Tool Post & Tool Holders

Section B of 2017 Machine Tool Accessories Catalog

Tool Post and Toolholders For CNC and Manual Lathes

Technical Support

Manual Lathe Terminology
CNC Toolroom Lathe Terminology
Turning and Boring Applications
Tool Post Tolerance and Crossover
Tool Post Mounting Data Form
Quadra® Indexing Quick Change Tool Post Locking and Indexing System
Quadra® Indexing Quick Change Tool Post Mounting, Set-Up and Function Data
Quadra® Indexing Quick Change Tool Post Applications
Triple Action Wedge Style Locking System
SUPER Quick Change Tool Post Mounting, Set-Up and Function Data
SUPER Quick Change Tool Post System
Victory™ Automatic Thru-Coolant Quick Change Tool Post Mounting
Victory™ Automatic Thru-Coolant Quick Change Tool Post System
Victory™ CNC Quick Change Gang Tool Installation and Set up

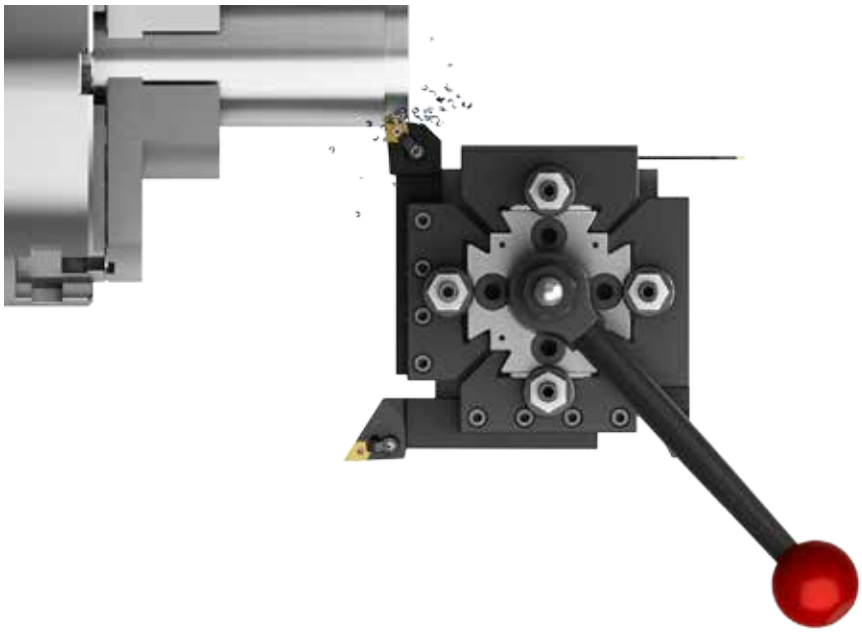
Quadra® Indexing Quick Change Tool Post & Toolholders

Graphic Index
Quadra® Indexing Quick Change Tool Post Specifications
Quadra® Indexing Quick Change Toolholders Specifications
Quadra® Indexing Quick Change Tool Post & Toolholders SETS

SUPER Quick Change Tool Post & Toolholders

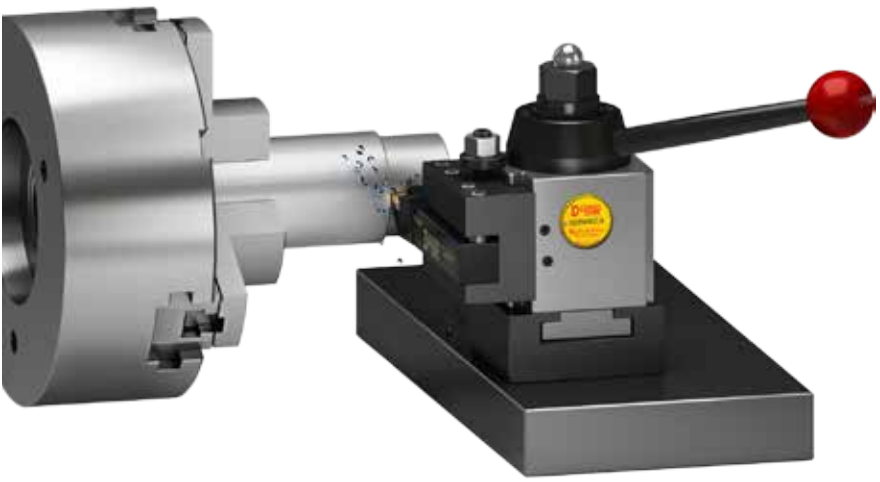
Graphic Index
SUPER Quick Change Tool Post Specifications
SUPER Quick Change Toolholders Specifications
SUPER Quick Change Tool Post & Toolholders SETS

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

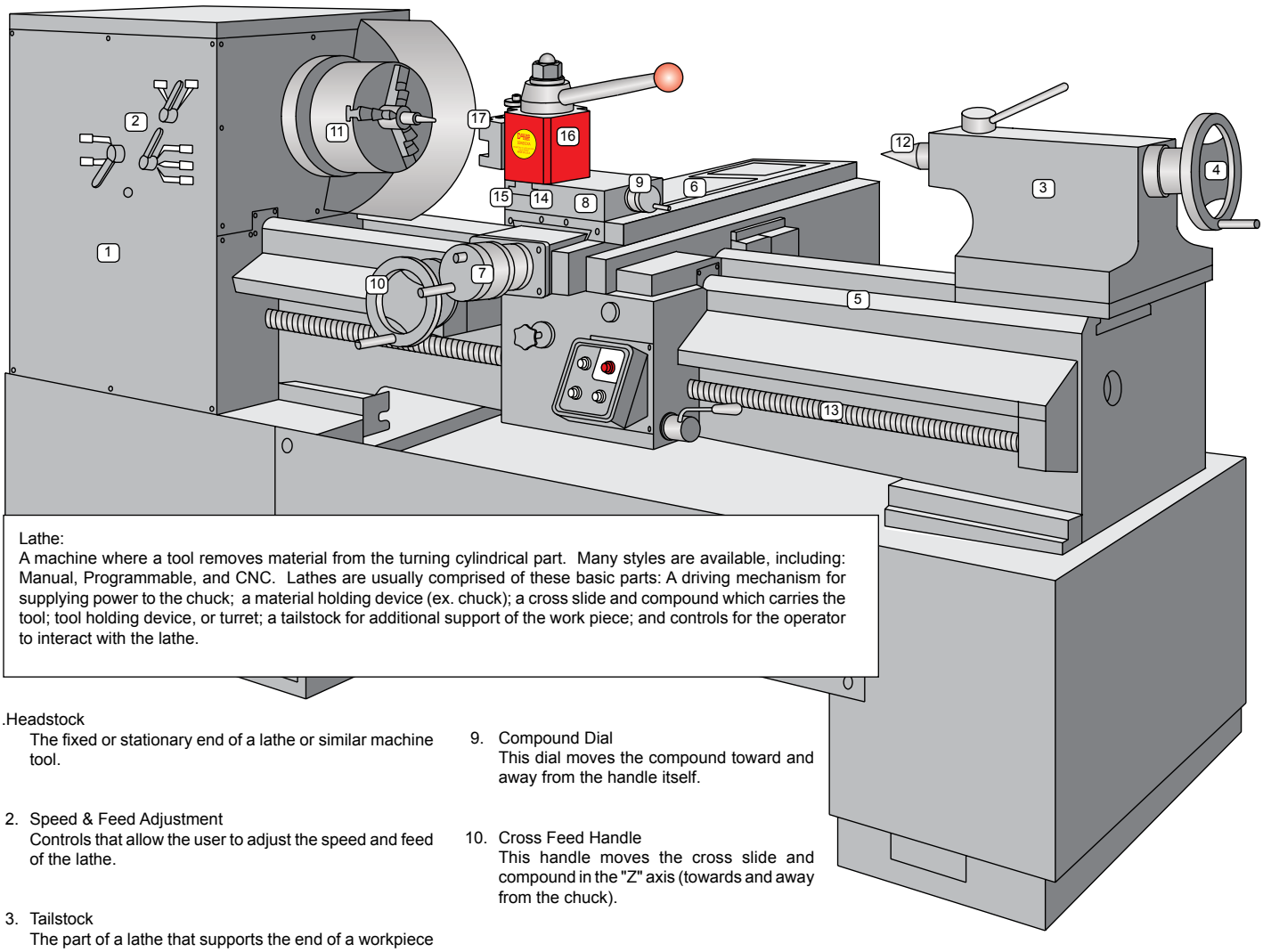


- Heavy duty construction
- Heat-treated alloy steel body
- Precision ground
- Four quick change tool holders locked independently
- Industry Standard holders
- Positive lock with absolute zero backlash
- One to four tools ready to be used
- Precise tool repeatability of .00005" / ,00127 mm
- Cam-Lock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

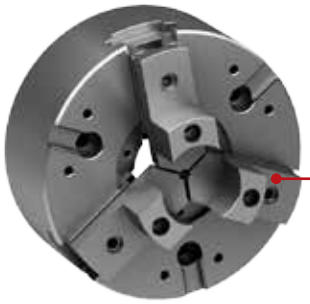
20. Shank System
The diameter of a round cutting tool or the height of a square shank cutting tool.

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.

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

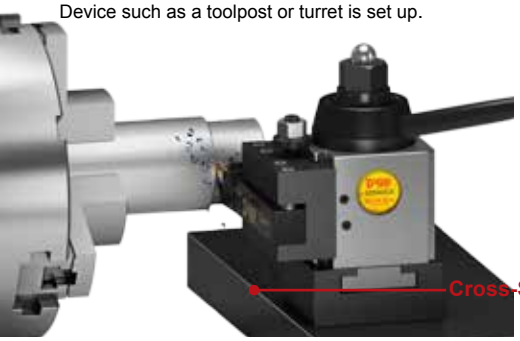
Chuck Guard: Protects the operator from chips and coolant.

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

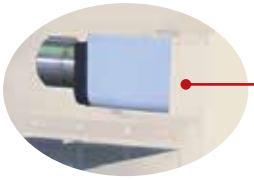
Manual Handle: To operates the machine manually.

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

Live Center

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

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.

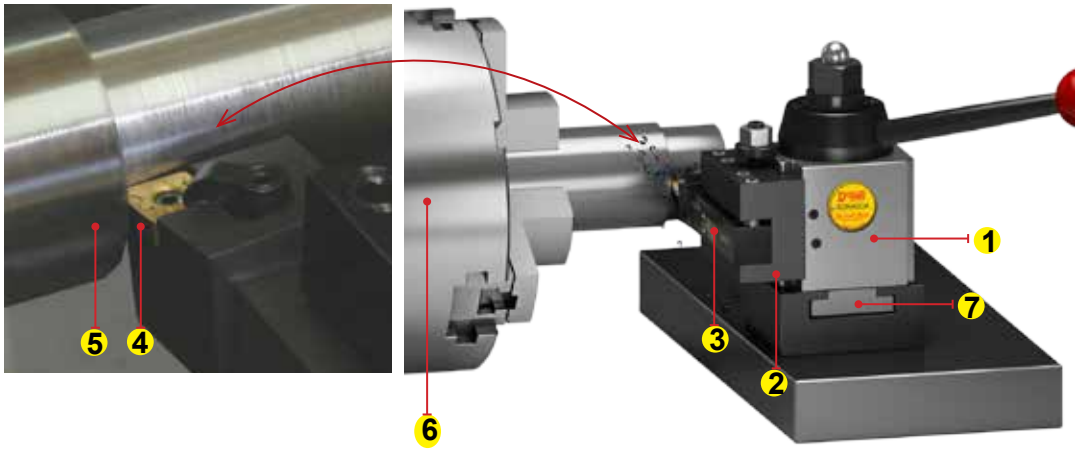


Tail Stock

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

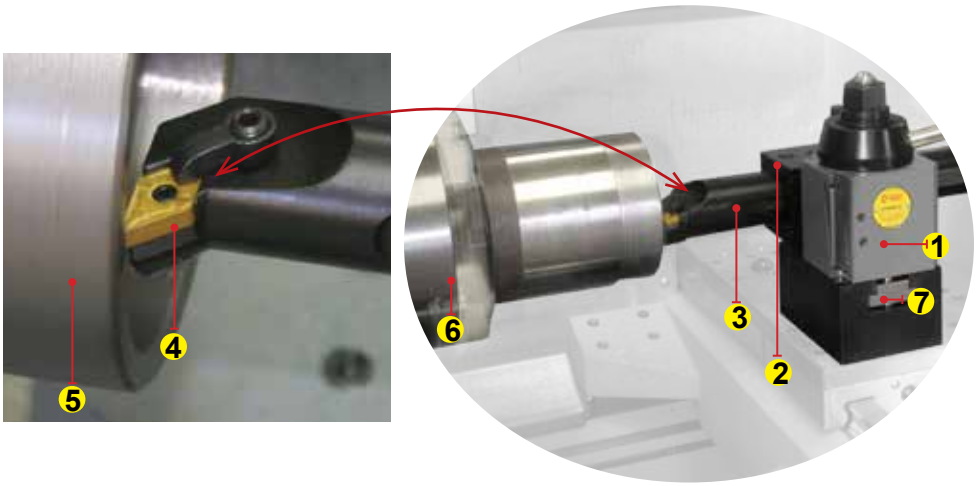
Turning Application with a Manual or CNC Toolroom Lathe

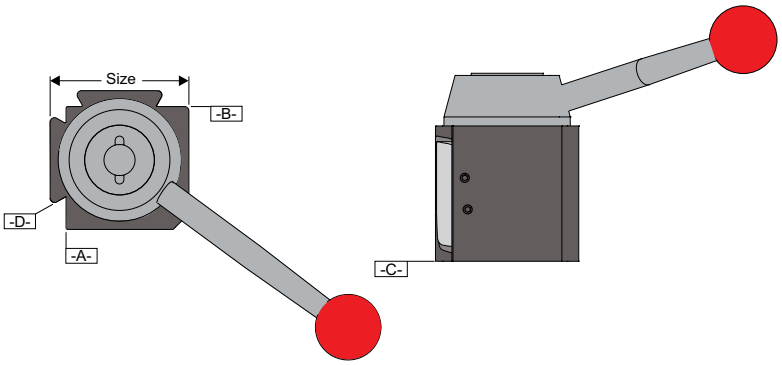
1. Quick Change Tool Post
2. Quick Change Turning and Facing Toolholder
3. Square Shank Toolholder
4. Insert
5. Workpiece
6. Chuck
7. Custom T-Nut

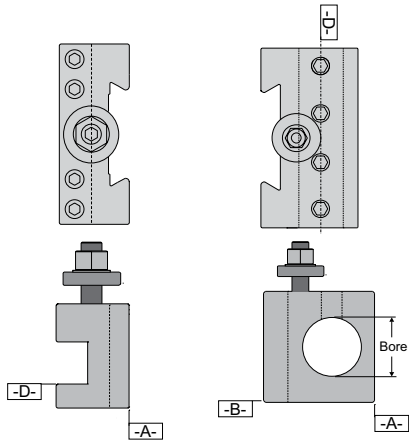


Boring Application with a Manual or CNC Toolroom Lathe

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





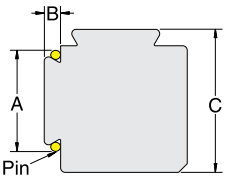


Tool Post Series	System (Square) in.	mm
25	2.5	66
30	3.0	76
35	3.5	89
40	4.0	102
50	5.0	127
60	6.0	152
Tolerance (* Per Inches)		
Quick Change Repeatability	± .0001	± 0,00254
Face to Face Squareness A-B*	± .0001	± 0,00254
Bottom to Face Squareness A-C*	± .0001	± 0,00254
Bottom to Dovetail Squareness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

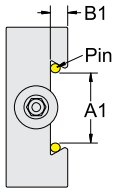
Holder Tolerance (* Per Inches)		in.	mm
Quick Change Repeatability		± .0001	± 0,00254
Face to Face Squareness		± .0005	± 0,0127
Bottom to Face Squareness		± .0005	± 0,0127
Bottom to Dovetail Squareness		± .0005	± 0,0127
Square Shank Holder Tolerance (* Per Inches)			
Tool Slot Taper	D	± .0001	± 0,00254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

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						

Tool Post Dovetail

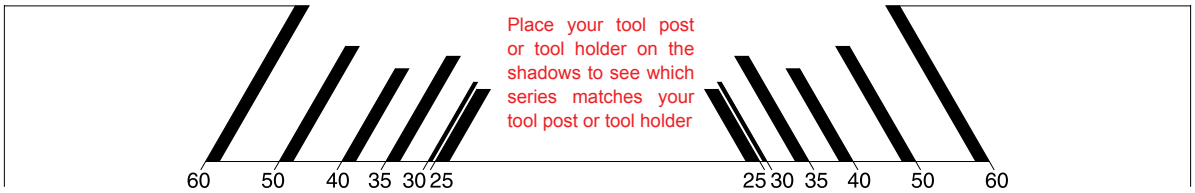


Toolholder Dovetail



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.

Place Tool Post On This Side



Place Toolholder On This Side

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 #_____

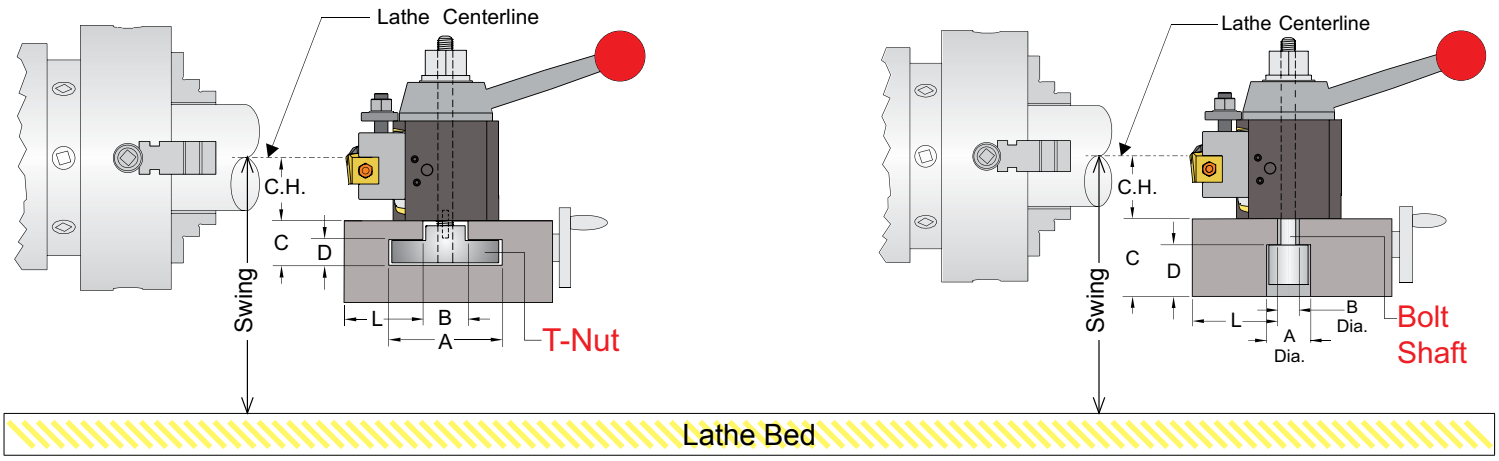
Company_____ Phone ( ) _____

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)** ☐

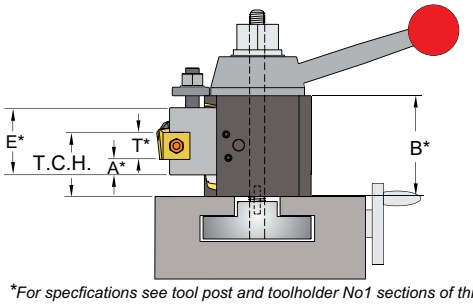


Make & Model of Lathe	Lathe Swing Over Bed		CH		Tool Size		A		B		C		D		L	
System	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm

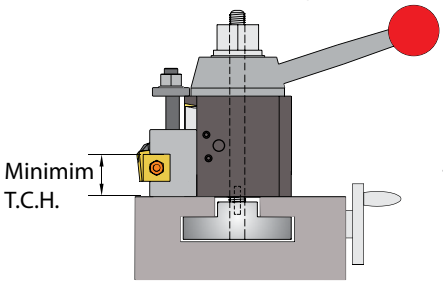
Tool Post recommendation will be based on the accuracy of the information provided by the customer. Each Tool Post is supplied with a Blank T-Nut or Bolt Shaft that the customer machines to their required dimensions. For custom machined T-Nut or Bolt Shaft, please specify the dimensions A, B, C, and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

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

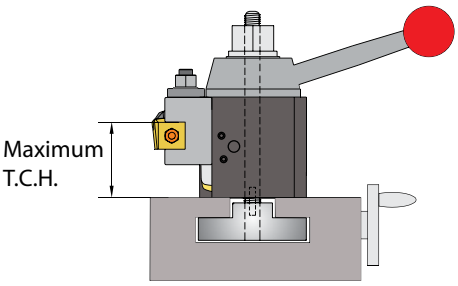
"CH" = Center Height is measured from top of compound to lathe center line
"A" = Toolholder bottom lip
"T" = Shank System
"T.C.H." = Tool Center Height



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



Minimim T.C.H. = A + T



Maximum T.C.H. = (B - E) + (A +T)

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

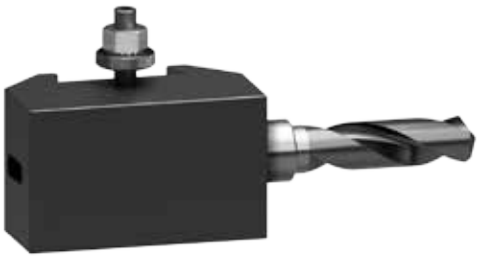
Tool Post & Toolholders

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 	• 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 • Tight Tolerances and Excellent Finish Requiring Applications • Deep Drilling and Boring • Heavy Material Removal • Multi Turning, Drilling, Boring, Threading Applications
No. QITPN-1 Turning & Facing Holder 	• 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 	• 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-DQ41S DUAL **Heavy Duty Boring Bar Holder** 	• 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

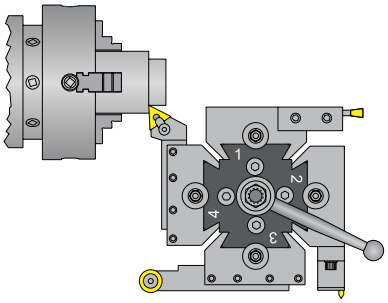
Style	Features	Application
No. QITPN-5 Morse Taper Holder 	• Precision Ground Morse Taper • Qualified for Precise Tool Alignment and Squareness • Designed for Deep Drilling • Heavy Duty Drilling • Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel • Hardened & Black Finished • 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-7-71C Reversible Cut-Off Blade Holder 	• 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-36 5C Collet Holder 	• 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 Aplications • Boring Applications • Reaming Applications • Tapping • From 1/16” to 1.0” Diameter Tools
No. QITPN-881 O.D. or I.D. Threading Holder 	• 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

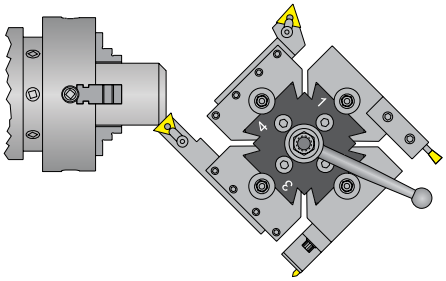
24 Super Precise Positioning Ball Bearings
& Pre-Loaded Indexing Pins

Strong - Rigid - Precise!

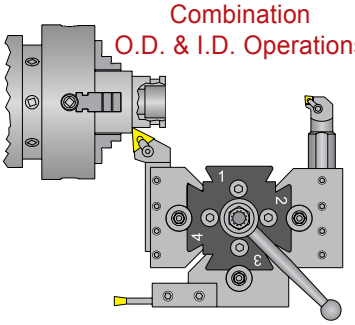
O.D. Turning Operations



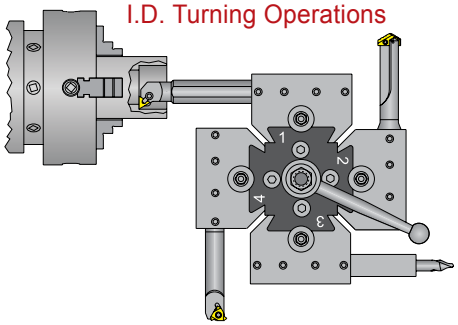
O.D. Chamfering Operations
15° Increments

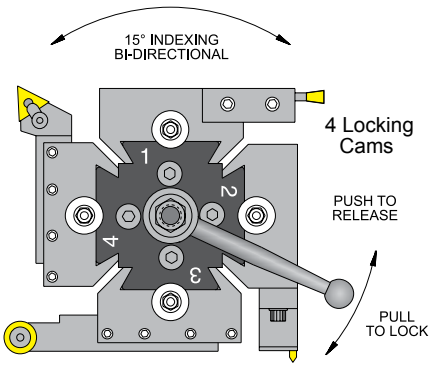


Combination
O.D. & I.D. Operations



I.D. Turning Operations



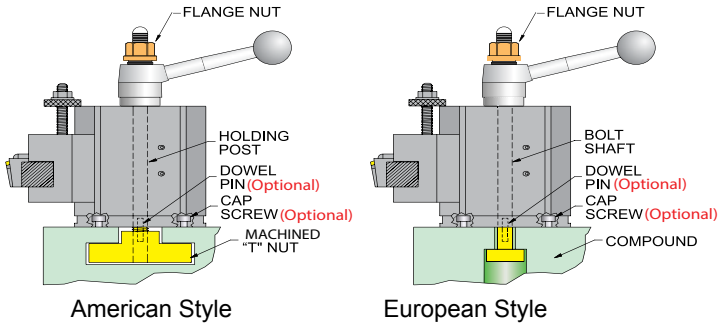


Easy To Operate: Push the handle away to release the indexing mechanism, rotate tool post to desired position and then pull the handle to lock the indexing mechanism.

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

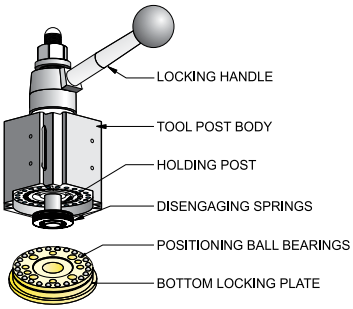


American Style European Style

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

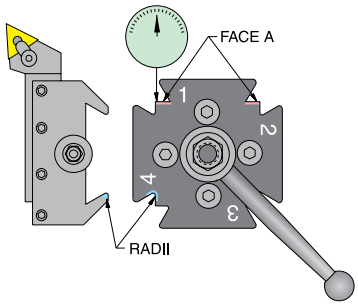
Repeatability within .00005"



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

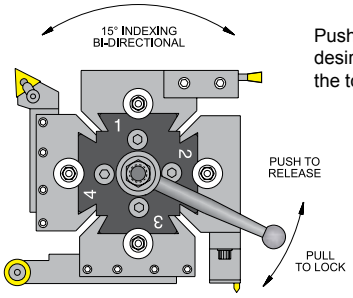
Squareness within .0005"



The four dovetails are machined at 90° square (± .0005"). When mounting, it is necessary that the Face "A" to 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

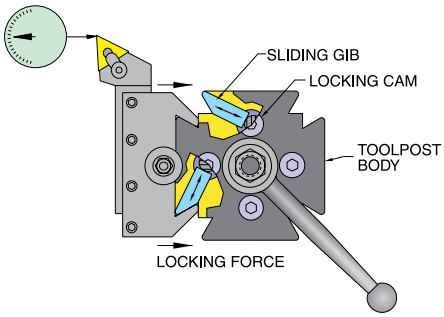
Index from Tool to Tool in Seconds



Push the handle to release , index into the desired position, then pull the handle to lock the tool post.

Holder Locking System

20,000 lbs Locking Force

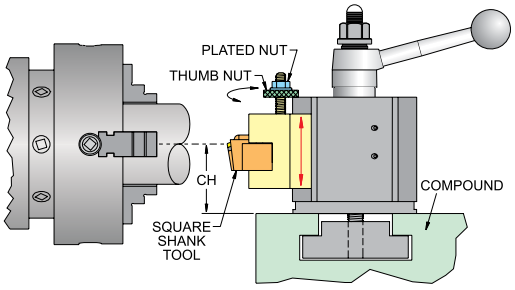


The holder locking system of the Quadra Indexing Tool Post is based on the four Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam style Locking Pin, locking it positively. The cam rotates from 0° (Release Position) to approximately 45° (Locking Position).

The repeatability of the tool holders is ± .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



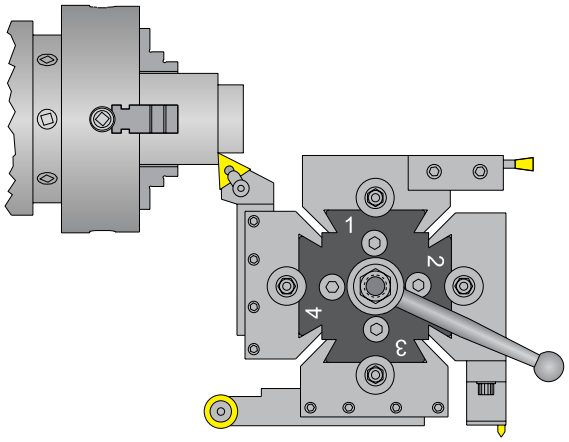
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool height, first, by screwing or unscrewing the Thumb Nut until the desired height is reached, and next, by locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder 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

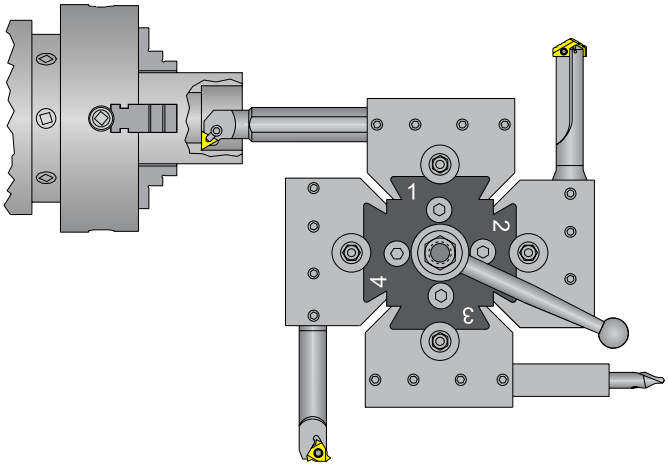
Finishing to Roughing or Threading



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

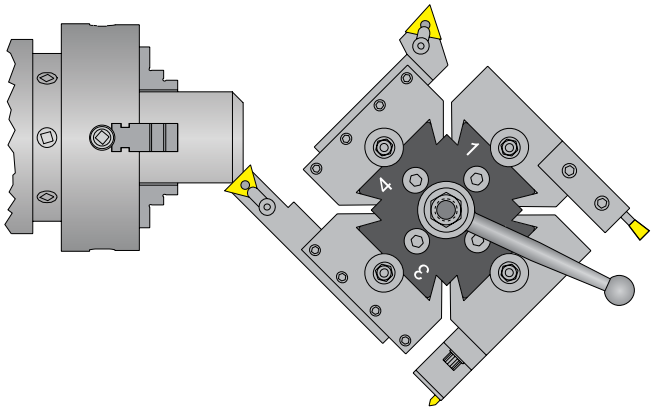
Finishing to Roughing or Threading



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

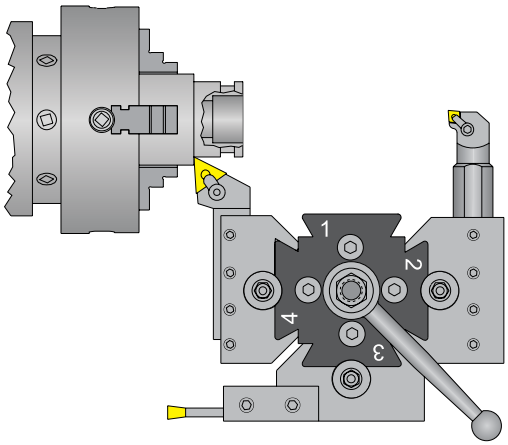
15º Increments



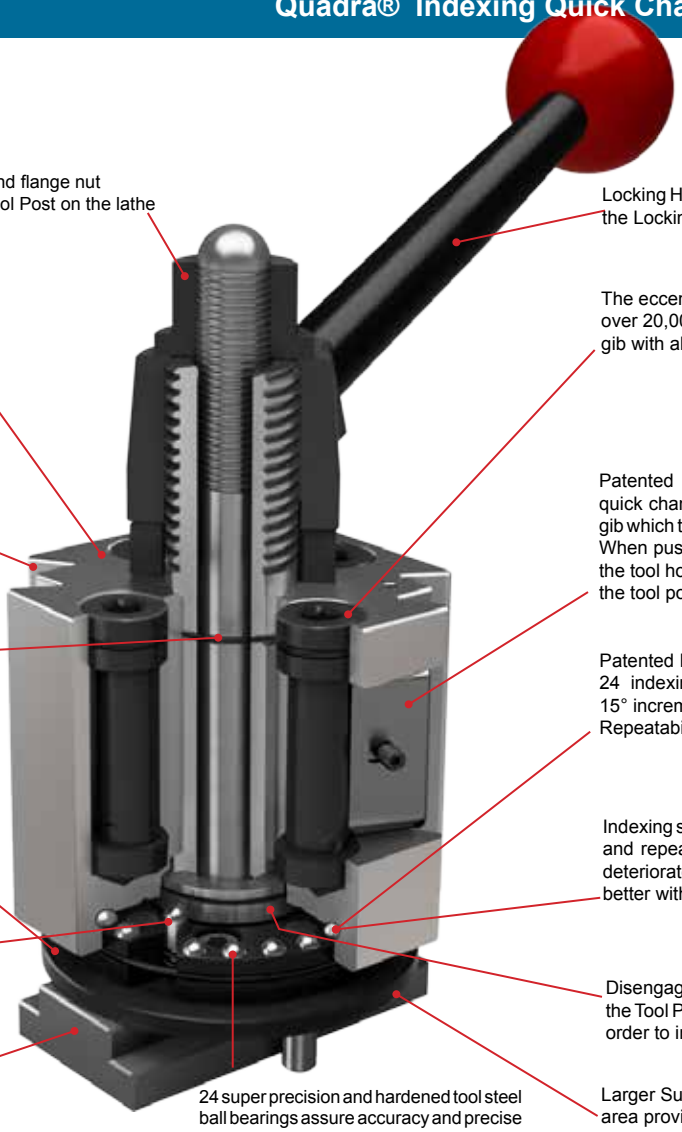
The tool post can be indexed every 15°. This will allow the user to rotate a tool into chamfering position. One tool could then be used for O.D. turning and chamfering, reducing the number of tools to complete a job.

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.



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

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.

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

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

The eccentric tool holder locking pin (cam) excercises 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.

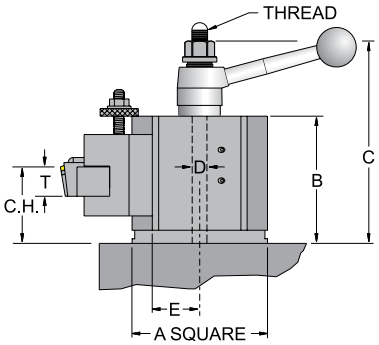
Patented Indexing System:
24 indexing positions
15° increments
Repeatability within .00005"

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.

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

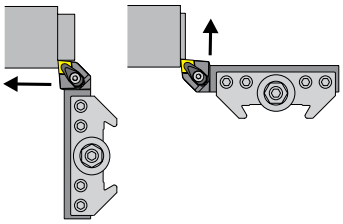
- 24 Locking Positions, every 15º
- Ideal for Manual & CNC Lathes
- Super Precise for Tight Tolerance Machining
- Heavy Duty For Oil Field Applications

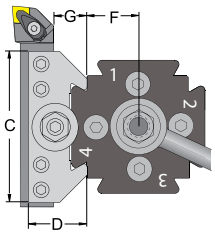
Description	QITP25N		QITP30N		QITP35N		QITP40N		QITP50N		QITP60N	
UPC No. 733101-	00000		00002		00004		00006		00008		00010	
System	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
Lathe Swing Over Bed	≤12"	≤300,0	13-15"	320,0	14-17"	400,0	16-20"	450,0	17-32"	500,0	≥25-XHD	XHD
A	2.500	63.5	3.000	76.2	3.500	88.9	4.000	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	1⅛-12	M27x3,0

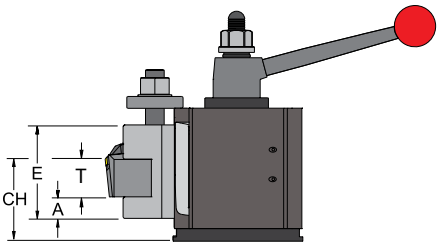
*Optimum center height is calculated with the smaller tool System of the tool capacity.

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.



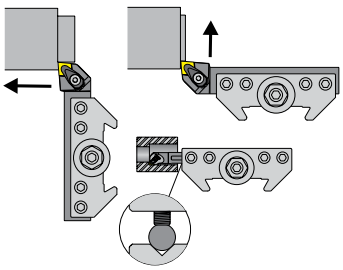


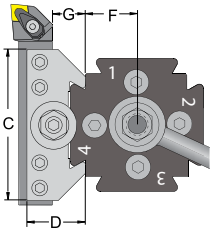


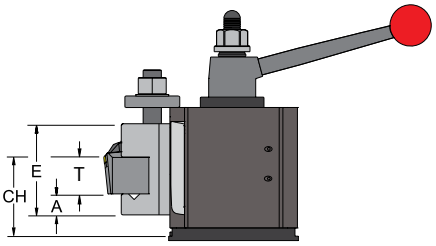
Description	UPC No.733101-	System	A	T	C	D	E	F	G
QITP25N-1	00100	in	0.375	0.750	2.750	1.240	1.740	0.880	0.770
		mm	10	20	70	32	44	22	20
QITP30N-1	00250	in	0.437	1.000	3.250	1.490	2.240	1.115	0.890
		mm	11	25	83	38	57	28	23
QITP35N-1	00400	in	0.500	1.000	3.750	1.740	2.490	1.245	1.010
		mm	13	25	95	44	63	32	26
QITP40N-1	00550	in	0.562	1.250	4.500	1.990	2.990	1.530	1.040
		mm	14	32	114	51	76	39	26
QITP50N-1	00700	in	0.750	1.500	6.000	2.490	3.490	1.900	1.290
		mm	19	40	152	63	89	48	33
QITP60N-1	00850	in	1.000	1.500	7.000	2.990	3.990	2.207	1.540
		mm	25	40	178	76	101	56	40

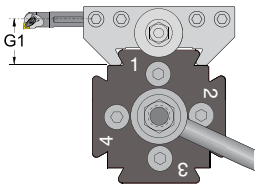
No. QITPN-2 Turning, Facing & Boring Toolholder

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.









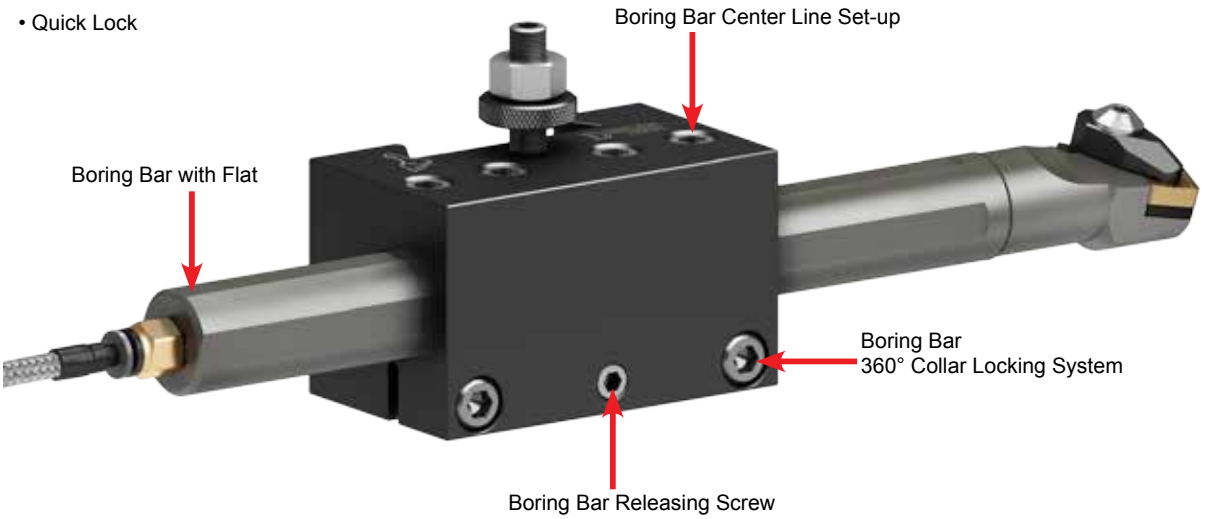
Description	UPC No.733101-	System	A	T	C	D	E	F	G	G1
QITP25N-2	00104	in	0.375	.750	2.750	1.240	1.740	0.880	0.770	1.030
		mm	10	20	70	31	44	22	20	26
QITP30N-2	00254	in	0.437	1.000	3.250	1.490	2.240	1.115	0.890	1.210
		mm	11	25	83	38	57	28	23	31
QITP35N-2	00404	in	0.500	1.000	3.750	1.740	2.490	1.245	1.010	1.410
		mm	13	25	95	44	63	32	26	36
QITP40N-2	00554	in	0.562	1.250	4.500	1.990	2.990	1.530	1.040	1.575
		mm	14	32	114	51	76	39	26	40
QITP50N-2	00704	in	0.750	1.500	6.000	2.490	3.490	1.900	1.290	1.950
		mm	19	40	152	63	89	48	33	50
QITP60N-2	00854	in	1.000	1.500	7.000	2.990	3.990	2.207	1.540	2.340
		mm	25	40	178	76	102	56	39	59

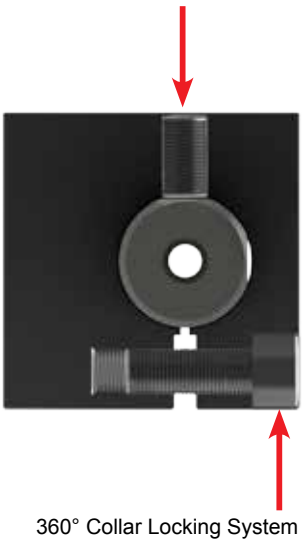
Dual Boring Bar Quick Change Holder NEW

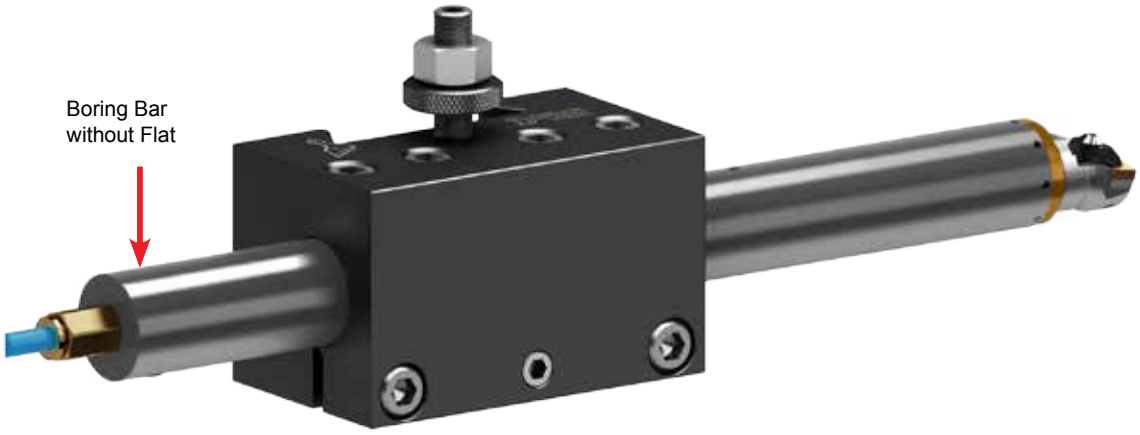
with the Double Locking System

For Precise Set-up and Maximum Rigidity

- Boring Bar Center Line Set-up
- Set Screw Locking System
- 360° Collar Locking System
- Maximum Locking force
- No Boring Bar Damage
- Quick Release
- Quick Lock

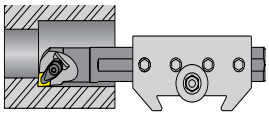


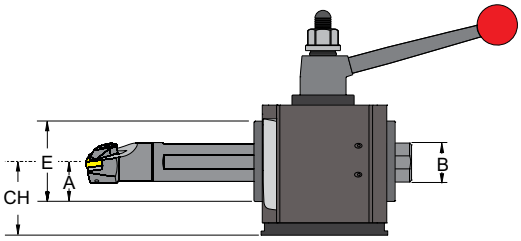


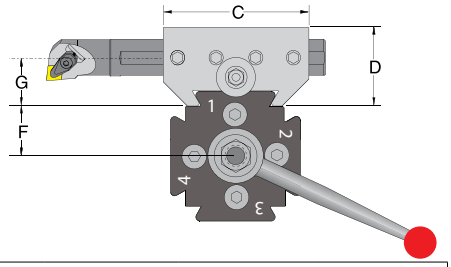


No. QITPN-4-DUAL Heavy Duty Boring Bar Toolholder

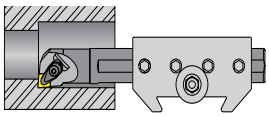
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the centerheight and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

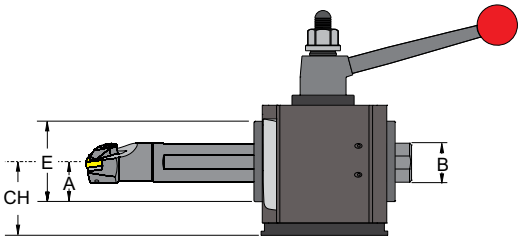


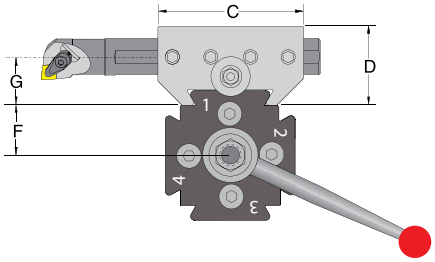




Description	UPC No.733101-	System	Boring Bar Capacity A	B	C	D	E	F	G
QITP25N-4-750 DUAL	00111	in	0.745	0.750	2.750	1.490	1.490	0.880	0.937
QITP30N-4-1000-DUAL	00261	in	0.995	1.000	3.250	1.990	1.990	1.115	1.250
QITP35N-4-1000-DUAL	00411	in	1.120	1.000	3.750	2.240	2.240	1.245	1.375
QITP40N-4-1250-DUAL	00561	in	1.245	1.250	4.500	2.490	2.490	1.530	1.500
QITP50N-4-1500-DUAL	00711	in	1.495	1.500	5.500	2.990	2.990	1.900	2.000
QITP60N-4-2000-DUAL	00861	in	1.995	2.000	6.500	3.990	3.990	2.207	2.500

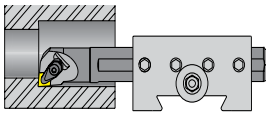


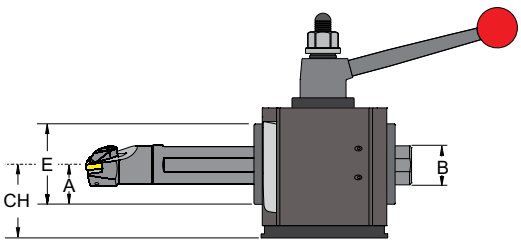


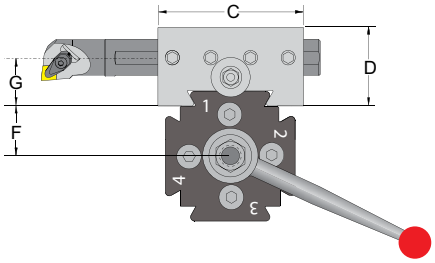


No. QITPN-41-DUAL Universal Extra Heavy Duty Boring Bar Toolholder

Description	UPC No.733101-	System	Boring Bar Capacity A	B	C	D	E	F	G
QITP35N-41-1250-DUAL	00413	in	1.120	1.250	3.750	2.240	2.240	1.245	1.375
QITP40N-41-1500-DUAL	00563	in	1.370	1.500	4.500	2.740	2.740	1.530	1.625
QITP50N-41-2000-DUAL	00713	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250
QITP60N-41-2500-DUAL	00863	in	2.245	2.500	6.500	4.490	4.490	2.207	2.750





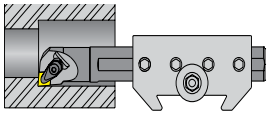


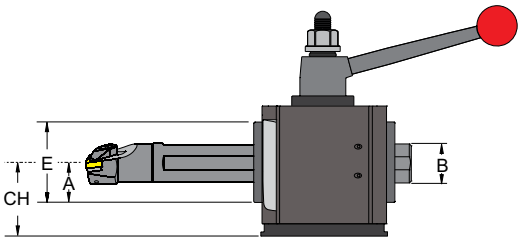
No. DQ-41S-DUAL Universal Super Over Sized Boring Bar Toolholder

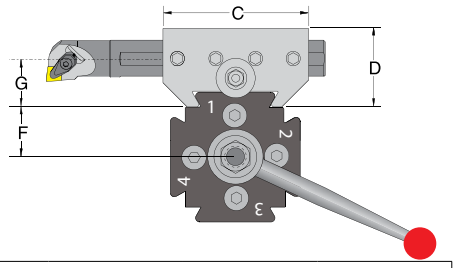
Description	UPC No.733101-	System	Boring Bar Capacity A	B	C	D	E	F	G
DQ35CXA-41S-1500-DUAL	00415	in	1.245	1.500	4.000	2.490	2.490	1.245	1.500
DQ40CA-41S-2000-DUAL	00565	in	1.495	2.000	4.500	2.990	2.990	1.530	1.750
DQ50DA-41S-2500-DUAL	00715	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250
DQ60EA-41S-3000-DUAL	00865	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625

No. QITPN-4M-DUAL Heavy Duty Boring Bar Toolholder

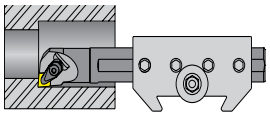
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the centerheight and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

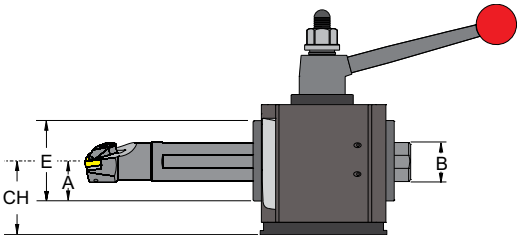


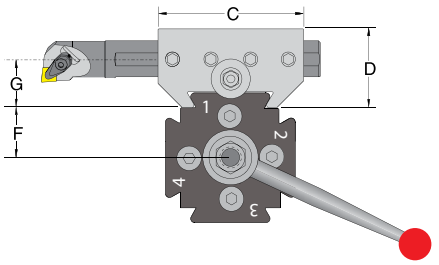




Description	UPC No.733101-	System	Boring Bar Capacity A	B	C	D	E	F	G
QITP25N-4M-20-DUAL	00113	mm	19	19	70	38	38	22	24
QITP30N-4M-25-DUAL	00263	mm	25	25	83	51	51	28	32
QITP35N-4M-25-DUAL	00419	mm	28	25	95	57	57	32	35
QITP40N-4M-32-DUAL	00567	mm	32	32	114	63	63	39	38
QITP50N-4M-40-DUAL	00717	mm	38	38	140	76	76	48	51
QITP60N-4M-50-DUAL	00867	mm	51	51	165	101	101	56	63

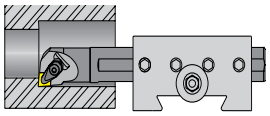


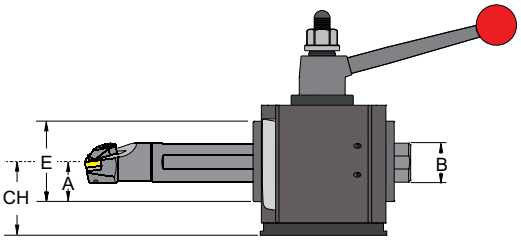


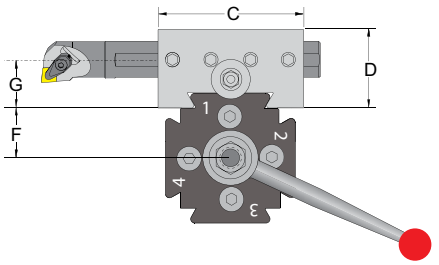


No. QITPN-41M-DUALUniversal Extra Heavy Duty Boring Bar Toolholder

Description	UPC No.733101-	System	Boring Bar Capacity A	B	C	D	E	F	G
QITP35N-41M-32-DUAL	00421	mm	28	32	95	57	57	32	35
QITP40N-41M-40-DUAL	00569	mm	35	40	114	70	70	39	41
QITP50N-41M-50-DUAL	00719	mm	44	50	140	89	89	48	57
QITP60N-41M-60-DUAL	00869	mm	57	60	165	114	114	56	70





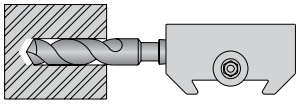


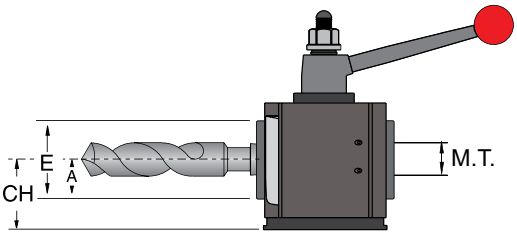
No. DQ-41S-DUAL Universal Super Over Sized Boring Bar Toolholder

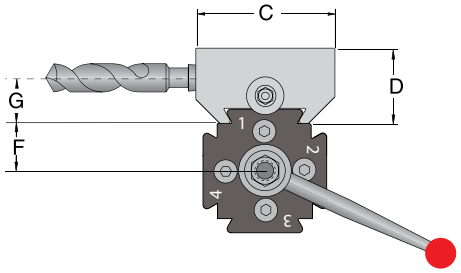
Description	UPC No.733101-	System	Boring Bar Capacity A	B	C	D	E	F	G
DQ35CXA-41SM-40-DUAL	00423	mm	32	40	102	63	63	32	38
DQ40CA-41SM-50-DUAL	00571	mm	38	50	114	76	76	39	45
DQ50DA-41SM-60-DUAL	00721	mm	51	60	165	101	101	48	57
DQ60EA-41SM-80-DUAL	00871	mm	57	80	178	114	114	56	67

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.



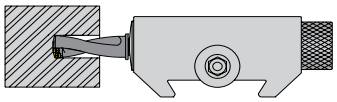


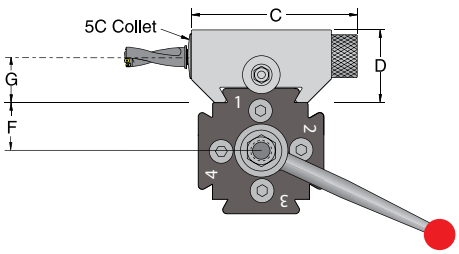


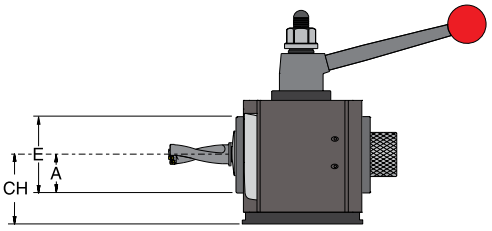
Description	UPC No. 733101-	System	A	Morse Taper	C	D	E	F	G
QITP35N-5-4	00424	in	1.250	MT4	4.150	2.500	2.500	1.245	1.615
		mm	32	MT4	105	64	64	32	41
QITP40N-5-4	00572	in	1.250	MT4	4.500	2.500	2.500	1.530	1.615
		mm	32	MT4	114	64	64	39	41
QITP50N-5-5	00722	in	1.750	MT5	5.625	3.500	3.500	1.900	2.310
		mm	45	MT5	143	89	89	48	59
QITP60N-5-5	00872	in	1.750	MT5	5.625	3.500	3.500	2.207	2.310
		mm	45	MT5	143	89	89	56	59

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.



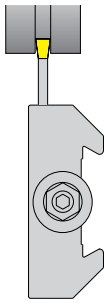


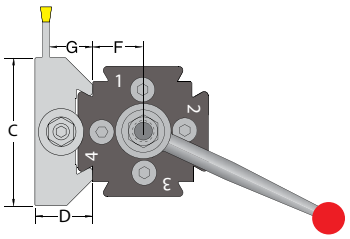


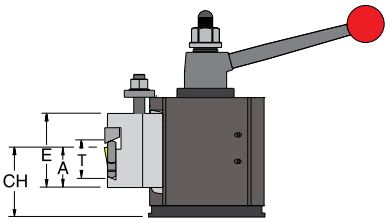
Description	UPC No. 733101-	System	A	C	D	E	F	G
QITP25N-36	00142	in	1.125	4.250	2.500	2.250	0.880	1.500
		mm	29	108	64	57	22	38
QITP30N-36	00292	in	1.125	4.250	2.500	2.250	1.115	1.500
		mm	29	108	64	57	28	38
QITP35N-36	00444	in	1.375	4.500	2.750	2.750	1.245	1.625
		mm	34	114	70	70	32	41
QITP40N-36	00592	in	1.375	5.000	2.750	2.750	1.530	1.625
		mm	35	127	70	70	39	41

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



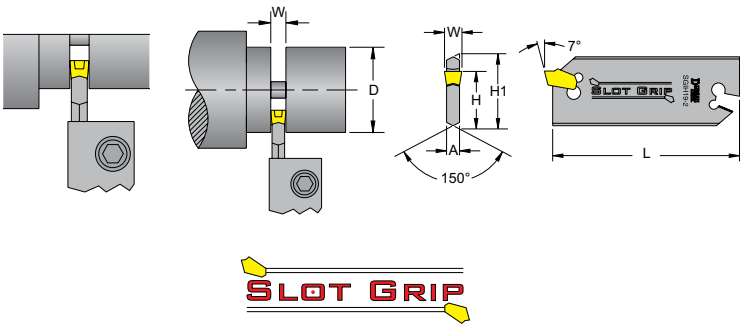




Description	UPC No.733101-	System	A	Slot Grip Blade T	C	D	E	F	G
QITP25N-7-71C	00126	in	0.933	SGIH-19-2	2.750	1.250	2.000	0.880	1.127
		mm	24		70	32	51	22	29
QITP30N-7-71C	00276	in	0.933		3.250	1.250	2.000	1.115	1.127
		mm	24		83	32	51	28	29
QITP35N-7-71C	00428	in	1.255	SGIH-26-2 to 26-6	3.750	1.750	2.500	1.245	1.520
		mm	32		95	45	64	32	39
QITP40N-7-71C	00576	in	1.255		4.500	1.750	3.000	1.530	1.520
		mm	32		114	45	76	39	39
QITP50N-7-71C	00726	in	1.483	SGIH-32-3 to 32-9	6.000	2.000	3.000	1.900	1.710
		mm	38		152	51	76	48	43
QITP60N-7-71C	00876	in	2.050		7.000	2.250	3.500	2.207	2.150
		mm	52		178	57	89	56	55

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 in	W mm	D Max in	D Max mm	A in	A mm	L in	L mm	H in	H mm	H 1 in	H 1 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

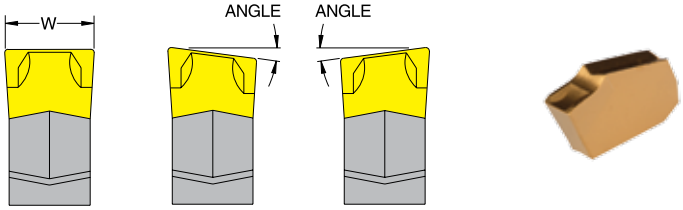
Description	DASK25B First Choice for High Performance Machining	DC656 First Choice for General Turning Applications	Insert System	Lead Angle	Width ± .004 in	Width ± .004 mm
SGTN-2	82223	82222	2	0º	.087	2mm
SGTR-2-8	82251	82250	2	8º	.087	2mm
SGTL-2-8	82279	82278	2	8º	.087	2mm
SGTN-3	82227	82226	3	0º	.122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

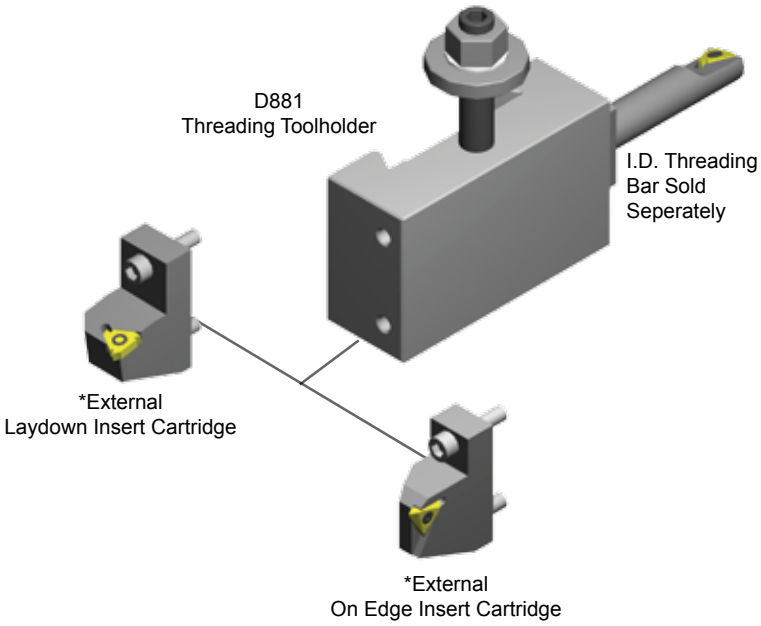
First Choice for High Performance Machining of all carbon and alloy steels, non-ferrous metals, aerospace titanium alloys, inconel, austenitic stainless steels, cast iron, copper/brass, with medium to high sfm, in dry or wet conditions. PVD TiN-TiAlN-TiN multi layer with micro dense coating structure 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.

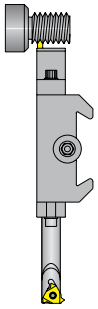
DC656 -
(C5-C6 Substrate with CVD TiN/TiC-TiN coating)

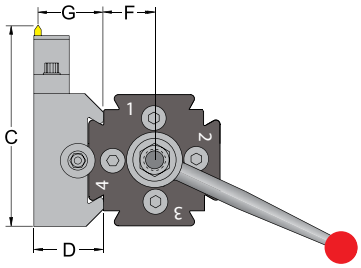
First Choice for general turning applications on ferrous metals and 400 series stainless steels, at medium cutting sfm and wet conditions. Multi Layer CVD carbide grade. Thermal deformation and abrasion resistant substrate with cobalt enriched periphery.

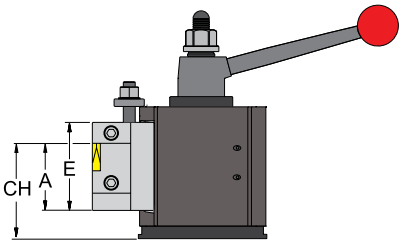
No. QITPN-881 O.D. and I.D. Threading Toolholder

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.







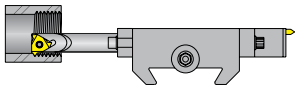


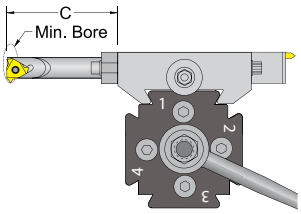
Description	UPC No. 733101-	System	A	C	D	E	F	G	*External On Edge Insert Cartridge					*External Laydown Insert Cartridge						
									Desc.	UPC No. 733101-	TNMC Insert	Torx Screw	Torx Key	Desc.	UPC No. 733101-	Insert	Torx Screw	Torx Key	Pitch TPI	Pitch mm
QITP25N-881-OE	00132	in	0.875	4.130	1.250	1.750	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	105	32	45	22	25												
QITP30N-881-OE	00282	in	1.000	4.630	1.500	2.000	1.115	1.250												
		mm	25	118	32	51	28	32												
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	32	143	45	64	32	36												
QITP40N-881-OE	00582	in	1.500	6.130	1.750	2.500	1.530	1.435												
		mm	38	156	45	64	39	36												

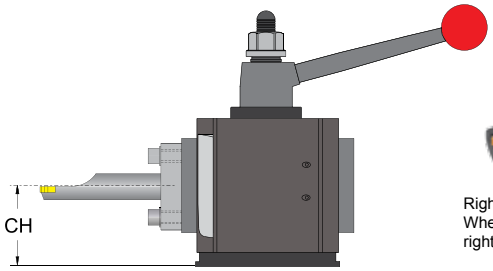
* Holder is supplied standard with External On Edge Insert Cartridge. The External Laydown Insert Cartridge is sold separately.
Internal threading bar sold separately. Inserts not included.

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.



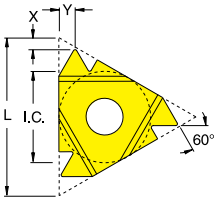


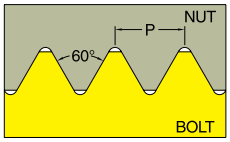


Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

Series	Right Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	in	mm	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

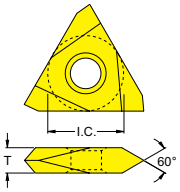
Laydown Threading Insert 60° Partial Profile





Internal Right Hand	DVP656 Grade For Steel UPC No. 733101-	DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No.733101-	Internal Left Hand	DVP656 Grade For Steel UPC No. 733101-	DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No.733101-	L mm	I.C. in	Pitch TPI	Pitch MM	x mm	y mm
11IR-A60	74056	74057	11IL-A60	74060	74061	11	.250	16-48	0,5-1,5	0,8	0,9
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	1,2	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

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**

1ea. QITPN-1 + Free Toolholder & 2 Free TCMT Turning Inserts

1ea. QITPN-2 + Free Toolholder & 1 Free 11/16IR-A60 Laydown Inserts

1ea. QITPN-7-71C + Free Toolholder & 1 Free SGTN Cut-off Inserts

1ea. QITPN-881 + Free Toolholder & 1 Free TNMC OnEdge Inserts

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 QITP25N-2 QITP25N-7-71C QITP25N-881-OE	QITP30N-1 QITP30N-2 QITP30N-7-71C QITP30N-881-OE	QITP35N-1 QITP35N-2 QITP35N-7-71C QITP35N-881-OE	QITP40N-1 QITP40N-2 QITP40N-7-71C QITP40N-881-OE
Free Tooling				
(4)Toolholders	STNCR08-2J STCMB06-2 SGIH19-2 NL50R	STNCR10-2A STCMB08-2 SGIH19-2 NL50R	STNCR12-3B STCMB10-2 SGIH26-3 NL75R	STNCR64-3D STCMB12-3 SGIH26-3 NL75R
(5) Inserts	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DC656 TNMC-32NV-DVP656 11IR-A60-DVP656	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DC656 TNMC-32NV-DVP656 11IR-A60-DVP656	TCMT-21.51-UM-DHCP25 TCMT-32.52-UM-DHCP25 SGTN-3-DC656 TNMC-32NV-DVP656 16IR-A60-DVP656	TCMT-32.51-UM-DHCP25 TCMT-32.52-UM-DHCP25 SGTN-3-DC656 TNMC-32NV-DVP656 16IR-A60-DVP656

Quadra® Indexing Quick Change Tool Post Turning Set

Turning Set Includes

(1) Tool Post
(4) Holders

Tooling Not Included

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) QITP2N5-1 (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

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!

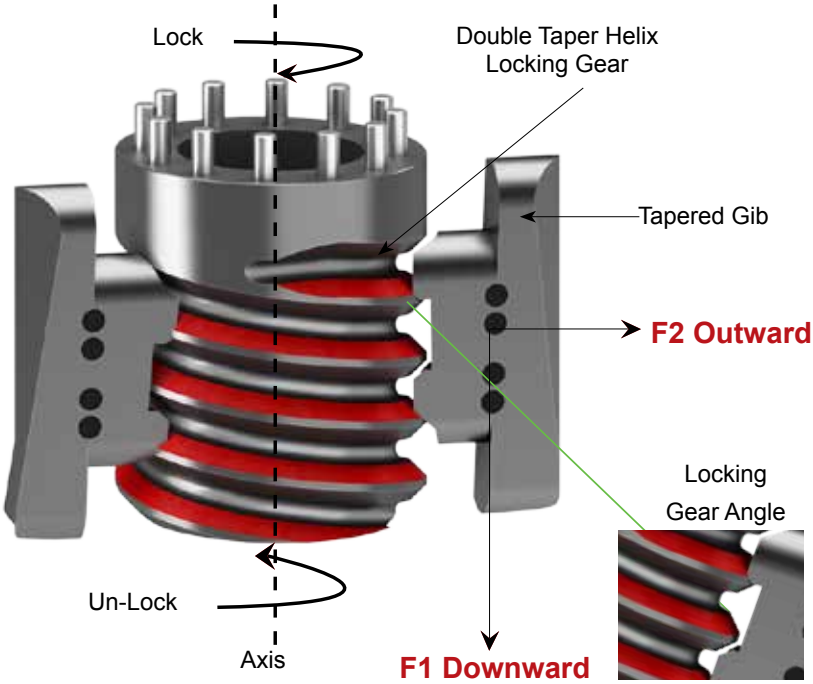
- Multi-position locking handle adjustment
- Anti-Rotation mounting
- Super precision toolholder locking
- Repeatability within millionths
- Thousands of pounds of locking force with a finger tip

Style	Features	Application
SUPER Quick Change Tool Post 	• 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 	• 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 	• 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-DQ41S DUAL **Heavy Duty Boring Bar Holder** 	• 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 	• 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 	• 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. D35 Dovetail Drill Chuck Holder 	• 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. D881 O.D. or I.D. Threading Holder 	• 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
	• 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 Aplications • 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:

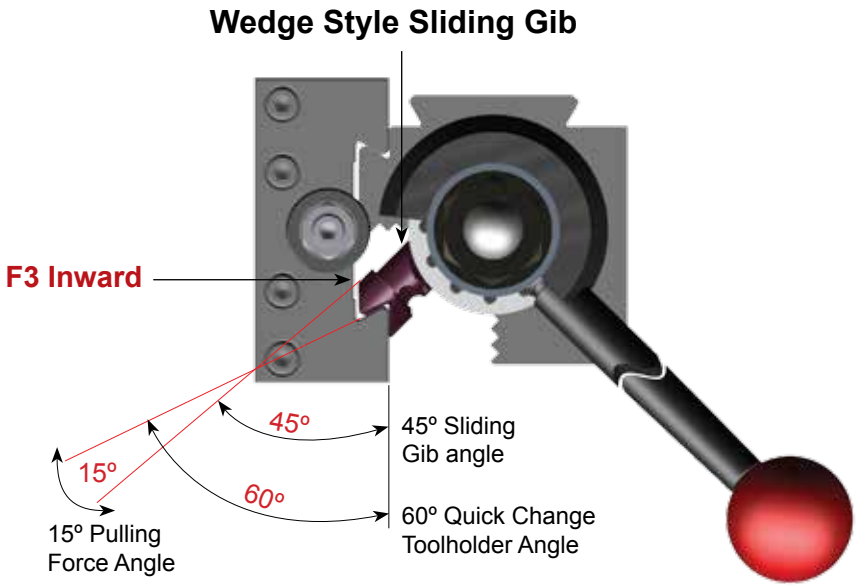
(shown right) Rotating the locking gear moves the gib down, expanding the tool post dovetail to lock the toolholder.

2. F2 Outward Force:

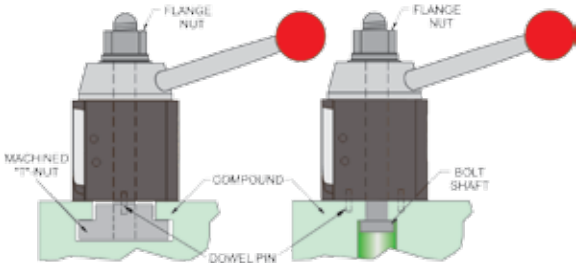
(shown right) When the gibs make full contact with the toolholder dovetail, the double-angle helix of the locking gear forces the gib outward, neutralizing any backlash to zero.

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.

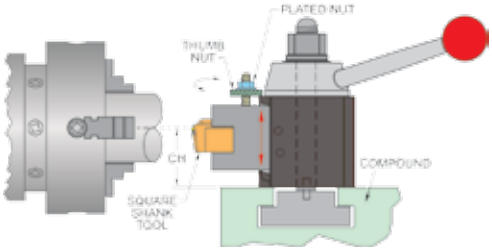


Tool Post Mounting



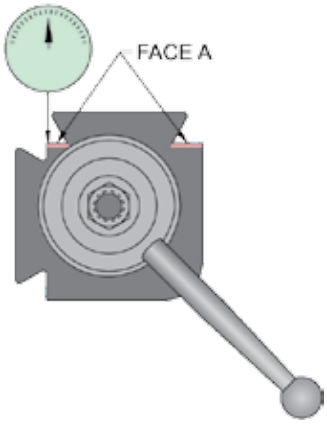
The tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flange Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using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



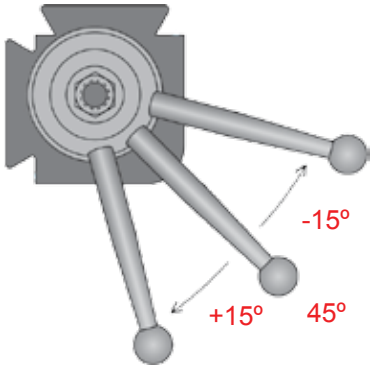
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool by rotating the Thumb Nut until the desired height is reached and locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool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

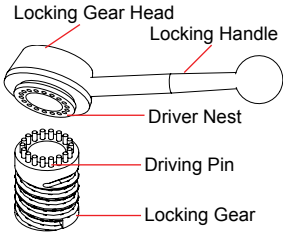
Indicating Position



The double dovetails are ground at 90° square (± .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 ± .0005".

Locking Handle Positioning



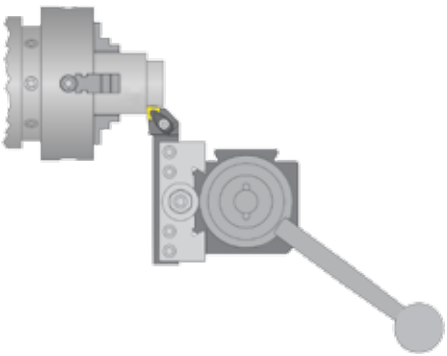


To change the position of the handle: remove the *flange nut; remove the *guide bushing; pull the locking gear head and place to the desired position.

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

O.D. Turning Operations

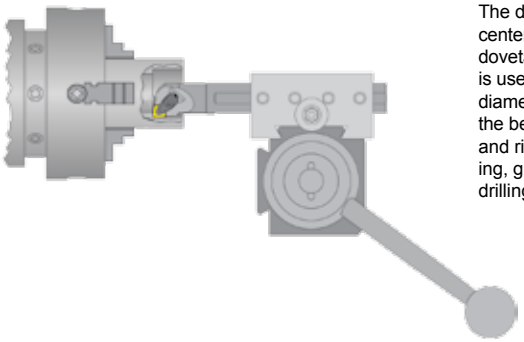
Turning, Threading, Cut-Off, Grooving, & Chamfering



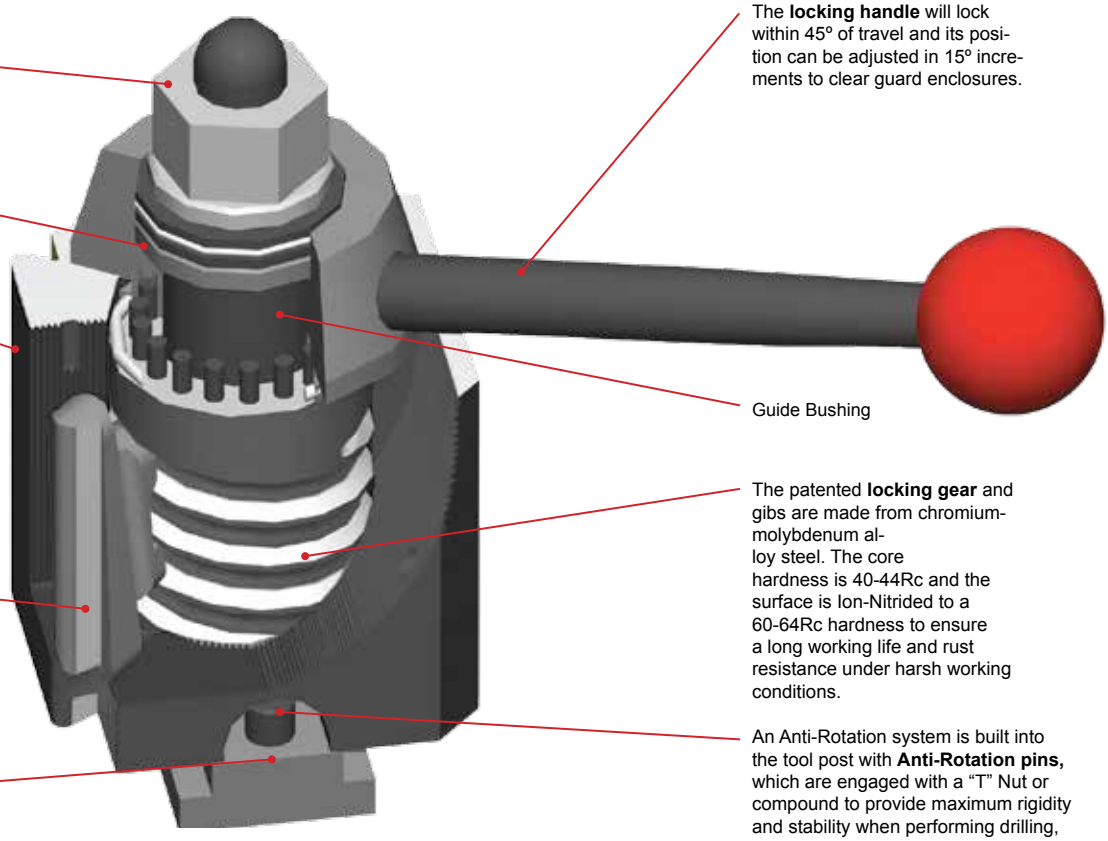
The dovetail closest to the chuck (left dovetail as shown below) is used for turning outside diameters. It holds the tool at the best location for clearance and rigidity for turning, threading, cut-off, grooving, and chamfering.

I.D. Turning Operations

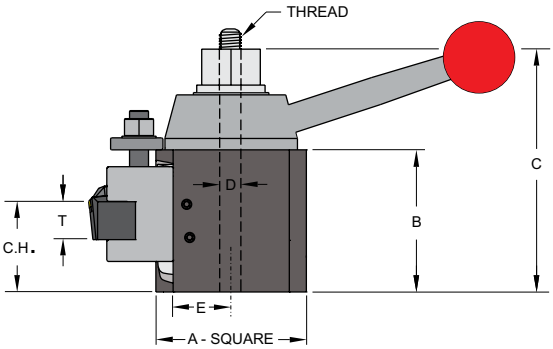
Boring, Threading, Grooving, Drilling, & Center Drilling



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 Specifications



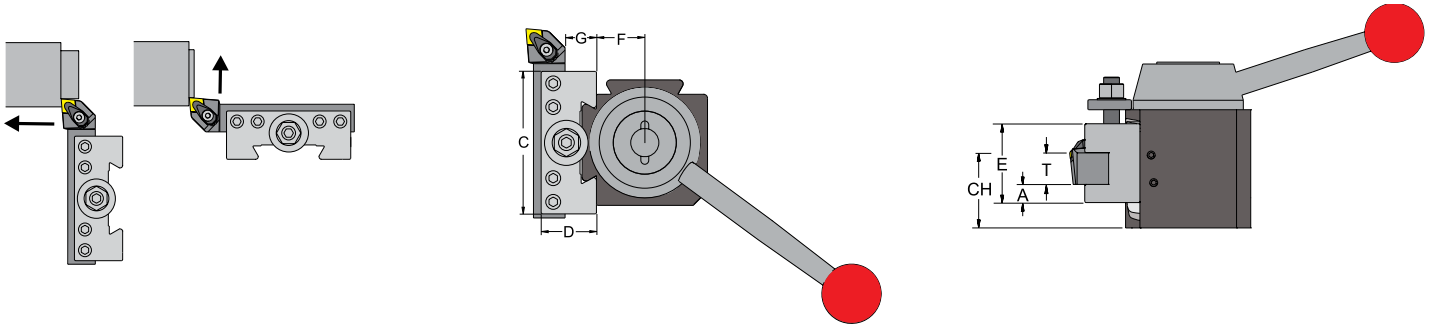
- Zero Backlash
- Triple Action Locking System
- Precise Repeatability within .0001
- 15º Locking Handle Position Adjustment
- Industry-Standard Interchangeable Holders

Description	SDN25AXA		SDN30BXA		SDN35CXA		SDN40CA		SDN50DA		SDN60EA	
UPC No. 733101-	01000		01002		01004		01006		01008		01010	
System	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
Lathe Swing Over Bed	≤12	≤300	13-15	330-380	14-17	350-430	16-20	400-500	17-32	430-810	≥25	≥635
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	1⅛-12	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

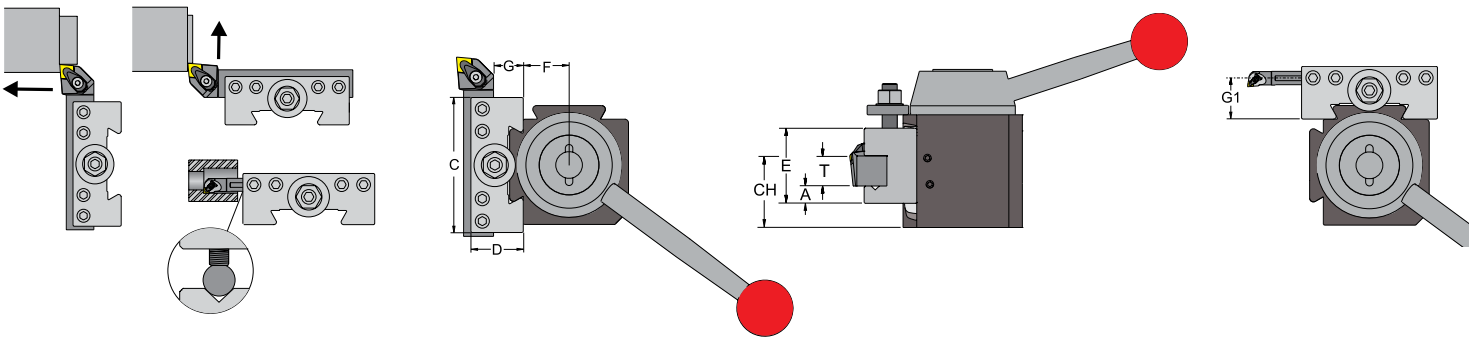
This toolholder is best used for holding square shank toolholders close to the tool post to maximize rigidity when turning, facing, and threading.
Fits industry standard tool posts.



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	10	20	70	32	44	22	20
D30BXA-1	01250	in	0.437	1.000	3.250	1.500	2.250	1.115	.915
		mm	11	25	83	38	57	28	23
D35CXA-1	01400	in	0.500	1.000	3.750	1.750	2.500	1.199	1.040
		mm	13	25	95	44	64	30	26
D40CA-1	01550	in	0.562	1.250	4.500	2.000	3.000	1.530	1.040
		mm	14	32	114	51	76	39	26
D50DA-1	01700	in	0.750	1.500	6.000	2.500	3.500	1.900	1.290
		mm	19	40	152	64	89	48	33
D60EA-1	01850	in	1.000	1.500	7.000	3.000	4.000	2.207	1.540
		mm	25	40	178	76	102	56	39

No. D2 Turning, Facing & Boring Toolholder

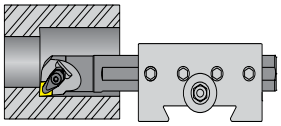
The “V” groove makes this holder more versatile so that it can hold either square shank toolholders or boring bars. Holds the tool close to the tool post to maximize rigidity when turning, facing, threading or boring. Fits industry standard toolposts.

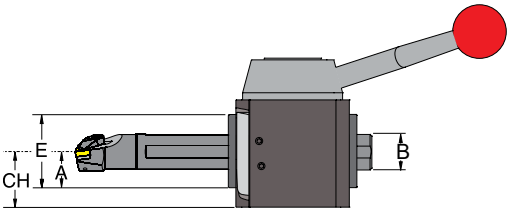


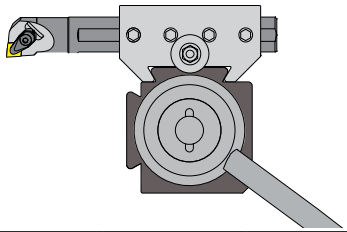
Description	UPC No.733101-	System	A	T	C	D	E	F	G	G1
D25AXA-2	01104	in	0.375	0.750	2.750	1.250	1.750	0.880	0.790	1.015
		mm	10	20	70	32	44	22	20	26
D30BXA-2	01254	in	0.437	1.000	3.250	1.500	2.250	1.115	0.915	1.205
		mm	11	25	83	38	57	28	23	31
D35CXA-2	01404	in	0.500	1.000	3.750	1.750	2.500	1.199	1.040	1.390
		mm	13	25	95	44	64	30	26	35
D40CA-2	01554	in	0.562	1.250	4.500	2.000	3.000	1.530	1.040	1.515
		mm	14	32	114	51	76	39	26	38
D50DA-2	01704	in	0.750	1.500	6.000	2.500	3.500	1.900	1.290	1.890
		mm	19	40	152	64	89	48	33	48
D60EA-2	01854	in	1.000	1.500	7.000	3.000	4.000	2.207	1.540	2.265
		mm	25	40	178	76	102	56	40	58

No. D4-DUAL Heavy Duty Boring Bar Toolholder

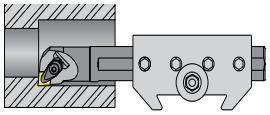
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

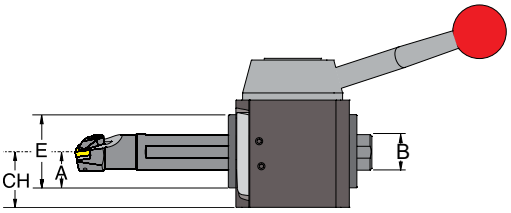


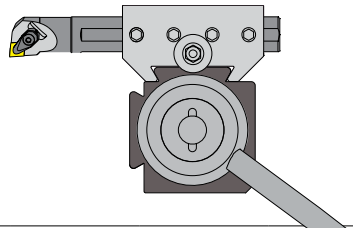




Description	UPC No.733101-	System	A	B Boring Bar Capacity	C	D	E	F	G
D25AXA-4-750-DUAL	01111	in	.745	.750	2.750	1.490	1.490	.880	.937
D30BXA-4-1000-DUAL	01261	in	.995	1.000	3.250	1.990	1.990	1.115	1.250
D35CXA-4-1000-DUAL	01411	in	1.120	1.000	3.750	2.240	2.240	1.199	1.375
D40CA-4-1250-DUAL	01559	in	1.245	1.250	4.500	2.490	2.490	1.530	1.500
D50DA-4-1500-DUAL	01709	in	1.495	1.500	5.500	2.990	2.990	1.900	2.000
D60EA-4-2000-DUAL	01859	in	1.995	2.000	6.500	3.990	3.990	2.207	2.500

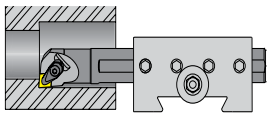


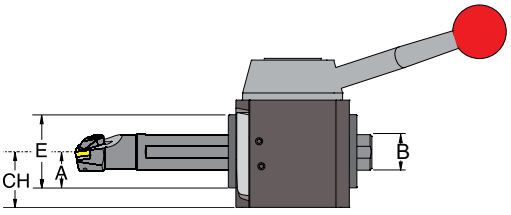


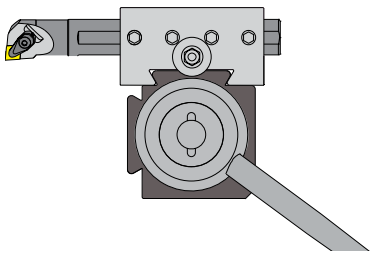


No. D41-DUAL Universal Extra Heavy Duty Boring Bar Toolholder

Description	UPC No.733101-	System	A	B Boring Bar Capacity	C	D	E	F	G
D25AXA-41-1000-DUAL	01113	in	.870	1.000	2.750	1.740	1.740	.880	1.062
D30BXA-41-1250-DUAL	01263	in	1.120	1.250	3.250	2.240	2.240	1.115	1.375
D35CXA-41-1250-DUAL	01413	in	1.120	1.250	3.750	2.240	2.240	1.199	1.375
D40CA-41-1500-DUAL	01563	in	1.245	1.500	4.500	2.490	2.490	1.530	1.500
D50DA-41-2000-DUAL	01713	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250
D60EA-41-2500-DUAL	01863	in	1.995	2.500	6.500	3.990	3.990	2.207	2.375





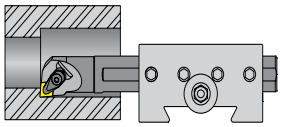


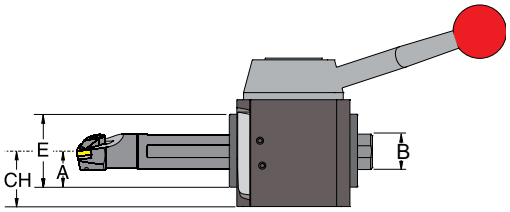
No. DQ41S-DUAL Super Universal Over Sized Boring Bar Toolholder

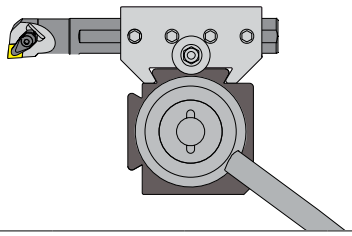
Description	UPC No.733101-	System	A	B Boring Bar Capacity	C	D	E	F	G
DQ35CXA-41S-1500-DUAL	00415	in	1.245	1.500	4.000	2.490	2.490	1.199	1.500
DQ40CA-41S-2000-DUAL	00565	in	1.495	2.000	4.500	2.990	2.990	1.530	1.750
DQ50DA-41S-2500-DUAL	00715	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250
DQ60EA-41S-3000-DUAL	00865	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625

No. D4-DUAL Heavy Duty Boring Bar Toolholder

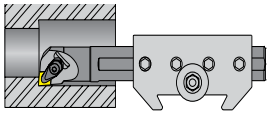
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

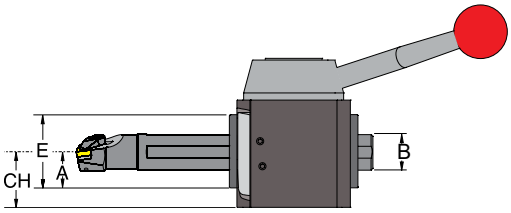


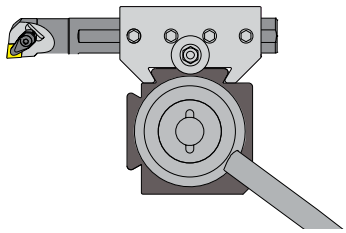




Description	UPC No.733101-	System	A	B Boring Bar Capacity	C	D	E	F	G
D25AXA-4M-20-DUAL	01117	mm	19	19	70	38	38	22	24
D30BXA-4M-25-DUAL	01267	mm	25	25	83	51	51	28	32
D35CXA-4M-25-DUAL	01417	mm	28	25	95	57	57	31	35
D40CA-4M-32-DUAL	01567	mm	32	32	114	63	63	39	38
D50DA-4M-40-DUAL	01717	mm	38	38	140	76	76	48	51
D60EA-4M-50-DUAL	01867	mm	51	51	165	101	101	56	64

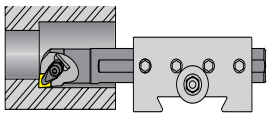


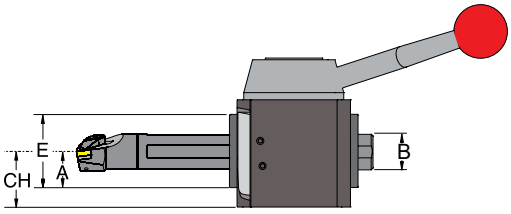


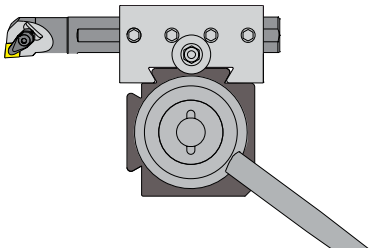


No. D41-DUAL Universal Extra Heavy Duty Boring Bar Toolholder

Description	UPC No.733101-	System	A	B Boring Bar Capacity	C	D	E	F	G
D25AXA-41M-25-DUAL	01119	mm	22	25	70	44	44	22	27
D30BXA-41M-32-DUAL	01269	mm	28	32	83	57	57	28	35
D35CXA-41M-32-DUAL	01419	mm	28	32	95	57	57	31	35
D40CA-41M-40-DUAL	01569	mm	32	40	114	63	63	39	38
D50DA-41M-50-DUAL	01719	mm	44	50	140	89	89	48	57
D60EA-41M-60-DUAL	01869	mm	51	60	165	101	101	56	60





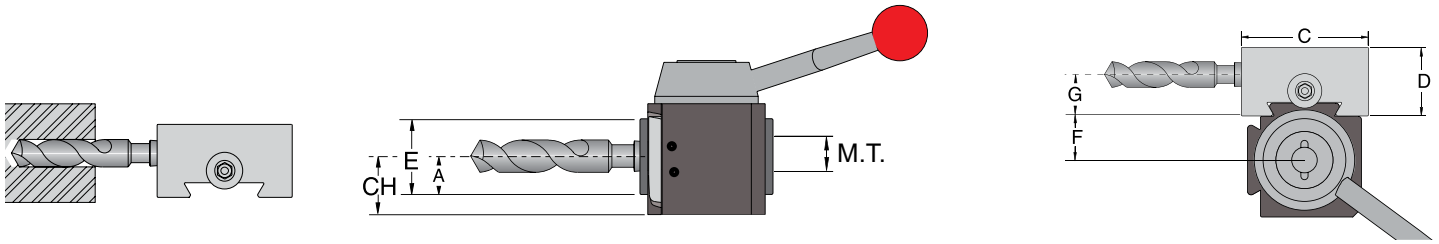


No. DQ41S-DUAL Super Universal Over Sized Boring Bar Toolholder

Description	UPC No.733101-	System	A	B Boring Bar Capacity	C	D	E	F	G
DQ35CXA-41SM-40-DUAL	00423	mm	32	40	102	63	63	31	38
DQ40CA-41SM-50-DUAL	00571	mm	38	50	114	76	76	39	45
DQ50DA-41SM-60-DUAL	00721	mm	51	60	165	101	101	18	57
DQ60EA-41SM-80-DUAL	00871	mm	57	80	178	114	114	56	67

No. D5 Morse Taper Toolholder

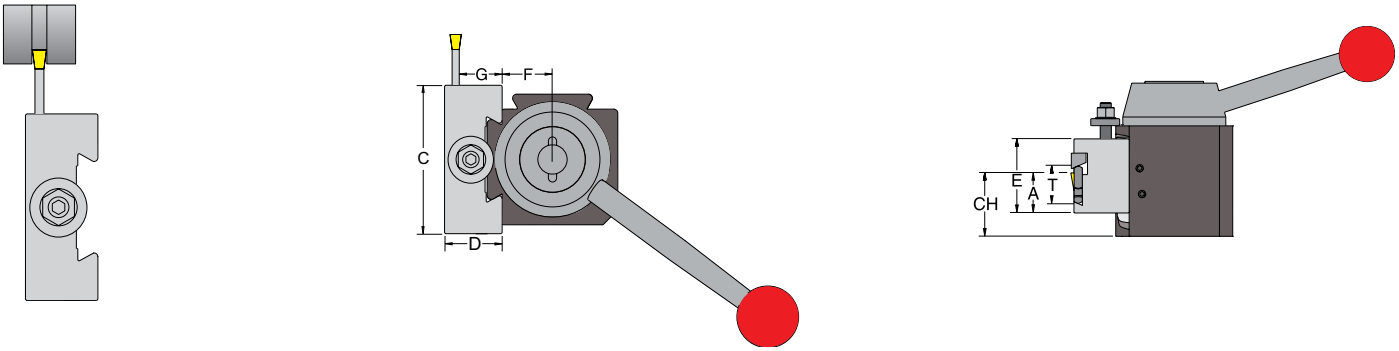
This holder is best used for holding morse taper tools. It can be used for drilling, boring, or reaming operations. Fits industry standard tool posts.



Description	UPC No. 733101-	System	A	Morse Taper	C	D	E	F	G
D35CXA-5-4	01424	in	1.125	MT4	4.150	2.500	2.250	1.199	1.615
		mm	29	MT4	105	64	57	30	41
D40CA-5-4	01572	in	1.250	MT4	4.500	2.500	2.500	1.530	1.615
		mm	32	MT4	114	64	64	39	41
D50DA-5-5	01722	in	1.750	MT5	5.625	3.500	3.500	1.900	2.300
		mm	45	MT5	143	89	89	48	58
D60EA-5-5	01872	in	1.750	MT5	5.500	3.500	3.500	2.207	2.240
		mm	45	MT5	140	89	89	56	57

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

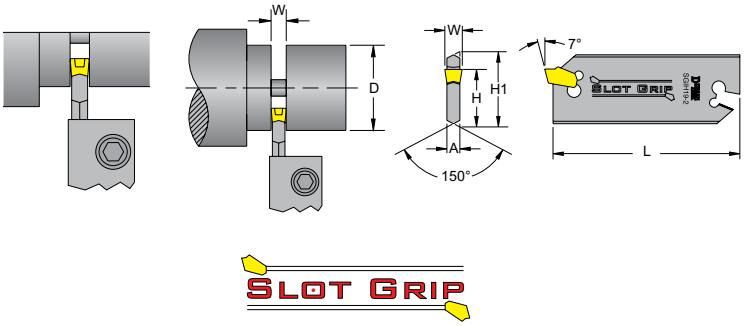
This holder is best used for holding cut-off blades. It has a taper locking system for maximum rigidity and performance in cut-off and face grooving operations. Fits industry standard tool posts. For Slot Grip Cut-Off Blades and Inserts see next page.



Description	UPC No.733101-	System	A	Slot Grip Blade 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	24		70	32	50	22	29
D30BXA-7-71C	01276	in	0.933		3.250	1.250	2.000	1.115	1.127
		mm	24		83	32	50	28	29
D35CXA-7-71C	01428	in	1.255	SGIH-26-2 to 26-6	3.750	1.750	2.500	1.245	1.520
		mm	32		95	44	64	32	39
D40CA-7-71C	01576	in	1.255		4.500	1.750	3.000	1.530	1.520
		mm	32		114	44	76	39	39
D50DA-7-71C	01726	in	1.483	SGIH-32-3 to 32-9	6.000	2.000	3.000	1.900	1.710
		mm	38		152	50	76	48	43
D60EA-7-71C	01876	in	2.050		7.000	2.250	3.500	2.207	1.980
		mm	52		178	57	89	56	50

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 in	W mm	D Max in	D Max mm	A in	A mm	L in	L mm	H in	H mm	H 1 in	H 1 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						
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	4.33	110,0	.842	21,4	1.02	25,9
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						
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	5.90	149.9	.984	25,0	1.25	31,8
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

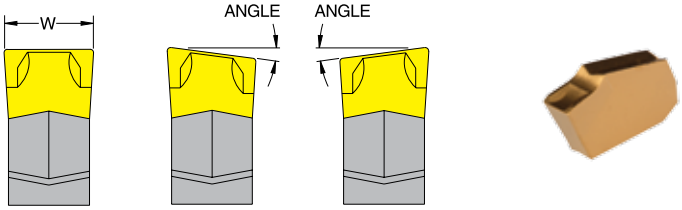
Description	DASK25B First Choice for High Performance Machining	DC656 First Choice for General Turning Applications	Insert System	Lead Angle	Width ± .004 in	Width ± .004 mm
SGTN-2	82223	82222	2	0°	.087	2mm
SGTR-2-8	82251	82250	2	8°	.087	2mm
SGTL-2-8	82279	82278	2	8°	.087	2mm
SGTN-3	82227	82226	3	0°	.122	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.

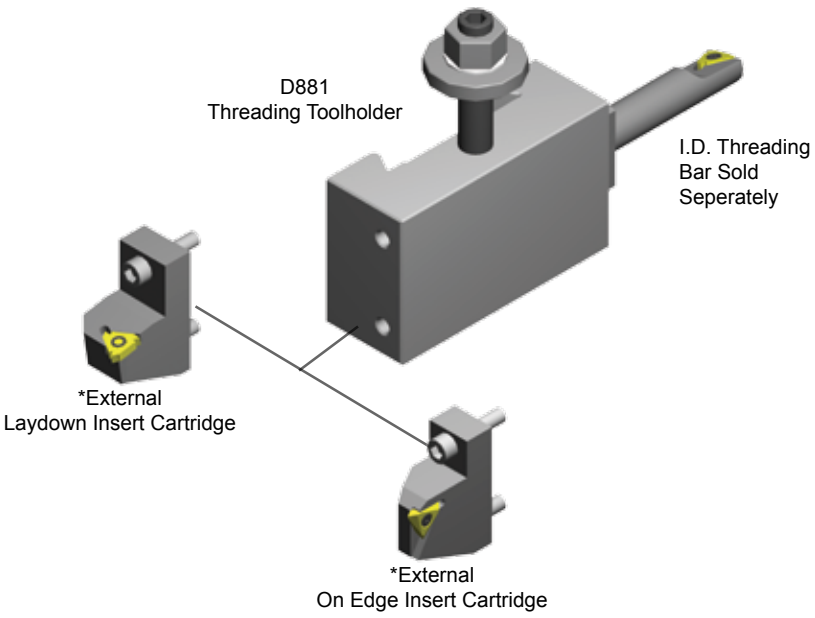
DC656 -

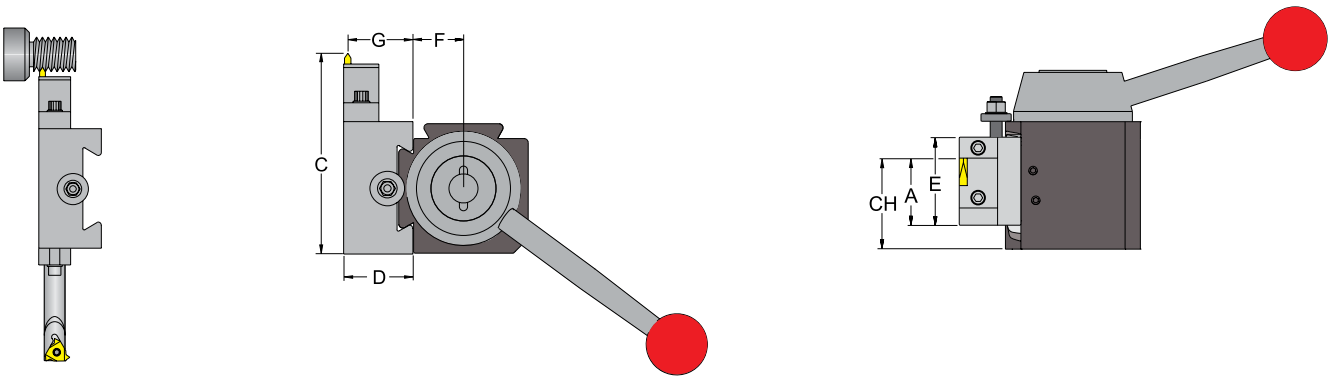
(C5-C6 Substrate with CVD TiN/TiC-TiN coating)

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.



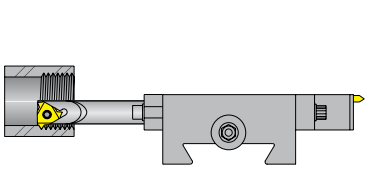


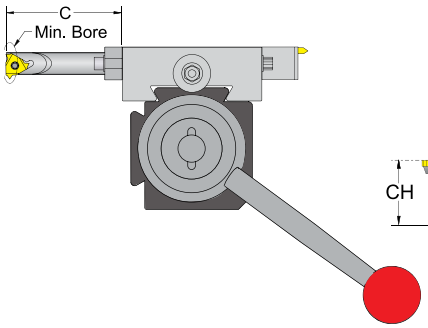
Description	UPC No. 733101-	System	A	C	D	E	F	G	*External On Edge Insert Cartridge					*External Laydown Insert Cartridge						
									Desc.	UPC No. 733101-	TNMC Insert	Torx Screw	Torx Key	Desc.	UPC No. 733101-	Insert	Torx Screw	Torx Key	Pitch TPI	Pitch mm
D25AXA-881-OE	01132	in	0.875	3.869	1.000	1.500	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												
		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												
		mm	38.10	142.72	38.10	57.15	38.86	36.45												

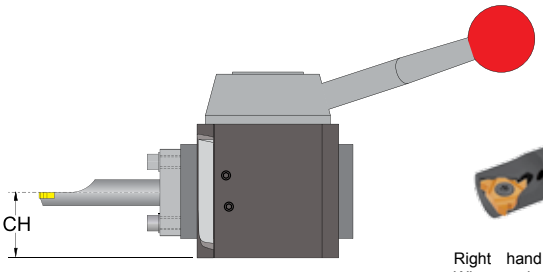
* Holder is supplied standard with External On Edge Insert Cartridge. The External Laydown Insert Cartridge is sold separately.
Internal threading bar sold separately. Inserts not included.

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.



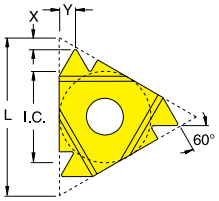


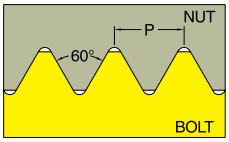


Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

Series	Right Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	in	mm	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

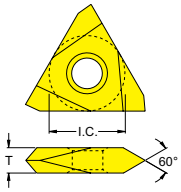
Laydown Threading Insert 60° Partial Profile





Internal Right Hand	DVP656 Grade For Steel UPC No. 733101-	DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No.733101-	Internal Left Hand	DVP656 Grade For Steel UPC No. 733101-	DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No.733101-	L mm	I.C. in	Pitch TPI	Pitch mm	x mm	y mm
11IR-A60	74056	74057	11IL-A60	74060	74061	11	.250	16-48	0,5-1,5	0,8	0,9
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	1,2	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

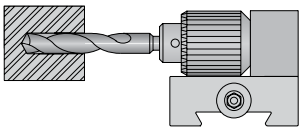
On Edge TNMC 60° Negative Rake Threading Insert

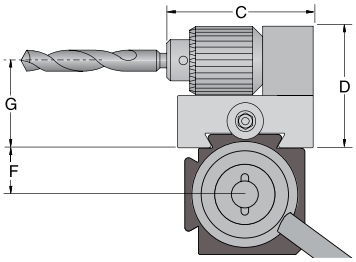


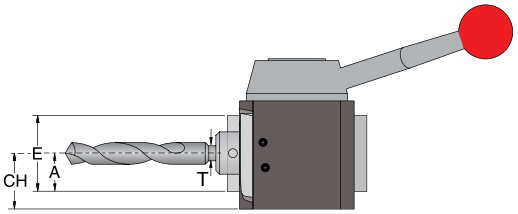
Desc.	DVP656 Grade For Steel UPC No. 733101-	DVK10 Grade For Stainless Steel, Cast Iron & Aluminum UPC No.733101-	I.C.		Thickness		Hole Dia.		Depth.	
			in	mm	in	mm	in	mm	in	mm
TNMC-32NV-	72003	72004	.375	9,5	.1250	3,18	.150	3,81	.150	3,81

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.



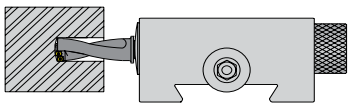


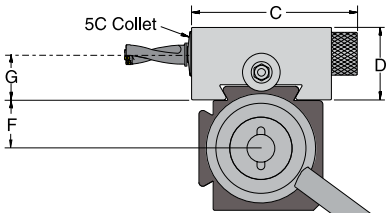


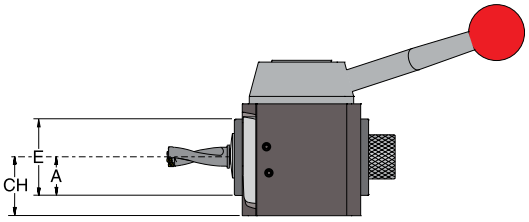
Description	UPC No. 733101-	System	A	T Capacity	C	D	E	F	G
D25AXA-35	01140	in	1.000	0 - .500	4.175	3.101	2.000	0.880	2.063
		mm	25	0 - 12.0	106	79	51	22	52
D30BXA-35	01290	in	1.000	0 - .500	4.175	3.101	2.000	1.115	2.063
		mm	25	0 - 12.0	106	79	51	28	52
D35CXA-35	01442	in	1.125	0 - .500	4.673	3.726	2.250	1.199	2.625
		mm	29	0 - 12.0	119	95	57	30	67
D40CA-35	01590	in	1.125	0 - .500	4.673	3.726	2.250	1.530	2.625
		mm	29	0 - 12.0	119	95	57	39	67

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.







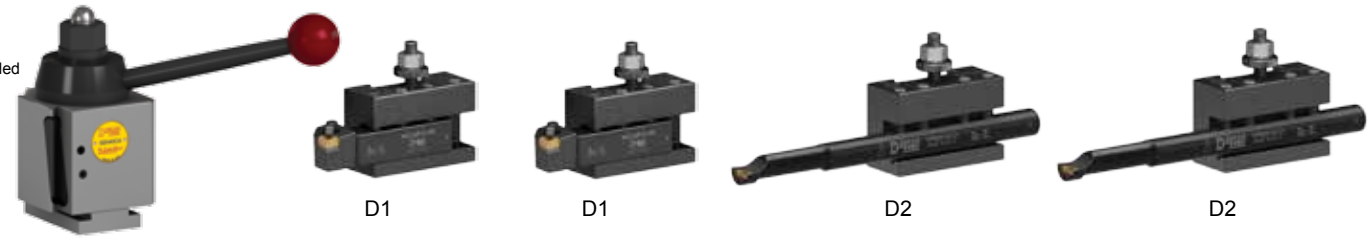
Description	UPC No. 733101-	System	A	C	D	E	F	G
D25AXA-36	01142	in	1.125	4.250	2.500	2.250	0.880	1.500
		mm	29	108	64	57	22	38
D30BXA-36	01292	in	1.250	4.250	2.500	2.250	1.115	1.500
		mm	29	108	64	57	28	38
D35CXA-36	01444	in	1.375	4.500	2.750	2.750	1.199	1.625
		mm	35	114	70	70	30	41
D40CA-36	01592	in	1.375	5.000	2.750	2.750	1.530	1.625
		mm	35	127	70	70	39	41

SUPER Quick Change Turning Sets

Turning Set Includes

(1) Tool Post
(4) Holders

Tooling Not Included



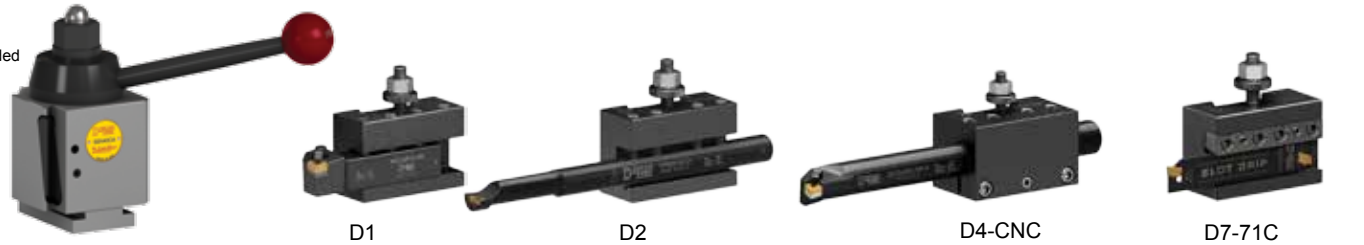
UPC No. 733101-	01014	01015	01016	01017	01018	01019
Description	SDN25AXA-TS	SDN30BXA-TS	SDN35CXA-TS	SDN40CA-TS	SDN50DA-TS	SDN60EA-TS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
Set Includes						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
(4) Holders	(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 & 1 Free TCMT Turning Insert

1ea. D2 + Free Boring Bar & 1 Free TCMT Turning Insert

1ea. D7-71C + Free Blade & 1 Free Cut-off Insert

1ea. D881 + Free ID Threading Bar & 1 Free TNMC OnEdge & 1 Free Laydown Threading 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 D25AXA-2 D25AXA-7-71C D25AXA-881-OE	D30BXA-1 D30BXA-2 D30BXA-7-71C D30BXA-881-OE	D35CXA-1 D35CXA-2 D35CXA-7-71C D35CXA-881-OE	D40CA-1 D40CA-2 D40CA-7-71C D40CA-881-OE
Free Tooling				
(4)Toolholders	STNCR08-2J STCMB06-2 SGIH19-2 NL50R	STNCR10-2A STCMB08-2 SGIH19-2 NL50R	STNCR12-3B STCMB10-2 SGIH26-3 NL75R	STNCR64-3D STCMB12-3 SGIH26-3 NL75R
(5) Inserts	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DC656 TNMC-32NV-DVP656 11IR-A60-DVP656	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DC656 TNMC-32NV-DVP656 11IR-A60-DVP656	TCMT-21.51-UM-DHCP25 TCMT-32.52-UM-DHCP25 SGTN-3-DC656 TNMC-32NV-DVP656 16IR-A60-DVP656	TCMT-32.51-UM-DHCP25 TCMT-32.52-UM-DHCP25 SGTN-3-DC656 TNMC-32NV-DVP656 16IR-A60-DVP656