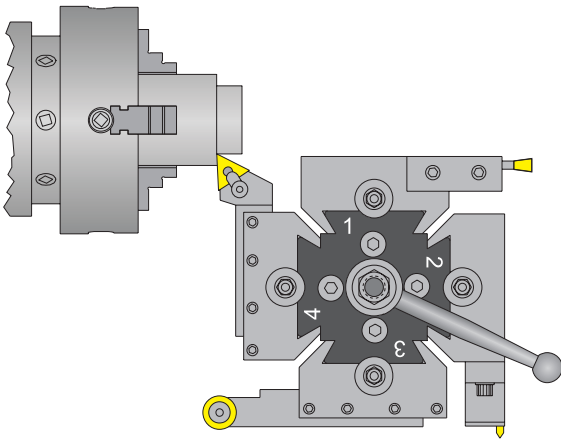
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool height, first, by screwing or unscrewing the Thumb Nut until the desired height is reached, and next, by locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool post. Minimum center height has been reached when the bottom of the holder comes in contact with the Bottom Locking Plate.

Features

- Heavy duty construction
- Heat-treated alloy steel body
- Precision ground
- Four quick change tool holders locked independently
- Industry Standard toolholders
- Positive lock with absolute zero backlash
- One to four tools ready to be used
- Precise tool repeatability of .00005" / .00127 mm
- Instant tool positioning
- Highest locking rigidity in the industry
- Indexing flexibility every 15°
- 24 positive positions
- Wide range of holders
- Maintenance-free
- "T"-nut for easy mounting
- Ready to install

O.D. Turning Operations

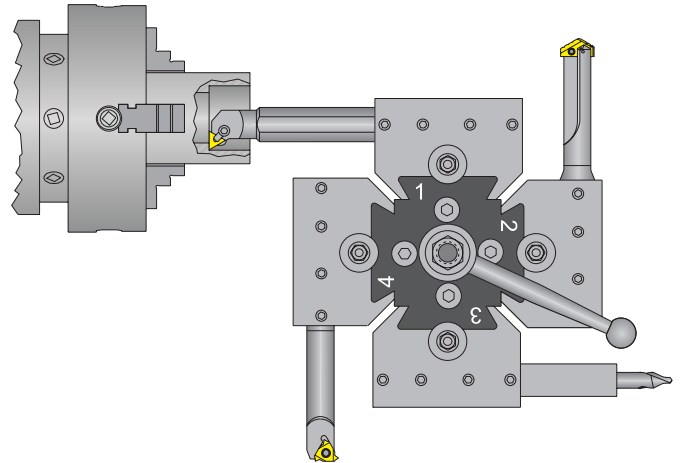
Finishing to Roughing or Threading



The tool position closest to the chuck (left dovetail as shown above) is used for turning outside diameters. It holds the tool at the best location for clearance and rigidity when turning, threading, cut-off, grooving, and chamfering.

I.D. Turning Operations

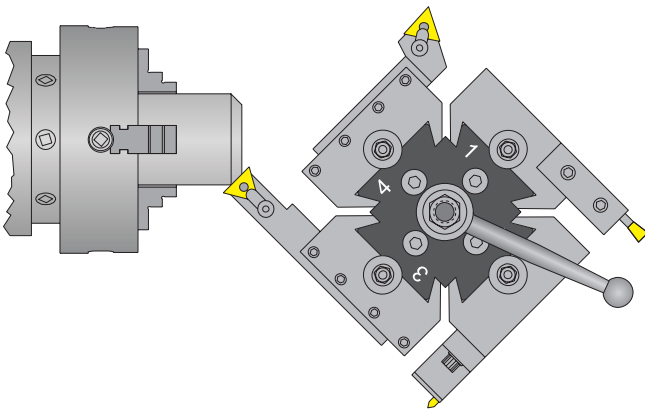
Finishing to Roughing or Threading



The tool position closest to the centerline of the chuck (top dovetail as shown above) is used for turning inside diameters. It holds the tool at the best location for clearance and rigidity when boring, threading, grooving, drilling, and center drilling.

O.D. Chamfering Operations

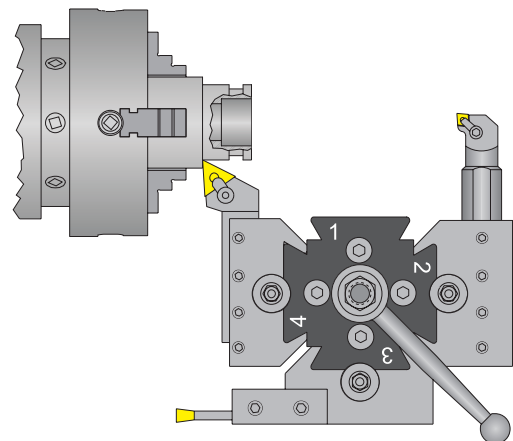
15° Increments



The tool post can be indexed every 15°. This will allow the user to rotate a tool into chamfering position. One tool could then be used for O.D. turning and chamfering, reducing the number of tools to complete a job.

Combination O.D. & I.D. Operations

Finishing to Roughing or Threading



Combinations of O.D. and I.D. tools can be used on the tool post at once. For simple parts where minimum tool changes are required, this method can increase productivity and precision. Tool clearance should be considered when placing the tools on the tool post.

Heavy Duty Construction
Hardened and Precision Ground Alloy Steel

Tool Holder Station:
• 4 super precision dovetail holding stations
• 1 to 4 tool holders locked independently

The toolpost is equipped with six O-Ring seals to prevent any coolant, chips, and contaminants from getting inside the toolpost.

Bottom locking plate holds the Tool Post in fixed position. Provides a mounting surface. Determines the rigidity, stability and the precise repeatability of the Tool Post.

Pre-loaded index pins locate the preset tool post positions.

Tool Post is provided with a T-nut for American mounting style or with a bolt shaft for European mounting style.

Holding post and flange nut
Secures the Tool Post on the lathe

Locking Handle engages and disengages the Locking Mechanism of the Tool Post.

The eccentric tool holder locking pin (cam) exercises over 20,000 lbs of positive locking force on the sliding gib with absolute zero backlash.

Patented quick change holder Locking System: The quick change tool holder locking system has a sliding gib which travels inside the fixed dovetail of the tool post. When pushed out by the locking pin, it pulls and locks the tool holder against the precision ground dovetail of the tool post within .0001" of repeatability.

Patented Indexing System:
24 indexing positions
15° increments
Repeatability within .00005"

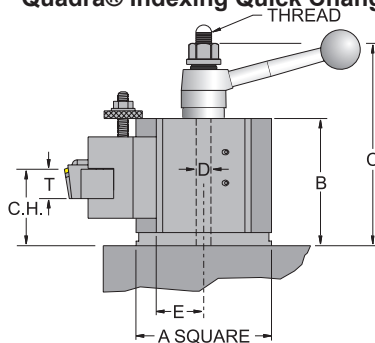
Indexing system performance: The accuracy and repeatability of this system will not be deteriorated by wear; however, will only get better with usage.

Disengaging springs: Lifts and disengages the Tool Post from the bottom locking plate in order to index to the desired position.

24 super precision and hardened tool steel ball bearings assure accuracy and precise repeatability when the tool post is locked.

Larger Surface Plate: A larger surface area provides more mounting rigidity.

Quadra® Indexing Quick Change Tool Post Specifications



- 4 Tool Holders Held Simultaneously
- Indexing Repeatability within .00005"
- Tool Holder Repeatability within .0001"
- From Prototype to High Production
- Quick and Versatile for Any Operation

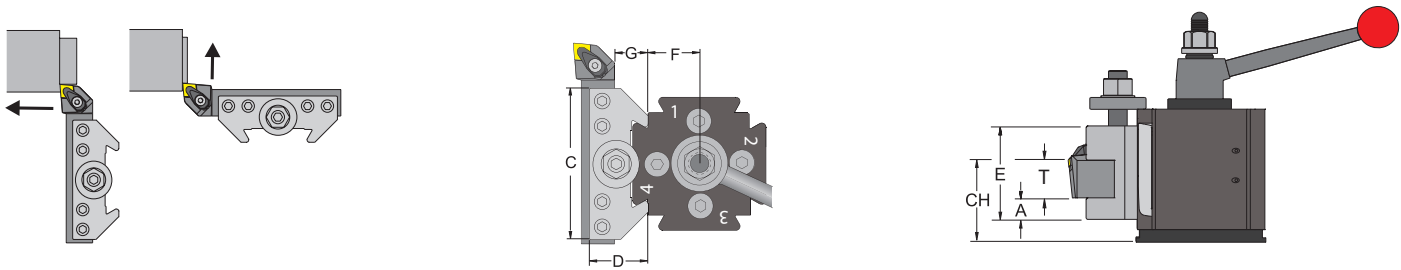
- 24 Locking Positions, every 15°
- Ideal for Manual & CNC Lathes
- Super Precise for Tight Tolerance Machining
- Heavy Duty For Oil Field Applications

| Description | QITP25N 00000 | | QITP30N 00002 | | QITP35N 00004 | | QITP40N 00006 | | QITP50N 00008 | | QITP60N 00010 | |
|----------------------|------------------|----------|------------------|----------|------------------|---------|------------------|---------|------------------|---------|------------------|---------|
| System | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm |
| Lathe Swing Over Bed | ≤12" | ≤300,0 | 13-15" | 320,0 | 14-17" | 400,0 | 16-20" | 450,0 | 17-32" | 500,0 | ≥25-XHD | XHD |
| A | 2.500 | 63.5 | 3.000 | 76.2 | 3.500 | 88.9 | 4.000 | 101.60 | 5.000 | 127.0 | 6.000 | 152.4 |
| B | 2.570 | 65.3 | 3.205 | 81.4 | 3.460 | 87.9 | 4.070 | 103.4 | 5.230 | 132.8 | 5.615 | 142.6 |
| C | 5.210 | 132.3 | 5.720 | 145.3 | 6.415 | 162.9 | 7.525 | 191.1 | 9.135 | 232.0 | 9.855 | 250.3 |
| D | 0.500 | 12.7 | 0.500 | 12.7 | 0.625 | 16.0 | 0.750 | 19.0 | 1.000 | 25.40 | 1.125 | 28.6 |
| E | 0.880 | 22.4 | 1.115 | 28.3 | 1.245 | 31.6 | 1.530 | 38.9 | 1.897 | 48.2 | 2.207 | 56.1 |
| T-Tool Capacity | 1/2-3/4 | 12-20 | 5/8-1.0 | 16-25 | 3/4-1.0 | 20-25 | 1.0-1¼ | 25-32 | 1¼ - 1½ | 32-40 | 1 ½ | 40.0 |
| Optimum C.H.* | 1.422 | 36.1 | 1.747 | 44.4 | 1.835 | 46.6 | 2.202 | 55.9 | 2.995 | 76.1 | 3.440 | 87.4 |
| C.H. MIN. | 0.995 | 25.3 | 1.213 | 30.8 | 1.445 | 36.7 | 1.757 | 44.6 | 2.245 | 57.0 | 2.750 | 69.9 |
| C.H. MAX. | 1.849 | 50.0 | 2.282 | 58.0 | 2.225 | 56.5 | 2.646 | 67.2 | 3.744 | 95.1 | 4.129 | 104.9 |
| Thread | 1/2-20 | M12x1,75 | 1/2-20 | M12x1,75 | 5/8-18 | M16x2,0 | 3/4-16 | M18x2,5 | 1.0-14 | M24x3,0 | 1¼-12 | M27x3,0 |

*Optimum center height is calculated with the smaller tool System of the tool capacity.

No. QITPN-1 Turning & Facing Toolholder

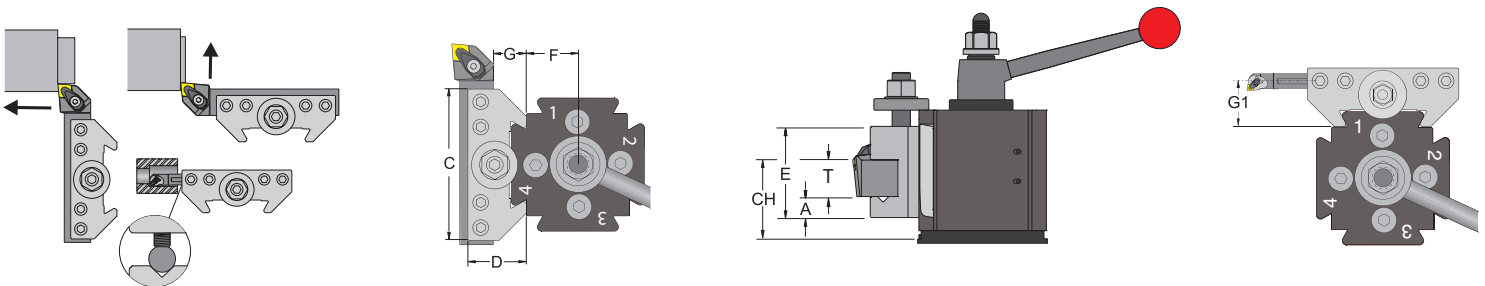
This toolholder is best used for holding square shank toolholders close to the tool post to maximize rigidity when turning, facing, and threading. Fits industry standard tool posts.



| Description | UPC No.733101- | System | A | T | C | D | E | F | G |
|-------------|----------------|--------|-------|-------|--------|-------|--------|-------|-------|
| QITP25N-1 | 00100 | in | 0.375 | 0.750 | 2.750 | 1.240 | 1.740 | 0.880 | 0.770 |
| | | mm | 9.53 | 20.00 | 69.85 | 31.50 | 44.20 | 22.35 | 19.56 |
| QITP30N-1 | 00250 | in | 0.437 | 1.000 | 3.250 | 1.490 | 2.240 | 1.115 | 0.890 |
| | | mm | 11.10 | 25.00 | 82.55 | 37.85 | 56.90 | 28.32 | 22.61 |
| QITP35N-1 | 00400 | in | 0.500 | 1.000 | 3.750 | 1.740 | 2.490 | 1.245 | 1.010 |
| | | mm | 12.70 | 25.00 | 95.25 | 44.20 | 63.25 | 31.62 | 25.65 |
| QITP40N-1 | 00550 | in | 0.562 | 1.250 | 4.500 | 1.990 | 2.990 | 1.530 | 1.040 |
| | | mm | 14.27 | 32.00 | 114.30 | 50.55 | 75.95 | 38.86 | 26.42 |
| QITP50N-1 | 00700 | in | 0.750 | 1.500 | 6.000 | 2.490 | 3.490 | 1.900 | 1.290 |
| | | mm | 19.05 | 40.00 | 152.40 | 63.25 | 88.65 | 48.26 | 32.77 |
| QITP60N-1 | 00850 | in | 1.000 | 1.500 | 7.000 | 2.990 | 3.990 | 2.207 | 1.540 |
| | | mm | 25.40 | 40.00 | 177.80 | 75.95 | 101.35 | 56.06 | 39.12 |

No. QITPN-2 Turning, Facing & Boring Toolholder

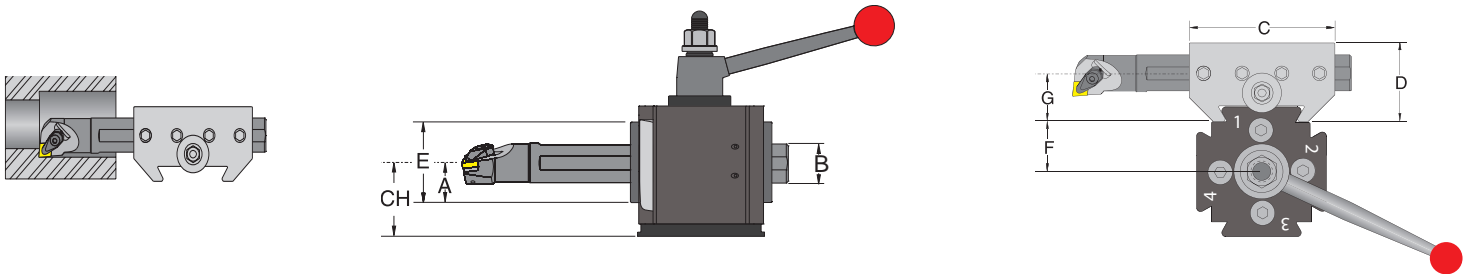
The "V" groove makes this holder more versatile so that it can hold either square shank toolholders or boring bars. Holds the tool close to the tool post to maximize rigidity when turning, facing, threading or boring. Fits industry standard toolposts.



| Description | UPC No.733101- | System | A | T | C | D | E | F | G | G1 |
|-------------|----------------|--------|-------|-------|--------|-------|--------|-------|-------|-------|
| QITP25N-2 | 00104 | in | 0.375 | .750 | 2.750 | 1.240 | 1.740 | 0.880 | 0.770 | 1.030 |
| | | mm | 9.53 | 20.00 | 69.85 | 31.50 | 44.20 | 22.35 | 19.56 | 26.16 |
| QITP30N-2 | 00254 | in | 0.437 | 1.000 | 3.250 | 1.490 | 2.240 | 1.115 | 0.890 | 1.210 |
| | | mm | 11.10 | 25.00 | 82.55 | 37.85 | 56.90 | 28.32 | 22.61 | 30.73 |
| QITP35N-2 | 00404 | in | 0.500 | 1.000 | 3.750 | 1.740 | 2.490 | 1.245 | 1.010 | 1.410 |
| | | mm | 12.70 | 25.00 | 95.25 | 44.20 | 63.25 | 31.62 | 25.65 | 35.81 |
| QITP40N-2 | 00554 | in | 0.562 | 1.250 | 4.500 | 1.990 | 2.990 | 1.530 | 1.040 | 1.575 |
| | | mm | 14.27 | 32.00 | 114.30 | 50.55 | 75.95 | 38.86 | 26.42 | 40.01 |
| QITP50N-2 | 00704 | in | 0.750 | 1.500 | 6.000 | 2.490 | 3.490 | 1.900 | 1.290 | 1.950 |
| | | mm | 19.05 | 40.00 | 152.40 | 63.25 | 88.65 | 48.26 | 32.77 | 49.53 |
| QITP60N-2 | 00854 | in | 1.000 | 1.500 | 7.000 | 2.990 | 3.990 | 2.207 | 1.540 | 2.340 |
| | | mm | 25.40 | 40.00 | 177.80 | 75.95 | 101.35 | 56.06 | 39.12 | 59.44 |

No. QITPN-4-CNC Heavy Duty Boring Bar Toolholder

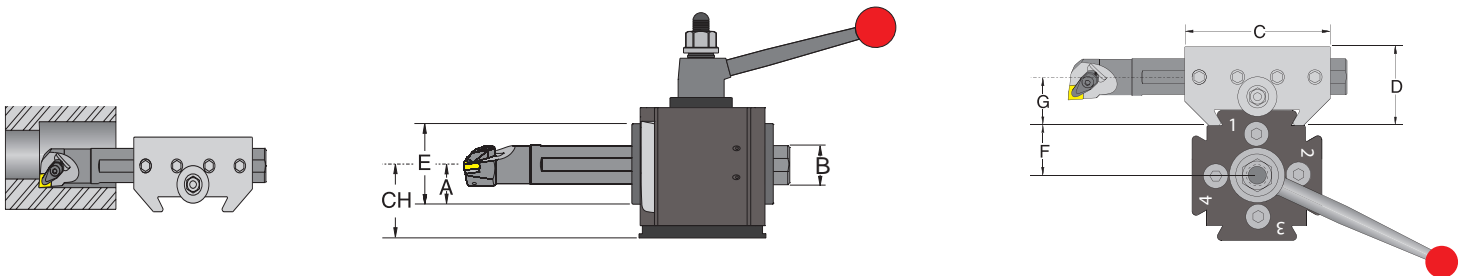
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the centerheight and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by eliminating the need to indicate across the boring bar flat. Fits industry standard tool posts.



| Description | UPC No.733101- | System | A | B Boring Bar Capacity | C | D | E | F | G |
|---------------|----------------|--------|-------|--------------------------|--------|--------|--------|-------|-------|
| QITP25N-4-CNC | 00110 | in | 0.745 | 0.750 | 2.750 | 1.490 | 1.490 | 0.880 | 0.937 |
| | | mm | 18.92 | 19.05 | 69.85 | 37.85 | 37.85 | 22.35 | 23.80 |
| QITP30N-4-CNC | 00260 | in | 0.995 | 1.000 | 3.250 | 1.990 | 1.990 | 1.115 | 1.250 |
| | | mm | 25.27 | 25.40 | 82.55 | 50.55 | 50.55 | 28.32 | 31.75 |
| QITP35N-4-CNC | 00410 | in | 1.120 | 1.000 | 3.750 | 2.240 | 2.240 | 1.245 | 1.375 |
| | | mm | 28.45 | 25.40 | 95.25 | 56.90 | 56.90 | 31.62 | 34.93 |
| QITP40N-4-CNC | 00560 | in | 1.245 | 1.250 | 4.500 | 2.490 | 2.490 | 1.530 | 1.500 |
| | | mm | 31.62 | 31.75 | 114.30 | 63.25 | 63.25 | 38.86 | 38.10 |
| QITP50N-4-CNC | 00710 | in | 1.495 | 1.500 | 5.500 | 2.990 | 2.990 | 1.900 | 2.000 |
| | | mm | 37.97 | 38.10 | 139.70 | 75.95 | 75.95 | 48.26 | 50.80 |
| QITP60N-4-CNC | 00860 | in | 1.995 | 2.000 | 6.500 | 3.990 | 3.990 | 2.207 | 2.500 |
| | | mm | 50.67 | 50.80 | 165.10 | 101.35 | 101.35 | 56.06 | 63.50 |

No. QITPN-41-CNC Universal Extra Heavy Duty Boring Bar Toolholder

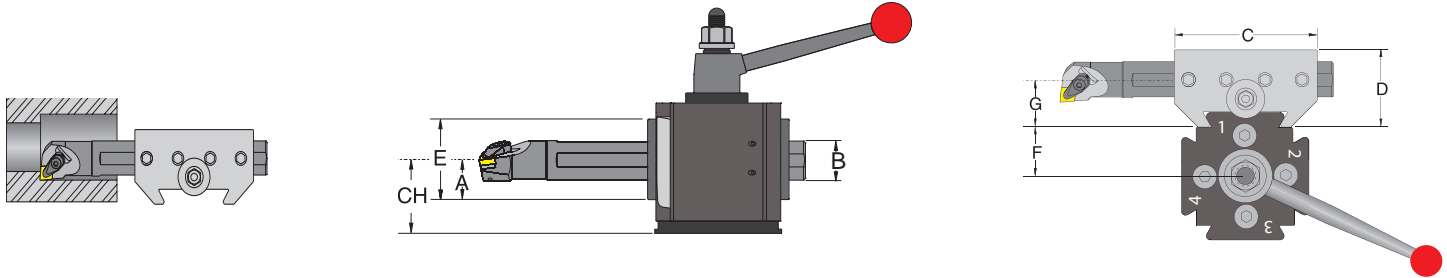
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by eliminating the need to indicate across the boring bar flat. Fits industry standard tool posts.



| Description | UPC No.733101- | System | A | B Boring Bar Capacity | C | D | E | F | G |
|-----------------|----------------|--------|-------|--------------------------|--------|--------|--------|-------|-------|
| QITP35N-41-CNC | 00414 | in | 1.120 | 1.250 | 3.750 | 2.240 | 2.240 | 1.245 | 1.375 |
| QITP35N-41M-CNC | 00416 | mm | 28.40 | 32.00 | 95.30 | 56.90 | 56.90 | 31.60 | 34.90 |
| QITP40N-41-CNC | 00564 | in | 1.370 | 1.500 | 4.500 | 2.740 | 2.740 | 1.530 | 1.625 |
| QITP40N-41M-CNC | 00566 | mm | 34.80 | 40.00 | 114.30 | 69.60 | 69.60 | 38.90 | 41.30 |
| QITP50N-41-CNC | 00714 | in | 1.745 | 2.000 | 5.500 | 3.490 | 3.490 | 1.900 | 2.250 |
| QITP50N-41M-CNC | 00716 | mm | 44.30 | 50.00 | 139.70 | 88.60 | 88.60 | 48.30 | 57.20 |
| QITP60N-41-CNC | 00864 | in | 2.245 | 2.500 | 6.500 | 4.490 | 4.490 | 2.207 | 2.750 |
| QITP60N-41M-CNC | 00866 | mm | 57.00 | 60.00 | 165.10 | 114.00 | 114.00 | 56.10 | 69.90 |

No. QITPN-41S-CNC Universal Super Over Sized Boring Bar Toolholder

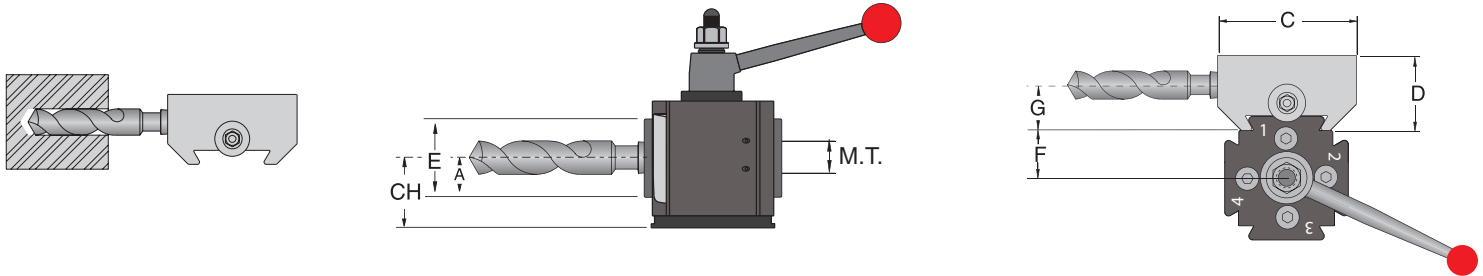
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by eliminating the need to indicate across the boring bar flat. Fits industry standard tool posts.



| Description | UPC No.733101- | System | B | | C | D | E | F | G |
|--------------------|----------------|--------|-------|---------------------|--------|--------|--------|-------|-------|
| | | | A | Boring Bar Capacity | | | | | |
| QITP35N-41-150-CNC | 00418 | in | 1.245 | 1.500 | 4.000 | 2.490 | 2.490 | 1.245 | 1.500 |
| | | mm | 31.60 | 38.10 | 101.60 | 63.20 | 63.20 | 31.60 | 38.10 |
| QITP40N-41-200-CNC | 00568 | in | 1.495 | 2.000 | 4.500 | 2.990 | 2.990 | 1.530 | 1.750 |
| | | mm | 38.00 | 50.80 | 114.30 | 75.90 | 75.90 | 38.90 | 44.50 |
| QITP50N-41-250-CNC | 00718 | in | 1.995 | 2.500 | 6.500 | 3.990 | 3.990 | 1.900 | 2.250 |
| | | mm | 50.70 | 63.50 | 165.10 | 101.30 | 101.30 | 48.30 | 57.20 |
| QITP60N-41-300-CNC | 00868 | in | 2.245 | 3.000 | 7.000 | 4.490 | 4.490 | 2.207 | 2.625 |
| | | mm | 57.00 | 76.20 | 177.80 | 114.00 | 114.00 | 56.10 | 66.70 |

No. QITPN-5 Morse Taper Toolholder

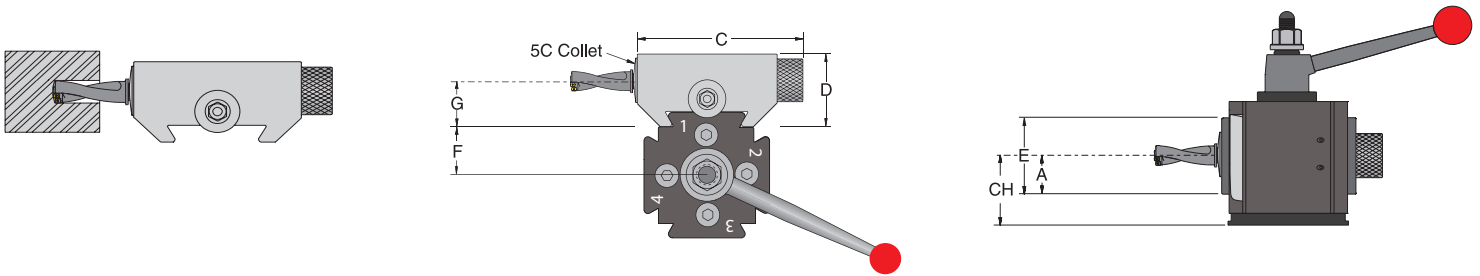
This holder is best used for holding morse taper tools. It can be used for drilling, boring, or reaming operations. Fits industry standard tool posts.



| Description | UPC No. 733101- | System | Morse Taper | | C | D | E | F | G |
|-------------|-----------------|--------|-------------|-------------|--------|-------|-------|-------|-------|
| | | | A | Morse Taper | | | | | |
| QITP35N-5-4 | 00424 | in | 1.250 | MT4 | 4.150 | 2.500 | 2.500 | 1.245 | 1.615 |
| | | mm | 31.80 | MT4 | 105.41 | 63.50 | 63.50 | 31.62 | 41.02 |
| QITP40N-5-4 | 00572 | in | 1.250 | MT4 | 4.500 | 2.500 | 2.500 | 1.530 | 1.615 |
| | | mm | 31.80 | MT4 | 114.30 | 63.50 | 63.50 | 38.90 | 41.02 |
| QITP50N-5-5 | 00722 | in | 1.750 | MT5 | 5.625 | 3.500 | 3.500 | 1.900 | 2.310 |
| | | mm | 44.50 | MT5 | 142.90 | 88.90 | 88.90 | 48.30 | 58.70 |
| QITP60N-5-5 | 00872 | in | 1.750 | MT5 | 5.625 | 3.500 | 3.500 | 2.207 | 2.310 |
| | | mm | 44.50 | MT5 | 142.90 | 88.90 | 88.90 | 56.10 | 58.70 |

No. QITPN-36 5C Collet Toolholder

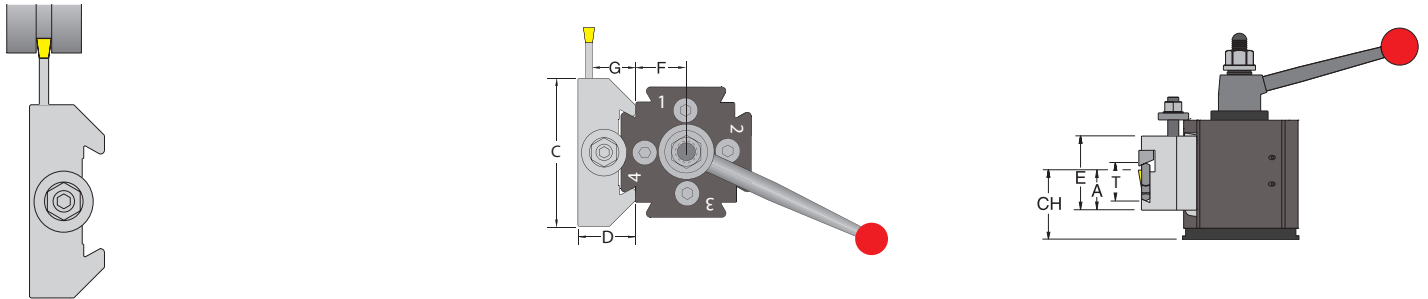
This holder's wide range of collet adaptability makes this tool ideal for holding drills, taps, chucks, & boring bars. It holds the tools with extreme rigidity without scarring them. Fits industry standard tool posts.



| Description | UPC No. 733101- | System | A | C | D | E | F | G |
|-------------|-----------------|--------|-------|--------|-------|-------|-------|-------|
| QITP25N-36 | 00142 | in | 1.125 | 4.250 | 2.500 | 2.250 | 0.880 | 1.500 |
| | | mm | 28.58 | 107.95 | 63.50 | 57.15 | 22.35 | 38.10 |
| QITP30N-36 | 00292 | in | 1.125 | 4.250 | 2.500 | 2.250 | 1.115 | 1.500 |
| | | mm | 28.58 | 107.95 | 63.50 | 57.15 | 28.32 | 38.10 |
| QITP35N-36 | 00444 | in | 1.375 | 4.500 | 2.750 | 2.750 | 1.245 | 1.625 |
| | | mm | 34.93 | 114.30 | 69.85 | 69.85 | 31.62 | 41.28 |
| QITP40N-36 | 00592 | in | 1.375 | 5.000 | 2.750 | 2.750 | 1.530 | 1.625 |
| | | mm | 34.93 | 127.00 | 69.85 | 69.85 | 38.86 | 41.28 |

No. QITPN-7-71C Extra Heavy Duty Cut-Off Blade Toolholder

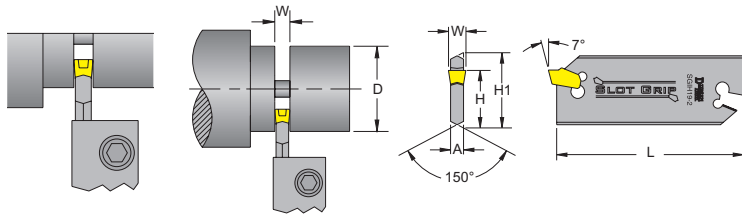
This holder is best used for holding cut-off blades. It has a taper locking system for maximum rigidity and performance in cut-off and face grooving operations. Fits industry standard tool posts. For Slot Grip Cut-Off Blades and Inserts see next page



| Description | UPC No.733101- | System | Slot Grip Blade | | | | | | |
|---------------|----------------|--------|-----------------|-------------------|--------|-------|-------|-------|-------|
| | | | A | T | C | D | E | F | G |
| QITP25N-7-71C | 00126 | in | 0.933 | SGIH-19-2 | 2.750 | 1.250 | 2.000 | 0.880 | 1.127 |
| | | mm | 23.70 | | 69.85 | 31.75 | 50.80 | 22.35 | 28.63 |
| QITP30N-7-71C | 00276 | in | 0.933 | SGIH-19-2 | 3.250 | 1.250 | 2.000 | 1.115 | 1.127 |
| | | mm | 23.70 | | 82.60 | 31.80 | 50.80 | 28.30 | 28.60 |
| QITP35N-7-71C | 00428 | in | 1.255 | SGIH-26-2 to 26-6 | 3.750 | 1.750 | 2.500 | 1.245 | 1.520 |
| | | mm | 31.88 | | 95.25 | 44.45 | 63.50 | 31.62 | 38.61 |
| QITP40N-7-71C | 00576 | in | 1.255 | SGIH-26-2 to 26-6 | 4.500 | 1.750 | 3.000 | 1.530 | 1.520 |
| | | mm | 31.88 | | 114.30 | 44.45 | 76.20 | 38.86 | 38.61 |
| QITP50N-7-71C | 00726 | in | 1.483 | SGIH-32-3 to 32-9 | 6.000 | 2.000 | 3.000 | 1.900 | 1.710 |
| | | mm | 37.67 | | 152.40 | 50.80 | 76.20 | 48.26 | 43.43 |
| QITP60N-7-71C | 00876 | in | 2.050 | SGIH-32-3 to 32-9 | 7.000 | 2.250 | 3.500 | 2.207 | 2.150 |
| | | mm | 52.07 | | 177.80 | 57.15 | 88.90 | 56.06 | 54.61 |

Slot Grip Cut-Off Blades

Designed for use with standard cut-off inserts and standard cut-off blade holders. The insert's cutting edge location repeats accurately and as a result prevents insert splitting under heavy feed and shock loads. The blade and insert geometry allows free chip flow, minimizing insert breakage due to chip build-up.



Improved design featuring a "Positive Stop". Inserts are securely held in Slot Grip Positive Stop Blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is firmly in place.

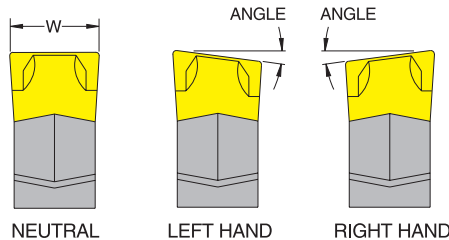
| Description | UPC No. 733101- | Insert Used | W | | D Max | | A | | L | | H | | H 1 | |
|-------------|-----------------|--------------|------|----|-------|-------|------|------|------|-------|------|------|------|------|
| | | | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm |
| SGIH19-2 | 62950 | SGT(N/R/L)-2 | .087 | 2 | 1.57 | 39,9 | .063 | 1,57 | 4.33 | 110,0 | .618 | 15,7 | 0.75 | 19,1 |
| SGIH26-2 | 62951 | SGT(N/R/L)-2 | .087 | 2 | 2.00 | 50,8 | .063 | 1,57 | | | | | | |
| SGIH26-3 | 62952 | SGT(N/R/L)-3 | .122 | 3 | 3.00 | 76,2 | .094 | 2,39 | | | | | | |
| SGIH26-4 | 62953 | SGT(N/R/L)-4 | .161 | 4 | 3.15 | 80,0 | .125 | 3,18 | | | | | | |
| SGIH26-5 | 62954 | SGT(N/R/L)-5 | .201 | 5 | 3.15 | 80,0 | .156 | 3,96 | | | | | | |
| SGIH26-6 | 62955 | SGT(N/R/L)-6 | .252 | 6 | 3.15 | 80,0 | .203 | 5,16 | | | | | | |
| SGIH32-3 | 62956 | SGT(N/R/L)-3 | .122 | 3 | 3.94 | 100,0 | .094 | 2,39 | 5.90 | 149,9 | .984 | 25,0 | 1.25 | 31,8 |
| SGIH32-4 | 62957 | SGT(N/R/L)-4 | .161 | 4 | 3.94 | 100,0 | .125 | 3,18 | | | | | | |
| SGIH32-5 | 62958 | SGT(N/R/L)-5 | .201 | 5 | 4.71 | 119,6 | .156 | 3,96 | | | | | | |
| SGIH32-6 | 62959 | SGT(N/R/L)-6 | .252 | 6 | 4.72 | 119,9 | .203 | 5,16 | | | | | | |
| SGIH32-8 | 62960 | SGT(N/R/L)-8 | .315 | 8 | 5.51 | 140,0 | .268 | 6,81 | | | | | | |
| SGIH32-9 | 62961 | SGT(N/R/L)-9 | .378 | 9 | 5.51 | 140,0 | .312 | 7,92 | | | | | | |

Cut-Off & Grooving Inserts

| Description | DASK25B First Choice for High Performance Machining | DC656 First Choice for General Turning Applications | Insert System | Lead Angle | Width ± .004 | |
|-------------|---|---|------------------|---------------|--------------|-----|
| | | | | | in | mm |
| SGTN-2 | 82223 | 82222 | 2 | 0° | .087 | 2mm |
| SGTR-2-8 | 82251 | 82250 | 2 | 8° | .087 | 2mm |
| SGTL-2-8 | 82279 | 82278 | 2 | 8° | .087 | 2mm |
| SGTN-3 | 82227 | 82226 | 3 | 0° | .122 | 3mm |
| SGTR-3-8 | 82255 | 82254 | 3 | 8° | .122 | 3mm |
| SGTL-3-8 | 82283 | 82282 | 3 | 8° | .122 | 3mm |
| SGTN-4 | 82231 | 82230 | 4 | 0° | .161 | 4mm |
| SGTR-4-8 | 82259 | 82258 | 4 | 8° | .161 | 4mm |
| SGTL-4-8 | 82287 | 82286 | 4 | 8° | .161 | 4mm |
| SGTN-5 | 82235 | 82234 | 5 | 0° | .201 | 5mm |
| SGTR-5-8 | 82263 | 82262 | 5 | 8° | .201 | 5mm |
| SGTL-5-8 | 82291 | 82290 | 5 | 8° | .201 | 5mm |
| SGTN-6 | 82239 | 82238 | 6 | 0° | .252 | 6mm |
| SGTR-6-8 | 82267 | 82266 | 6 | 8° | .252 | 6mm |
| SGTL-6-8 | 82295 | 82294 | 6 | 8° | .252 | 6mm |
| SGTN-8 | 82243 | 82242 | 8 | 0° | .315 | 8mm |
| SGTR-8-8 | 82271 | 82270 | 8 | 8° | .315 | 8mm |
| SGTL-8-8 | 82299 | 82298 | 8 | 8° | .315 | 8mm |
| SGTN-9 | 82247 | 82246 | 9 | 0° | .378 | 9mm |
| SGTR-9-8 | 82275 | 82274 | 9 | 8° | .378 | 9mm |
| SGTL-9-8 | 82303 | 82302 | 9 | 8° | .378 | 9mm |

Chipbreaker Geometry

- Reduced machining force
- Controlled, coiled chip flow
- Higher material removal rate

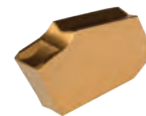


DASK25B -
(C2-C3 Substrate with
PVD TiN-TiAlN-TiN coating)

First Choice for High Performance Machining of all carbon and alloy steels, non-ferrous metals, aerospace titanium alloys, inconel, austenitic stainless steels, cast iron, copper/brass, with medium to high sfm, in dry or wet conditions. PVD TiN-TiAlN-TiN multi layer with micro dense coating structure builds a strong and tough cutting edge, dissipates heat, reduces thermal cracking and improves wear resistance and insert life. Maximum working temperature is 1650°F. Best used on CNC Lathes.

Application

- Quickly inserted into cut-off blades
- For cut-off and grooving
- Fair for interrupted cuts

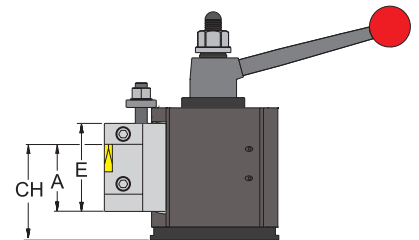
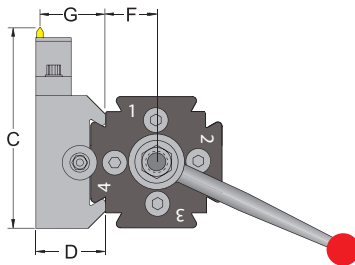
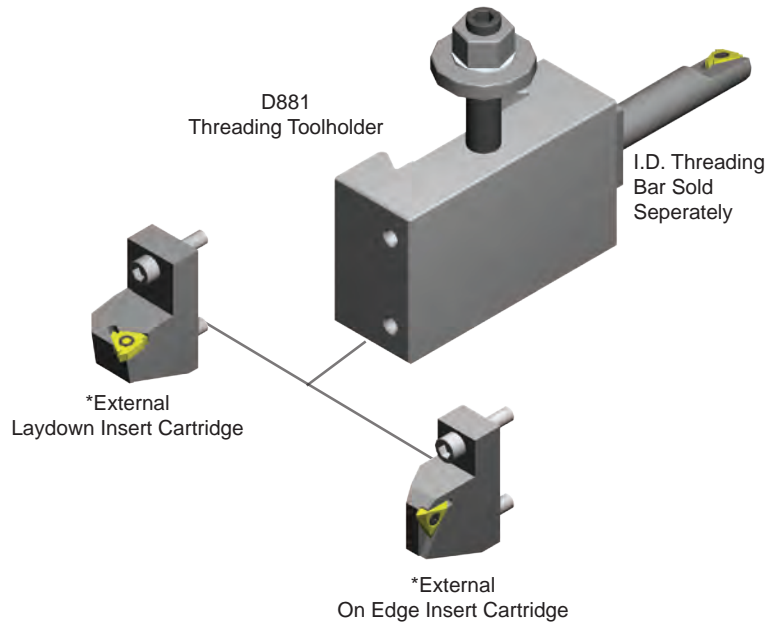


DC656 -
(C5-C6 Substrate with
CVD TiN/TiC-TiN coating)

First Choice for general turning applications on ferrous metals and 400 series stainless steels, at medium cutting sfm and wet conditions. Multi Layer CVD carbide grade. Thermal deformation and abrasion resistant substrate with cobalt enriched periphery.

No. QITPN-881 O.D. and I.D. Threading Toolholder

This holder is capable of covering all threading requirements. It uses standard carbide inserts. The holder is supplied with a cartridge for external threading. Fits industry standard tool posts.

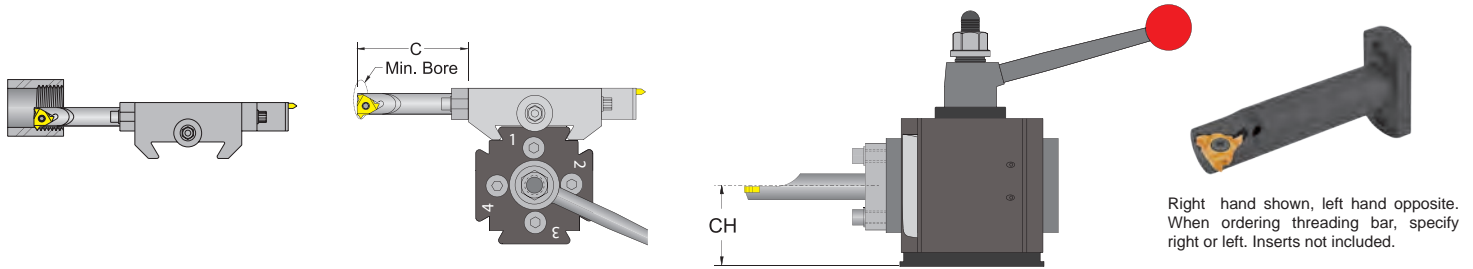


| Description | UPC No. 733101- | System | A | C | D | E | F | G | *External On Edge Insert Cartridge | | | | *External Laydown Insert Cartridge | | | | | | | |
|----------------|--------------------|--------|-------|--------|-------|-------|-------|-------|------------------------------------|--------------------|----------------|---------------|------------------------------------|----------|--------------------|-----------|---------------|-------------|-------|---------|
| | | | | | | | | | Desc. | UPC No. 733101- | TNMC Insert | Torx Screw | Torx Key | Desc. | UPC No. 733101- | Insert | Torx Screw | Torx Key | Pitch | |
| | | | | | | | | | | | | | | | | | | | TPI | mm |
| QITP25N-881-OE | 00132 | in | 0.875 | 4.130 | 1.250 | 1.750 | 0.880 | 1.000 | TIH253-32 | 03621 | 32 | GTS-1M | T-10 | NL253-3R | 03635 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 22.20 | 104.90 | 31.80 | 44.50 | 22.40 | 25.40 | | | | | | | | | | | | |
| QITP30N-881-OE | 00282 | in | 1.000 | 4.630 | 1.500 | 2.000 | 1.115 | 1.250 | TIH354-32 | 03623 | 32 | GTS-1M | T-10 | NL354-3R | 03637 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 25.40 | 117.60 | 38.10 | 50.80 | 28.30 | 31.80 | | | | | | | | | | | | |
| QITP35N-881-OE | 00434 | in | 1.250 | 5.630 | 1.750 | 2.500 | 1.245 | 1.435 | TIH354-32 | 03623 | 32 | GTS-1M | T-10 | NL354-3R | 03637 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 31.80 | 143.00 | 44.50 | 63.50 | 31.60 | 36.40 | | | | | | | | | | | | |
| QITP40N-881-OE | 00582 | in | 1.500 | 6.130 | 1.750 | 2.500 | 1.530 | 1.435 | TIH354-32 | 03623 | 32 | GTS-1M | T-10 | NL354-3R | 03637 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 38.10 | 155.70 | 44.50 | 63.50 | 38.90 | 36.40 | | | | | | | | | | | | |

* Holder is supplied standard with External On Edge Insert Cartridge. The External Laydown Insert Cartridge is sold separately. Internal threading bar sold separately. Inserts not included.

Internal Threading Bar For QITPN-881 Toolholder

This cartridge is to be used on the #881 holder. It is used for internal threading with a laydown insert. It can be mounted on either end of the base holder.



Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

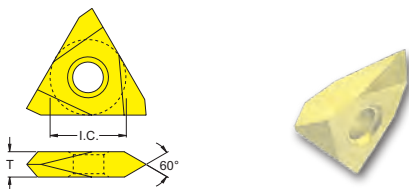
| Series | Right Hand | | | Min. Bore in mm | C | | Pitch | | Insert I.C. | Torx Screw | Torx Key | |
|-------------|------------|-------------|-----------|--------------------|------|-------|-------|-------|-------------|------------|--------------|------|
| | Desc. | No. 733101- | Insert | | in | mm | TPI | mm | | | | |
| 25,30,35,40 | NL50R | 03661 | 11IR-A60 | 0.500 | 12,7 | 2.375 | 60,3 | 16-48 | 0,5-1,5 | .250 | TS-25.45-6M1 | T-8 |
| 25,30,35,40 | NL75R | 03663 | 16IR-AG60 | 0.750 | 19,1 | 2.875 | 73,0 | 8-48 | 0,5-3,0 | .375 | TS-16 | T-10 |
| 35,40 | NL125R | 03665 | 22IR-N60 | 1.250 | 31,8 | 3.375 | 3.375 | 5-7 | 3,5-5,0 | .500 | TS-22 | T-20 |

Laydown Threading Insert 60° Partial Profile



| Internal Right Hand | DVP656 Grade For Steel | | DVK10 Grade For Stainless Steel, Cast Iron & Aluminum | | Internal Left Hand | DVP656 Grade For Steel | | DVK10 Grade For Stainless Steel, Cast Iron & Aluminum | | L mm | I.C. in | Pitch | | x mm | y mm |
|---------------------|------------------------|-----------------|---|-----------------|--------------------|------------------------|-----------------|---|----------|------|---------|-------|-----|------|------|
| | UPC No. 733101- | UPC No. 733101- | UPC No. 733101- | UPC No. 733101- | | UPC No. 733101- | UPC No. 733101- | TPI | MM | | | | | | |
| 11IR-A60 | 74056 | 74057 | 11IL-A60 | 74060 | 74061 | 11 | .250 | 16-48 | 0,5-1,5 | 0,8 | 0,9 | 1,2 | 1,7 | | |
| 16IR-A60 | 74064 | 74065 | 16IL-A60 | 74068 | 74069 | 16 | .375 | 16-48 | 0,5-1,5 | | | | | | |
| 16IR-G60 | 74072 | 74073 | 16IL-G60 | 74076 | 74077 | 16 | .375 | 8-14 | 1,75-3,0 | 1,7 | 2,5 | | | | |
| 16IR-AG60 | 74080 | 74081 | 16IL-AG60 | 74084 | 74085 | 16 | .375 | 8-48 | 0,5-3,0 | | | | | | |
| 22IR-N60 | 74088 | 74089 | 22IL-N60 | 74092 | 74093 | 22 | .500 | 5-7 | 3,5-5,0 | | | | | | |

On Edge TNMC 60° Negative Rake Threading Insert



| Desc. | DVP656 Grade For Steel UPC No. 733101- | DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No. 733101- | I.C. | | Thickness | | Hole Dia. | | Depth. | |
|------------|---|--|------|-----|-----------|------|-----------|------|--------|------|
| | | | in | mm | in | mm | in | mm | in | mm |
| TNMC-32NV- | 72003 | 72004 | .375 | 9,5 | .1250 | 3,18 | .150 | 3,81 | .150 | 3,81 |

Quadra® Indexing Quick Change Tool Post First Time Buyer Set

Quadra® First Time Buyer SET
Includes FREE TOOLING

Set Includes:

- (1) Tool Post
- (4) Holders
- (4) Toolholders **FREE**
- (5) Inserts **FREE**



| UPC No. 733101- | 00056 | 00058 | 00060 | 00062 |
|---------------------|----------------------|----------------------|----------------------|----------------------|
| Description | QITP25N-FTB | QITP30N-FTB | QITP35N-FTB | QITP40N-FTB |
| Lathe Swing | Up to 12" | 13" to 15" | 14" to 17" | 16" to 20" |
| Set Includes | | | | |
| (1) Tool Post | QITP25N | QITP30N | QITP35N | QITP40N |
| (4) Holders | QITP25N-1 | QITP30N-1 | QITP35N-1 | QITP40N-1 |
| | QITP25N-2 | QITP30N-2 | QITP35N-2 | QITP40N-2 |
| | QITP25N-7-71C | QITP30N-7-71C | QITP35N-7-71C | QITP40N-7-71C |
| | QITP25N-881-OE | QITP30N-881-OE | QITP35N-881-OE | QITP40N-881-OE |
| Free Tooling | | | | |
| (4) Toolholders | STNCR08-2J | STNCR10-2A | STNCR12-3B | STNCR64-3D |
| | STCMB06-2 | STCMB08-2 | STCMB10-2 | STCMB12-3 |
| | SGIH19-2 | SGIH19-2 | SGIH26-3 | SGIH26-3 |
| | NL50R | NL50R | NL75R | NL75R |
| (5) Inserts | TCMT-21.51-UM-DHCP25 | TCMT-21.51-UM-DHCP25 | TCMT-21.51-UM-DHCP25 | TCMT-32.51-UM-DHCP25 |
| | TCMT-21.52-UM-DHCP25 | TCMT-21.52-UM-DHCP25 | TCMT-32.52-UM-DHCP25 | TCMT-32.52-UM-DHCP25 |
| | SGTN-2-DC656 | SGTN-2-DC656 | SGTN-3-DC656 | SGTN-3-DC656 |
| | TNMC-32NV-DVP656 | TNMC-32NV-DVP656 | TNMC-32NV-DVP656 | TNMC-32NV-DVP656 |
| | 11IR-A60-DVP656 | 11IR-A60-DVP656 | 16IR-A60-DVP656 | 16IR-A60-DVP656 |

Quadra® Indexing Quick Change Tool Post Turning Set

Turning Set Includes

- (1) Tool Post
- (4) Holders

Tooling Not Included



QITPN-1



QITPN-1



QITPN-2



QITPN-2

| | | | | | | |
|-----------------|------------|------------|------------|------------|------------|------------|
| UPC No. 733101- | 00014 | 00015 | 00016 | 00017 | 00018 | 00019 |
| Description | QITP25N-TS | QITP30N-TS | QITP35N-TS | QITP40N-TS | QITP50N-TS | QITP60N-TS |
| Lathe Swing | Up to 12" | 13" to 15" | 14" to 17" | 16" to 20" | 17" to 32" | ≥ 25" |

Set Includes

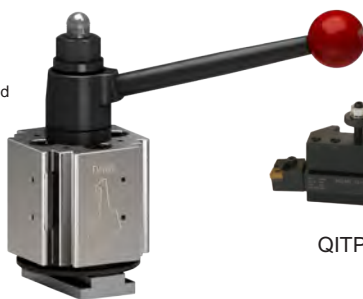
| | | | | | | |
|---------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| (1) Tool Post | QITP25N | QITP30N | QITP35N | QITP40N | QITP50N | QITP60N |
| (4) Holders | (2) QITP25N-1 (2) QITP25N-2 | (2) QITP30N-1 (2) QITP30N-2 | (2) QITP35N-1 (2) QITP35N-2 | (2) QITP40N-1 (2) QITP40N-2 | (2) QITP50N-1 (2) QITP50N-2 | (2) QITP60N-1 (2) QITP60N-2 |

Quadra® Indexing Quick Change Tool Post Standard Set

Standard Set Includes

- (1) Tool Post
- (4) Holders

Tooling Not Included



QITPN-1



QITPN-2



QITPN-4-CNC



QITPN-7-71C

| | | | | | | |
|-----------------|--------------|--------------|--------------|--------------|--------------|--------------|
| UPC No. 733101- | 00020 | 00021 | 00022 | 00023 | 00024 | 00025 |
| Desc. | QITP25N-INSS | QITP30N-INSS | QITP35N-INSS | QITP40N-INSS | QITP50N-INSS | QITP60N-INSS |
| Lathe Swing | Up to 12" | 13" to 15" | 14" to 17" | 16" to 20" | 17" to 32" | ≥ 25" |

Set Includes

| | | | | | | |
|---------------|--|--|--|--|--|--|
| (1) Tool Post | QITP25N | QITP30N | QITP35N | QITP40N | QITP50N | QITP60N |
| (4) Holders | (1) QITP25N-1 (1) QITP25N-2 (1) QITP25N-4-CNC (1) QITP25N-7-71C | (1) QITP30N-1 (1) QITP30N-2 (1) QITP30N-4-CNC (1) QITP30N-7-71C | (1) QITP35N-1 (1) QITP35N-2 (1) QITP35N-4-CNC (1) QITP35N-7-71C | (1) QITP40N-1 (1) QITP40N-2 (1) QITP40N-4-CNC (1) QITP40N-7-71C | (1) QITP50N-1 (1) QITP50N-2 (1) QITP50N-4-CNC (1) QITP50N-7-71C | (1) QITP60N-1 (1) QITP60N-2 (1) QITP60N-4-CNC (1) QITP60N-7-71C |

SUPER Quick Change

Tool Post & Toolholders

with a **Triple Action**

Wedge-Locking System



Precision!
Rigidity!
Repeatability!

- Multi-position locking handle adjustment
- Anti-Rotation mounting
- Super precision toolholder locking
- Repeatability within millionths
- Thousands of pounds of locking force with a finger tip

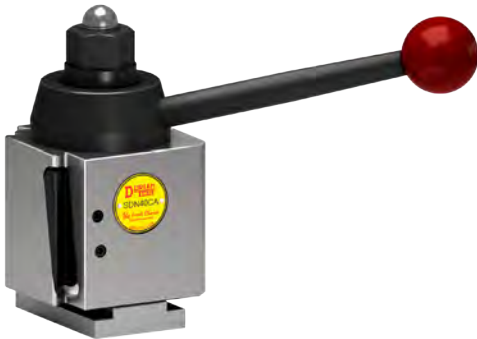
Style

Features

Application

SUPER Quick Change Tool Post

Page B-30



- Triple Action Locking System
- Zero Backlash
- Precise Repeatability within .0001"
- 15° Locking Handle Position Adjustment
- Super Heavy Duty Locking Gear and Wedge Style Sliding Gibs
- Industry Standard Interchangeable Toolholders
- High Tensile Strength Chromium-Molybdenum Alloy Steel Body, Locking Gear, Sliding Gibs, Locking Gear Head, and Locking Handle

- Through-Hardened, Ion Nitrided, and Nickel-plated Body
- Through-Hardened and Ion Nitrided and Precision Ground Locking Gear and Sliding Gibs for Wear Resistance and Repeatability
- CNC Precision Ground and Qualified for accuracy and super precise repeatability

- CNC Toolroom Lathes
- Manual Toolroom Lathes
- Engine Lathes
- Heavy Duty Oil-Country Lathes
- Super Precision High Speed
- Tight Tolerances and Excellent Finish Requiring Applications
- Deep Drilling and Boring
- Heavy Duty Material Removal
- Multi Turning, Drilling, Boring, Threading Applications

No. D1 Turning & Facing Holder

Page B-31



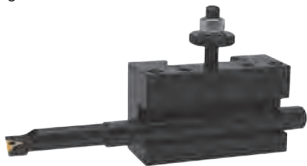
- Quick Change Mounting
- High Tensile Strength Chromium-Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Holds Square Shank Tools
- Turning and Facing
- Threading and Grooving
- Cut-Off Applications

No. D2 Turning, Facing & Boring Holder

Page B-31



- Boring Bar "V" Seat
- Quick Change Mounting
- High Tensile Strength Chromium-Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Holds Square Shank Tools
- Holds Boring Bars
- Turning and Facing
- Light to Medium Boring
- Threading and Grooving
- Cut-Off Applications

No. D4-D41-D41S CNC Extra Heavy Duty Boring Bar Holder

Page B-32 - B-33



- Precision Ground and Honed Bore
- Qualified Bore for Precise Tool Alignment and Squareness
- Quick-Lock System Aligns Boring Bar Centerheight and Rake Angle Automatically.
- Four Special Flat Machined Locking Screws for High Rigidity Extended Overhangs without Scarring the Boring Bar
- Systems Up to 3" Capacity
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Precision Boring Applications
- Heavy Duty Boring Applications
- Heavy Duty Drilling Applications
- Deep Boring, Drilling and Threading Applications

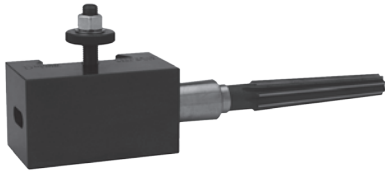
Style

Features

Application

No. D5 Morse Taper Holder

Page B-33



- Precision Ground Morse Taper
- Qualified for Precise Tool Alignment and Squareness
- Designed for Deep Drilling
- Heavy Duty Drilling
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Deep Drilling Applications
- Heavy Duty Drilling Applications
- Reaming and Tapping

No. D7-71C Reversible Cut-Off Blade Holder

Page B-34



- Precision Ground Blade Dovetail Seat
- Qualified for Precise Tool Alignment and Squareness
- Quick Change Mounting
- High Tensile Strength Chromium- Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Cut-Off Applications
- Grooving Applications

No. D881 O.D. or I.D. Threading Holder

Page B-36



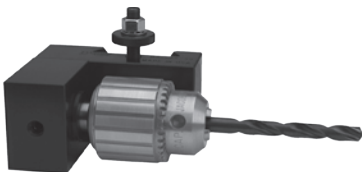
- Quick Change Mounting
- On Edge and Laydown Cartridge
- High Tensile Strength Chromium- Molybdenum Alloy Steel

- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- OD and ID Threading

No. D35 Dovetail Drill Chuck Holder

Page B-38



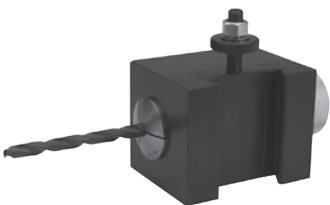
- Supplied with a Rohm Chuck
- Qualified for Precise Tool Alignment and Squareness
- Designed for Versatility
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Center Drilling
- Precision Drilling
- Precision Reaming
- Tapping

No. D36 5C Collet Holder

Page B-38

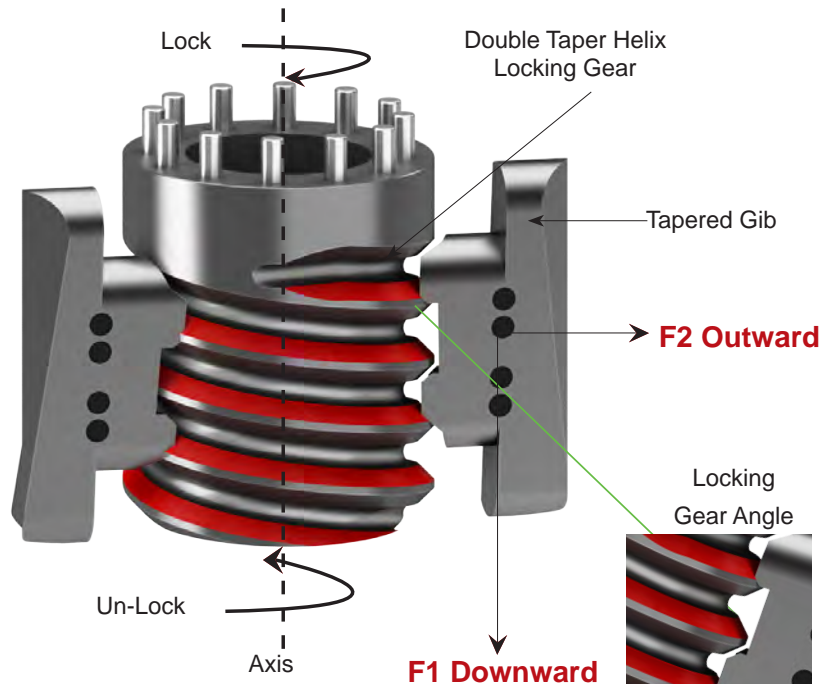


- 5C Collet Holding System
- Supplied with Collet Closer
- Qualified for Precise Tool Alignment and Squareness
- Designed for Versatility
- Quick Change Mounting

- High Tensile Strength Chromium-Molybdenum Alloy Steel
- Hardened & Black Finished
- CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"

- Miniature to Medium System Tools
- For Special Tool System and Shapes
- Accepts Square, Round & Hex Collets
- Drilling Applications
- Boring Applications
- Reaming Applications
- Tapping
- From 1/16" to 1.0" Diameter Tools

The Triple Action Wedge-Locking System is a powerful combination of a **downward, outward and inward force** simultaneously locking the holder.



1. F1 Downward Force:

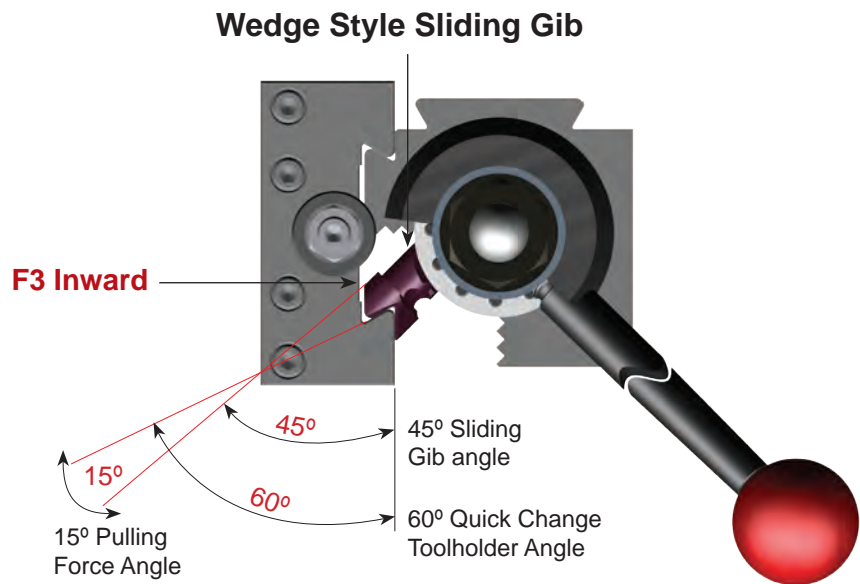
(shown right) Rotating the locking gear moves the gib down, expanding the tool post dovetail to lock the toolholder.

2. F2 Outward Force:

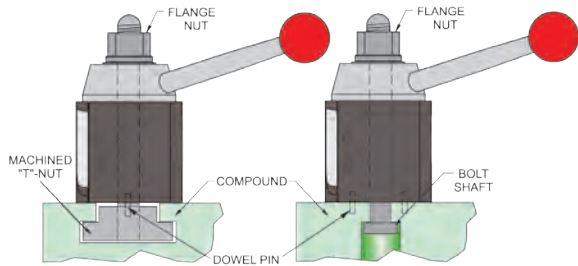
(shown right) When the gibs make full contact with the toolholder dovetail, the double-angle helix of the locking gear forces the gib outward, neutralizing any backlash to zero.

3. F3 Inward Force:

(shown right) The differential between the sliding gib angle and the quick change holder angle pulls the toolholder towards the tool post dovetail surface, creating a one-piece locking effect.

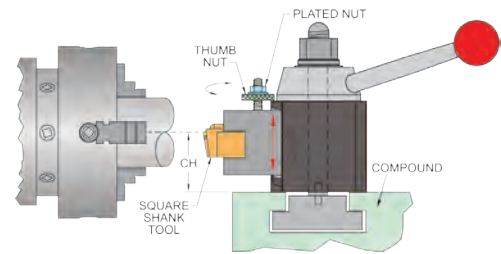


Tool Post Mounting



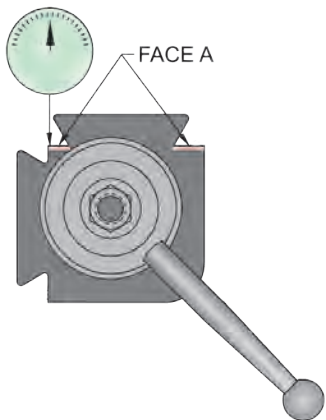
The tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flange Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using the Bolt Shaft is the common mounting method on European lathes. Dowel pins are supplied standard to increase tool post mounting rigidity, if tool post shifting is a concern under heavy or interrupted cuts.

Center Height Adjustment



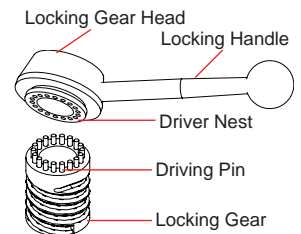
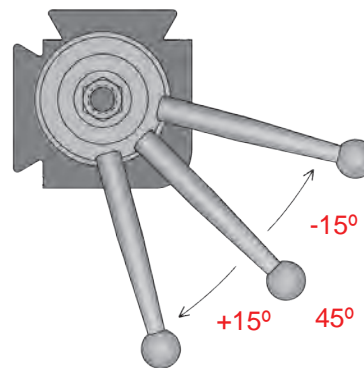
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool by rotating the Thumb Nut until the desired height is reached and locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool post body. Minimum center height has been reached when the bottom of the holder is flush with the top of the compound.

Indicating Position



The double dovetails are ground at 90° square ($\pm .0002$ "). When mounting, it is necessary that Face "A" is set parallel to the lathe axis with an indicator in order for drills to work properly. The holder is slid over the tool post dovetail and locked with the handle. The surfaces in contact must be kept clean and lubricated at all times to prevent misalignment of the tool and loss of the tool post repeatability and rigidity. Also, whenever the drilling operation produces vibration, the parallelism of the tool post must be checked and kept within $\pm .0005$ ".

Locking Handle Positioning

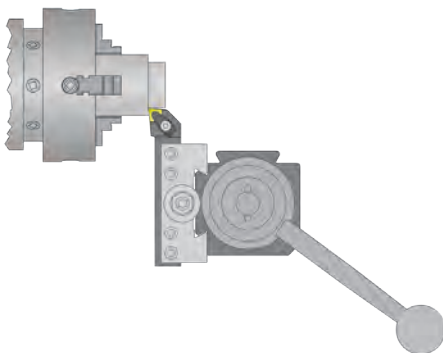


To change the position of the handle: remove the *flange nut; remove the *guide bushing; pull the locking gear head and place to the desired position.

The locking handle will be at a 45° position when the holder is locked; however it is adjustable in 15° increments according to the machine requirements, to clear the machine tail stock, the safety door, or the machine safety guard.

O.D. Turning Operations

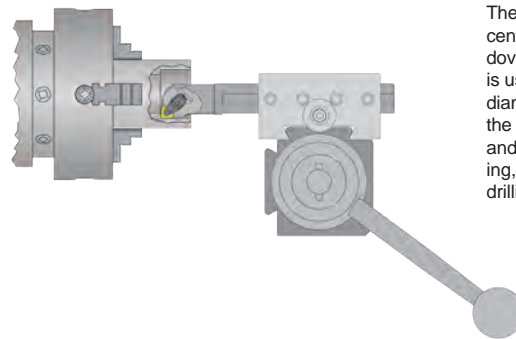
Turning, Threading, Cut-Off, Grooving, & Chamfering



The dovetail closest to the chuck (left dovetail as shown below) is used for turning outside diameters. It holds the tool at the best location for clearance and rigidity for turning, threading, cut-off, grooving, and chamfering.

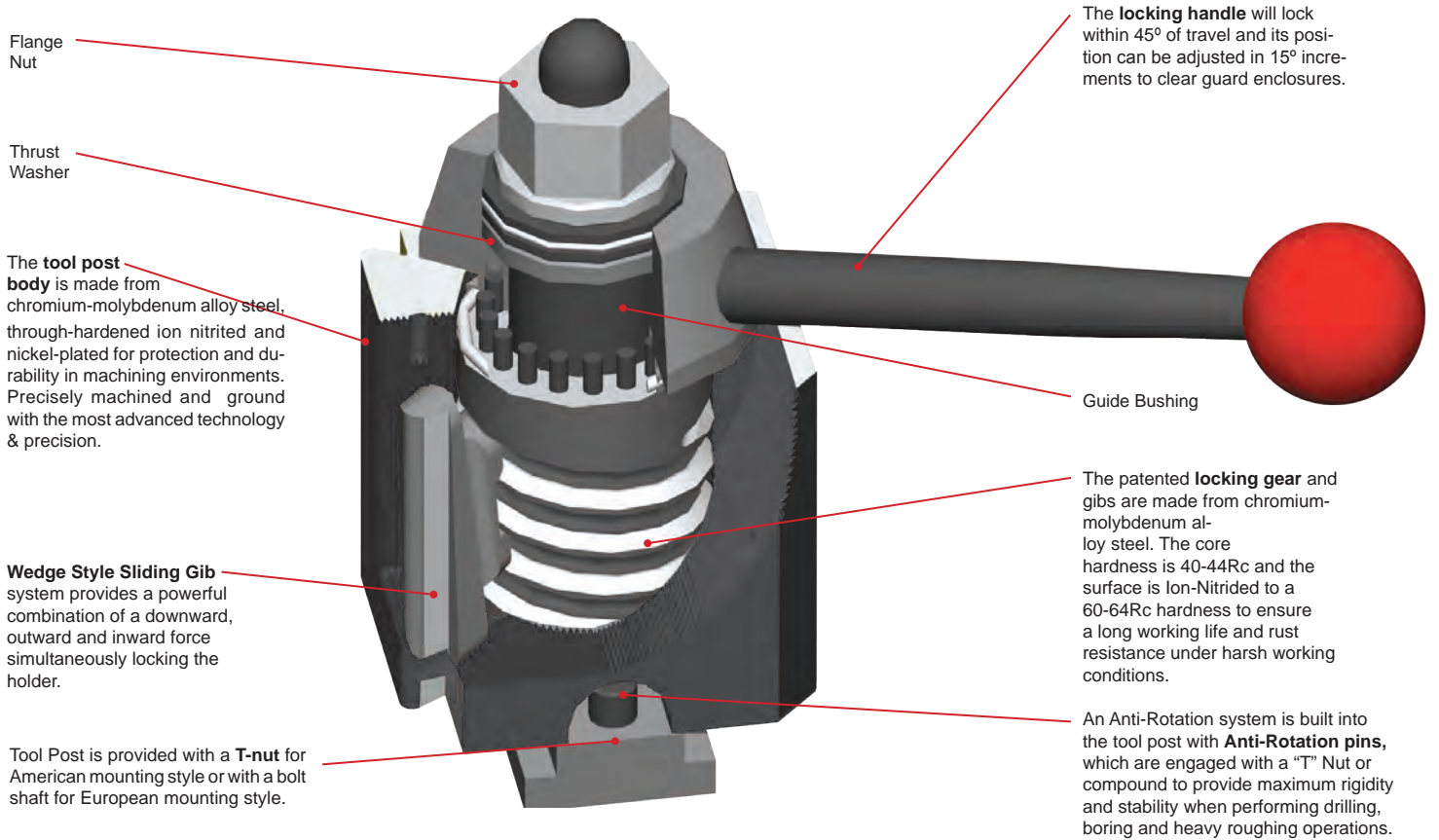
I.D. Turning Operations

Boring, Threading, Grooving, Drilling, & Center Drilling

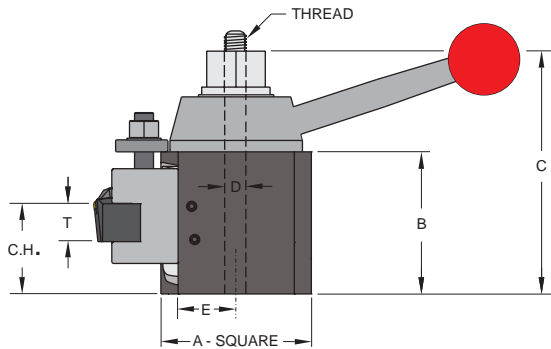


The dovetail closest to the center of the chuck (top dovetail as shown below) is used for turning inside diameters. It holds the tool at the best location for clearance and rigidity when boring, threading, grooving, drilling, and center drilling.

SUPER Quick Change Tool Post System



SUPER Quick Change Tool Post Specifications



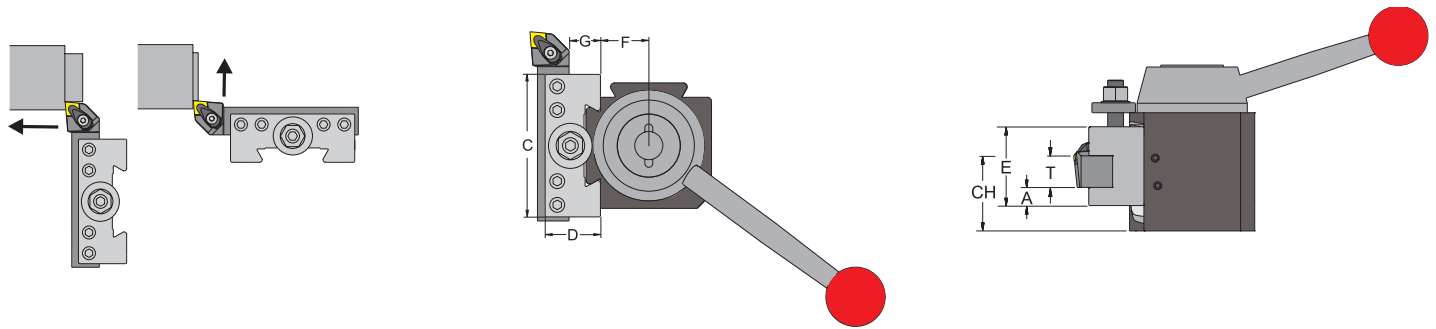
- Zero Backlash
- Triple Action Locking System
- Precise Repeatability within .0001
- 15° Locking Handle Position Adjustment
- Industry-Standard Interchangeable Holders

| Description | SDN25AXA | | SDN30BXA | | SDN35CXA | | SDN40CA | | SDN50DA | | SDN60EA | |
|----------------------|----------|----------|----------|---------|----------|---------|---------|---------|---------|---------|---------|---------|
| | 01000 | | 01002 | | 01004 | | 01006 | | 01008 | | 01010 | |
| UPC No. 733101- | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm |
| System | ≤12 | ≤300 | 13-15 | 330-380 | 14-17 | 350-430 | 16-20 | 400-500 | 17-32 | 430-810 | ≥25 | ≥635 |
| Lathe Swing Over Bed | | | | | | | | | | | | |
| A | 2.625 | 66.67 | 3.000 | 76.2 | 3.500 | 88.90 | 4.000 | 101.60 | 5.000 | 127.00 | 6.000 | 152.4 |
| B | 2.500 | 63.5 | 2.750 | 69.9 | 3.250 | 82.60 | 3.750 | 95.25 | 4.625 | 117.48 | 5.000 | 127.0 |
| C | 4.240 | 107.7 | 4.710 | 119.6 | 5.650 | 143.51 | 6.335 | 160.91 | 7.435 | 188.85 | 8.060 | 204.72 |
| D | 0.500 | 12.7 | 0.625 | 16.0 | 0.750 | 19.0 | 0.875 | 22.23 | 1.000 | 25.40 | 1.125 | 28.6 |
| E | 0.880 | 22.35 | 1.115 | 28.32 | 1.199 | 30.45 | 1.530 | 38.86 | 1.900 | 48.26 | 2.207 | 56.06 |
| T-Tool Capacity | 1/2-3/4 | 12-20 | 5/8-1.0 | 16-25 | 3/4-1.0 | 20-25 | 1.0-1¼ | 25-32 | 1¼-1½ | 32-40 | 1 1/2 | 40 |
| Optimum C.H.* | 1.250 | 31.75 | 1.312 | 33.32 | 1.625 | 41.28 | 1.937 | 49.20 | 2.562 | 65.07 | 3.000 | 76.20 |
| C.H. MIN. | 0.875 | 22.2 | 1.062 | 27.0 | 1.250 | 31.8 | 1.562 | 39.7 | 2.000 | 50.80 | 2.500 | 63.5 |
| C.H. MAX. | 1.875 | 47.63 | 1.937 | 49.20 | 2.250 | 57.75 | 2.562 | 65.07 | 3.575 | 85.73 | 3.500 | 88.90 |
| Thread | 1/2-20 | M12x1,75 | 5/8-18 | M16x2,0 | 3/4-16 | M18x2,5 | 7/8-14 | M20x1,5 | 1.0-14 | M24x3,0 | 1½-12 | M27x3,0 |

* Optimum center height is calculated with the smaller tool System of the tool capacity. If the higher System tool is to be used, add 1/8" to the optimum center height.

No. D1 Turning & Facing Toolholder

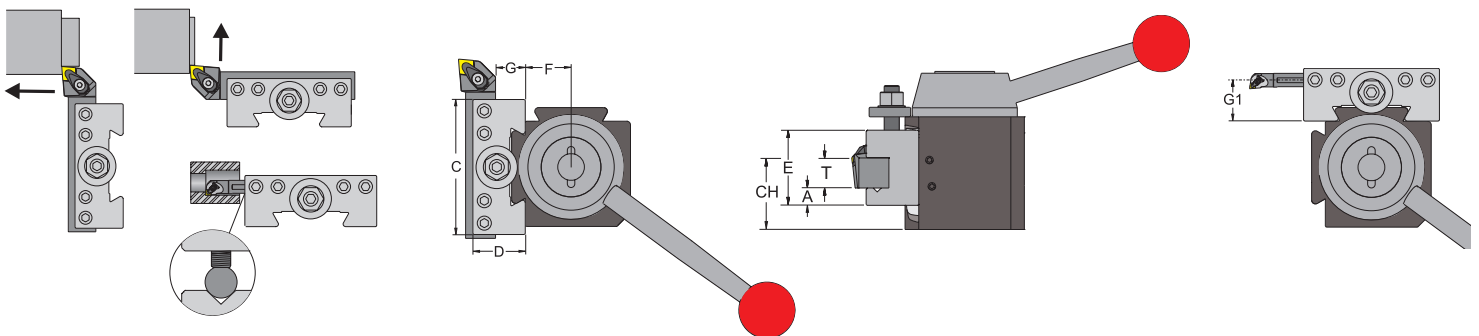
This toolholder is best used for holding square shank toolholders close to the tool post to maximize rigidity when turning, facing, and threading. Fits industry standard tool posts.



| Description | UPC No.733101- | System | A | T | C | D | E | F | G |
|-------------|----------------|--------|-------|-------|--------|-------|--------|-------|-------|
| D25AXA-1 | 01100 | in | 0.375 | 0.750 | 2.750 | 1.250 | 1.750 | 0.880 | .790 |
| | | mm | 9.53 | 20.00 | 69.85 | 31.75 | 44.45 | 22.35 | 20.07 |
| D30BXA-1 | 01250 | in | 0.437 | 1.000 | 3.250 | 1.500 | 2.250 | 1.115 | .915 |
| | | mm | 11.10 | 25.00 | 82.55 | 38.10 | 57.15 | 28.32 | 23.24 |
| D35CXA-1 | 01400 | in | 0.500 | 1.000 | 3.750 | 1.750 | 2.500 | 1.199 | 1.040 |
| | | mm | 12.70 | 25.00 | 95.25 | 44.45 | 63.50 | 30.45 | 26.42 |
| D40CA-1 | 01550 | in | 0.562 | 1.250 | 4.500 | 2.000 | 3.000 | 1.530 | 1.040 |
| | | mm | 14.27 | 32.00 | 114.30 | 50.80 | 76.20 | 38.86 | 26.42 |
| D50DA-1 | 01700 | in | 0.750 | 1.500 | 6.000 | 2.500 | 3.500 | 1.900 | 1.290 |
| | | mm | 19.05 | 40.00 | 152.40 | 63.50 | 88.90 | 48.26 | 32.77 |
| D60EA-1 | 01850 | in | 1.000 | 1.500 | 7.000 | 3.000 | 4.000 | 2.207 | 1.540 |
| | | mm | 25.40 | 40.00 | 177.80 | 76.20 | 101.60 | 56.06 | 39.12 |

No. D2 Turning, Facing & Boring Toolholder

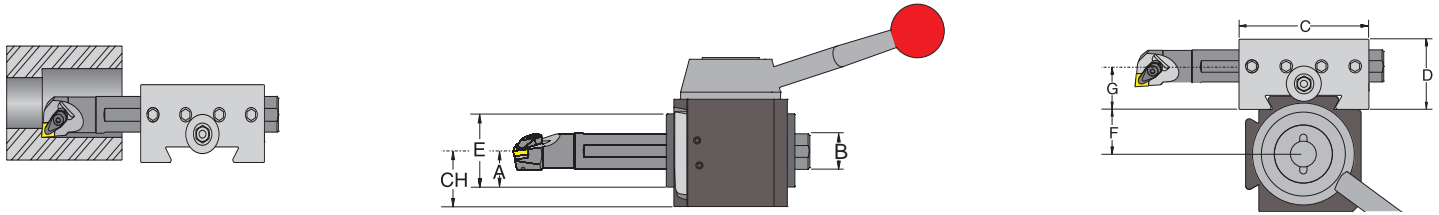
The "V" groove makes this holder more versatile so that it can hold either square shank toolholders or boring bars. Holds the tool close to the tool post to maximize rigidity when turning, facing, threading or boring. Fits industry standard toolposts.



| Description | UPC No.733101- | System | A | T | C | D | E | F | G | G1 |
|-------------|----------------|--------|-------|-------|--------|-------|--------|-------|-------|-------|
| D25AXA-2 | 01104 | in | 0.375 | 0.750 | 2.750 | 1.250 | 1.750 | 0.880 | 0.790 | 1.015 |
| | | mm | 9.53 | 20.00 | 69.85 | 31.75 | 44.45 | 22.35 | 20.07 | 25.78 |
| D30BXA-2 | 01254 | in | 0.437 | 1.000 | 3.250 | 1.500 | 2.250 | 1.115 | 0.915 | 1.205 |
| | | mm | 11.10 | 25.00 | 82.55 | 38.10 | 57.15 | 28.32 | 23.24 | 30.61 |
| D35CXA-2 | 01404 | in | 0.500 | 1.000 | 3.750 | 1.750 | 2.500 | 1.199 | 1.040 | 1.390 |
| | | mm | 12.70 | 25.00 | 95.25 | 44.45 | 63.50 | 30.45 | 26.42 | 35.31 |
| D40CA-2 | 01554 | in | 0.562 | 1.250 | 4.500 | 2.000 | 3.000 | 1.530 | 1.040 | 1.515 |
| | | mm | 14.27 | 32.00 | 114.30 | 50.80 | 76.20 | 38.86 | 26.42 | 38.48 |
| D50DA-2 | 01704 | in | 0.750 | 1.500 | 6.000 | 2.500 | 3.500 | 1.900 | 1.290 | 1.890 |
| | | mm | 19.05 | 40.00 | 152.40 | 63.50 | 88.90 | 48.26 | 32.77 | 48.01 |
| D60EA-2 | 01854 | in | 1.000 | 1.500 | 7.000 | 3.000 | 4.000 | 2.207 | 1.540 | 2.265 |
| | | mm | 25.40 | 40.00 | 177.80 | 76.20 | 101.60 | 56.06 | 39.12 | 57.53 |

No. D4-CNC Heavy Duty Boring Bar Toolholder

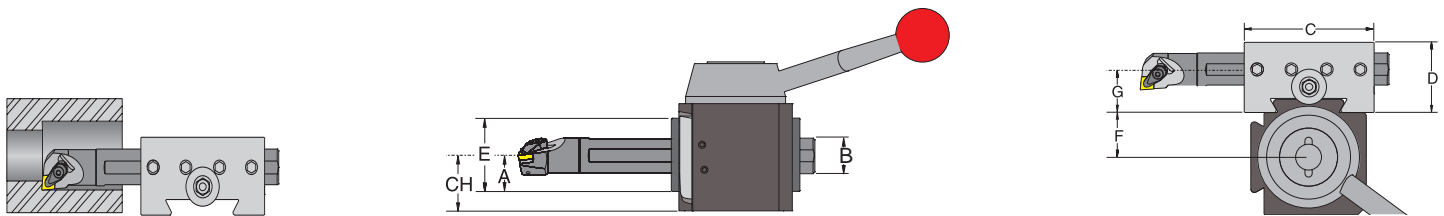
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by eliminating the need to indicate across the boring bar flat. Fits industry standard tool posts.



| Description | UPC No.733101- | System | A | B Boring Bar Capacity | C | D | E | F | G |
|--------------|----------------|--------|-------|--------------------------|--------|--------|--------|-------|-------|
| D25AXA-4-CNC | 01110 | in | .745 | .750 | 2.750 | 1.490 | 1.490 | .880 | .937 |
| | | mm | 18.90 | 19.10 | 69.90 | 37.80 | 37.80 | 22.40 | 23.80 |
| D30BXA-4-CNC | 01260 | in | .995 | 1.000 | 3.250 | 1.990 | 1.990 | 1.115 | 1.250 |
| | | mm | 25.30 | 25.40 | 82.60 | 50.50 | 50.50 | 28.30 | 31.80 |
| D35CXA-4-CNC | 01410 | in | 1.120 | 1.000 | 3.750 | 2.240 | 2.240 | 1.199 | 1.375 |
| | | mm | 28.40 | 25.40 | 95.30 | 56.90 | 56.90 | 30.50 | 34.90 |
| D40CA-4-CNC | 01560 | in | 1.245 | 1.250 | 4.500 | 2.490 | 2.490 | 1.530 | 1.500 |
| | | mm | 31.60 | 31.80 | 114.30 | 63.20 | 63.20 | 38.90 | 38.10 |
| D50DA-4-CNC | 01710 | in | 1.495 | 1.500 | 5.500 | 2.990 | 2.990 | 1.900 | 2.000 |
| | | mm | 38.00 | 38.10 | 139.70 | 75.90 | 75.90 | 48.30 | 50.80 |
| D60EA-4-CNC | 01860 | in | 1.995 | 2.000 | 6.500 | 3.990 | 3.990 | 2.207 | 2.500 |
| | | mm | 50.70 | 50.80 | 165.10 | 101.30 | 101.30 | 56.10 | 63.50 |

No. D41-CNC Universal Extra Heavy Duty Boring Bar Toolholder

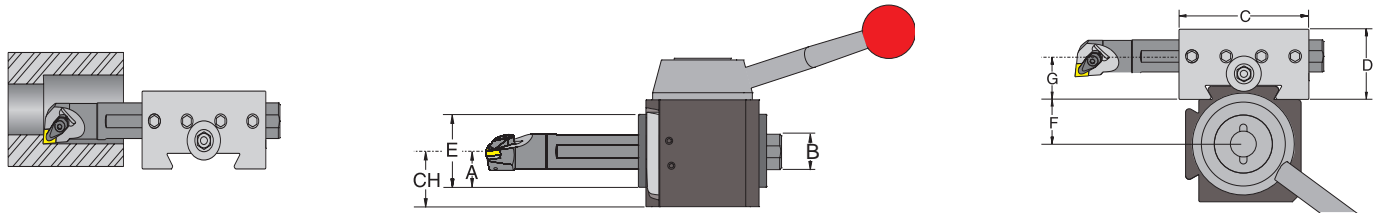
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by eliminating the need to indicate across the boring bar flat. Fits industry standard tool posts.



| Description | UPC No.733101- | System | A | B Boring Bar Capacity | C | D | E | F | G |
|----------------|----------------|--------|-------|--------------------------|--------|--------|--------|-------|-------|
| D25AXA-41-CNC | 01114 | in | .870 | 1.000 | 2.750 | 1.740 | 1.740 | .880 | 1.062 |
| D30BXA-41-CNC | 01264 | in | 1.120 | 1.250 | 3.250 | 2.240 | 2.240 | 1.115 | 1.375 |
| D30BXA-41M-CNC | 01266 | mm | 28.40 | 32.00 | 82.60 | 56.90 | 56.90 | 28.30 | 34.90 |
| D35CXA-41-CNC | 01414 | in | 1.120 | 1.250 | 3.750 | 2.240 | 2.240 | 1.199 | 1.375 |
| D35CXA-41M-CNC | 01416 | mm | 28.40 | 32.00 | 95.30 | 56.90 | 56.90 | 30.50 | 34.90 |
| D40CA-41-CNC | 01564 | in | 1.245 | 1.500 | 4.500 | 2.490 | 2.490 | 1.530 | 1.500 |
| D40CA-41M-CNC | 01566 | mm | 31.60 | 40.00 | 114.30 | 63.20 | 63.20 | 38.90 | 38.10 |
| D50DA-41-CNC | 01714 | in | 1.745 | 2.000 | 5.500 | 3.490 | 3.490 | 1.900 | 2.250 |
| D50DA-41M-CNC | 01716 | mm | 44.30 | 50.00 | 139.70 | 88.60 | 88.60 | 48.30 | 57.20 |
| D60EA-41-CNC | 01864 | in | 1.995 | 2.500 | 6.500 | 3.990 | 3.990 | 2.207 | 2.375 |
| D60EA-41M-CNC | 11866 | mm | 50.70 | 60.00 | 165.10 | 101.30 | 101.30 | 56.10 | 60.30 |

No. D41S-CNC Super Universal Over Sized Boring Bar Toolholder

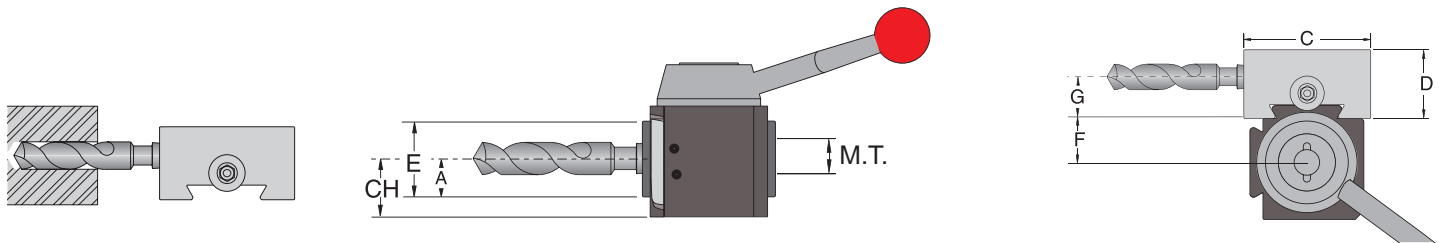
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by eliminating the need to indicate across the boring bar flat. Fits industry standard tool posts.



| Description | UPC No.733101- | System | B | | C | D | E | F | G |
|-------------------|----------------|--------|-------|---------------------|--------|--------|--------|-------|-------|
| | | | A | Boring Bar Capacity | | | | | |
| D35CXA-41-150-CNC | 01418 | in | 1.245 | 1.500 | 4.000 | 2.490 | 2.490 | 1.199 | 1.500 |
| | | mm | 31.60 | 38.10 | 101.60 | 63.30 | 63.30 | 30.50 | 38.10 |
| D40CA-41-200-CNC | 01568 | in | 1.495 | 2.000 | 4.500 | 2.990 | 2.990 | 1.530 | 1.750 |
| | | mm | 38.00 | 50.80 | 114.30 | 76.00 | 76.00 | 38.90 | 44.50 |
| D50DA-41-250-CNC | 01718 | in | 1.995 | 2.500 | 6.500 | 3.990 | 3.990 | 1.900 | 2.250 |
| | | mm | 50.70 | 63.50 | 165.10 | 101.40 | 101.40 | 48.30 | 57.20 |
| D60EA-41-300-CNC | 01868 | in | 2.245 | 3.000 | 7.000 | 4.490 | 4.490 | 2.207 | 2.625 |
| | | mm | 57.00 | 76.20 | 177.80 | 114.10 | 114.10 | 56.10 | 66.70 |

No. D5 Morse Taper Toolholder

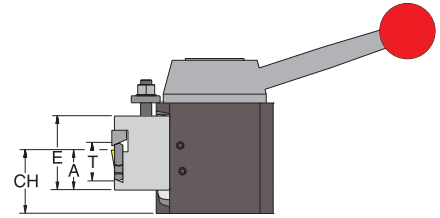
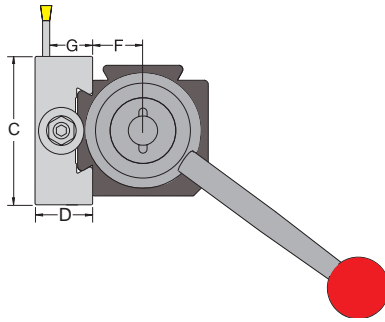
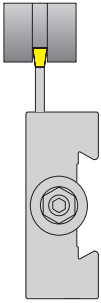
This holder is best used for holding morse taper tools. It can be used for drilling, boring, or reaming operations. Fits industry standard tool posts.



| Description | UPC No. 733101- | System | Morse Taper | | C | D | E | F | G |
|-------------|-----------------|--------|-------------|-------------|--------|-------|-------|-------|-------|
| | | | A | Morse Taper | | | | | |
| D35CXA-5-4 | 01424 | in | 1.125 | MT4 | 4.150 | 2.500 | 2.250 | 1.199 | 1.615 |
| | | mm | 28.58 | MT4 | 105.41 | 63.50 | 57.15 | 30.45 | 41.02 |
| D40CA-5-4 | 01572 | in | 1.250 | MT4 | 4.500 | 2.500 | 2.500 | 1.530 | 1.615 |
| | | mm | 31.75 | MT4 | 114.30 | 63.50 | 63.50 | 38.86 | 41.02 |
| D50DA-5-5 | 01722 | in | 1.750 | MT5 | 5.625 | 3.500 | 3.500 | 1.900 | 2.300 |
| | | mm | 44.45 | MT5 | 142.88 | 88.90 | 88.90 | 48.26 | 58.42 |
| D60EA-5-5 | 01872 | in | 1.750 | MT5 | 5.500 | 3.500 | 3.500 | 2.207 | 2.240 |
| | | mm | 44.45 | MT5 | 139.70 | 88.90 | 88.90 | 56.06 | 56.90 |

No. D7-71C Extra Heavy Duty Cut-Off Blade Toolholder

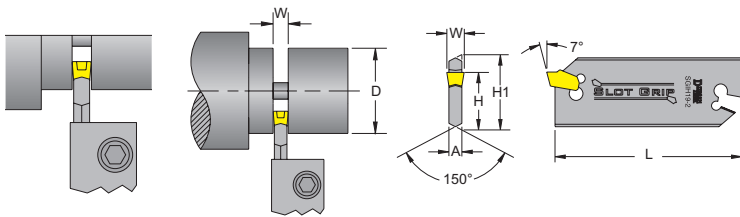
This holder is best used for holding cut-off blades. It has a taper locking system for maximum rigidity and performance in cut-off and face grooving operations. Fits industry standard tool posts. For Slot Grip Cut-Off Blades and Inserts see next page.



| Description | UPC No.733101- | System | Slot Grip Blade | | | | | | | |
|--------------|----------------|--------|-----------------|-------------------|-------------------|--------|-------|-------|-------|-------|
| | | | A | T | C | D | E | F | G | |
| D25AXA-7-71C | 01126 | in | 0.933 | SGIH-19-2 | 2.750 | 1.250 | 2.000 | 0.880 | 1.127 | |
| | | mm | 23.70 | | 69.85 | 31.75 | 50.80 | 22.35 | 28.63 | |
| D30BXA-7-71C | 01276 | in | 0.933 | | 3.250 | 1.250 | 2.000 | 1.115 | 1.127 | |
| | | mm | 23.70 | | 82.60 | 31.80 | 50.80 | 28.30 | 28.60 | |
| D35CXA-7-71C | 01428 | in | 1.255 | | SGIH-26-2 to 26-6 | 3.750 | 1.750 | 2.500 | 1.245 | 1.520 |
| | | mm | 31.88 | | | 95.25 | 44.45 | 63.50 | 31.62 | 38.61 |
| D40CA-7-71C | 01576 | in | 1.255 | 4.500 | | 1.750 | 3.000 | 1.530 | 1.520 | |
| | | mm | 31.88 | 114.30 | | 44.45 | 76.20 | 38.86 | 38.61 | |
| D50DA-7-71C | 01726 | in | 1.483 | SGIH-32-3 to 32-9 | | 6.000 | 2.000 | 3.000 | 1.900 | 1.710 |
| | | mm | 37.67 | | | 152.40 | 50.80 | 76.20 | 48.26 | 43.43 |
| D60EA-7-71C | 01876 | in | 2.050 | | 7.000 | 2.250 | 3.500 | 2.207 | 1.980 | |
| | | mm | 52.07 | | 177.80 | 57.15 | 88.90 | 56.06 | 50.30 | |

Slot Grip Cut-Off Blades

Designed for use with standard cut-off inserts and standard cut-off blade holders. The insert's cutting edge location repeats accurately and as a result prevents insert splitting under heavy feed and shock loads. The blade and insert geometry allows free chip flow, minimizing insert breakage due to chip build-up.



Improved design featuring a "Positive Stop". Inserts are securely held in Slot Grip Positive Stop Blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is firmly in place.

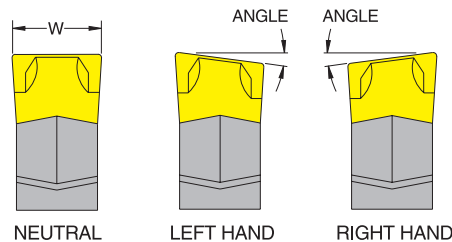
| Description | UPC No. 733101- | Insert Used | W | | D Max | | A | | L | | H | | H 1 | |
|-------------|-----------------|--------------|------|----|-------|-------|------|------|------|-------|------|------|------|------|
| | | | in | mm | in | mm | in | mm | in | mm | in | mm | in | mm |
| SGIH19-2 | 62950 | SGT(N/R/L)-2 | .087 | 2 | 1.57 | 39,9 | .063 | 1,57 | 3.38 | 85,9 | .618 | 15,7 | 0.75 | 19,1 |
| SGIH26-2 | 62951 | SGT(N/R/L)-2 | .087 | 2 | 2.00 | 50,8 | .063 | 1,57 | 4.33 | 110,0 | .842 | 21,4 | 1.02 | 25,9 |
| SGIH26-3 | 62952 | SGT(N/R/L)-3 | .122 | 3 | 3.00 | 76,2 | .094 | 2,39 | | | | | | |
| SGIH26-4 | 62953 | SGT(N/R/L)-4 | .161 | 4 | 3.15 | 80,0 | .125 | 3,18 | | | | | | |
| SGIH26-5 | 62954 | SGT(N/R/L)-5 | .201 | 5 | 3.15 | 80,0 | .156 | 3,96 | | | | | | |
| SGIH26-6 | 62955 | SGT(N/R/L)-6 | .252 | 6 | 3.15 | 80,0 | .203 | 5,16 | | | | | | |
| SGIH32-3 | 62956 | SGT(N/RL)-3 | .122 | 3 | 3.94 | 100,0 | .094 | 2,39 | 5.90 | 149,9 | .984 | 25,0 | 1.25 | 31,8 |
| SGIH32-4 | 62957 | SGT(N/R/L)-4 | .161 | 4 | 3.94 | 100,0 | .125 | 3,18 | | | | | | |
| SGIH32-5 | 62958 | SGT(N/R/L)-5 | .201 | 5 | 4.71 | 119,6 | .156 | 3,96 | | | | | | |
| SGIH32-6 | 62959 | SGT(N/R/L)-6 | .252 | 6 | 4.72 | 119,9 | .203 | 5,16 | | | | | | |
| SGIH32-8 | 62960 | SGT(N/R/L)-8 | .315 | 8 | 5.51 | 140,0 | .268 | 6,81 | | | | | | |
| SGIH32-9 | 62961 | SGT(N/R/L)-9 | .378 | 9 | 5.51 | 140,0 | .312 | 7,92 | | | | | | |

Cut-Off & Grooving Inserts

| Description | DASK25B First Choice for High Performance Machining | DC656 First Choice for General Turning Applications | Insert System | Lead Angle | Width ± .004 | |
|-------------|---|---|------------------|---------------|--------------|-----|
| | | | | | in | mm |
| SGTN-2 | 82223 | 82222 | 2 | 0° | .087 | 2mm |
| SGTR-2-8 | 82251 | 82250 | 2 | 8° | .087 | 2mm |
| SGTL-2-8 | 82279 | 82278 | 2 | 8° | .087 | 2mm |
| SGTN-3 | 82227 | 82226 | 3 | 0° | .122 | 3mm |
| SGTR-3-8 | 82255 | 82254 | 3 | 8° | .122 | 3mm |
| SGTL-3-8 | 82283 | 82282 | 3 | 8° | .122 | 3mm |
| SGTN-4 | 82231 | 82230 | 4 | 0° | .161 | 4mm |
| SGTR-4-8 | 82259 | 82258 | 4 | 8° | .161 | 4mm |
| SGTL-4-8 | 82287 | 82286 | 4 | 8° | .161 | 4mm |
| SGTN-5 | 82235 | 82234 | 5 | 0° | .201 | 5mm |
| SGTR-5-8 | 82263 | 82262 | 5 | 8° | .201 | 5mm |
| SGTL-5-8 | 82291 | 82290 | 5 | 8° | .201 | 5mm |
| SGTN-6 | 82239 | 82238 | 6 | 0° | .252 | 6mm |
| SGTR-6-8 | 82267 | 82266 | 6 | 8° | .252 | 6mm |
| SGTL-6-8 | 82295 | 82294 | 6 | 8° | .252 | 6mm |
| SGTN-8 | 82243 | 82242 | 8 | 0° | .315 | 8mm |
| SGTR-8-8 | 82271 | 82270 | 8 | 8° | .315 | 8mm |
| SGTL-8-8 | 82299 | 82298 | 8 | 8° | .315 | 8mm |
| SGTN-9 | 82247 | 82246 | 9 | 0° | .378 | 9mm |
| SGTR-9-8 | 82275 | 82274 | 9 | 8° | .378 | 9mm |
| SGTL-9-8 | 82303 | 82302 | 9 | 8° | .378 | 9mm |

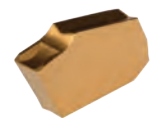
Chipbreaker Geometry

- Reduced machining force
- Controlled, coiled chip flow
- Higher material removal rate



Application

- Quickly inserted into cut-off blades
- For cut-off and grooving
- Fair for interrupted cuts



DASK25B -

(C2-C3 Substrate with PVD TiN-TiAlN-TiN coating)

First Choice for High Performance Machining of all carbon and alloy steels, non-ferrous metals, aerospace titanium alloys, inconel, austenitic stainless steels, cast iron, copper/brass, with medium to high sfm, in dry or wet conditions. PVD TiN-TiAlN-TiN multi layer with micro dense coating structure builds a strong and tough cutting edge, dissipates heat, reduces thermal cracking and improves wear resistance and insert life. Maximum working temperature is 1650°F. Best used on CNC Lathes.

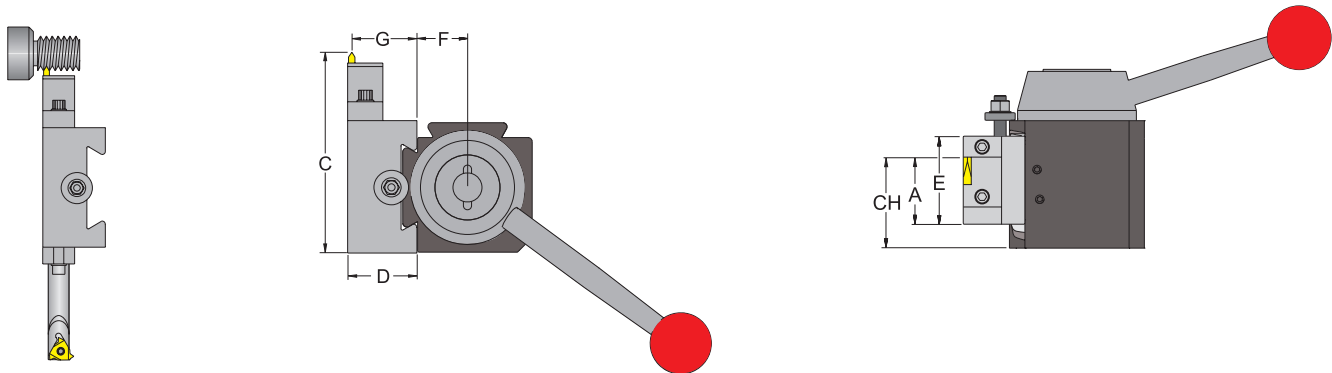
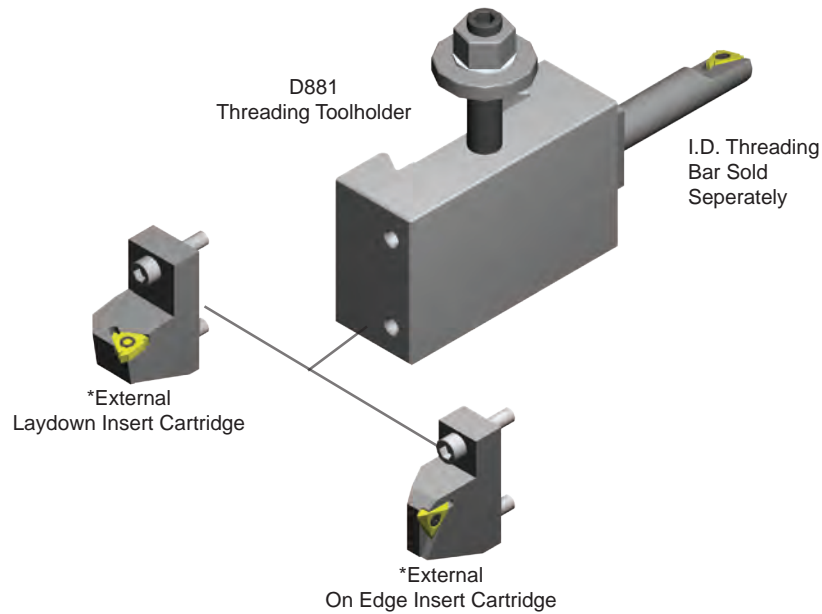
DC656 -

(C5-C6 Substrate with CVD TiN/TiC-TiN coating)

First Choice for general turning applications on ferrous metals and 400 series stainless steels, at medium cutting sfm and wet conditions. Multi Layer CVD carbide grade. Thermal deformation and abrasion resistant substrate with cobalt enriched periphery.

No. D881 O.D. and I.D. Threading Toolholder

This holder is capable of covering all threading requirements. It uses standard carbide inserts. The holder is supplied with a cartridge for external threading. Fits industry standard tool posts.

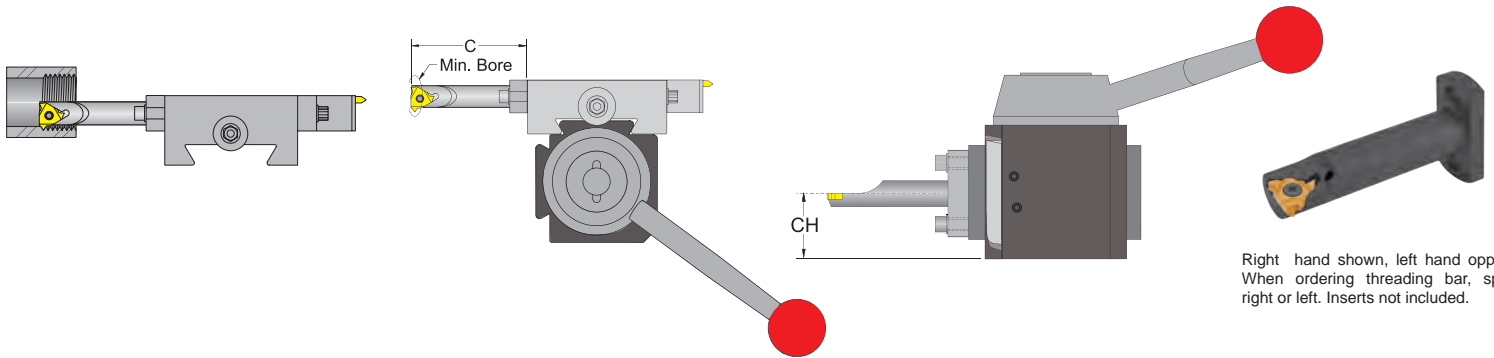


| Description | UPC No. 733101- | System | A | C | D | E | F | G | *External On Edge Insert Cartridge | | | | *External Laydown Insert Cartridge | | | | | | | |
|---------------|--------------------|--------|-------|--------|-------|-------|-------|-------|------------------------------------|--------------------|----------------|---------------|------------------------------------|----------|--------------------|-----------|---------------|-------------|-------|---------|
| | | | | | | | | | Desc. | UPC No. 733101- | TNMC Insert | Torx Screw | Torx Key | Desc. | UPC No. 733101- | Insert | Torx Screw | Torx Key | Pitch | |
| | | | | | | | | | | | | | | | | | | | TPI | mm |
| D25AXA-881-OE | 01132 | in | 0.875 | 3.869 | 1.000 | 1.500 | 0.880 | 1.000 | TIH253-32 | 03621 | 32 | GTS-1M | T-10 | NL253-3R | 03635 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 22.23 | 98.27 | 25.40 | 38.10 | 22.35 | 25.40 | | | | | | | | | | | | |
| D30BXA-881-OE | 01282 | in | 1.000 | 4.369 | 1.250 | 1.750 | 1.115 | 1.250 | TIH354-32 | 03623 | 32 | GTS-1M | T-10 | NL354-3R | 03637 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 25.40 | 110.97 | 31.75 | 44.45 | 28.32 | 31.75 | | | | | | | | | | | | |
| D35CXA-881-OE | 01434 | in | 1.250 | 5.119 | 1.500 | 2.000 | 1.199 | 1.435 | TIH354-32 | 03623 | 32 | GTS-1M | T-10 | NL354-3R | 03637 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 31.75 | 130.02 | 38.10 | 50.80 | 30.45 | 36.45 | | | | | | | | | | | | |
| D40CA-881-OE | 01582 | in | 1.500 | 5.619 | 1.500 | 2.250 | 1.530 | 1.435 | TIH354-32 | 03623 | 32 | GTS-1M | T-10 | NL354-3R | 03637 | 16ER-AG60 | TS-16 | T-10 | 8-48 | 0,5-3,5 |
| | | mm | 38.10 | 142.72 | 38.10 | 57.15 | 38.86 | 36.45 | | | | | | | | | | | | |

* Holder is supplied standard with External On Edge Insert Cartridge. The External Laydown Insert Cartridge is sold separately. Internal threading bar sold separately. Inserts not included.

Internal Threading Bar For D881 Toolholder

This cartridge is to be used on the #881 holder. It is used for internal threading with a laydown insert. It can be mounted on either end of the base holder.



Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

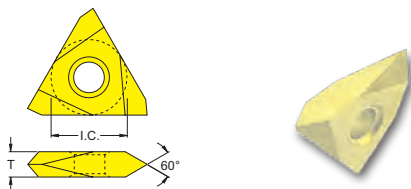
| Series | Right Hand | | | Min. Bore in mm | C | | Pitch | | Insert I.C. | Torx Screw | Torx Key | |
|-------------|------------|-------------|-----------|--------------------|------|-------|-------|-------|-------------|------------|--------------|------|
| | Desc. | No. 733101- | Insert | | in | mm | TPI | mm | | | | |
| 25,30,35,40 | NL50R | 03661 | 11IR-A60 | 0.500 | 12,7 | 2.375 | 60,3 | 16-48 | 0,5-1,5 | .250 | TS-25.45-6M1 | T-8 |
| 25,30,35,40 | NL75R | 03663 | 16IR-AG60 | 0.750 | 19,1 | 2.875 | 73,0 | 8-48 | 0,5-3,0 | .375 | TS-16 | T-10 |
| 35,40 | NL125R | 03665 | 22IR-N60 | 1.250 | 31,8 | 3.375 | 3.375 | 5-7 | 3,5-5,0 | .500 | TS-22 | T-20 |

Laydown Threading Insert 60° Partial Profile



| Internal Right Hand | DVP656 Grade For Steel | | DVK10 Grade For Stainless Steel, Cast Iron & Aluminum | | Internal Left Hand | DVP656 Grade For Steel | | DVK10 Grade For Stainless Steel, Cast Iron & Aluminum | | L mm | I.C. in | Pitch | | x mm | y mm |
|---------------------|------------------------|-----------------|---|-----------------|--------------------|------------------------|-----------------|---|----------|------|---------|-------|-----|------|------|
| | UPC No. 733101- | UPC No. 733101- | UPC No. 733101- | UPC No. 733101- | | UPC No. 733101- | UPC No. 733101- | TPI | mm | | | | | | |
| 11IR-A60 | 74056 | 74057 | 11IL-A60 | 74060 | 74061 | 11 | .250 | 16-48 | 0,5-1,5 | 0,8 | 0,9 | 1,2 | 1,7 | | |
| 16IR-A60 | 74064 | 74065 | 16IL-A60 | 74068 | 74069 | 16 | .375 | 16-48 | 0,5-1,5 | | | | | | |
| 16IR-G60 | 74072 | 74073 | 16IL-G60 | 74076 | 74077 | 16 | .375 | 8-14 | 1,75-3,0 | 1,7 | | | | | |
| 16IR-AG60 | 74080 | 74081 | 16IL-AG60 | 74084 | 74085 | 16 | .375 | 8-48 | 0,5-3,0 | | | | | | |
| 22IR-N60 | 74088 | 74089 | 22IL-N60 | 74092 | 74093 | 22 | .500 | 5-7 | 3,5-5,0 | 1,7 | 2,5 | | | | |

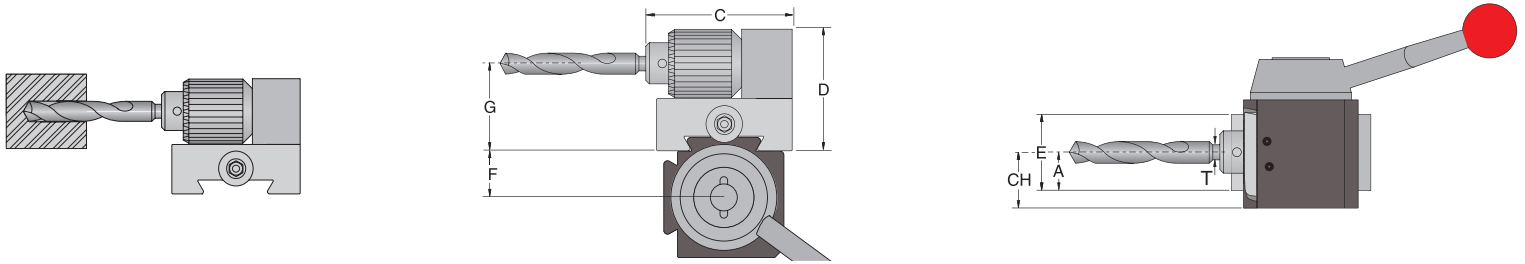
On Edge TNMC 60° Negative Rake Threading Insert



| Desc. | DVP656 Grade For Steel UPC No. 733101- | DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No. 733101- | I.C. | | Thickness | | Hole Dia. | | Depth. | |
|------------|---|--|------|-----|-----------|------|-----------|------|--------|------|
| | | | in | mm | in | mm | in | mm | in | mm |
| TNMC-32NV- | 72003 | 72004 | .375 | 9,5 | .1250 | 3,18 | .150 | 3,81 | .150 | 3,81 |

No. D35 Drill Chuck Toolholder

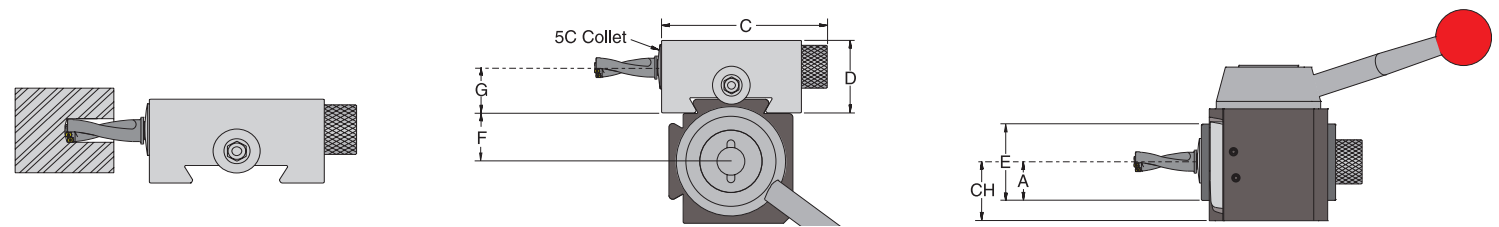
This holder is best used for holding drills, reamers, taps, etc., without tailstock mounting. It uses a drill chuck mounted directly to a quick change holder. This holder is supplied with a drill-chuck. Fits industry standard tool posts.



| Description | UPC No. 733101- | System | A | T Capacity | C | D | E | F | G |
|-------------|-----------------|--------|-------|------------|--------|-------|-------|-------|-------|
| D25AXA-35 | 01140 | in | 1.000 | 0 - .500 | 4.175 | 3.101 | 2.000 | 0.880 | 2.063 |
| | | mm | 25.40 | 0 - 12.0 | 106.05 | 78.77 | 50.80 | 22.35 | 52.40 |
| D30BXA-35 | 01290 | in | 1.000 | 0 - .500 | 4.175 | 3.101 | 2.000 | 1.115 | 2.063 |
| | | mm | 25.40 | 0 - 12.0 | 106.05 | 78.77 | 50.80 | 28.32 | 52.40 |
| D35CXA-35 | 01442 | in | 1.125 | 0 - .500 | 4.673 | 3.726 | 2.250 | 1.199 | 2.625 |
| | | mm | 28.58 | 0 - 12.0 | 118.69 | 94.64 | 57.15 | 30.45 | 66.68 |
| D40CA-35 | 01590 | in | 1.125 | 0 - .500 | 4.673 | 3.726 | 2.250 | 1.530 | 2.625 |
| | | mm | 28.60 | 0 - 12.0 | 118.70 | 94.60 | 57.20 | 38.90 | 66.70 |

No. D36 5C Collet Toolholder

This holder's wide range of collet adaptability makes this tool ideal for holding drills, taps, chucks & boring bars. It holds the tools with extreme rigidity without scarring them. Fits industry standard tool posts.



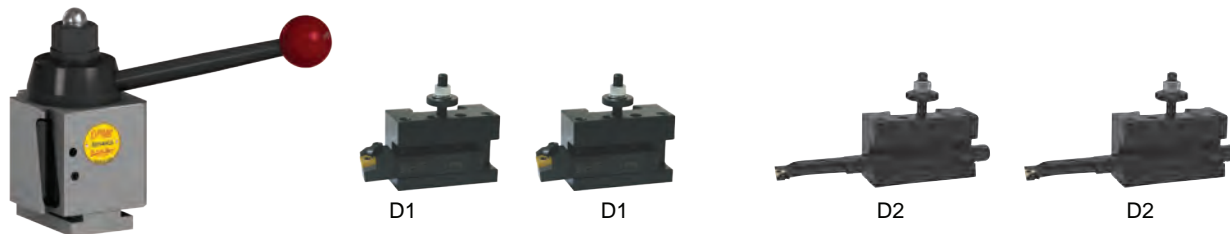
| Description | UPC No. 733101- | System | A | C | D | E | F | G |
|-------------|-----------------|--------|-------|--------|-------|-------|-------|-------|
| D25AXA-36 | 01142 | in | 1.125 | 4.250 | 2.500 | 2.250 | 0.880 | 1.500 |
| | | mm | 28.58 | 107.95 | 63.50 | 57.15 | 22.35 | 38.10 |
| D30BXA-36 | 01292 | in | 1.250 | 4.250 | 2.500 | 2.250 | 1.115 | 1.500 |
| | | mm | 28.58 | 107.95 | 63.50 | 57.15 | 28.32 | 38.10 |
| D35CXA-36 | 01444 | in | 1.375 | 4.500 | 2.750 | 2.750 | 1.199 | 1.625 |
| | | mm | 34.93 | 114.30 | 69.85 | 69.85 | 30.45 | 41.28 |
| D40CA-36 | 01592 | in | 1.375 | 5.000 | 2.750 | 2.750 | 1.530 | 1.625 |
| | | mm | 34.93 | 127.00 | 69.85 | 69.85 | 38.86 | 41.28 |

SUPER Quick Change Turning Sets

Turning Set Includes

- (1) Tool Post
- (4) Holders

Tooling Not Included



| | | | | | | |
|-----------------|-------------|-------------|-------------|------------|------------|------------|
| UPC No. 733101- | 01014 | 01015 | 01016 | 01017 | 01018 | 01019 |
| Description | SDN25AXA-TS | SDN30BXA-TS | SDN35CXA-TS | SDN40CA-TS | SDN50DA-TS | SDN60EA-TS |
| Lathe Swing | Up to 12" | 13" to 15" | 14" to 17" | 16" to 20" | 17" to 32" | ≥ 25" |

Set Includes

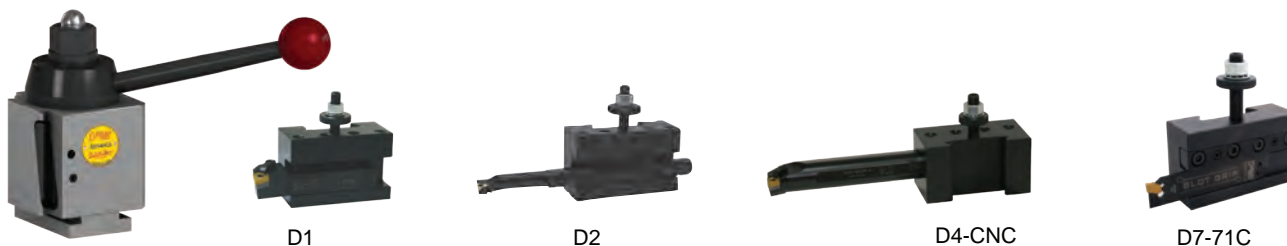
| | | | | | | |
|---------------|------------------------------|------------------------------|------------------------------|----------------------------|----------------------------|----------------------------|
| (1) Tool Post | SDN25AXA | SDN30BXA | SDN35CXA | SDN40CA | SDN50DA | SDN60EA |
| (4) Holders | (2) D25AXA-1 (2) D25AXA-2 | (2) D30BXA-1 (2) D30BXA-2 | (2) D35CXA-1 (2) D35CXA-2 | (2) D40CA-1 (2) D40CA-2 | (2) D50DA-1 (2) D50DA-2 | (2) D60EA-1 (2) D60EA-2 |

SUPER Quick Change Standard Sets

Standard Set Includes

- (1) Tool Post
- (4) Holders

Tooling Not Included



| | | | | | | |
|-----------------|---------------|---------------|---------------|--------------|--------------|--------------|
| UPC No. 733101- | 01020 | 01021 | 01022 | 01023 | 01024 | 01025 |
| Desc. | SDN25AXA-INSS | SDN30BXA-INSS | SDN35CXA-INSS | SDN40CA-INSS | SDN50DA-INSS | SDN60EA-INSS |
| Lathe Swing | Up to 12" | 13" to 15" | 14" to 17" | 16" to 20" | 17" to 32" | ≥ 25" |

Set Includes

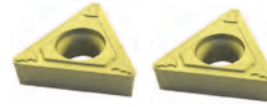
| | | | | | | |
|---------------|--|--|--|--|--|--|
| (1) Tool Post | SDN25AXA | SDN30BXA | SDN35CXA | SDN40CA | SDN50DA | SDN60EA |
| (4) Holders | (1) D25AXA-1 (1) D25AXA-2 (1) D25AXA-4-CNC (1) D25AXA-7-71C | (1) D30BXA-1 (1) D30BXA-2 (1) D30BXA-4-CNC (1) D30BXA-7-71C | (1) D35CXA-1 (1) D35CXA-2 (1) D35CXA-4-CNC (1) D35CXA-7-71C | (1) D40CA-1 (1) D40CA-2 (1) D40CA-4-CNC (1) D40CA-7-71C | (1) D50DA-1 (1) D50DA-2 (1) D50DA-4-CNC (1) D50DA-7-71C | (1) D60EA-1 (1) D60EA-2 (1) D60EA-4-CNC (1) D60EA-7-71C |

SUPER Quick Change Tool Post First Time Buyer Set

SUPER Quick Change First Time Buyer SET Includes FREE TOOLING

Set Includes:

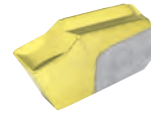
- (1) Tool Post
- (4) Holders
- (4) Toolholders **FREE**
- (5) Inserts **FREE**



1ea. D1 + Free Toolholder & 2 Free TCMT Turning Inserts



1ea. D2 + Free Toolholder & 1 Free 11/16IR-A60 Laydown Inserts



1ea. D7-71C + Free Toolholder & 1 Free SGTN Cut-off Inserts



1ea. D881 + Free Toolholder & 1 Free TNMC OnEdge Inserts

| UPC No. 733101- | 01056 | 01058 | 01060 | 01062 |
|---------------------|----------------------|----------------------|----------------------|----------------------|
| Description | SDN25AXA-FTB | SDN30BXA-FTB | SDN35CXA-FTB | SDN40CA-FTB |
| Lathe Swing | Up to 12" | 13" to 15" | 14" to 17" | 16" to 20" |
| Set Includes | | | | |
| (1) Tool Post | SDN25AXA | SDN30BXA | SDN35CXA | SDN40CA |
| (4) Holders | D25AXA-1 | D30BXA-1 | D35CXA-1 | D40CA-1 |
| | D25AXA-2 | D30BXA-2 | D35CXA-2 | D40CA-2 |
| | D25AXA-7-71C | D30BXA-7-71C | D35CXA-7-71C | D40CA-7-71C |
| | D25AXA-881-OE | D30BXA-881-OE | D35CXA-881-OE | D40CA-881-OE |
| Free Tooling | | | | |
| (4) Toolholders | STNCR08-2J | STNCR10-2A | STNCR12-3B | STNCR64-3D |
| | STCMB06-2 | STCMB08-2 | STCMB10-2 | STCMB12-3 |
| | SGIH19-2 | SGIH19-2 | SGIH26-3 | SGIH26-3 |
| | NL50R | NL50R | NL75R | NL75R |
| (5) Inserts | TCMT-21.51-UM-DHCP25 | TCMT-21.51-UM-DHCP25 | TCMT-21.51-UM-DHCP25 | TCMT-32.51-UM-DHCP25 |
| | TCMT-21.52-UM-DHCP25 | TCMT-21.52-UM-DHCP25 | TCMT-32.52-UM-DHCP25 | TCMT-32.52-UM-DHCP25 |
| | SGTN-2-DC656 | SGTN-2-DC656 | SGTN-3-DC656 | SGTN-3-DC656 |
| | TNMC-32NV-DVP656 | TNMC-32NV-DVP656 | TNMC-32NV-DVP656 | TNMC-32NV-DVP656 |
| | 11IR-A60-DVP656 | 11IR-A60-DVP656 | 16IR-A60-DVP656 | 16IR-A60-DVP656 |