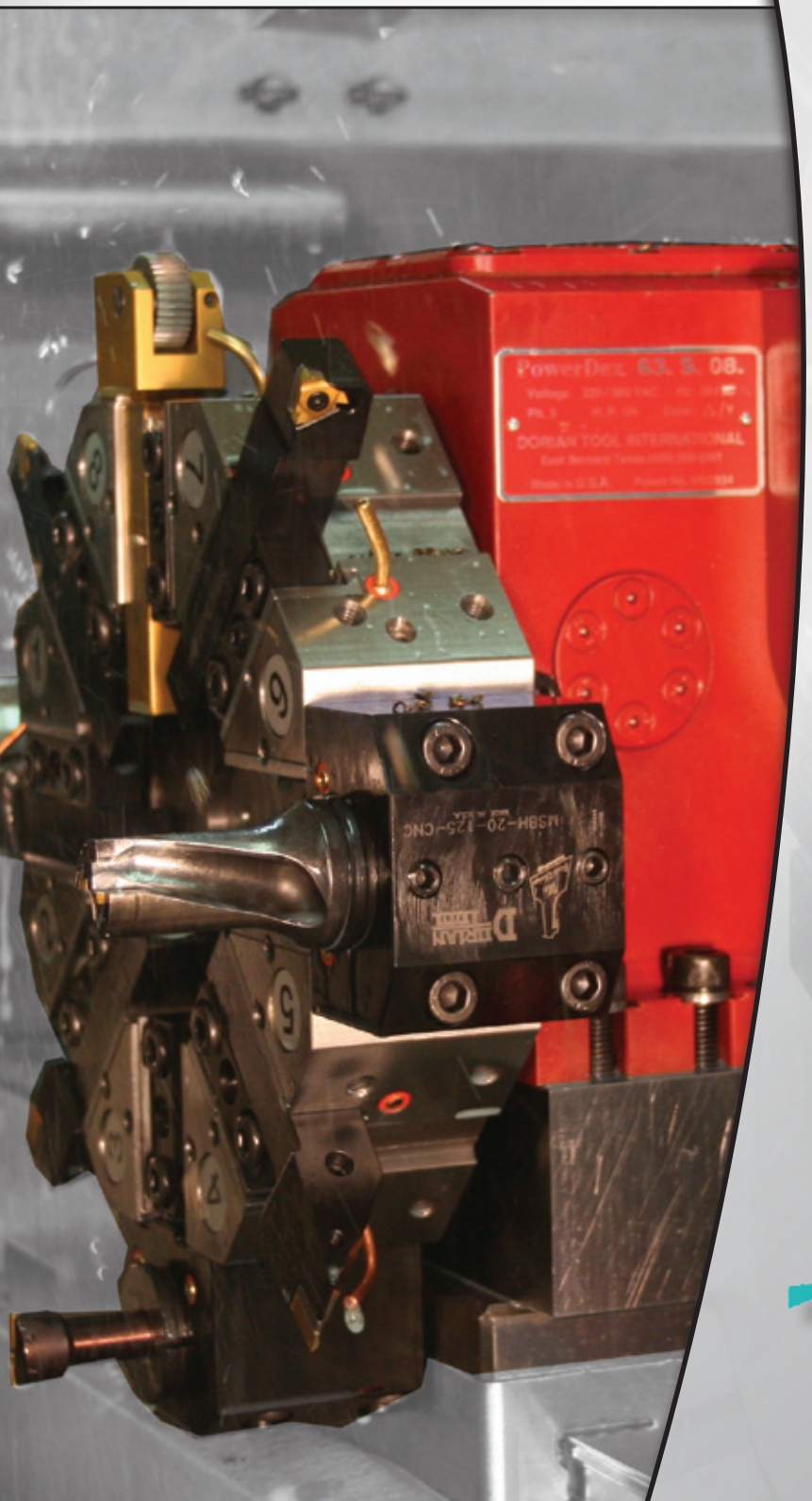
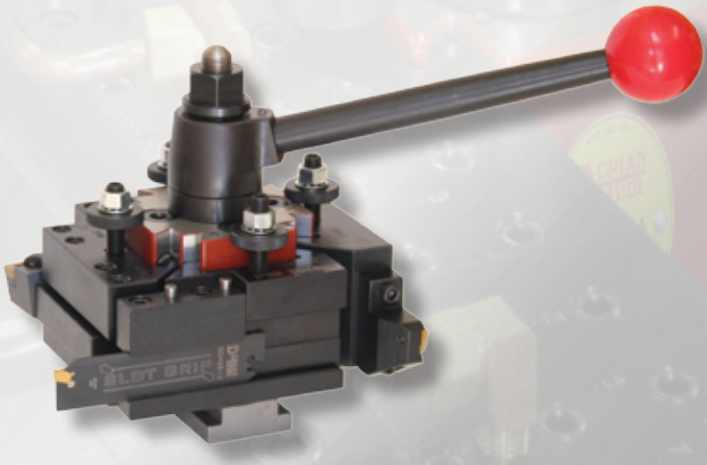
DORIAN® INTERNATIONAL TOOL

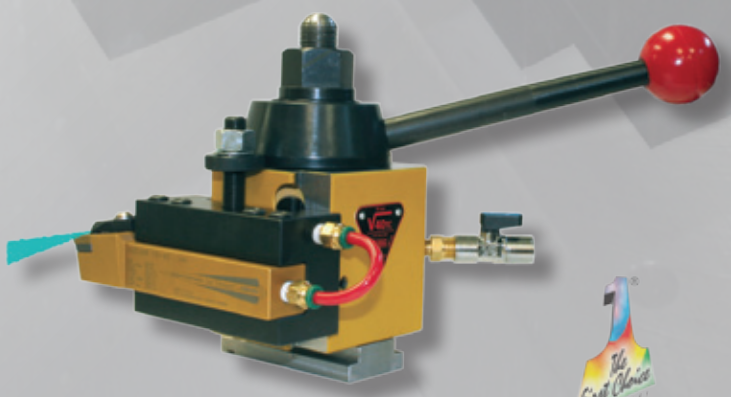
Lathe Accessories

For CNC And Manual Lathes











Enrico R. Giannetti
President

A Word from the President:

Since the introduction of the Quadra Index Tool Post in 1982, the Dorian Evolution has never stopped. By developing new ideas and promoting new technology, Dorian Tool has continuously improved it's service, technical support, and delivery to customers.

At Dorian Tool, the quest for innovative tools will never end. Our highly trained and skilled engineers have developed technology that set new standards in the industry and changed the machining process forever.

Today, Dorian Tool offers a wide selection of products for manual and CNC machines. From carbide inserts to toolholders; knurling tools to marking tools; machine tool accessories to automated turrets & rotary tables; tool setters to tool presetters; our tool selection has become the First Choice Technology for thousands of small and large shops around the world.

Thank you for making Dorian Tool successful. Our success comes from the original commitment we made to our customers:

Technology, Quality, & Service



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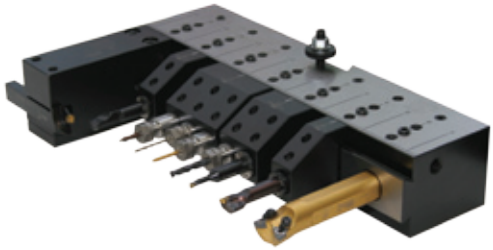
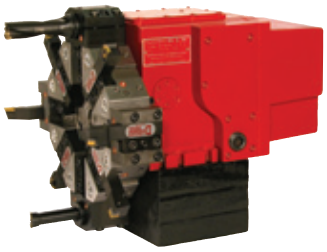
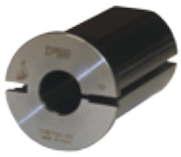


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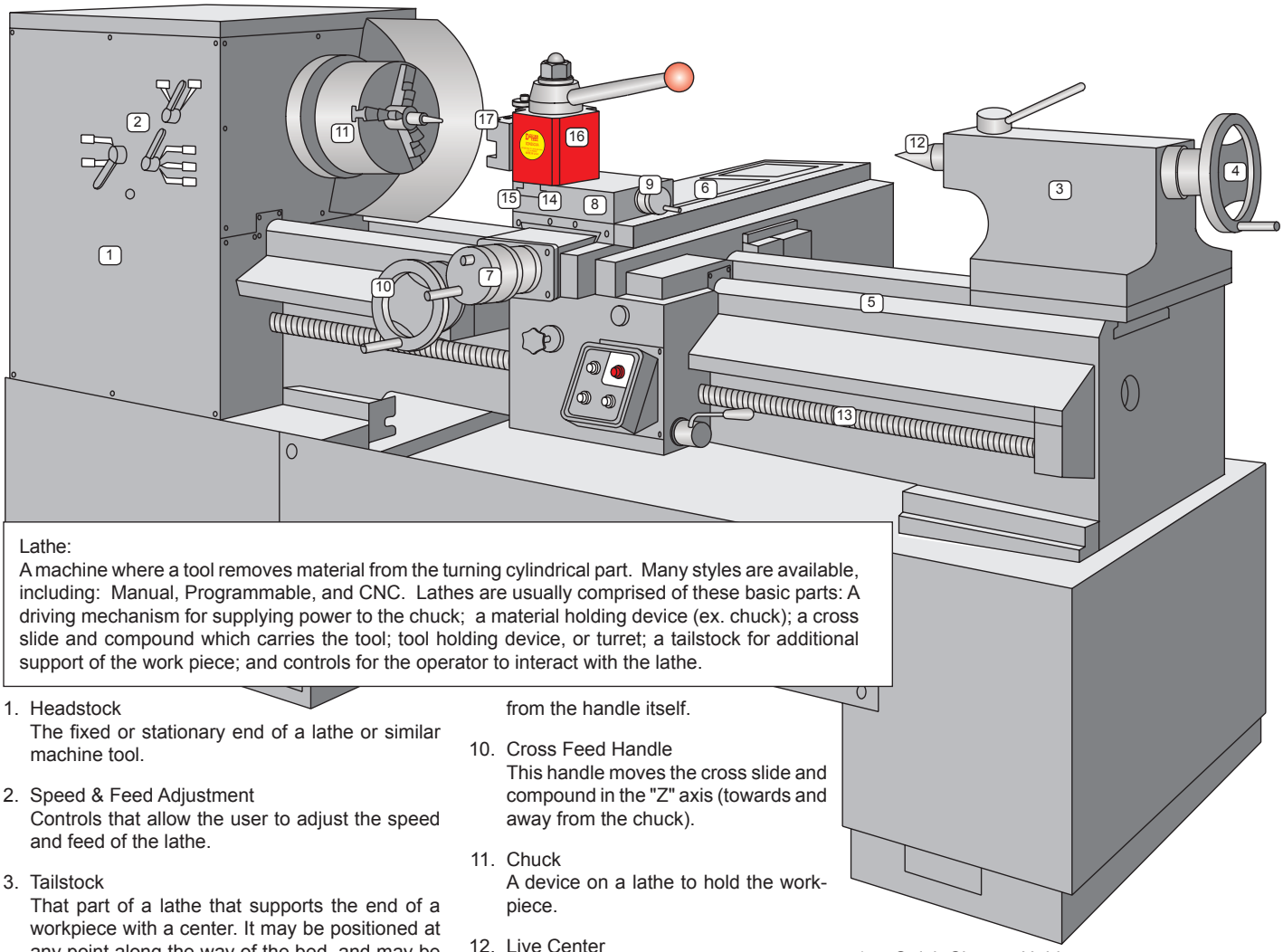












Lathe:
A machine where a tool removes material from the turning cylindrical part. Many styles are available, including: Manual, Programmable, and CNC. Lathes are usually comprised of these basic parts: A driving mechanism for supplying power to the chuck; a material holding device (ex. chuck); a cross 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
   That 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 work-piece.

12. Live Center
    A tool that is inserted into the tailstock to support longer 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 cavity 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.

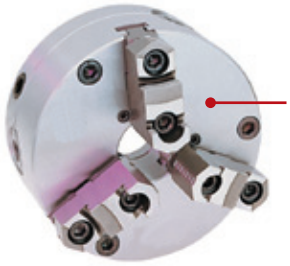
20. Shank Size
    The diameter of a round cutting tool or the height of a square shank cutting tool.

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.

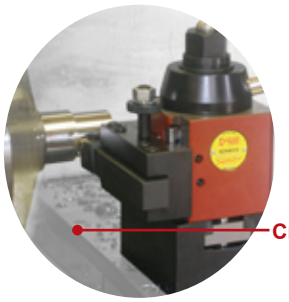
Chuck Guard: Protects the operator from chips and coolant.

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



Chuck

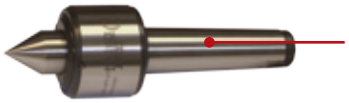
Cross-Slide: Where the tooling device such as a toolpost or turret is set up.



Cross-Slide

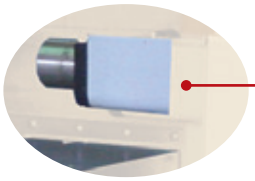
Manual Handle: To operates the machine manually.

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

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.



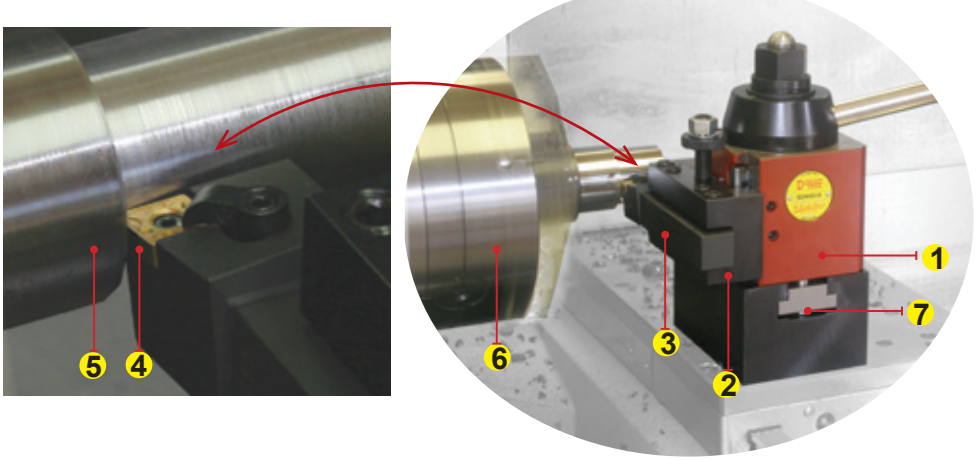
Tail Stock

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

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

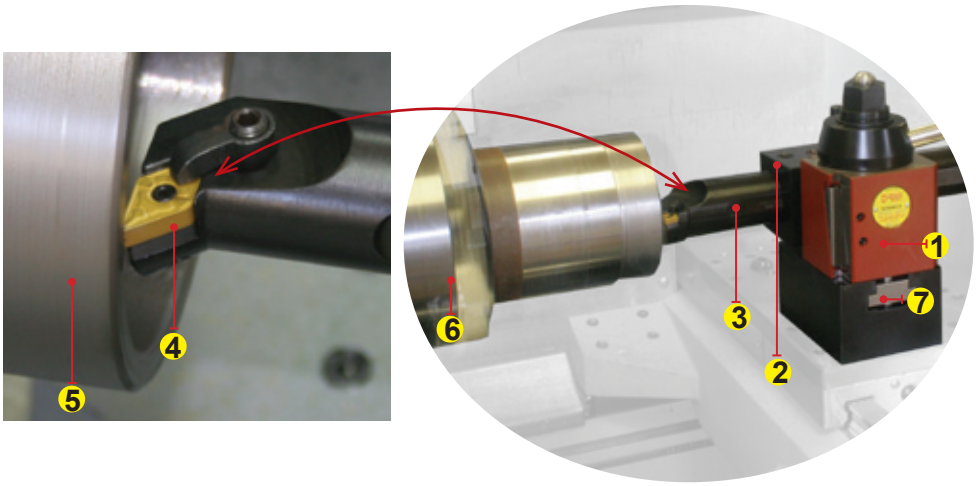
Turning Application with a Manual or CNC Toolroom Lathe

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



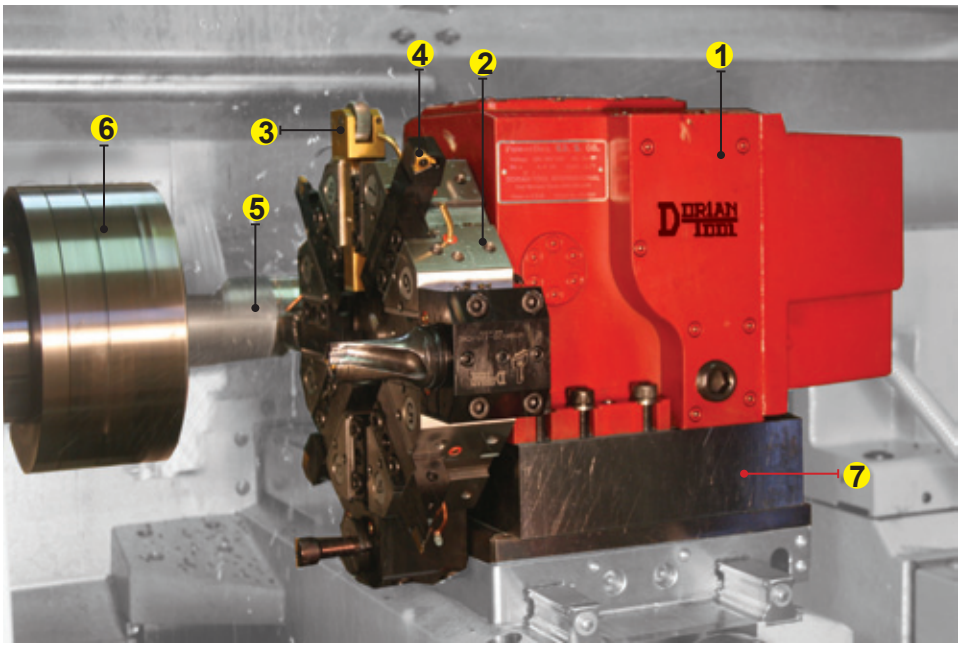
Boring Application with a Manual or CNC Toolroom Lathe

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



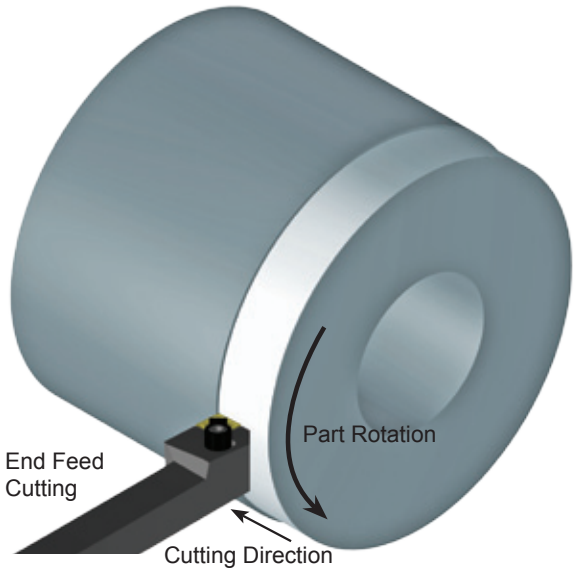
Automated Turning and Boring Applications with CNC Toolroom Lathe

1. CNC Automated Turret
2. Turret Head
3. Turning, Boring and various cutting operations are all applicable with the CNC Automated Turret.
4. Insert
5. Workpiece
6. Chuck
7. Custom Riser Block



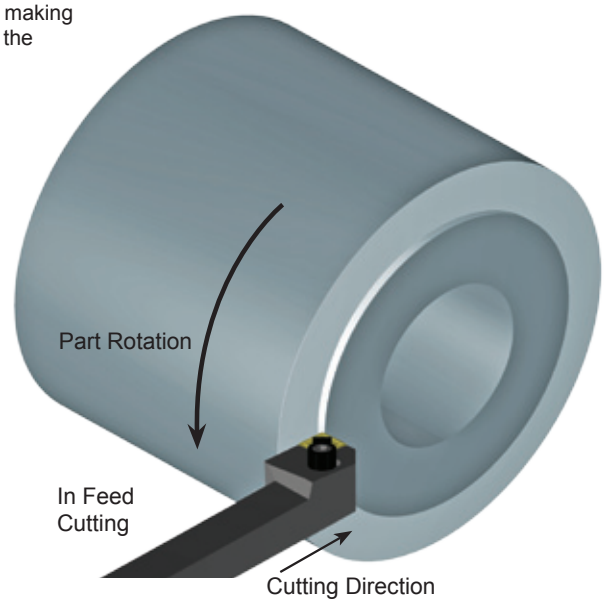
Turning Operation-

A machining process used to generate external, cylindrical forms by removing material, usually with a single-point cutting tool.



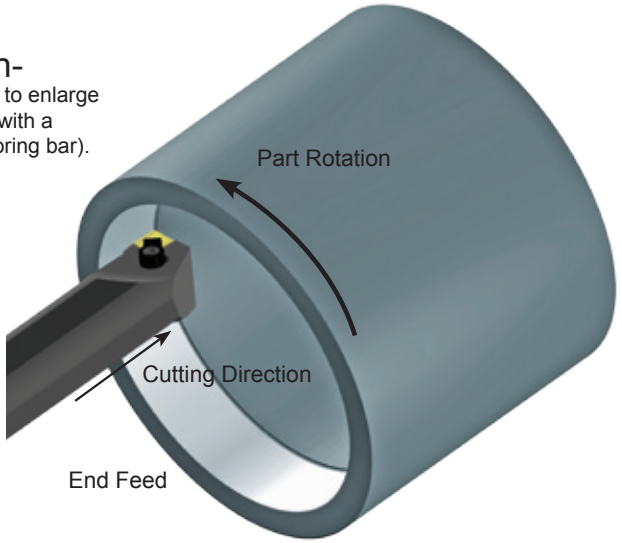
Facing Operation-

The process of making a flat surface at the end of a part.



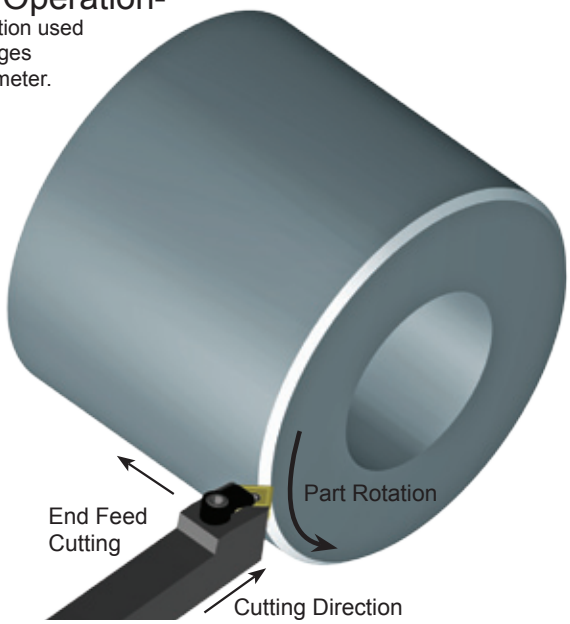
Boring Operation-

A machining process used to enlarge a cylindrical hole, usually with a single-point cutting tool (boring bar).



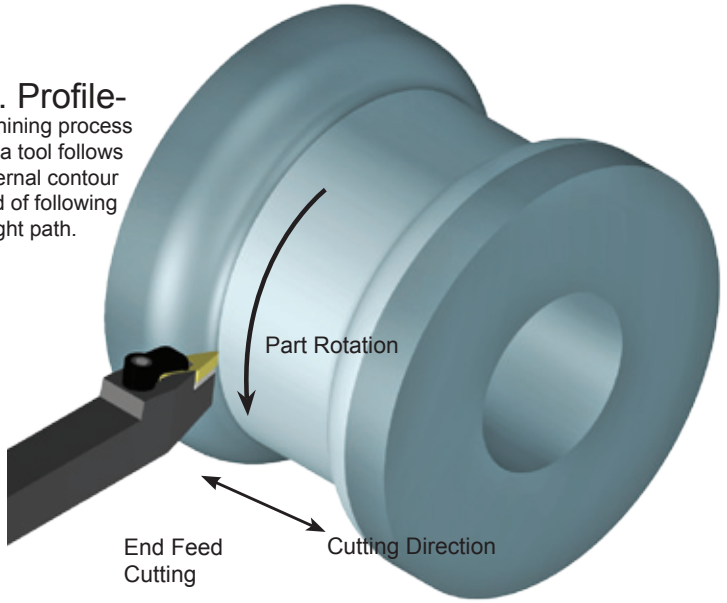
Chamfering Operation-

Metal turning operation used to remove sharp edges from workpiece diameter.



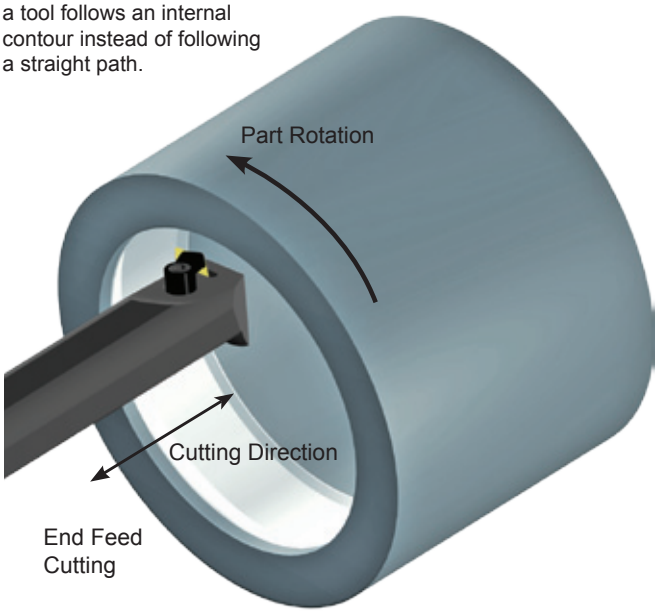
O.D. Profile-

A machining process where a tool follows an external contour instead of following a straight path.



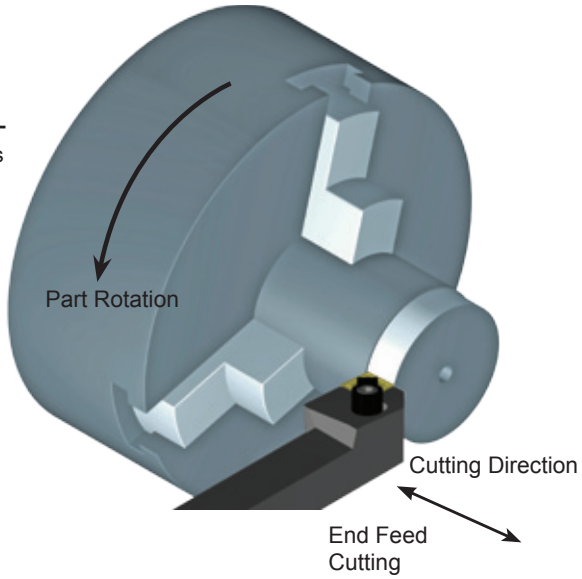
I.D. Profile-

A machining process where a tool follows an internal contour instead of following a straight path.



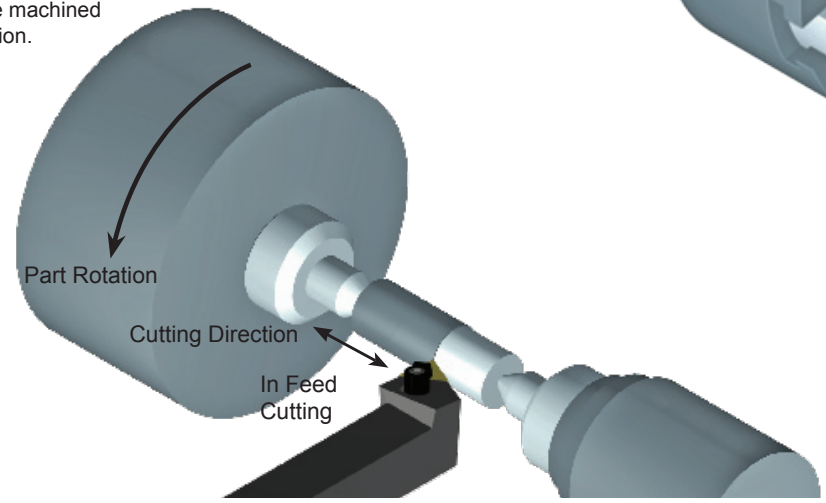
Chuck Work-

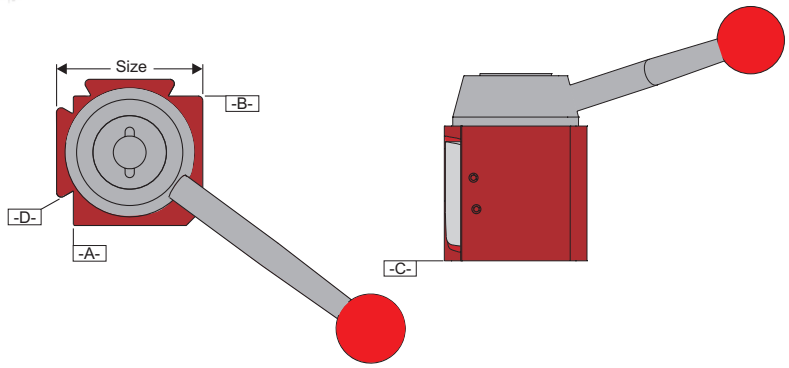
A machining process where any type of workpiece has to be held by a chuck.

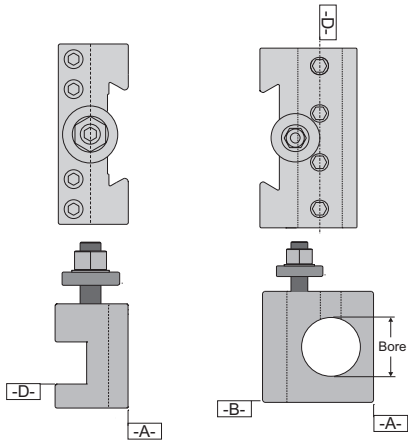


Between Centers Work-

A machining process where a work piece is held by using centers on each end. It allows the entire length of the outside diameter of the part to be machined in one continuous operation.





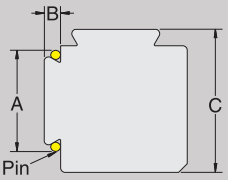


Tool Post Series	Size (Square) in.	mm
25	2.5	66
30	3.0	76
35	3.5	89
40	4.0	102
50	5.0	127
60	6.0	152
Tolerance (* Per Inches)		
Quick Change Repeatability	± .0001	± 0,00254
Face to Face Squareness A-B*	± .0001	± 0,00254
Bottom to Face Squareness A-C*	± .0001	± 0,00254
Bottom to Dovetail Squareness C-D*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

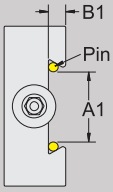
Holder Tolerance (* Per Inches)		in.	mm
Quick Change Repeatability		± .0001	± 0,00254
Face to Face Squareness		± .0005	± 0,0127
Bottom to Face Squareness		± .0005	± 0,0127
Bottom to Dovetail Squareness		± .0005	± 0,0127
Square Shank Holder Tolerance (* Per Inches)			
Tool Slot Taper	D	± .0001	± 0,00254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

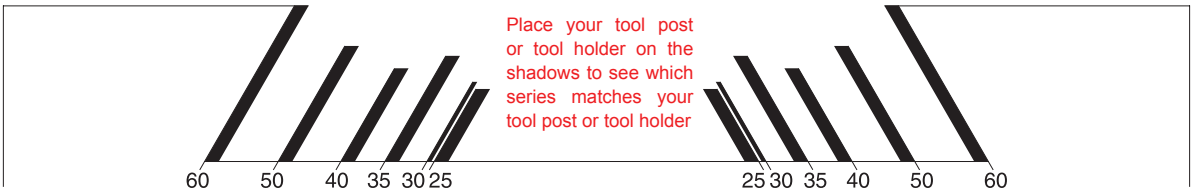


Toolholder Dovetail



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 size 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	V25tc	AXA	TP65A	250-100	QITP25N	-
	SDN30BXA	V30tc	BXA	TP75A	250-200	QITP30N	BXA-I
	SDN35CXA	V35tc	CXA	TP90A	250-300	QITP35N	-
	SDN40CA	V40tc	CA	TP100A	250-400	QITP40N	CA-I
	SDN50DA	V50tc	DA	TP125A	-	QITP50N	DA-I
	SDN60EA	V60tc	EA	TP150A	-	QITP60N	-

Quote No.
Purchase Order Number

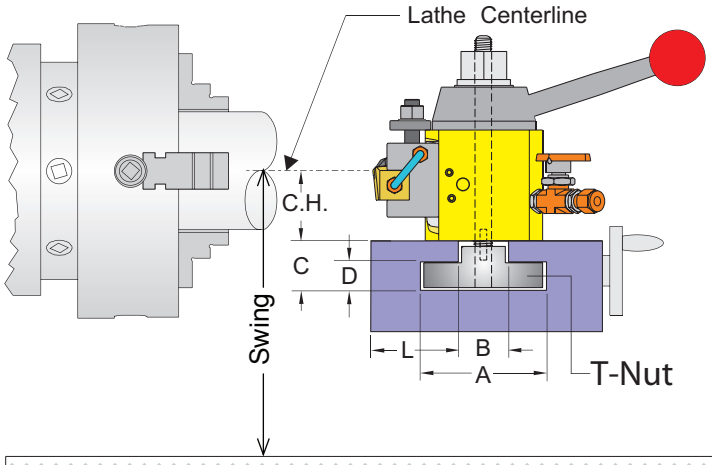
For Tool Post and Toolholder recommendations, please complete the sections below and fax to 979-282-2951

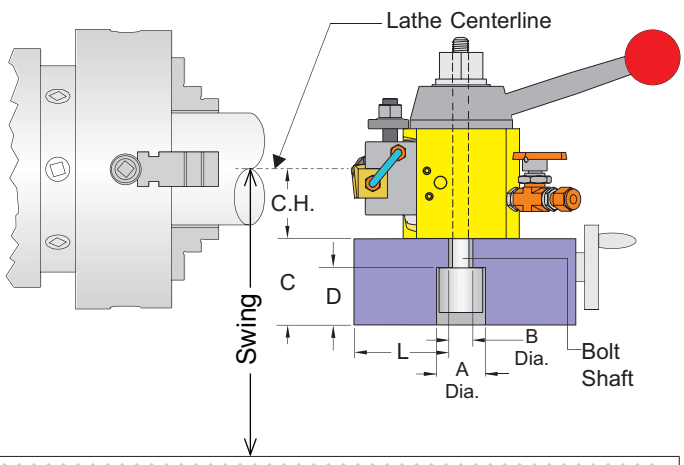
Company:			Name:
Address:			Phone ( )
City:	State:	Zip:	Fax ( )
Email:			Type of Machine:

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

American Style Mounting ("T-Nut") | T-Nut

European Style Mounting (Bolt Shaft) | Bolt Shaft





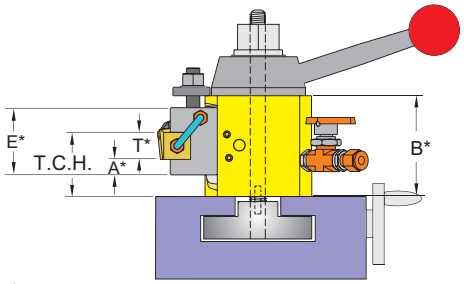
Lathe Bed

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

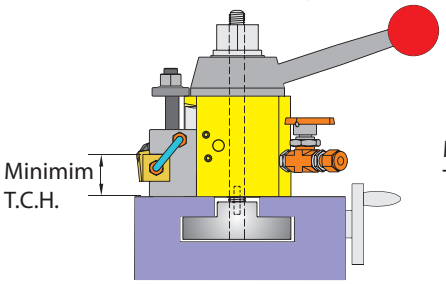
Tool Post recommendation will be based on the accuracy of the information provided by the customer. Each Tool Post is supplied with a Blank T-Nut or Bolt Shaft that the customer machines to their required dimensions. For custom machined T-Nut or Bolt Shaft, please specify the dimensions A, B, C, and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

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

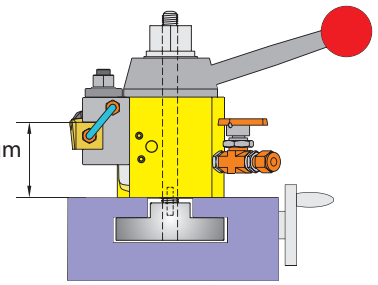
"CH" = Center Height is measured from top of compound to lathe center line
"A" = Toolholder bottom lip
"T" = Shank Size
"T.C.H." = Tool Center Height



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 size tool post for a particular lathe:

- Lathe swing
- Center height
- Tool size
- Mounting type
- Horse power of motor
- RPM of chuck
- Type of machine
- Type of work
- Prototype or production
- Roughing or finishing

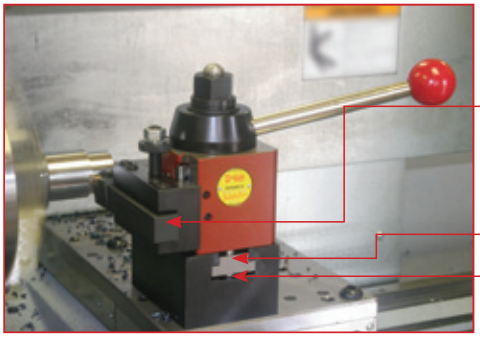
Customer to complete with choice of tool post & toolholders

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

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

- Made of more superior materials and heat treatment processes than any other tool post on the market.
- Top, bottom and dovetail surfaces are precision ground for utmost precision and repeatability.
- Oversized locking gear and wedge style sliding gibs for the most powerful locking mechanism on the market.
- Locking handle position can be adjusted in 15° increments so that it does not interfere with machine doors or chuck guards.
- All tool posts are individually inspected and qualified for accuracy, squareness and repeatability.

Precision! Rigidity ! Repeatability!

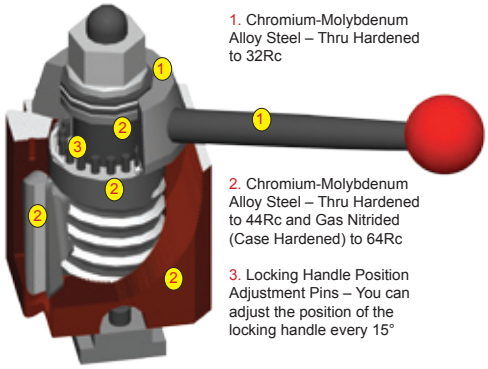


Super Quick Change Tool Post
Bonus Features:

Oversized-capacity, heavy duty turning and facing holders as standard for the same price as competition's smaller capacity turning and facing holders.

Machined T-Nut at no additional cost.

Two large dowel pins prevent the Tool Post from rotating under heavy drilling, boring or turning operations.



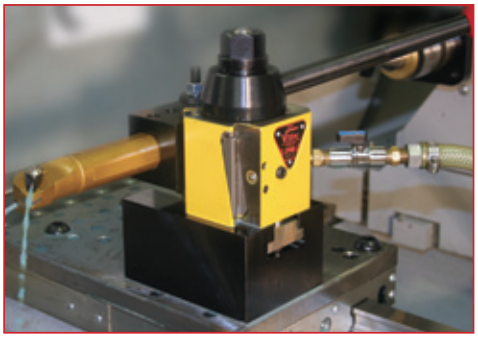
1. Chromium-Molybdenum Alloy Steel – Thru Hardened to 32Rc

2. Chromium-Molybdenum Alloy Steel – Thru Hardened to 44Rc and Gas Nitrided (Case Hardened) to 64Rc

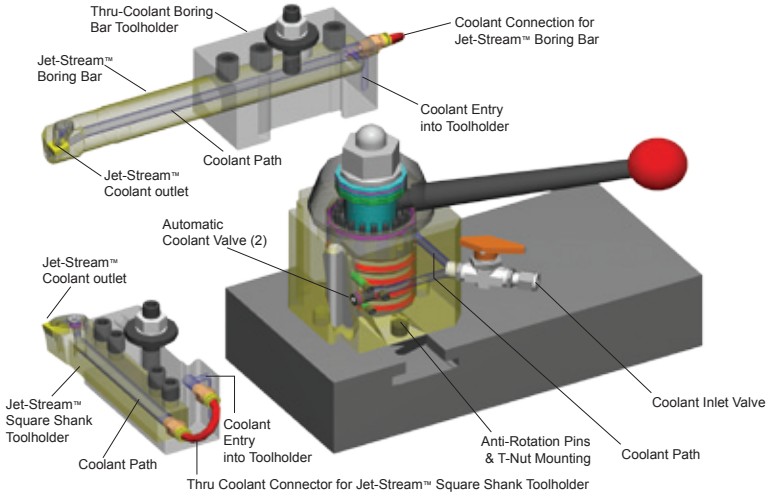
3. Locking Handle Position Adjustment Pins – You can adjust the position of the locking handle every 15°

Victory™ Thru Coolant Tool Post with Triple Action Wedge-Locking System

Includes all the same features as the Super Quick Change Tool Post Plus an Automatic Thru Coolant System

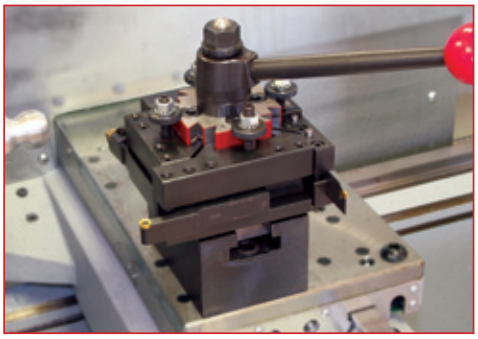


External Turning and Internal Boring with Automatic Thru Coolant



Quadra® IndexingTool Post with Advanced Indexing and Locking Technology

- Indexing repeatability of .00005"
- Toolholder locking repeatability of .0001"
- Ideal for prototype or high production
- Ideal for roughing and finishing
- Indexes every 15 degrees
- Quick and versatile for multiple operations

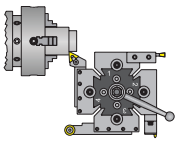


4 Tool Holders Held Simultaneously with a Quick Change Indexing System!

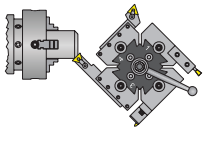
Strong! Rigid ! Precise!

24 Super Precise Positioning Ball Bearings & 2 Pre-Loaded Indexing Pins

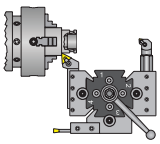
O.D. Turning Operations



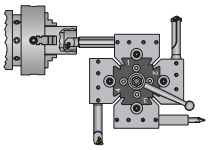
O.D. Chamfering Operations 15° Increments



Combination O.D. & I.D. Operations



I.D. Turning Operations

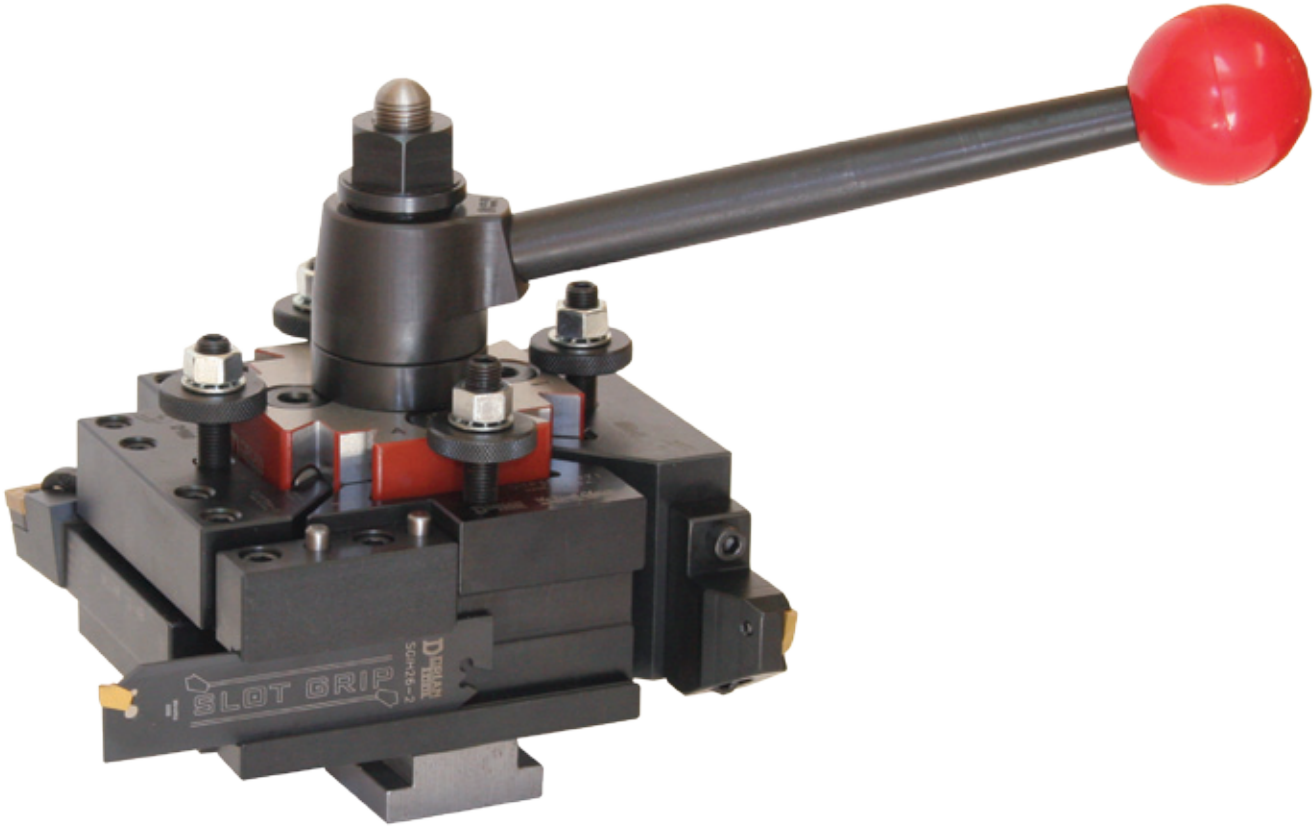


Quadra™ Indexing

Quick Change

Tool Post & Toolholders

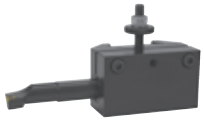
Section



Quick and Versatile for Any Operation!

Locking and Indexing System with 24 Super Precise Positioning Ball Bearings & 2 Pre-Loaded Indexing Pins

4 Toolholders Held Simultaneously!

Style	Features		Application
QITPN Quadra Indexing Quick Change Tool Post			
 PG. 15	• Heavy duty construction • Heat-treated alloy steel body • Precision ground • Four quick change tool holders locked independently • Industry Standard holders • Positive lock with absolute zero backlash • One to four tools ready to be used • Precise tool repeatability of .00005" / ,00127 mm • Cam-Lock toolholder locking system for maximum rigity	• 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			
 PG. 18	• Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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			
 PG. 18	• Boring Bar "V" Seat • Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001"	• Holds Square Shank Tools • Holds Boring Bars • Turning and Facing • Light to Medium Boring • Threading and Grooving • Cut-Off Applications
No. QITPN-3R Extended Turning & Facing Holder			
 PG. 18	• Extra Rigidity for Extended Reach • Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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-4,41,41S CNC Extra Heavy Duty Boring Bar Holder - CNC Locking system			
 PG. 19	• 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 • Sizes Up to 3" Capacity • Quick Change Mounting	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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
No. QITPN- 41, 41S COL Extra Heavy Duty Boring Bar Holder- Collar Locking System			
 PG. 20	• Precision Ground and Honed Bore • Qualified Bore for Precise Tool Alignment and Squareness • 360° Locking for High Rigidity and Extended Overhangs without Scarring the Boring Bar • Sizes Up to 3" Capacity • Quick Change Mounting	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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

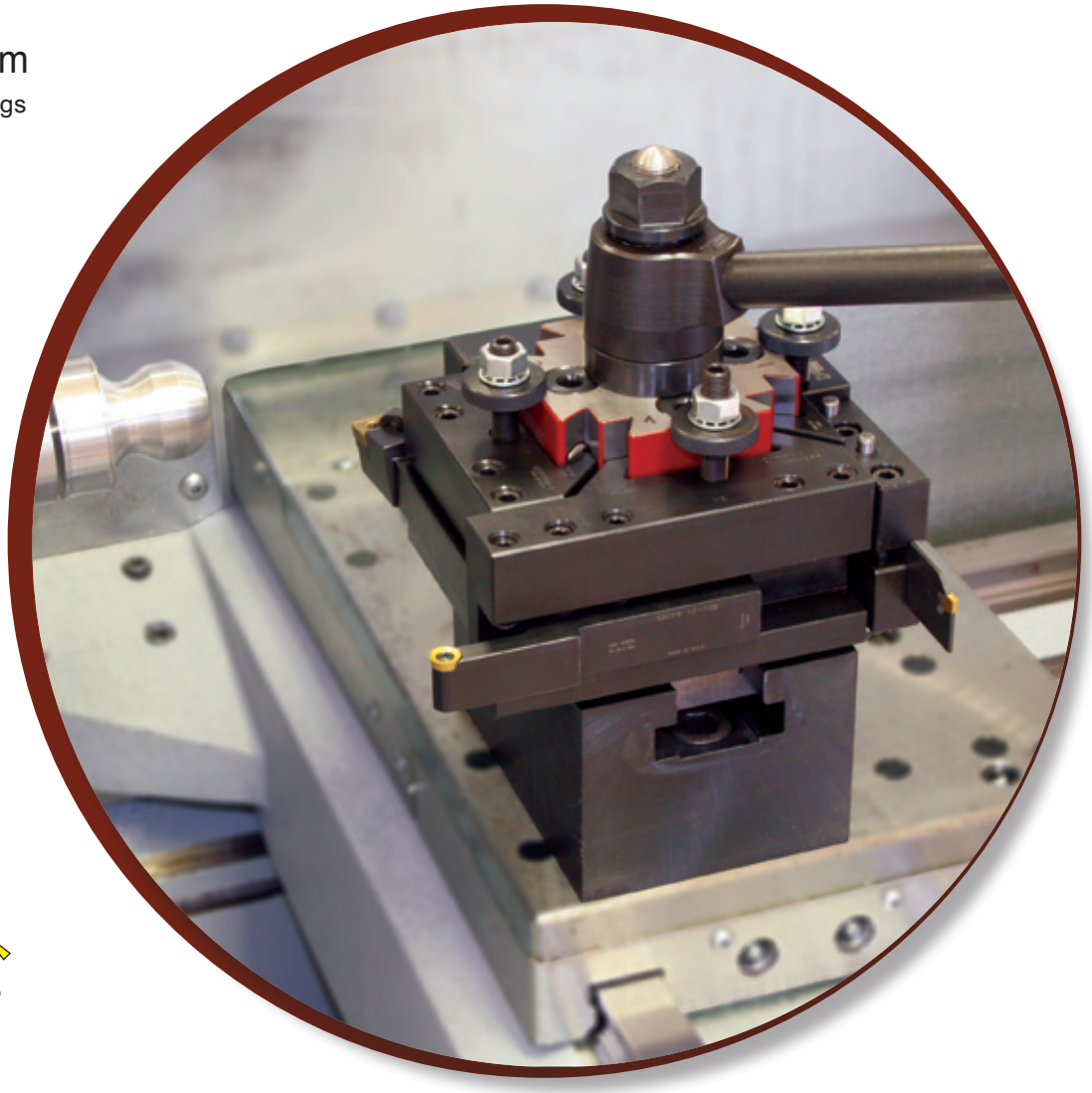
Style	Features		Application
No. QITPN-5 Morse Taper Holder			
 PG. 20	• Precision Ground Morse Taper • Qualified for Precise Tool Alignment and Squareness • Designed for Deep Drilling • Heavy Duty Drilling • Quick Change Mounting	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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			
 PG. 21	• Precision Ground Blade Dovetail Seat • Qualified for Precise Tool Alignment and Squareness • Quick Change Mounting • High Tensile Strength Chromium- Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Cut-Off Applications • Grooving Applications
No. QITPN-71S Oversized Cut-Off Blade Holder			
 PG. 21	• Oversized Blade Capacity • Precision Ground Blade Dovetail Seat • Qualified for Precise Tool Alignment and Squareness • Quick Change Mounting • High Tensile Strength Chromium- Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Cut-Off Applications • Grooving Applications
No. QITPN-881 O.D. or I.D. Threading Holder			
 PG. 23	• Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• OD and ID Threading
No. QITPN-10 Knurling Holder			
 PG. 24	• Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• OD Straight Knurling • OD Diamond Knurling
No. QITPN-35 Dovetail Drill Chuck Holder			
 PG. 24	• 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 • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Center Drilling • Precision Drilling • Precision Reaming • Tapping
No. QITPN-36 5C Collet Holder			
 PG. 25	• 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 • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Miniature to Medium Size Tools • For Special Tool Size and Shapes • Accepts Square, Round & Hex Collets • Drilling Aplications • Boring Applications • Reaming Applications • Tapping • From 1/16” to 1.0” Diameter Tools

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

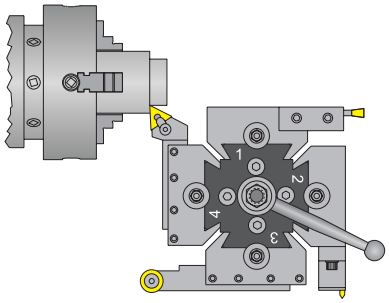
Locking and Indexing System

24 Super Precise Positioning Ball Bearings
& 2 Pre-Loaded Indexing Pins

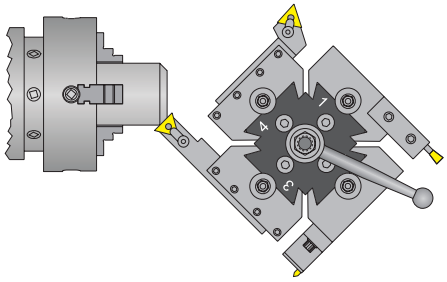
Strong - Rigid - Precise!



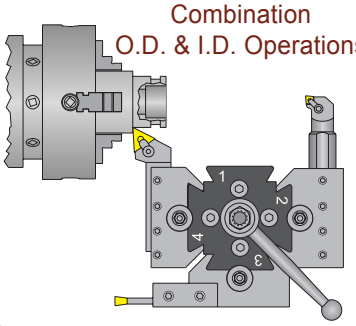
O.D. Turning Operations



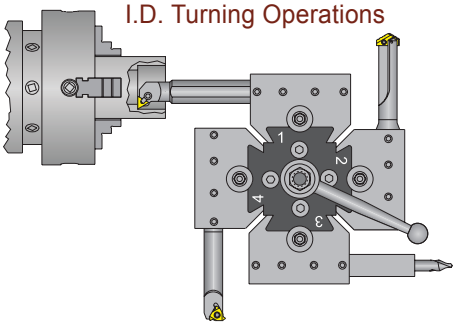
O.D. Chamfering Operations
15° Increments

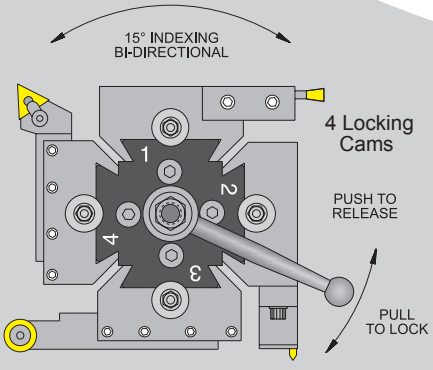


Combination
O.D. & I.D. Operations



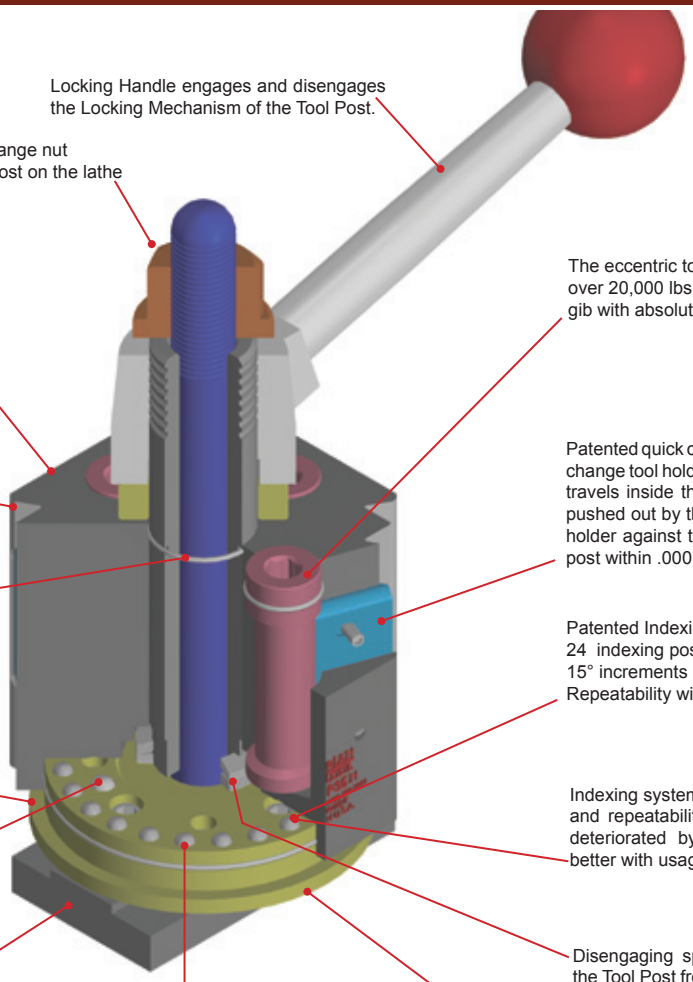
I.D. Turning Operations





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.



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

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

Heavy Duty Construction
Hardened and Precision Ground Alloy Steel

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

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

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.

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

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

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.

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

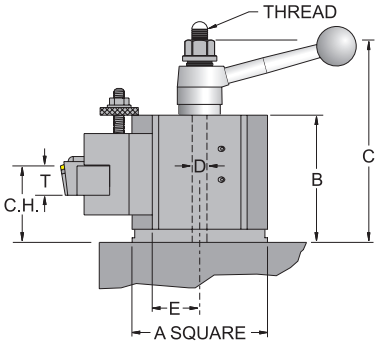
2 pre-loaded index pins locate the preset tool post positions.

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

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.

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



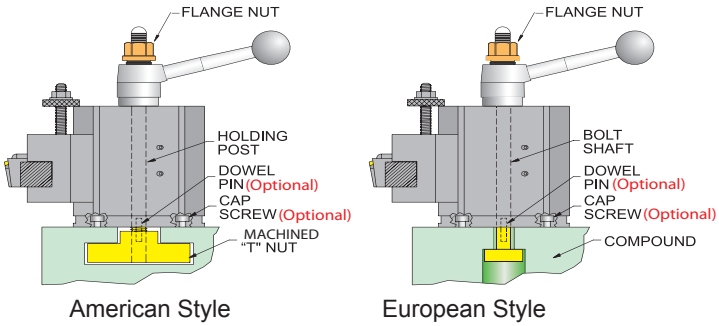
- 4 Tool Holders Held Simultaneously
- Indexing Repeatability within .00005”
- Tool Holder Repeatability within .0001”
- From Prototype to High Production
- Quick and Versatile for Any Operation
- 24 Locking Positions, every 15º
- Ideal for Manual & CNC Lathes
- Super Precise for Tight Tolerance Machining
- Heavy Duty For Oil Field Applications

Description	QITP25N		QITP30N		QITP35N		QITP40N		QITP50N		QITP60N	
Part No. 733101-	00000		00002		00004		00006		00008		00010	
Size	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
Optimim 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 size of the tool capacity.

Tool Post Mounting

Quick, Simple, & Rigid



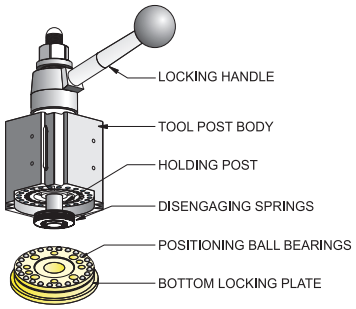
American Style European Style

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

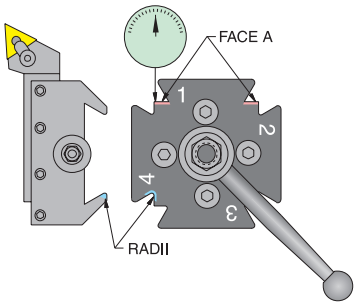
Repeatability within .00005"



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

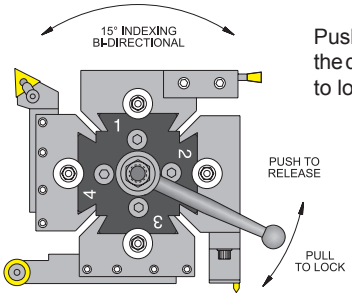
Squareness within .0005"



The four dovetails are machined at 90° square (± .0005"). At 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

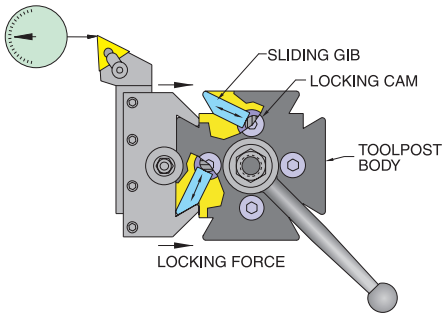
Index from Tool to Tool in Seconds



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

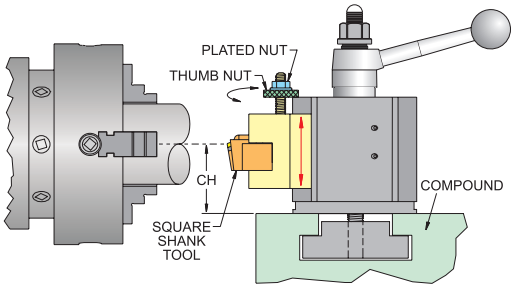


The holder locking system of the Quadra Indexing Tool Post is based on the four Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam style Locking Pin, locking it positively. The cam rotates from 0° (Release Position) to approximately 45° (Locking Position).

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



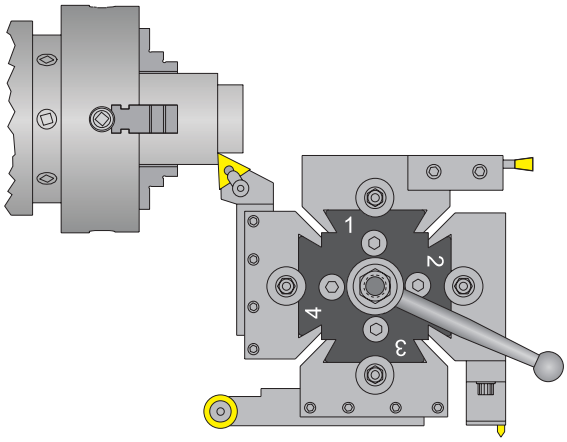
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool height, first, by screwing or unscrewing the Thumb Nut until the desired height is reached, and next, by locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder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

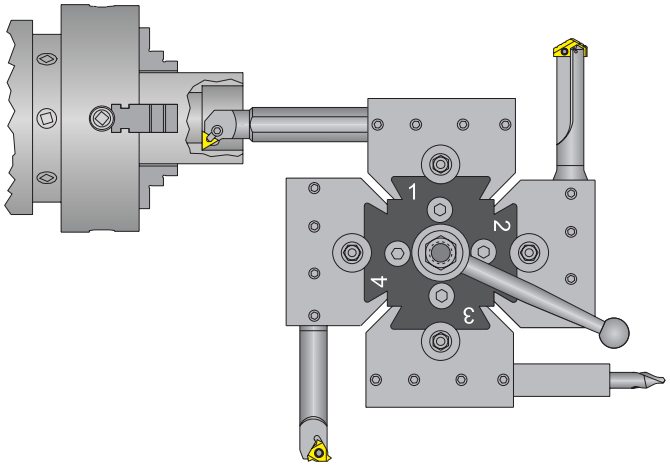
Finishing to Roughing or Threading



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

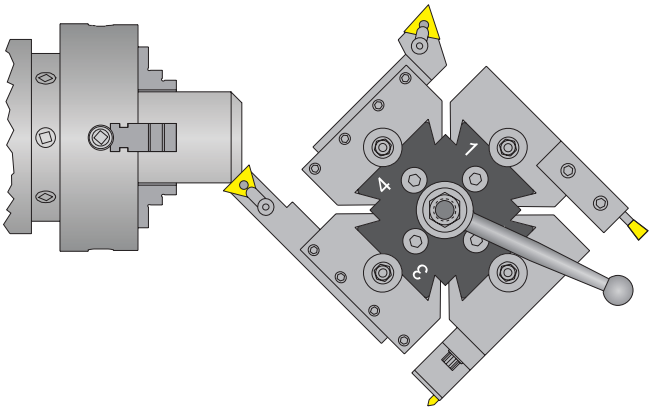
Finishing to Roughing or Threading



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

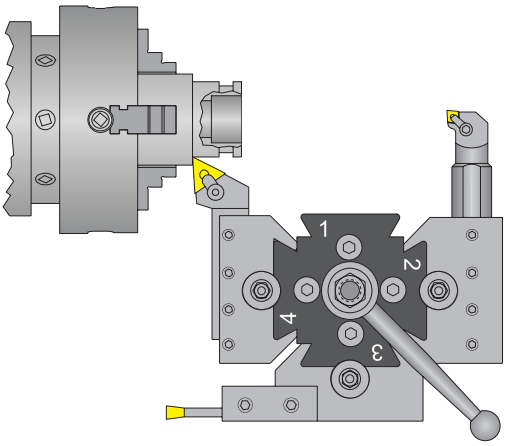
15° Increments



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

Combination O.D. & I.D. Operations

Finishing to Roughing or Threading

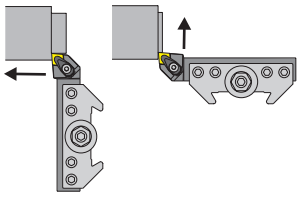


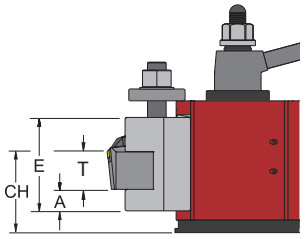
Combinations of O.D. and I.D. tools can be used on the tool post at once. For simple parts where minimum tool changes are required, this method can increase productivity and precision. Tool clearance should be considered when placing the tools on the tool post.

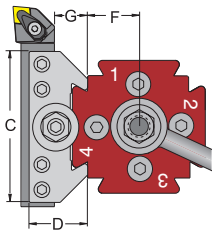
No. QITPN-1

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.





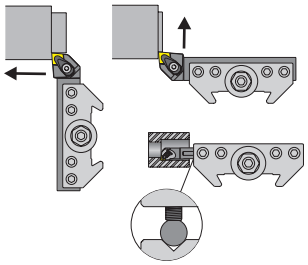


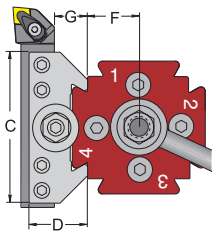
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP25N-1	00100	in	0.375	.750	2.750	1.240	1.740	0.880	0.770
		mm	9.53	20	69.85	31.50	44.20	22.35	19.56
QITP30N-1	00250	in	0.437	1.000	3.250	1.490	2.240	1.115	0.890
		mm	11.10	25	82.55	37.85	56.90	28.32	22.61
QITP35N-1	00400	in	0.500	1.000	3.750	1.740	2.490	1.245	1.010
		mm	12.70	25	95.25	44.20	63.25	31.62	25.65
QITP40N-1	00550	in	0.562	1.250	4.500	1.990	2.990	1.530	1.040
		mm	14.27	32	114.30	50.55	75.95	38.86	26.42
QITP50N-1	00700	in	0.750	1.500	6.000	2.490	3.490	1.900	1.290
		mm	19.05	40	152.40	63.25	88.65	48.26	32.77
QITP60N-1	00850	in	1.000	1.500	7.000	2.990	3.990	2.207	1.540
		mm	25.40	40	177.80	75.95	101.35	56.06	39.12

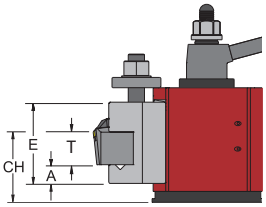
No. QITPN-2

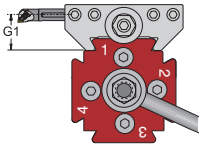
Turning, Facing & Boring Toolholder

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







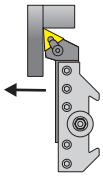


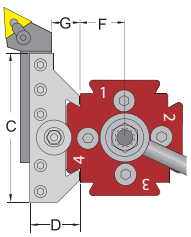
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G	G1
QITP25N-2	00104	in	0.375	.750	2.750	1.240	1.740	0.880	0.770	1.030
		mm	9.53	20	69.85	31.50	44.20	22.35	19.56	26.16
QITP30N-2	00254	in	0.437	1.000	3.250	1.490	2.240	1.115	0.890	1.210
		mm	11.10	25	82.55	37.85	56.90	28.32	22.61	30.73
QITP35N-2	00404	in	0.500	1.000	3.750	1.740	2.490	1.245	1.010	1.410
		mm	12.70	25	95.25	44.20	63.25	31.62	25.65	35.81
QITP40N-2	00554	in	0.562	1.250	4.500	1.990	2.990	1.530	1.040	1.575
		mm	14.27	32	114.30	50.55	75.95	38.86	26.42	40.01
QITP50N-2	00704	in	0.750	1.500	6.000	2.490	3.490	1.900	1.290	1.950
		mm	19.05	40	152.40	63.25	88.65	48.26	32.77	49.53
QITP60N-2	00854	in	1.000	1.500	7.000	2.990	3.990	2.207	1.540	2.340
		mm	25.40	40	177.80	75.95	101.35	56.06	39.12	59.44

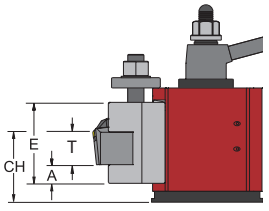
No. QITPN-3 Extended

Turning & Facing Toolholder

This holder is best used for extended reach turning operations. Fits industry standard tool posts.







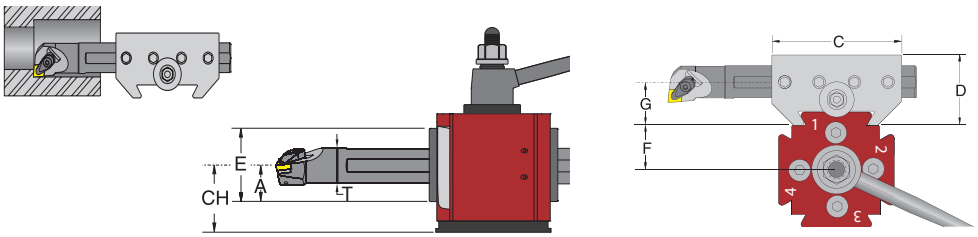
QITP Description	Part No. 733101-	Size	A	T	C	D	E	F	G
QITP25N-3R	00106	in	0.375	0.750	3.625	1.240	1.740	0.880	0.770
		mm	9.53	20	92.08	31.50	44.20	22.35	19.56
QITP30N-3R	00256	in	0.437	1.00	4.125	1.490	2.240	1.115	0.890
		mm	11.10	25	104.78	37.85	56.90	28.32	22.61
QITP35N-3R	00406	in	0.500	1.00	5.250	1.740	2.490	1.245	1.010
		mm	12.70	25	133.35	44.20	63.25	31.62	25.65
QITP40N-3R	00556	in	0.562	1.250	6.000	1.990	2.990	1.530	1.040
		mm	14.27	32	152.40	50.55	75.95	38.86	26.42
QITP50N-3R	00706	in	0.750	1.500	8.000	2.490	3.490	1.900	1.290
		mm	19.05	40	203.20	63.25	88.65	48.26	32.77
QITP60N-3R	00856	in	1.000	1.500	10.000	2.990	3.990	2.207	1.540
		mm	25.40	40	254.00	75.95	101.35	56.06	39.12

No. QITPN-4-CNC

Heavy Duty Boring Bar Toolholder

Inch/Metric

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.



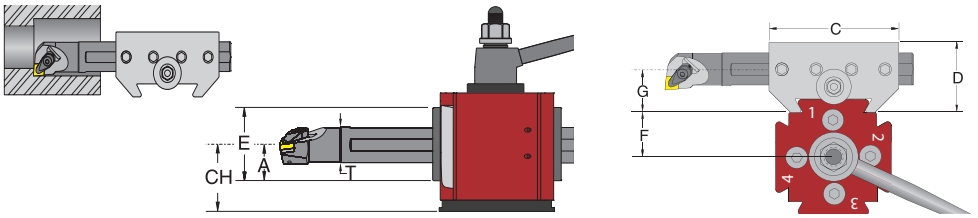
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP25N-4-CNC	00110	in	0.745	0.750	2.750	1.490	1.490	0.880	0.937
QITP25N-4M-CNC	00112	mm	18.92	20.00	69.85	37.85	37.85	22.35	23.80
QITP30N-4-CNC	00260	in	0.995	1.000	3.250	1.990	1.990	1.115	1.250
QITP30N-4M-CNC	00262	mm	25.27	25.00	82.55	50.55	50.55	28.32	31.75
QITP35N-4-CNC	00410	in	1.120	1.000	3.750	2.240	2.240	1.245	1.375
QITP35N-4M-CNC	00412	mm	28.45	25.00	95.25	56.90	56.90	31.62	34.93
QITP40N-4-CNC	00560	in	1.245	1.250	4.500	2.490	2.490	1.530	1.500
QITP40N-4M-CNC	00562	mm	31.62	32.00	114.30	63.25	63.25	38.86	38.10
QITP50N-4-CNC	00710	in	1.495	1.500	5.500	2.990	2.990	1.900	2.000
QITP50N-4M-CNC	00712	mm	37.97	40.00	139.70	75.95	75.95	48.26	50.80
QITP60N-4-CNC	00860	in	1.995	2.000	6.500	3.990	3.990	2.207	2.500
QITP60N-4M-CNC	00862	mm	50.67	50.00	165.10	101.35	101.35	56.06	63.50

No. QITPN-41-CNC

Extra Heavy Duty Boring Bar Toolholder

Inch/Metric

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.



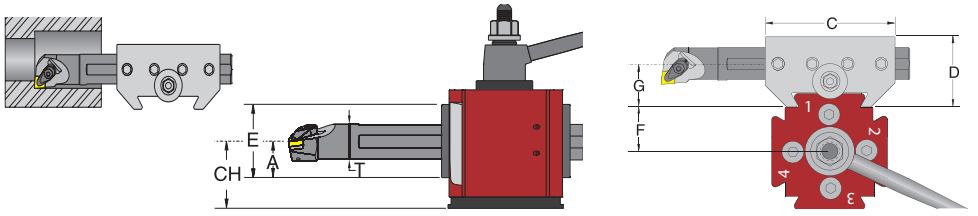
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP25N-41-CNC	00114	in	0.870	1.000	2.750	1.740	1.740	0.880	1.062
QITP25N-41M-CNC	00116	mm	22.10	25.00	69.85	44.20	44.20	22.35	26.97
QITP30N-41-CNC	00264	in	1.120	1.250	3.250	2.240	2.240	1.115	1.375
QITP30N-41M-CNC	00266	mm	28.45	32.00	82.55	56.90	56.90	28.32	34.93
QITP35N-41-CNC	00414	in	1.120	1.250	3.750	2.240	2.240	1.245	1.375
QITP35N-41M-CNC	00416	mm	28.45	32.00	95.25	56.90	56.90	31.62	34.93
QITP40N-41-CNC	00564	in	1.370	1.500	4.500	2.740	2.740	1.530	1.625
QITP40N-41M-CNC	00566	mm	34.80	40.00	114.30	69.60	69.60	38.86	41.28
QITP50N-41-CNC	00714	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250
QITP50N-41M-CNC	00716	mm	44.32	50.00	139.70	88.65	88.65	48.26	57.15
QITP60N-41-CNC	00864	in	2.245	2.500	6.500	4.490	4.490	2.207	2.750
QITP60N-41M-CNC	00866	mm	57.02	60.00	165.10	114.05	114.05	56.06	69.85

No. QITPN-41S-CNC

Super Oversized Boring Bar Toolholder

Inch/Metric

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.

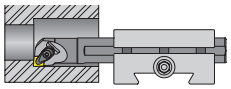


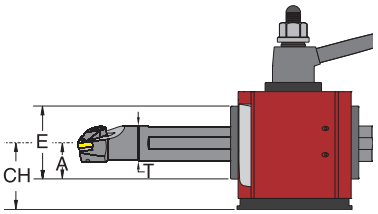
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP35N-41-150-CNC	00418	in	1.245	1.500	4.000	2.490	2.490	1.245	1.500
QITP35N-41M-40-CNC	00420	mm	31.62	40	101.6	63.25	63.25	31.62	38.1
QITP40N-41-200-CNC	00568	in	1.495	2.000	4.500	2.990	2.990	1.530	1.750
QITP40N-41M-50-CNC	00570	mm	37.97	50	114.3	75.95	75.95	38.86	44.45
QITP50N-41-250-CNC	00718	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250
QITP50N-41M-60-CNC	00720	mm	50.67	60	165.1	101.35	101.35	48.26	57.15
QITP60N-41-300-CNC	00868	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625
QITP60N-41M-80-CNC	00870	mm	57.02	80	177.8	114.05	114.05	56.06	66.68

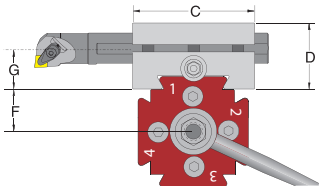
No. QITPN-41-COL

Extra Heavy Duty Boring Bar Toolholder
Inch

This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system providing the best rigidity in metal removing without scarring the boring bar. Fits industry standard tool posts.





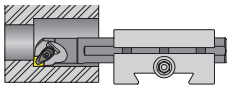


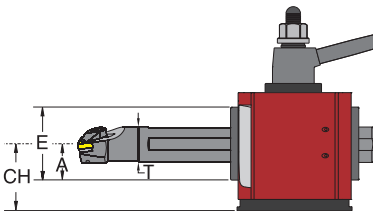
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP35N-41-COL	00456	in	1.220	1.250	4.000	2.490	2.490	1.245	1.500
QITP40N-41-COL	00604	in	1.395	1.500	4.500	2.990	2.990	1.530	1.750
QITP50N-41-COL	00746	in	1.995	2.000	6.500	3.990	3.990	1.900	2.250
QITP60N-41-COL	00896	in	2.245	2.500	7.000	4.490	4.490	2.207	2.625

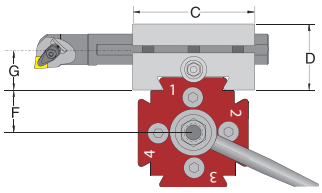
No. QITPN-41S-COL

Super Oversized Boring Bar Toolholder
Inch

This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system providing the best rigidity in metal removing without scarring the boring bar. Fits industry standard tool posts.





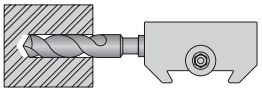


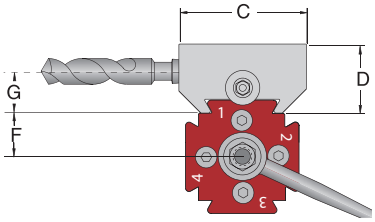
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP35N-41-150-COL	00458	in	1.220	1.500	4.000	2.490	2.490	1.245	1.500
QITP40N-41-200-COL	00606	in	1.395	2.000	4.500	2.990	2.990	1.530	1.750
QITP50N-41-250-COL	00748	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250
QITP60N-41-300-COL	00898	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625

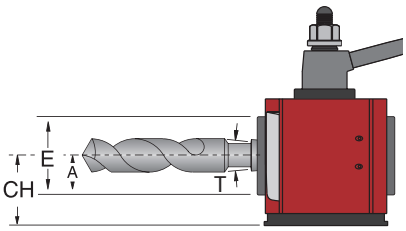
No. QITPN-5

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.







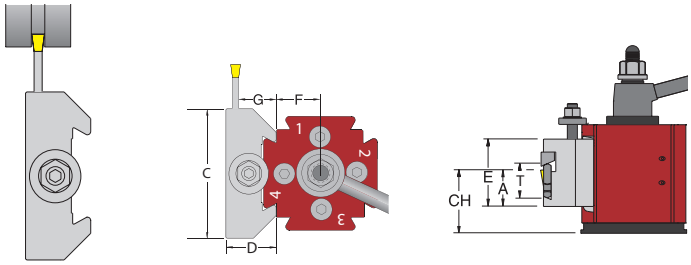
QITP Description	Part No.733101-	Size	A	T	C	D	E	F	G
QITP25N-5-2	00122	in	0.750	MT2	2.750	1.500	1.500	0.880	0.930
		mm	19.05	MT2	69.85	38.10	38.10	22.35	23.62
QITP30N-5-3	00272	in	1.000	MT3	3.500	2.000	2.000	1.115	1.250
		mm	25.40	MT3	88.90	50.80	50.80	28.32	31.75
QITP35N-5-4	00424	in	1.250	MT4	4.150	2.500	2.500	1.245	1.615
		mm	31.75	MT4	105.41	63.50	63.50	31.62	41.02
QITP40N-5-4	00572	in	1.250	MT4	4.500	2.500	2.500	1.530	1.615
		mm	31.75	MT4	114.30	63.50	63.50	38.86	41.02
QITP50N-5-5	00722	in	1.750	MT5	5.625	3.500	3.500	1.900	2.310
		mm	44.45	MT5	142.88	88.90	88.90	48.26	58.67
QITP60N-5-5	00872	in	1.750	MT5	5.625	3.500	3.500	2.207	2.310
		mm	44.45	MT5	142.88	88.90	88.90	56.06	58.67

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



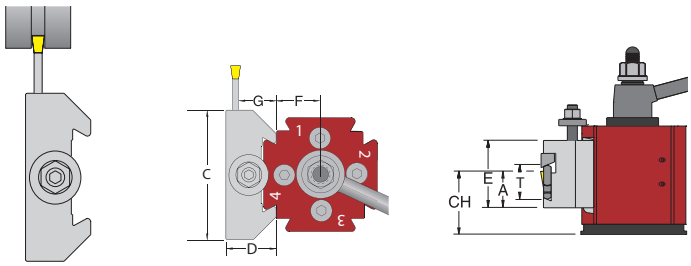
QITP Description	Part No. 733101-	Size	A	Slot Grip Blade Size "T"	C	D	E	F	G
QITP25N-7-71C	00126	in	0.875	SGIH-19-2	1.250	1.250	1.750	0.880	1.090
		mm	22.23		31.75	31.75	44.45	22.35	27.69
QITP30N-7-71C	00276	in	0.905		1.500	1.500	2.000	1.115	1.340
		mm	22.99		38.10	38.10	50.80	28.32	34.04
QITP35N-7-71C	00428	in	1.330	SGIH-26-2 to 26-6	1.500	1.750	2.500	1.245	1.530
		mm	33.78		38.10	44.45	63.50	31.62	38.86
QITP40N-7-71C	00576	in	1.330		1.500	1.750	2.500	1.530	1.530
		mm	33.78		38.10	44.45	63.50	38.86	38.86
QITP50N-7-71C	00726	in	1.585	SGIH-32-3 to 32-9	2.000	2.250	3.250	1.900	1.980
		mm	40.26		50.80	57.15	82.55	48.26	50.29
QITP60N-7-71C	00876	in	1.710		2.250	2.250	3.250	2.207	1.980
		mm	43.43		57.15	57.15	82.55	56.06	50.29

No. QITPN-71S

Oversized Cut-Off Blade Toolholder

This holder is best used for holding oversized 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.

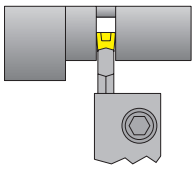
For Slot Grip Cut-Off Blades and Inserts see next page

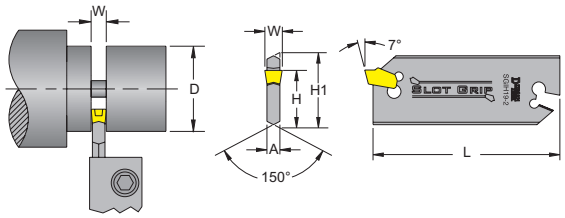


QITP Description	Part No. 733101-	Size	A	Slot Grip Blade Size "T"	C	D	E	F	G
QITP25N-71-26	00128	in	1.125	SGIH-26-2 to 26-6	2.750	1.500	2.000	0.880	1.280
		mm	28.58		69.85	38.10	50.80	22.35	32.51
QITP30N-71-26	00278	in	1.250		3.250	1.500	2.250	1.115	1.280
		mm	31.75		82.55	38.10	57.15	28.32	32.51
QITP35N-71-32	00430	in	1.500	SGIH-32-3 to 26-6	3.750	1.750	2.500	1.245	1.500
		mm	38.10		95.25	44.45	63.50	31.62	38.10
QITP40N-71-32	00578	in	1.500		4.500	1.750	2.500	1.530	1.500
		mm	38.10		114.30	44.45	63.50	38.86	38.10

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 permits free chip flow, minimizing insert breakage due to chip build-up.

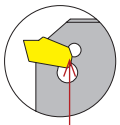






SLOT GRIP

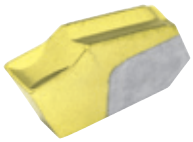
Improved design featuring a "Positive Stop". Inserts are securely held in Slot Grip Positive Stop Blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is firmly in place.



Positive Stop

Desc.	Part No. 733101-	Insert Used	W		D Max		A		L		H		H 1	
			in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
SGIH19-2	62950	SGT(N/R/L)-2	.087	2	1.57	39,9	.063	1,57	3.38	85,9	.618	15,7	0.75	19,1
SGIH26-2	62951	SGT(N/R/L)-2	.087	2	2.00	50,8	.063	1,57	4.33	110,0	.842	21,4	1.02	25,9
SGIH26-3	62952	SGT(N/R/L)-3	.122	3	3.00	76,2	.094	2,39						
SGIH26-4	62953	SGT(N/R/L)-4	.161	4	3.15	80,0	.125	3,18						
SGIH26-5	62954	SGT(N/R/L)-5	.201	5	3.15	80,0	.156	3,96						
SGIH26-6	62955	SGT(N/R/L)-6	.252	6	3.15	80,0	.203	5,16						
SGIH32-3	62956	SGT(N/RL)-3	.122	3	3.94	100,0	.094	2.39	5.90	149.9	.984	25,0	1.25	31,8
SGIH32-4	62957	SGT(N/R/L)-4	.161	4	3.94	100,0	.125	3,18						
SGIH32-5	62958	SGT(N/R/L)-5	.201	5	4.71	119,6	.156	3,96						
SGIH32-6	62959	SGT(N/R/L)-6	.252	6	4.72	119,9	.203	5,16						
SGIH32-8	62960	SGT(N/R/L)-8	.315	8	5.51	140,0	.268	6,81						
SGIH32-9	62961	SGT(N/R/L)-9	.378	9	5.51	140,0	.312	7,92						

Cut-Off & Grooving Inserts



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.

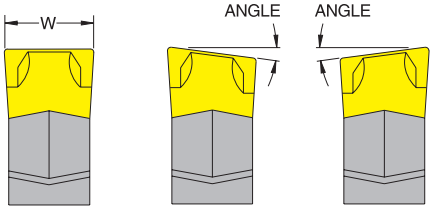
DC656 - (C5-C6 Substrate with CVD TiN/TiC-TiN coating) First Choice for general turning applications on ferrous metals and 400 series stainless steels, at medium cutting sfm and wet conditions. Multi Layer CVD carbide grade. Thermal deformation and abrasion resistant substrate with cobalt enriched periphery.

Chipbreaker Geometry

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

Application

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

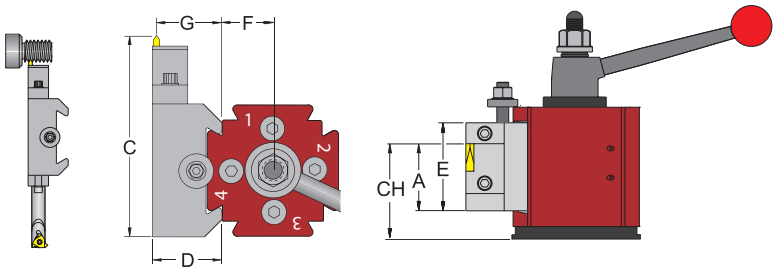


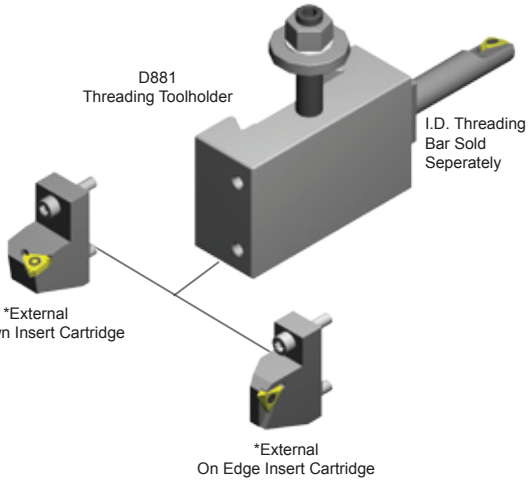
Desc.	DASK25 First Choice for High Performance Machining	DC656 First Choice for General Turning Applications	Insert Size	Lead Angle	Width + .004	
					in	mm
SGTN-2	82223	82222	2	0°	.087	2mm
SGTR-2-8	82251	82250	2	8°	.087	2mm
SGTL-2-8	82279	82278	2	8°	.087	2mm
SGTN-3	82227	82226	3	0°	.122	3mm
SGTR-3-8	82255	82254	3	8°	.122	3mm
SGTL-3-8	82283	82282	3	8°	.122	3mm
SGTN-4	82231	82230	4	0°	.161	4mm
SGTR-4-8	82259	82258	4	8°	.161	4mm
SGTL-4-8	82287	82286	4	8°	.161	4mm
SGTN-5	82235	82234	5	0°	.201	5mm
SGTR-5-8	82263	82262	5	8°	.201	5mm
SGTL-5-8	82291	82290	5	8°	.201	5mm
SGTN-6	82239	82238	6	0°	.252	6mm
SGTR-6-8	82267	82266	6	8°	.252	6mm
SGTL-6-8	82295	82294	6	8°	.252	6mm
SGTN-8	82243	82242	8	0°	.315	8mm
SGTR-8-8	82271	82270	8	8°	.315	8mm
SGTL-8-8	82299	82298	8	8°	.315	8mm
SGTN-9	82247	82246	9	0°	.378	9mm
SGTR-9-8	82275	82274	9	8°	.378	9mm
SGTL-9-8	82303	82302	9	8°	.378	9mm

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	Part No. 733101-	Size	A	C	D	E	F	G	*External On Edge Insert Cartridge					*External Laydown Insert Cartridge						
									Desc.	Part No. 733101-	TNMC Insert	Torx Screw	Torx Key	Desc.	Part No. 733101-	Insert	Torx Screw	Torx Key	Pitch TPI	Pitch mm
QITP25N-881-OE	00132	in	4.130	1.250	1.750	0.880	1.250	1.000	TIH253-32	03621	32	GTS-1	T-10	NL253-3R	03635	16ER-AG60	TS-16	T-10	8-48	0,5-3,5
QITP25N-881-LD	00133	mm	104.90	31.75	44.45	22.35	31.75	25.40												
QITP30N-881-OE	00282	in	4.630	1.500	2.000	1.115	1.500	1.250												
QITP30N-881-LD	00283	mm	117.60	38.10	50.80	28.32	38.10	31.75												
QITP35N-881-OE	00434	in	5.630	1.750	2.500	1.245	1.685	1.435	TIH354-32	03623	32	GTS-1	T-10	NL354-3R	03637	16ER-AG60	TS-16	T-10	8-48	0,5-3,5
QITP35N-881-LD	00435	mm	143.00	44.45	63.50	31.62	42.80	36.45												
QITP40N-881-OE	00582	in	6.130	1.750	2.500	1.530	1.685	1.435												
QITP40N-881-LD	00583	mm	155.70	44.45	63.50	38.86	42.80	36.45												

*Part Descriptions ending in -OE come with External On Edge Insert Cartridge. Part Descriptions ending in -LD come with External Laydown Insert Cartridge. Inserts not included. Internal threading bar is not supplied with the holder.

Laydown
Threading Insert
See below



On Edge
Threading Insert
TNMC - NV "V" Thread

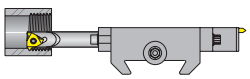


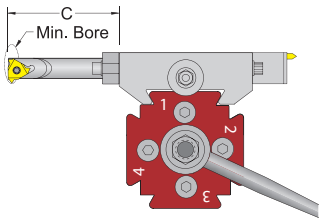
Desc.	Steel DVP656 Grade Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No. 733101-	I.C.		Thickness		Hole Dia.		Depth.	
			in	mm	in	mm	in	mm	in	mm
TNMC-32NV-	72003	72004	.375	9,5	.1250	3,18	.150	3,81	.150	3,81

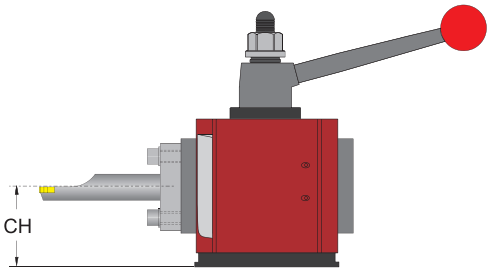
Internal Threading Bar

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.





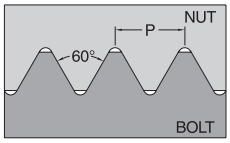


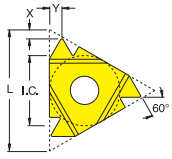


Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

Series	Right Hand			Left Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	Desc.	No. 733101-	Insert	in	mm	in	mm	TPI	mm			
25,30,35,40	NL50R	03661	11IR-A60	NL50L	03669	11IL-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	NL75L	03671	16IL-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	NL125L	03673	22IL-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



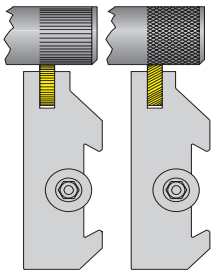


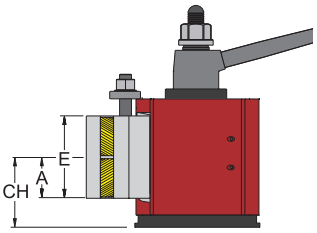
Internal Right Hand	Steel DVP656 Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No.733101-	Internal Left Hand	Steel DVP656 Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No.733101-	L mm	I.C. in	Pitch TPI	Pitch MM	x mm	y mm
11IR-A60	74056	74057	11IL-A60	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

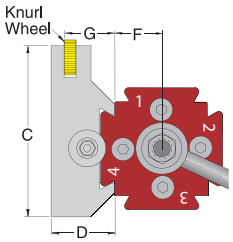
No. QITPN-10

Knurling Toolholder & Wheels

This holder is best used for knurling diamond or straight patterns. Fits industry standard tool posts.





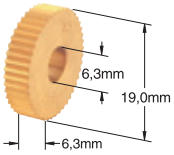


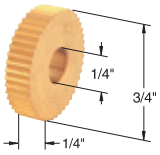
Supplied with one set of 25TPI diagonal knurl wheels for a diamond pattern.

Description	Part No. 733101-	Size	A	C	D	E	F	G	Knurling Wheel			Knurling Pin	
									Series	in	mm	Desc.	733101-
QITP25N-10	00134	in	0.875	3.500	1.250	1.750	0.880	1.065	S	O.D. ¾ I.D. ¼ T ¼	19,1 6,35 6,35	A60464	28620
		mm	22.23	88.90	31.75	44.45	22.35	27.05					
QITP30N-10	00284	in	1.000	4.250	1.500	2.000	1.115	1.315					
		mm	25.40	107.95	38.10	50.80	28.32	33.40					
QITP35N-10	00436	in	1.250	5.000	1.750	2.500	1.245	1.545	A	O.D. ¾ I.D. ¼ T ⅜	19,1 9,52 6,35	A60466	28630
		mm	31.75	127.00	44.45	63.50	31.62	39.24					
QITP40N-10	00584	in	1.250	5.500	1.750	2.500	1.530	1.545					
		mm	31.75	139.70	44.45	63.50	38.86	39.24					

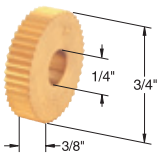
Knurling Wheels

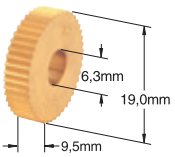
"S" Series





"A" Series





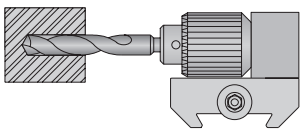
TPI Tooth Per In.	Metric Pitch	Included Tooth Angle	"S" Series-Circular Pitch			"A" Series-Circular Pitch		
			Straight	Diagonal Right	Diagonal Left	Straight	Diagonal Right	Diagonal Left
			High Speed Beveled			High Speed Beveled		
16	1,6mm	90°	SS-16-HSB-CP UPC No. 26839	SDR-16-HSB-CP UPC No. 26961	SDL-16-HSB-CP UPC No. 27085	AS-16-HSB-CP UPC No. 23541	ADR-16-HSB-CP UPC No. 23673	ADL-16-HSB-CP UPC No. 23805
20	1,2mm	90°	SS-20-HSB-CP UPC No. 26841	SDR-20-HSB-CP UPC No. 26963	SDL-20-HSB-CP UPC No. 27087	AS-20-HSB-CP UPC No. 23543	ADR-20-HSB-CP UPC No. 23675	ADL-20-HSB-CP UPC No. 23807
25	1,0mm	90°	SS-25-HSB-CP UPC No. 26843	SDR-25-HSB-CP UPC No. 26965	SDL-25-HSB-CP UPC No. 27089	AS-25-HSB-CP UPC No. 23545	ADR-25-HSB-CP UPC No. 23677	ADL-25-HSB-CP UPC No. 23809
30	0,8mm	90°	SS-30-HSB-CP UPC No. 26845	SDR-30-HSB-CP UPC No. 26967	SDL-30-HSB-CP UPC No. 27091	AS-30-HSB-CP UPC No. 23547	ADR-30-HSB-CP UPC No. 23679	ADL-30-HSB-CP UPC No. 23811

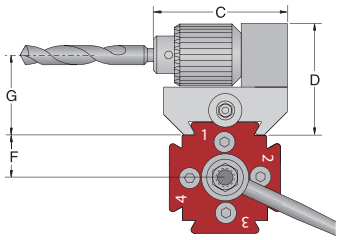
Call Dorian for more information or to request a knurling catalog.

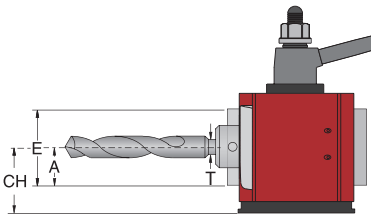
No. QITPN-35

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.





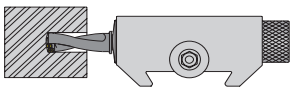


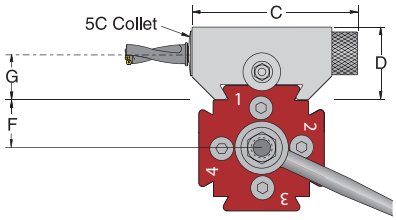
Description	Part No. 733101-	Size	A	T Capacity	C	D	E	F	G
QITP25N-35	00140	in	1.000	0 - 1/2	4.175	3.101	2.000	0.880	2.063
		mm	25.40	0 - 12	106.05	78.77	50.80	22.35	52.40
QITP30N-35	00290	in	1.000	0 - 1/2	4.175	3.101	2.000	1.115	2.063
		mm	25.40	0 - 12	106.05	78.77	50.80	28.32	52.40
QITP35N-35	00442	in	1.125	0 - 1/2	4.673	3.726	2.250	1.245	2.625
		mm	28.58	0 - 12	118.69	94.64	57.15	31.62	66.68
QITP40N-35	00590	in	1.125	0 - 1/2	4.673	3.726	2.250	1.530	2.625
		mm	28.58	0 - 12	118.69	94.64	57.15	38.86	66.68

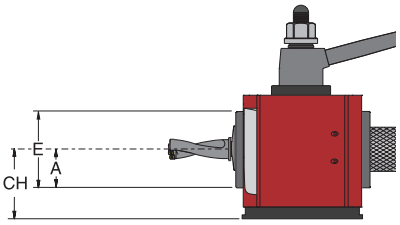
No. QITPN-36

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

Quadra® Indexing Quick Change Tool Post SETS

Quadra® First Time Buyer SET

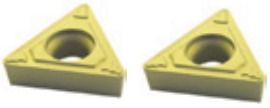
Includes FREE TOOLING

Set Includes:
(1) Tool Post
(4) Holders
(4) Toolholders **FREE**
(5) Inserts **FREE**





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



2ea. TCMT Turning Insert



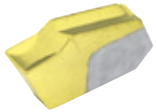
1ea. QITPN-2 + Free Toolholder & 1 Insert



1ea. 11/16IR-A60 Laydown



1ea. QITPN-7-71C + Free Toolholder & 1 Insert



1ea. SGTN Cut-off Insert



1ea. QITPN-881 + Free Toolholder & 1 Insert



1ea. TNMC OnEdge Insert

Part 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	QITP30N-1 QITP30N-2 QITP30N-7-71C QITP30N-881	QITP35N-1 QITP35N-2 QITP35N-7-71C QITP35N-881	QITP40N-1 QITP40N-2 QITP40N-7-71C QITP40N-881
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

Turning Sets

(1) Tool Post
(4) Holders

Tooling Not Included




QITPN-1


QITPN-1


QITPN-2


QITPN-2

Part 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

Standard Sets

(1) Tool Post
(4) Holders

Tooling Not Included

NEW




QITPN-1


QITPN-2


QITPN-4-CNC


QITPN-7-71C

Part 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"
Standard 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 with Triple Action Locking System

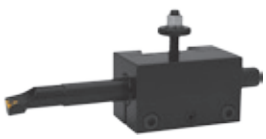
- Multi-position locking handle adjustment
- Anti-Rotation mounting
- Super precision toolholder locking
- Repeatability within millionths
- Thousands of pounds of locking force with a finger tip

Rigidity!

Repeatability!

Quality!

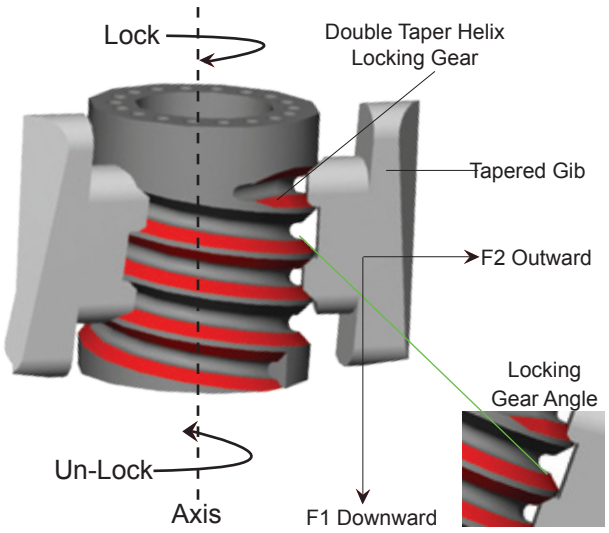


Style	Features		Application
SUPER Quick Change Tool Post			
 PG. 32	• Triple Action Locking System • Zero Backlash • Precise Repeatability within .0001” • 15° Locking Handle Position Adjustment • Super Heavy Duty Locking Gear and Wedge Style Sliding Gibs • Industry Standard Interchangeable Toolholders • High Tensile Strength Chromium-Molybdenum Alloy Steel Body, Locking Gear, Sliding Gibs, Locking Gear Head, and Locking Handle	• Thru Hardened, Ion Nitrided, and Nickel-plated Body • Thru 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 Material Removal • Multi Turning, Drilling, Boring, Threading Applications
No. D1 Turning & Facing Holder			
 PG. 33	• Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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			
 PG. 33	• Boring Bar “V” Seat • Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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. D4-41-41S CNC Extra Heavy Duty Boring Bar Holder - CNC Locking System			
 PG.33	• Precision Ground and Honed Bore • Qualified Bore for Precise Tool Alignment and Squareness • Quick-Lock System Aligns Boring Bar Centerheight and Rake Angle Automatically. • Four Special Flat Machined Locking Screws for High Rigidity Extended Overhangs without Scarring the Boring Bar • Sizes Up to 3” Capacity • Quick Change Mounting	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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
No. D41-D41S COL Extra Heavy Duty Boring Bar Holder- Collar Locking System			
 PG. 34-35	• Precision Ground and Honed Bore • Qualified Bore for Precise Tool Alignment and Squareness • 360° Locking for High Rigidity and Extended Overhangs without Scarring the Boring Bar • Sizes Up to 3” Capacity • Quick Change Mounting	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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			
 PG.35	• 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 • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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			
 PG.35	• Precision Ground Blade Dovetail Seat • Qualified for Precise Tool Alignment and Squareness • Quick Change Mounting • High Tensile Strength Chromium- Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Cut-Off Applications • Grooving Applications
No. D71S Oversized Cut-Off Blade Holder			
 PG.35	• Oversized Blade Capacity • Precision Ground Blade Dovetail Seat • Qualified for Precise Tool Alignment and Squareness • Quick Change Mounting • High Tensile Strength Chromium- Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Cut-Off Applications • Grooving Applications
No. D881 O.D. or I.D. Threading Holder			
 PG.37	• Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• OD and ID Threading
No. D10 Knurling Holder			
 PG.38	• Quick Change Mounting • High Tensile Strength Chromium-Molybdenum Alloy Steel	• Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• OD Straight Knurling • OD Diamond Knurling
No. D35 Dovetail Drill Chuck Holder			
 PG.38	• Supplied with a Rohm Chuck • Qualified for Precise Tool Alignment and Squareness • Designed for Versatility • Quick Change Mounting	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Center Drilling • Precision Drilling • Precision Reaming • Tapping
No. D36 5C Collet Holder			
 PG.39	• 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 • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Miniature to Medium Size Tools • For Special Tool Size 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

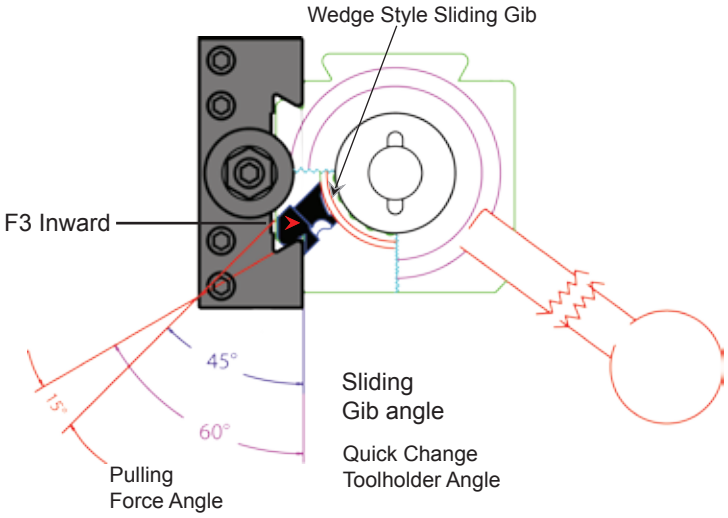
is a powerful combination of a downward, outward and inward force simultaneously locking the holder.

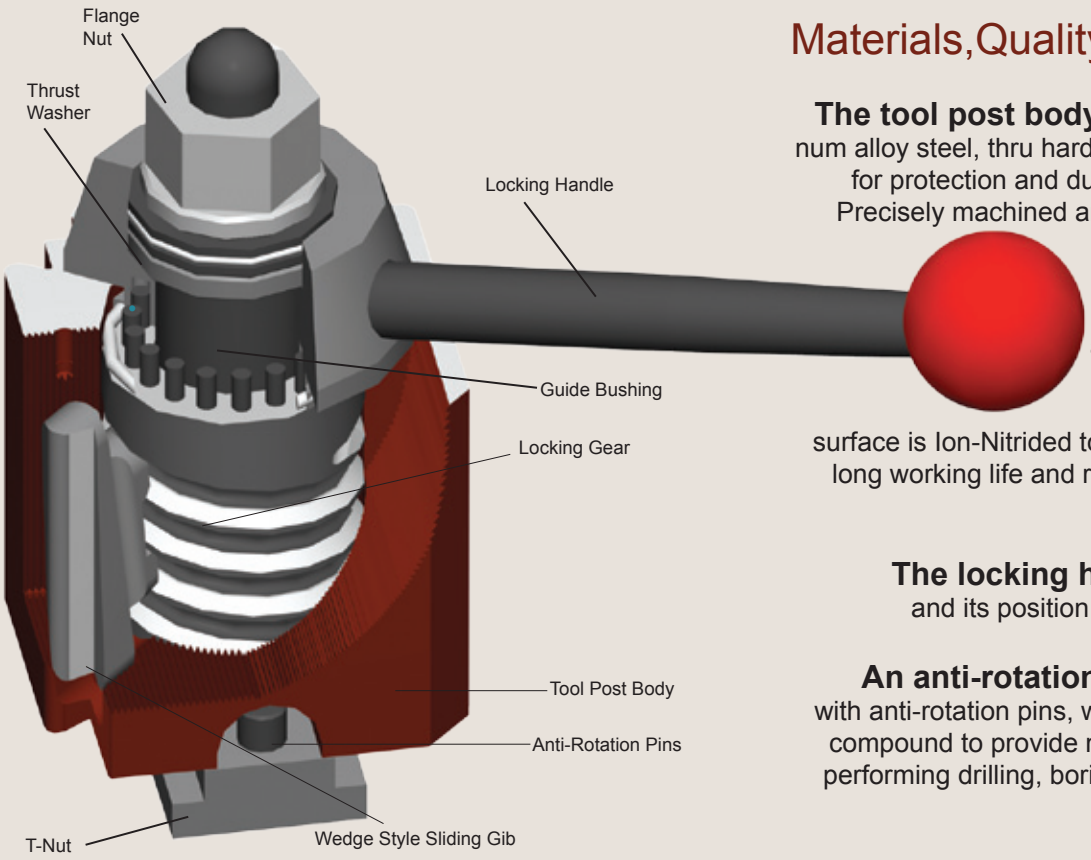


1. F1 Downward Force: (shown left) Rotating the locking gear moves the gib down, expanding the tool post dovetail to lock the toolholder.

2. F2 Outward Force: (shown left) 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 below) 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.





Materials,Quality & Workmanship

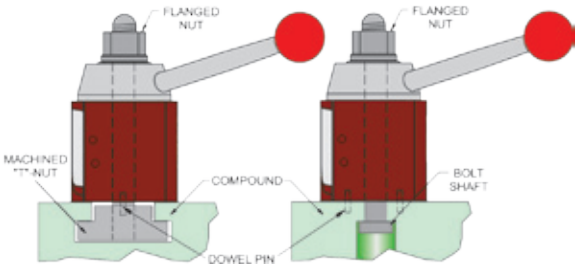
The tool post body is made from chromium-molybdenum alloy steel, thru hardened, ion nitrited and Nickel-plated for protection and durability in machining environments. Precisely machined and ground with the most advanced technology & precision.

The patented locking gear and gibs are made from chromium-molybdenum alloy steel. The core thru hardness is 40-44 Rc and the surface is Ion-Nitrided to a hardeness 60-64Rc to ensure a long working life and rust resistance under harsh working conditions.

The locking handle will lock within 45º of travel and its position can be adjusted in 15º increments.

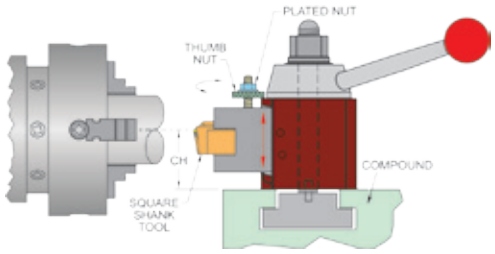
An anti-rotation system is built into the tool post with anti-rotation pins, which are engaged with a “T” Nut or compound to provide maximum rigidity and stability when performing drilling, boring and heavy roughing operations.

Tool Post Mounting



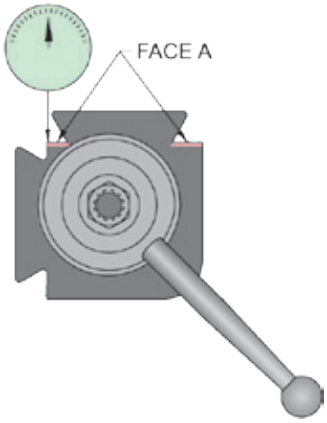
The tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flange Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using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



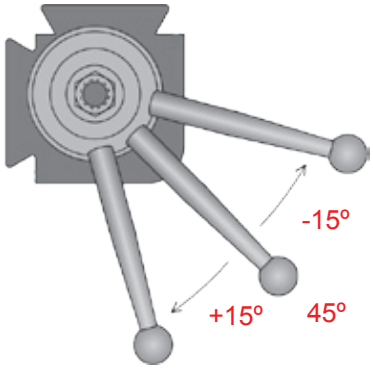
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool by rotating the Thumb Nut until the desired height is reached and locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool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

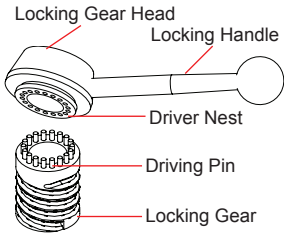
Indicating Position



The double dovetails are ground at 90° square (± .0002"). At 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

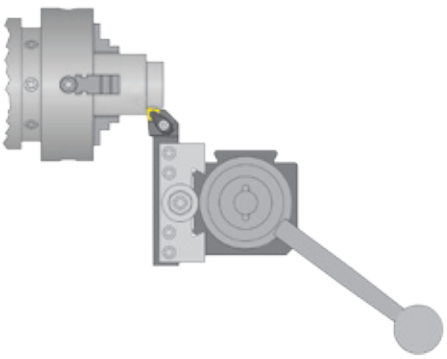




To change the position of the handle: remove the *flange nut; remove the *guide bushing; pull the locking gear head and place to the desired position.

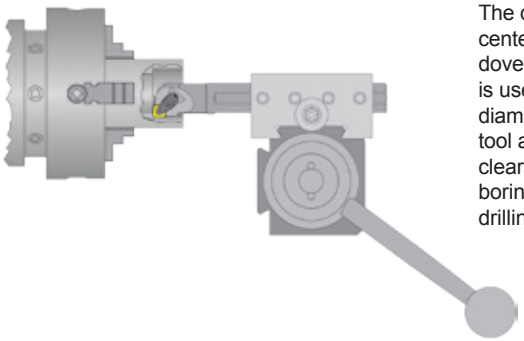
The locking handle will be at a 45º position when the holder is locked; however it is adjustable in 15º increments according to the machine requirements, to clear the machine tail stock, the safety door, or the machine safety guard.

O.D. Turning Operations

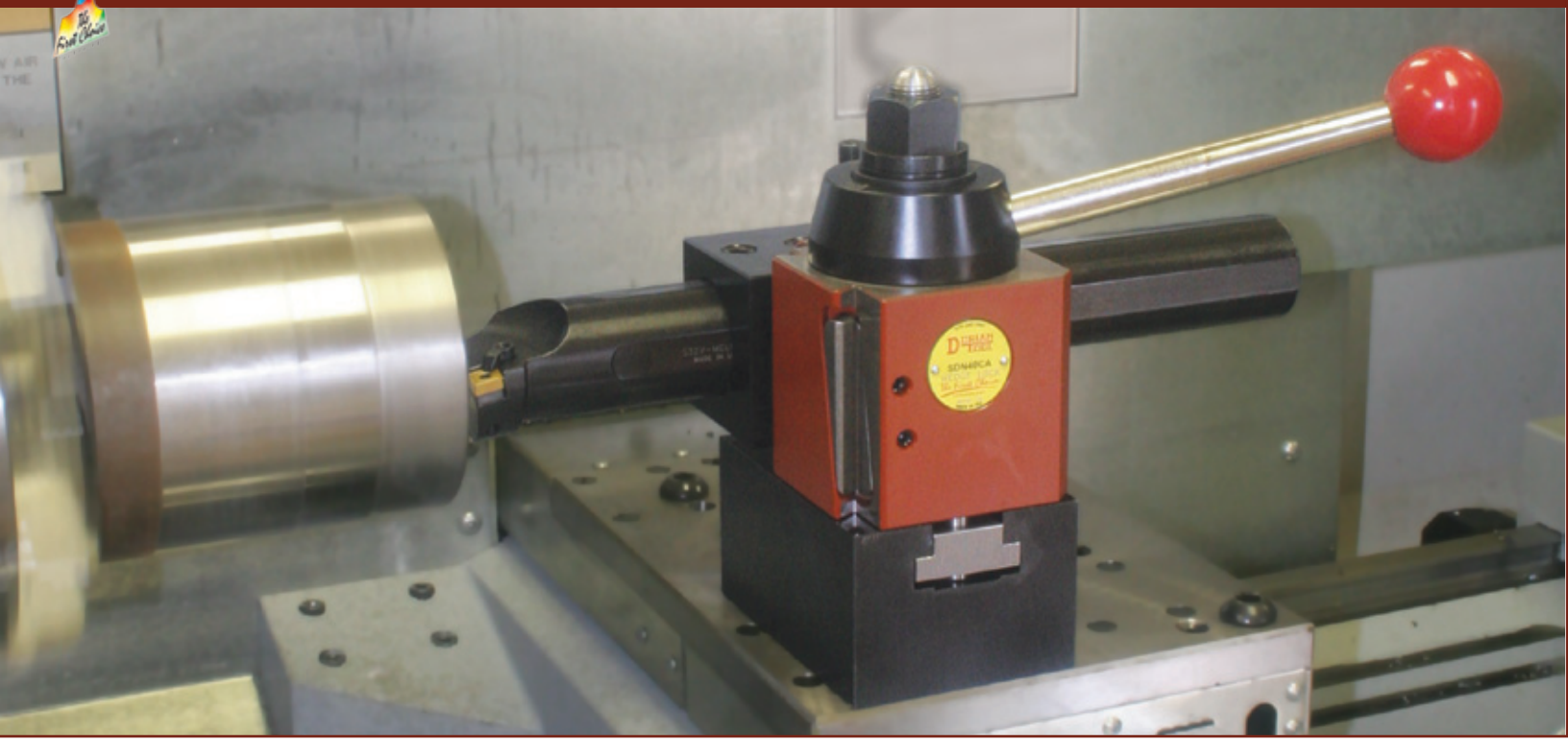


The dovetail closest to the chuck (left dovetail as shown below) is used for turning outside diameters. It holds the tool at the best location for clearance and rigidity for turning, threading, cut-off, grooving, and chamfering.

I.D. Turning Operations

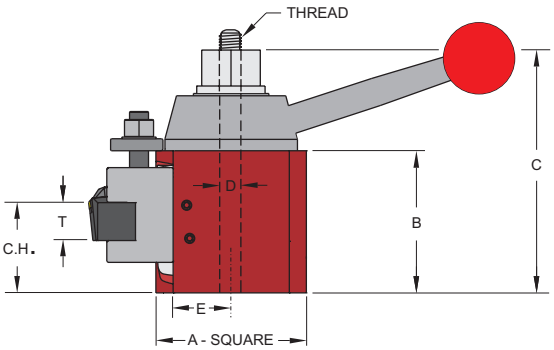


The dovetail closest to the center of the chuck (top dovetail as shown below) is used for turning inside diameters. It holds the tool at the best location for clearance and rigidity when boring, threading, grooving, drilling, and center drilling.



Identification System for SUPER Quick Change Tool Post		
SDN	35	CXA
Tool Post Style	Tool Post Size	Industry Standard Identification

Identification System for SUPER Quick Change Toolholders								
D	35	CXA	4	M	CNC	COL	OE	LD
Toolholder Style	Tool Post Size	Industry Standard Identification	Type of Toolholder	Metric Units	Boring Bar Locking System		Insert Type	



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

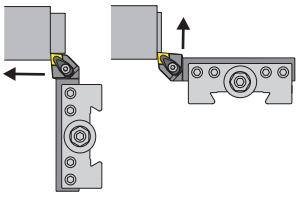
Description	SDN25AXA		SDN30BXA		SDN35CXA		SDN40CA		SDN50DA		SDN60EA	
Part No. 733101-	01000		01002		01004		01006		01008		01010	
Size	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
Lathe Swing Over Bed	≤12	≤300	13-15	330-380	14-17	350-430	16-20	400-500	17-32	430-810	≥25	≥635
A	2.625	66.67	3.000	76.2	3.500	88.90	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
Optimim 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

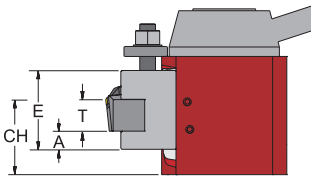
* Optimum center height is calculated with the smaller tool size of the tool capacity. If the higher size tool is to be used, add 1/8″ to the optimum center height.

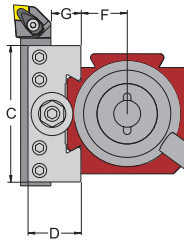
No. D1

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.







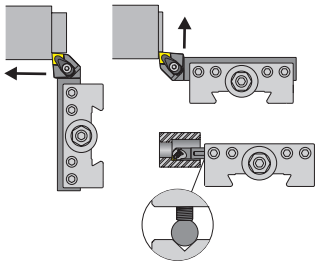
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D25AXA-1	01100	in	0.375	.750	2.750	1.250	1.750	0.880	.790
D25AXA-1MS	01101	mm	9.53	20	69.85	31.75	44.45	22.35	20.07
D30BXA-1	01250	in	0.437	1.000	3.250	1.500	2.250	1.115	.915
D30BXA-1MS	01251	mm	11.10	25	82.55	38.10	57.15	28.32	23.24
D35CXA-1	01400	in	0.500	1.000	3.750	1.750	2.500	1.199	1.040
D35CXA-1MS	01401	mm	12.70	25	95.25	44.45	63.50	30.45	26.42
D40CA-1	01550	in	0.562	1.250	4.500	2.000	3.000	1.530	1.040
D40CA-1MS	01551	mm	14.27	32	114.30	50.80	76.20	38.86	26.42
D50DA-1	01700	in	0.750	1.500	6.000	2.500	3.500	1.900	1.290
D50DA-1MS	01701	mm	19.05	40	152.40	63.50	88.90	48.26	32.77
D60EA-1	01850	in	1.000	1.500	7.000	3.000	4.000	2.207	1.540
D60EA-1MS	01851	mm	25.40	40	177.80	76.20	101.60	56.06	39.12

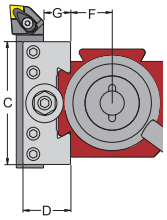
Note: MS Designates Metric Screw

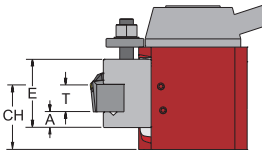
No. D2

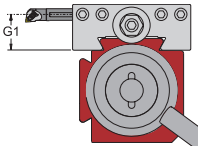
Turning, Facing & Boring Toolholder

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.









SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G	G1
D25AXA-2	01104	in	0.375	.750	2.750	1.250	1.750	0.880	.790	1.015
D25AXA-2MS	01105	mm	9.53	20	69.85	31.75	44.45	22.35	20.07	25.78
D30BXA-2	01254	in	0.437	1.000	3.250	1.500	2.250	1.115	.915	1.205
D30BXA-2MS	01255	mm	11.10	25	82.55	38.10	57.15	28.32	23.24	30.61
D35CXA-2	01404	in	0.500	1.000	3.750	1.750	2.500	1.199	1.040	1.390
D35CXA-2MS	01405	mm	12.70	25	95.25	44.45	63.50	30.45	26.42	35.31
D40CA-2	01554	in	0.562	1.250	4.500	2.000	3.000	1.530	1.040	1.515
D40CA-2MS	01555	mm	14.27	32	114.30	50.80	76.20	38.86	26.42	38.48
D50DA-2	01704	in	0.750	1.500	6.000	2.500	3.500	1.900	1.290	1.890
D50DA-2MS	01705	mm	19.05	40	152.40	63.50	88.90	48.26	32.77	48.01
D60EA-2	01854	in	1.000	1.500	7.000	3.000	4.000	2.207	1.540	2.265
D60EA-2MS	01855	mm	25.40	40	177.80	76.20	101.60	56.06	39.12	57.30

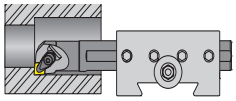
Note: MS Designates Metric Screw

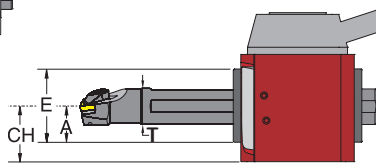
No. D4-CNC

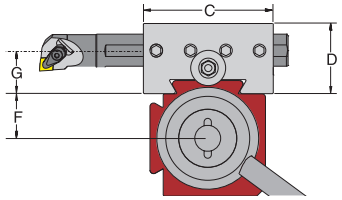
Heavy Duty Boring Bar Toolholder

Inch/Metric

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.







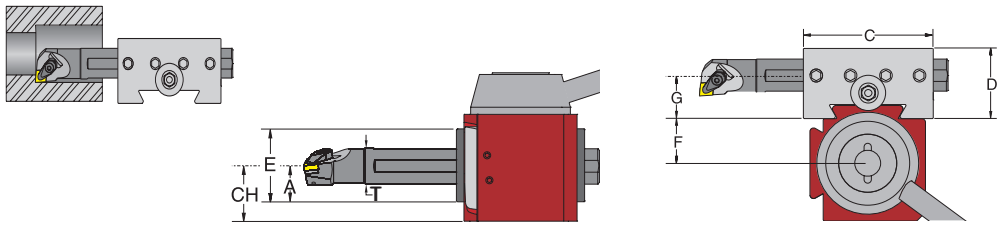
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D25AXA-4-CNC	01110	in	.745	.750	2.750	1.490	1.490	.880	.937
D25AXA-4M-CNC	01112	mm	18.92	20	69.85	37.85	37.85	22.35	23.80
D30BXA-4-CNC	01260	in	.995	1.000	3.250	1.990	1.990	1.115	1.250
D30BXA-4M-CNC	01262	mm	25.27	25	82.55	50.55	50.55	28.32	31.75
D35CXA-4-CNC	01410	in	1.120	1.000	3.750	2.240	2.240	1.199	1.375
D35CXA-4M-CNC	01412	mm	28.45	25	95.25	56.90	56.90	30.45	34.93
D40CA-4-CNC	01560	in	1.245	1.250	4.500	2.490	2.490	1.530	1.500
D40CA-4M-CNC	01562	mm	31.62	32	114.30	63.25	63.25	38.86	38.10
D50DA-4-CNC	01710	in	1.495	1.500	5.500	2.990	2.990	1.900	2.000
D50DA-4M-CNC	01712	mm	37.97	40	139.70	75.95	75.95	48.26	50.80
D60EA-4-CNC	01860	in	1.995	2.000	6.500	3.990	3.990	2.207	2.500
D60EA-4M-CNC	01862	mm	50.67	50	165.10	101.35	101.35	56.06	63.50

No. D41-CNC

Extra Heavy Duty Boring Bar Toolholder

Inch/Metric

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.



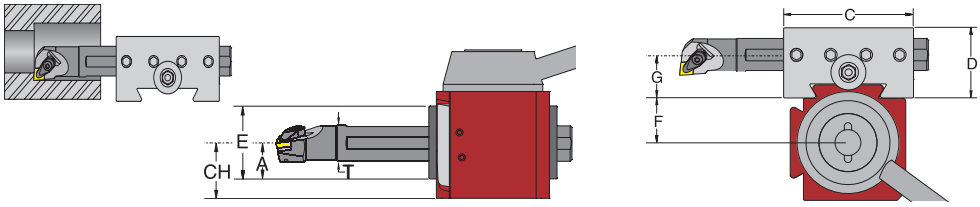
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D25AXA-41-CNC	01114	in	.870	1.000	2.750	1.740	1.740	.880	1.062
D25AXA-41M-CNC	01116	mm	22.10	25	69.85	44.20	44.20	22.35	26.97
D30BXA-41-CNC	01264	in	1.120	1.250	3.250	2.240	2.240	1.115	1.375
D30BXA-41M-CNC	01266	mm	28.45	32	82.55	56.90	56.90	28.32	34.93
D35CXA-41-CNC	01414	in	1.120	1.250	3.750	2.240	2.240	1.199	1.375
D35CXA-41M-CNC	01416	mm	28.45	32	95.25	56.90	56.90	30.45	34.93
D40CA-41-CNC	01564	in	1.245	1.500	4.500	2.490	2.490	1.530	1.500
D40CA-41M-CNC	01566	mm	31.62	40	114.30	63.25	63.25	38.86	38.10
D50DA-41-CNC	01714	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250
D50DA-41M-CNC	01716	mm	44.32	50	139.70	88.65	88.65	48.26	57.15
D60EA-41-CNC	01864	in	1.995	2.500	6.500	3.990	3.990	2.207	2.375
D60EA-41M-CNC	01866	mm	50.67	60	165.10	101.35	101.35	56.06	60.33

No. D41S-CNC

Super Oversized Boring Bar Toolholder

Inch/Metric

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.



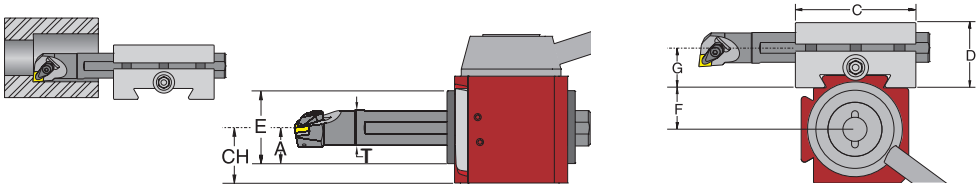
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D35CXA-41-150-CNC	01418	in	1.245	1.500	4.000	2.490	2.490	1.199	1.500
D35CXA-41M-40-CNC	01420	mm	31.62	40	101.60	63.25	63.25	30.45	38.10
D40CA-41-200-CNC	01568	in	1.495	2.000	4.500	2.990	2.990	1.530	1.750
D40CA-41M-50-CNC	01570	mm	37.97	50	114.30	75.95	75.95	38.86	44.45
D50DA-41-250-CNC	01718	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250
D50DA-41M-60-CNC	01720	mm	50.67	60	165.10	101.35	101.35	48.26	57.15
D60EA-41-300-CNC	01868	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625
D60EA-41M-80-CNC	01870	mm	57.02	80	177.80	114.05	114.05	56.06	66.68

No. D41-COL

Extra Heavy Duty Boring Bar Toolholder

Inch/Metric

This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system providing the best rigidity in metal removing without scarring the boring bar. Fits industry standard tool posts.



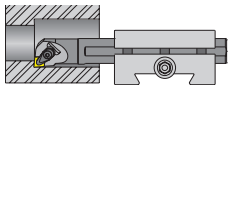
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D35CXA -41-COL	01460	in	1.045	1.250	3.750	2.240	2.240	1.999	1.375
D40CA-41-COL	01608	in	1.170	1.500	4.500	2.490	2.490	1.530	1.500
D50DA-41-COL	01752	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250
D60EA -41-COL	01896	in	1.995	2.500	6.500	3.990	3.990	2.207	2.375

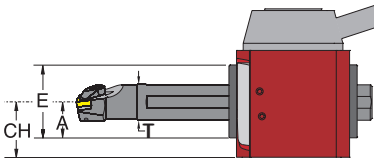
No. D41S-COL

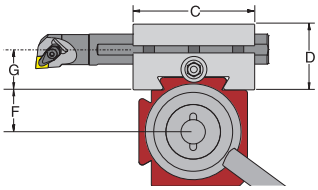
Super Oversized Boring Bar Toolholder

Inch/Metric

This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system providing the best rigidity in metal removing without scarring the boring bar. Fits industry standard tool posts.





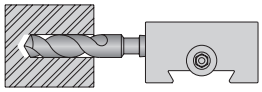


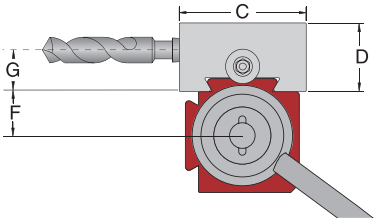
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D35CXA-41-150-COL	01462	in	1.220	1.500	4.000	2.490	2.490	1.199	1.500
D40CA-41-200-COL	01610	in	1.395	2.000	4.500	2.990	2.990	1.530	1.750
D50DA-41-250-COL	01754	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250
D60EA-41-300-COL	01898	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625

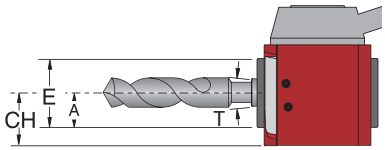
No. D5

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.







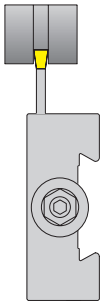
SDN Description	Part No.733101-	Size	A	T	C	D	E	F	G
D25AXA-5-2	01122	in	0.750	MT2	2.750	1.500	1.500	0.880	0.930
		mm	19.05	MT2	69.85	38.10	38.10	22.35	23.62
D30BXA-5-3	01272	in	1.000	MT3	3.500	2.000	2.000	1.115	1.250
		mm	25.40	MT3	88.90	50.80	50.80	28.32	31.75
D35CXA-5-4	01424	in	1.125	MT4	4.150	2.500	2.250	1.199	1.615
		mm	28.58	MT4	105.41	63.50	57.15	30.45	41.02
D40CA-5-4	01572	in	1.250	MT4	4.500	2.500	2.500	1.530	1.615
		mm	31.75	MT4	114.30	63.50	63.50	38.86	41.02
D50DA-5-5	01722	in	1.750	MT5	5.625	3.500	3.500	1.900	2.300
		mm	44.45	MT5	142.88	88.90	88.90	48.26	58.42
D60EA-5-5	01872	in	1.750	MT5	5.500	3.500	3.500	2.207	2.240
		mm	44.45	MT5	139.70	88.90	88.90	56.06	56.90

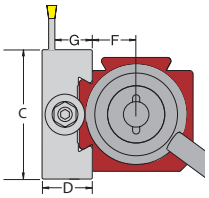
No. D7-71C & D71S

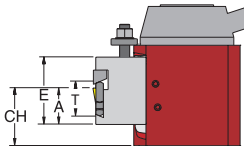
Extra Heavy Duty and Oversized Extra Heavy Duty Cut-Off Blade Toolholders

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.







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

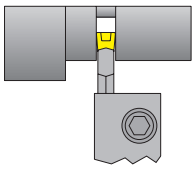
Desc.	Part No. 733101-	Size	A	Slot Grip Blade Size "T"	T Type Blade	C	D	E	F	G
D25AXA-7-71C	01126	in	0.875	SGIH-19-2	P3	2.750	1.250	1.750	0.880	1.090
		mm	22.23		P3	69.85	31.75	44.45	22.35	27.69
D30BXA-7-71C	01276	in	0.905		P3	3.250	1.250	1.750	1.115	1.090
		mm	22.99		P3	82.55	31.75	44.45	28.32	27.69
D35CXA-7-71C	01428	in	1.330	SGIH-26-2 to 26-6	P5	3.750	1.500	2.250	1.199	1.280
		mm	33.78		P5	95.25	38.10	57.15	30.45	32.51
D40CA-7-71C	01576	in	1.330		P9	4.500	1.500	2.500	1.530	1.280
		mm	33.78		P9	114.30	38.10	63.50	38.86	32.51
D50DA-7-71C	01726	in	1.585	SGIH-32-3 to 32-9	P9	6.000	2.000	3.000	1.900	1.730
		mm	40.26		P9	152.40	50.80	76.20	48.26	43.94
D60EA-7-71C	01876	in	1.710		P9	7.000	2.250	3.250	2.207	1.980
		mm	43.43		P9	177.80	57.15	82.55	56.06	50.29

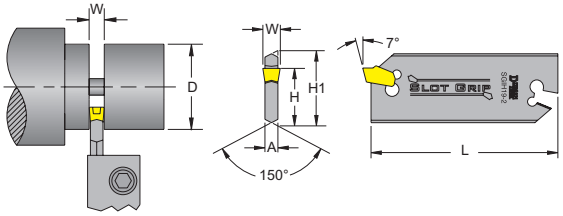
No. D71S *Oversized* Extra Heavy Duty Cut-Off Blade Toolholder

D25AXA-71-26	01128	in	1.125	SGIH-26-2 to 26-6	P5	2.750	1.500	2.000	0.880	1.280
		mm	28.58		P5	69.85	38.10	50.80	22.35	32.51
D30BXA-71-26	01278	in	1.250		P5	3.250	1.500	2.250	1.115	1.280
		mm	31.75		P5	82.55	38.10	57.15	28.32	32.51
D35CXA-71-32	01430	in	1.500	SGIH-32-3 to 32-9	P9	3.750	1.750	2.500	1.199	1.500
		mm	38.10		P9	95.25	44.45	63.50	30.45	38.10
D40CA-71-32	01578	in	1.500		P9	4.500	1.750	2.500	1.530	1.500
		mm	38.10		P9	114.30	44.45	63.50	38.86	38.10

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 permits free chip flow, minimizing insert breakage due to chip build-up.

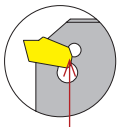






SLOT GRIP

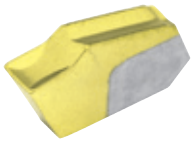
Improved design featuring a "Positive Stop". Inserts are securely held in Slot Grip Positive Stop Blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is firmly in place.



Positive Stop

Desc.	Part No. 733101-	Insert Used	W		D Max		A		L		H		H 1	
			in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
SGIH19-2	62950	SGT(N/R/L)-2	.087	2	1.57	39,9	.063	1,57	3.38	85,9	.618	15,7	0.75	19,1
SGIH26-2	62951	SGT(N/R/L)-2	.087	2	2.00	50,8	.063	1,57	4.33	110,0	.842	21,4	1.02	25,9
SGIH26-3	62952	SGT(N/R/L)-3	.122	3	3.00	76,2	.094	2,39						
SGIH26-4	62953	SGT(N/R/L)-4	.161	4	3.15	80,0	.125	3,18						
SGIH26-5	62954	SGT(N/R/L)-5	.201	5	3.15	80,0	.156	3,96						
SGIH26-6	62955	SGT(N/R/L)-6	.252	6	3.15	80,0	.203	5,16						
SGIH32-3	62956	SGT(N/RL)-3	.122	3	3.94	100,0	.094	2.39	5.90	149.9	.984	25,0	1.25	31,8
SGIH32-4	62957	SGT(N/R/L)-4	.161	4	3.94	100,0	.125	3,18						
SGIH32-5	62958	SGT(N/R/L)-5	.201	5	4.71	119,6	.156	3,96						
SGIH32-6	62959	SGT(N/R/L)-6	.252	6	4.72	119,9	.203	5,16						
SGIH32-8	62960	SGT(N/R/L)-8	.315	8	5.51	140,0	.268	6,81						
SGIH32-9	62961	SGT(N/R/L)-9	.378	9	5.51	140,0	.312	7,92						

Cut-Off & Grooving Inserts



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.

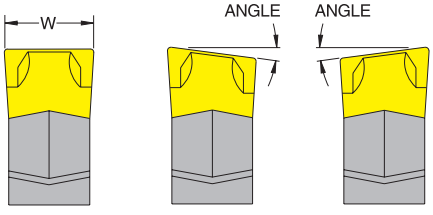
DC656 - (C5-C6 Substrate with CVD TiN/TiC-TiN coating) First Choice for general turning applications on ferrous metals and 400 series stainless steels, at medium cutting sfm and wet conditions. Multi Layer CVD carbide grade. Thermal deformation and abrasion resistant substrate with cobalt enriched periphery.

Chipbreaker Geometry

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

Application

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

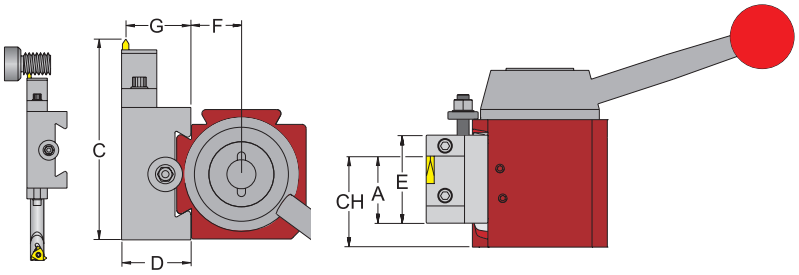


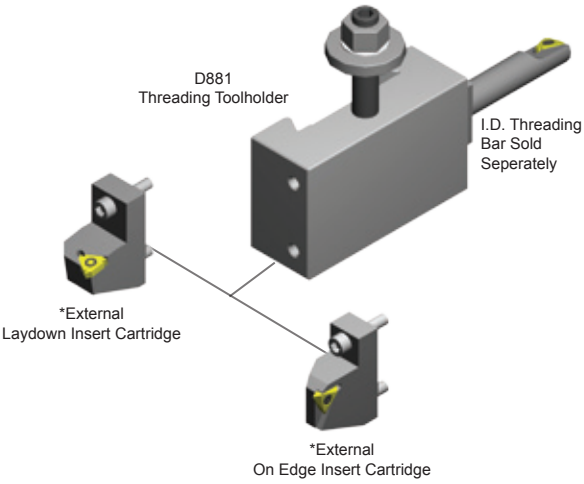
Desc.	DASK25 First Choice for High Performance Machining	DC656 First Choice for General Turning Applications	Insert Size	Lead Angle	Width + .004	
					in	mm
SGTN-2	82223	82222	2	0°	.087	2mm
SGTR-2-8	82251	82250	2	8°	.087	2mm
SGTL-2-8	82279	82278	2	8°	.087	2mm
SGTN-3	82227	82226	3	0°	.122	3mm
SGTR-3-8	82255	82254	3	8°	.122	3mm
SGTL-3-8	82283	82282	3	8°	.122	3mm
SGTN-4	82231	82230	4	0°	.161	4mm
SGTR-4-8	82259	82258	4	8°	.161	4mm
SGTL-4-8	82287	82286	4	8°	.161	4mm
SGTN-5	82235	82234	5	0°	.201	5mm
SGTR-5-8	82263	82262	5	8°	.201	5mm
SGTL-5-8	82291	82290	5	8°	.201	5mm
SGTN-6	82239	82238	6	0°	.252	6mm
SGTR-6-8	82267	82266	6	8°	.252	6mm
SGTL-6-8	82295	82294	6	8°	.252	6mm
SGTN-8	82243	82242	8	0°	.315	8mm
SGTR-8-8	82271	82270	8	8°	.315	8mm
SGTL-8-8	82299	82298	8	8°	.315	8mm
SGTN-9	82247	82246	9	0°	.378	9mm
SGTR-9-8	82275	82274	9	8°	.378	9mm
SGTL-9-8	82303	82302	9	8°	.378	9mm

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	Part No. 733101-	Size	A	C	D	E	F	G	*External On Edge Insert Cartridge					*External Laydown Insert Cartridge						
									Desc.	Part No. 733101-	TNMC Insert	Torx Screw	Torx Key	Desc.	Part 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-1	T-10	NL253-3R	03635	16ER-AG60	TS-16	T-10	8-48	0,5-3,5
D25AXA-881-LD	01133	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												
D30BXA-881-LD	01283	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-1	T-10	NL354-3R	03637	16ER-AG60	TS-16	T-10	8-48	0,5-3,5
D35CXA-881-LD	01435	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												
D40CA-881-LD	01583	mm	38.10	142.72	38.10	57.15	38.86	36.45												

*Part Descriptions ending in -OE come with External On Edge Insert Cartridge. Part Descriptions ending in -LD come with External Laydown Insert Cartridge. Inserts not included. Internal threading bar is not supplied with the holder.

On Edge
Threading Insert
TNMC - NV "V" Thread



Laydown
Threading Insert

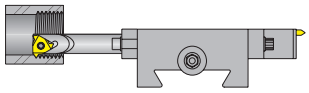


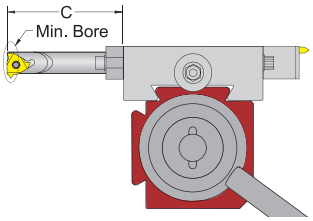
Desc.	Steel DVP656 Grade Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No. 733101-	I.C.		Thickness		Hole Dia.		Depth.	
			in	mm	in	mm	in	mm	in	mm
TNMC-32NV-	72003	72004	.375	9,5	.1250	3,18	.150	3,81	.150	3,81

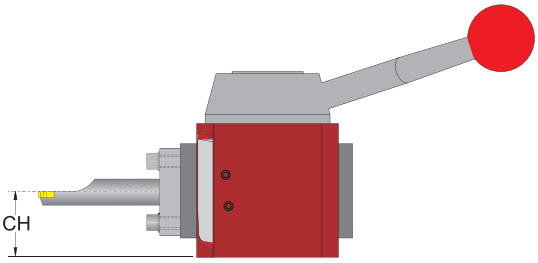
Internal Threading Bar

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.





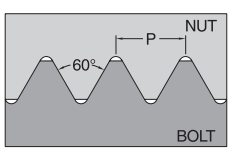


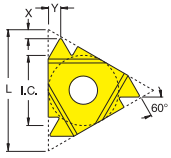


Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

Series	Right Hand			Left Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	Desc.	No. 733101-	Insert	in	mm	in	mm	TPI	mm			
25,30,35,40	NL50R	03661	11IR-A60	NL50L	03669	11IL-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	NL75L	03671	16IL-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	NL125L	03673	22IL-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



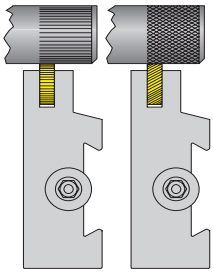


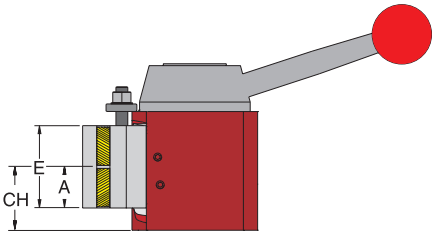
Internal Right Hand	Steel DVP656 Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No.733101-	Internal Left Hand	Steel DVP656 Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No.733101-	L mm	I.C. in	Pitch TPI	Pitch MM	x mm	y mm
11IR-A60	74056	74057	11IL-A60	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

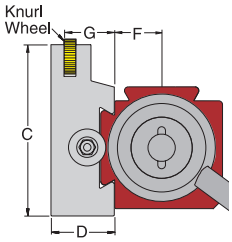
No. D10

Knurling Toolholder & Wheels

This holder is best used for knurling diamond or straight patterns. Fits industry standard tool posts.





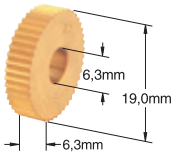


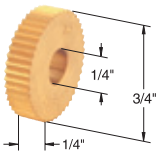
Supplied with one set of 25TPI diagonal knurl wheels for a diamond pattern.

Description	Part No. 733101-	Size	A	C	D	E	F	G	Knurling Wheel			Knurling Pin	
									Series	in	mm	Desc.	733101-
D25AXA-10	01134	in	0.750	3.000	1.000	1.500	0.880	0.813	S	O.D. ¾ I.D. ¼ T ¼	19,1 6,35 6,35	A60464	28620
		mm	19.05	76.20	25.40	38.10	22.35	20.65					
D30BXA-10	01284	in	0.875	3.750	1.250	1.750	1.115	1.063					
		mm	22.23	95.25	31.75	44.45	28.32	27.00					
D35CXA-10	01436	in	1.125	4.500	1.500	2.250	1.199	1.300	A	O.D. ¾ I.D. ¼ T ⅜	19,1 9,52 6,35	A60466	28630
		mm	28.58	114.30	38.10	57.15	30.45	33.02					
D40CA-10	01584	in	1.125	5.000	1.500	2.250	1.530	1.300					
		mm	28.58	127.00	38.10	57.15	38.86	33.02					

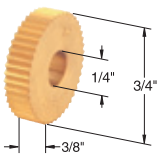
Knurling Wheels

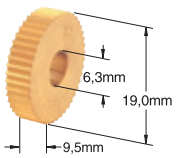
"S" Series





"A" Series





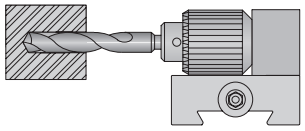
TPI Tooth Per In.	Metric Pitch	Included Tooth Angle	"S" Series-Circular Pitch			"A" Series-Circular Pitch		
			Straight	Diagonal Right	Diagonal Left	Straight	Diagonal Right	Diagonal Left
			High Speed Beveled			High Speed Beveled		
16	1,6mm	90°	SS-16-HSB-CP UPC No. 26839	SDR-16-HSB-CP UPC No. 26961	SDL-16-HSB-CP UPC No. 27085	AS-16-HSB-CP UPC No. 23541	ADR-16-HSB-CP UPC No. 23673	ADL-16-HSB-CP UPC No. 23805
20	1,2mm	90°	SS-20-HSB-CP UPC No. 26841	SDR-20-HSB-CP UPC No. 26963	SDL-20-HSB-CP UPC No. 27087	AS-20-HSB-CP UPC No. 23543	ADR-20-HSB-CP UPC No. 23675	ADL-20-HSB-CP UPC No. 23807
25	1,0mm	90°	SS-25-HSB-CP UPC No. 26843	SDR-25-HSB-CP UPC No. 26965	SDL-25-HSB-CP UPC No. 27089	AS-25-HSB-CP UPC No. 23545	ADR-25-HSB-CP UPC No. 23677	ADL-25-HSB-CP UPC No. 23809
30	0,8mm	90°	SS-30-HSB-CP UPC No. 26845	SDR-30-HSB-CP UPC No. 26967	SDL-30-HSB-CP UPC No. 27091	AS-30-HSB-CP UPC No. 23547	ADR-30-HSB-CP UPC No. 23679	ADL-30-HSB-CP UPC No. 23811

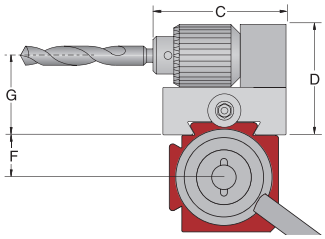
Call us for more information or to request a knurling catalog.

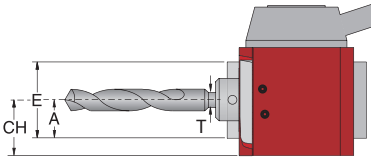
No. D35

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.





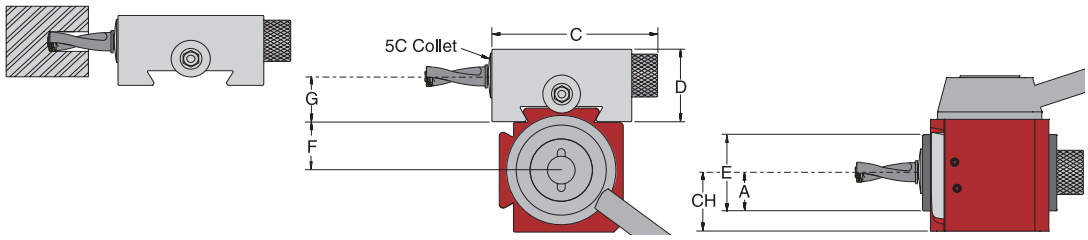


Description	Part No. 733101-	Size	A	T Capacity	C	D	E	F	G
D25AXA-35	01140	in	1.000	0 - 1/2	4.175	3.101	2.000	0.880	2.063
		mm	25.40	0 - 12	106.05	78.77	50.80	22.35	52.40
D30BXA-35	01290	in	1.000	0 - 1/2	4.175	3.101	2.000	1.115	2.063
		mm	25.40	0 - 12	106.05	78.77	50.80	28.32	52.40
D35CXA-35	01442	in	1.125	0 - 1/2	4.673	3.726	2.250	1.199	2.625
		mm	28.58	0 - 12	118.69	94.64	57.15	30.45	66.68
D40CA-35	01590	in	1.125	0 - 1/2	4.673	3.726	2.250	1.530	2.625
		mm	28.58	0 - 12	118.69	94.64	57.15	38.86	66.68

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

SUPER Quick Change Tool Post SETS

SUPER Quick Change First Time Buyer SETS

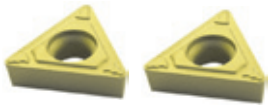
Includes FREE TOOLING

Set Includes:
(1) Tool Post
(4) Holders
(4) Toolholders **FREE**
(5) Inserts **FREE**





1ea. D-1 + Free Toolholder & 2 Inserts



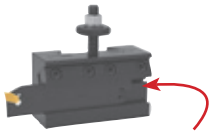
2ea. TCMT Turning Insert



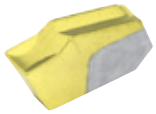
1ea. D-2 + Free Toolholder & 1 Insert



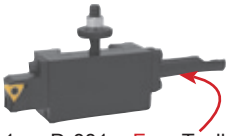
1ea. 11/16IR-A60 Laydown



1ea. D-7-71C + Free Toolholder & 1 Insert



1ea. SGTN Cut-off Insert



1ea. D-881 + Free Toolholder & 1 Insert



1ea. TNMC OnEdge Insert

Part 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	D30BXA-1 D30BXA-2 D30BXA-7-71C D30BXA-881	D35CXA-1 D35CXA-2 D35CXA-7-71C D35CXA-881	D40CA-1 D40CA-2 D40CA-7-71C D40CA-881
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

SUPER Quick Change Turning Sets

(1) Tool Post
(4) Holders



D1



D1



D2



D2



Tooling Not Included

Part No. 733101-	01014	01015	01016	01017	01018	01019
Desc.	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"
5 Piece Turning 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

(1) Tool Post
(4) Holders

NEW



D1



D2



D4-CNC



D7-71C



Tooling Not Included

Part 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"
5 Piece Standard 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

Victory™
Automatic Thru Coolant Quick Change Tool Post
with Triple Action Wedge-Lock System

- 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
- Automatic Thru Coolant System



The Quest for a Perfect Masterpiece Ends Right Here!

The New Patented

Victory™ Automatic Thru Coolant Tool Post

***& Quick Change Toolholders** are*

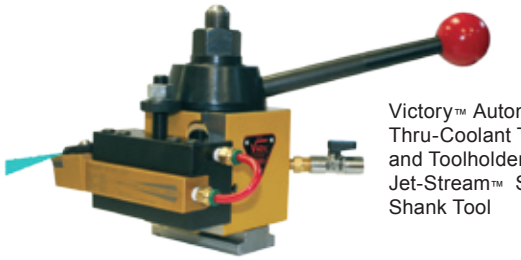
Quick - Clean - Precise



Victory™ Automatic Thru-Coolant Tool Post

Engineered with the Most Advanced Technology for

Unmatched Performance & Unsurpassed Precision



Victory™ Automatic Thru-Coolant Tool Post and Toolholder with Jet-Stream™ Square Shank Tool

Shoots the coolant exactly where it is needed

No Splash - No Waste - No Adjustment!



Victory™ Automatic Thru-Coolant Tool Post and Toolholder with Jet-Stream™ Boring Bar

Features:

Coolant Connection To Machine

The main coolant hose of the machine is attached directly to the Victory™ tool post's inlet valve. The coolant travels to both sides of the Victory™ tool post dovetail faces. An automatic shut-off valve on each dovetail face keeps the coolant pressurized inside the tool post body.

Closing the inlet valve manually blocks the coolant entry into the tool post body for applications where coolant should not be used.



Victory™ Automatic Thru-Coolant Tool Post and Toolholder with Industry Standard Square Shank Tool

Coolant Activation/Shut-Off

The coolant system will activate automatically every time a toolholder is placed and locked in the Victory™ tool post for any machining operation. The automatic shut-off valve opens to let the coolant flow thru the toolholder into the tool, and finally onto the cutting edge of the insert.



Victory™ Automatic Thru-Coolant Tool Post with Industry Standard Toolholder and Square Shank Tool

Best results are achieved when the Victory™ tool post is used with Victory™ Thru Coolant Toolholders that have a 1/8 NPT coolant port, allowing direct connection to a Jet-Stream™ (thru-coolant) square shank tool or boring bar.

The Victory™ tool post can also be used with any industry standard (non thru-coolant) quick change toolholders. For these applications, the Victory™ tool post comes standard with two coolant outlets, one on each side of the body, to allow a flexible coolant hose to be connected in order to deliver the coolant to the cutting edge of the insert.



Victory™ Automatic Thru-Coolant Tool Post with Non-Coolant Application

On Target!

At The Cutting Edge



Use Jet-Stream™ Thru Coolant Turning, Boring and Threading Tools with Victory™ Thru Coolant Quick Change Tool Post for Maximum Productivity!

Dorian Jet-Stream™ Thru Coolant System Will:

Improve Quality!

Improve Productivity!

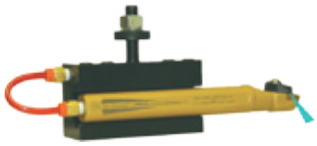
Improve Insert Life!

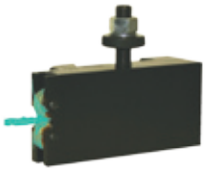
Dorian Tool's Jet-Stream™ Thru Coolant Cutting Tools use a patented thru-coolant locking clamp which is precisely aimed to direct high pressure, high velocity coolant exactly onto the cutting edge of the carbide insert, from a short distance of ¼".

This controlled Jet-Stream coolant, directed onto the insert chip interface (right under the chip and over the insert cutting edge) will dissipate the generated heat very effectively as well as lubricate the cutting edge of the insert, causing the chips to hydroplane over the insert surface instead of adhering to it. As a result, the insert will operate at a constant low temperature, with a clean and undamaged cutting edge, changing the way metal is cut.

Higher speeds and feeds can be achieved, with a better surface finish, tolerance control and machining performance. **The insert life is extended up to 200%.**

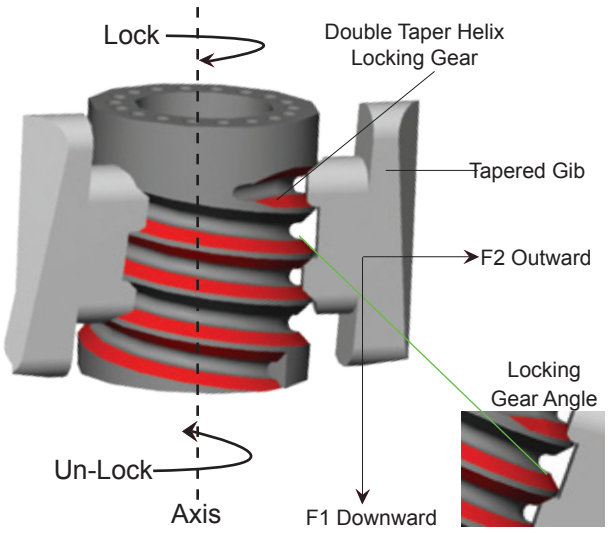


Style	Features		Application
Automatic Thru Coolant Quick Change Tool Post			
 PG. 49	• Automatic Thru Coolant System • Triple Action Locking System • Zero Backlash • Precise Repeatability within .0001” • 15° Locking Handle Position Adjustment • Super Heavy Duty Locking Gear and Wedge Style Sliding Gibs • Industry Standard Interchangeable Toolholders • Thru-Coolant Toolholders • Supplied With all Coolant Attachments and Valves	• High Tensile Strength Chromium-Molybdenum Alloy Steel Body, Locking Gear, Sliding Gibs, Locking Gear Head, and Locking Handle • Thru Hardened, Ion Nitrided, and Nickel-plated Body • Thru 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 Applications • Tight Tolerances and Excellent Finish Requiring Applications • Deep Drilling and Boring Applications • Heavy Material Removal Applications • Multi Turning, Drilling, Boring, Threading Applications
No. V1 Thru Coolant Turning & Facing Holder			
 PG. 50	• Quick Change Mounting • Double Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control • Increases Insert Life • Better Surface Finish • Tight Tolerances	• Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Holds Square Shank Tools • Turning and Facing Applications • Threading and Grooving Applications • Cut-Off Applications
No. V2 Thru Coolant Turning, Facing & Boring Holder			
 PG. 50	• Boring Bar “V” Seat • Quick Change Mounting • Double Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control • Increases Insert Life • Better Surface Finish • Tight Tolerances	• Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Holds Square Shank Tools • Holds Boring Bars and other Round Tools • Turning and Facing Applications • Light to Medium Boring Applications • Threading and Grooving Applications • Cut-Off Applications
No. V4-41-41S CNC Thru Coolant Extra Heavy Duty Boring Bar Holder - CNC Locking system			
 PG. 50-51	• 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 and Ground Locking Screws for High Rigidity Extended Overhangs without Scarring the Boring Bar • Sizes Up to 3” Capacity • Quick Change Mounting • Coolant System	• Constant Insert Cutting Edge Temperature Control • Chip Flow Control • Increases Insert Life • Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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
No. V41-V41S COL Thru Coolant Extra Heavy Duty Boring Bar Holder - Collar Locking System			
 PG. 51-52	• Precision Ground and Honed Bore • Qualified Bore for Precise Tool Alignment and Squareness • 360° Locking for High Rigidity and Extended Overhangs without Scarring the Boring Bar • Sizes Up to 3” Capacity • Quick Change Mounting • Coolant System • Constant Insert Cutting Edge Temperature Control	• Chip Flow Control • Increases Insert Life • Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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. V5 Thru Coolant Morse Taper Holder			
 PG. 52	• Precision Ground Morse Taper • Qualified for Precise Tool Alignment and Squareness • Designed for Deep Drilling • Heavy Duty Drilling • Quick Change Mounting • Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control	• Increases Insert Life • Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • 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 Applications
No. V-7-71C Thru Coolant Reversible Cut-Off Blade Holder			
 PG. 52	• Precision Ground Blade Dovetail Seat • Qualified for Precise Tool Alignment and Squareness • Quick Change Mounting • Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control • Increases Insert Life	• Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Cut-Off Applications • Grooving Applications
No. V881 Thru Coolant O.D. or I.D. Threading Holder			
 PG. 54	• Quick Change Mounting • Double Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control • Increases Insert Life • Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• OD and ID Threading
No. V10 Thru Coolant Knurling Holder			
 PG. 55	• Quick Change Mounting • Coolant System for High Performance Knurling • Constant Knurling Wheel Temperature Control • Increases Knurling Wheel Life • Better Knurl Quality	• High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• OD Straight Knurling • OD Diamond Knurling
No. V35 Thru Coolant Dovetail Drill Chuck Holder			
 PG. 56	• Supplied with a Rohm Chuck • Qualified for Precise Tool Alignment and Squareness • Designed for Versatility • Quick Change Mounting • Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control • Increases Insert Life	• Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Center Drilling • Precision Drilling • Precision Reaming • Tapping
No. V36 Thru Coolant 5C Collet Holder			
 PG. 56	• 5C Collet Holding System • Supplied with Collet Closer • Qualified for Precise Tool Alignment and Squareness • Designed for Versatility • Quick Change Mounting • Coolant System • Constant Insert Cutting Edge Temperature Control • Chip Flow Control	• Increases Insert Life • Better Surface Finish • Tight Tolerances • Higher Speeds and Feeds • High Tensile Strength Chromium-Molybdenum Alloy Steel • Thru Hardened, Ion-Nitrided, and Black Oxide Coated • CNC Precision Ground and Qualified for Accuracy and Super Precise Tool Change Repeatability within .0001”	• Miniature to Medium Size Tools • For Special Tool Size and Shapes • Accepts Square, Round and Hex Collets • Drilling Aplications • Boring Applications • Reaming Applications • Tapping • From 1/16” to 1.0” Diameter Tools

The Triple Action Wedge-Locking System

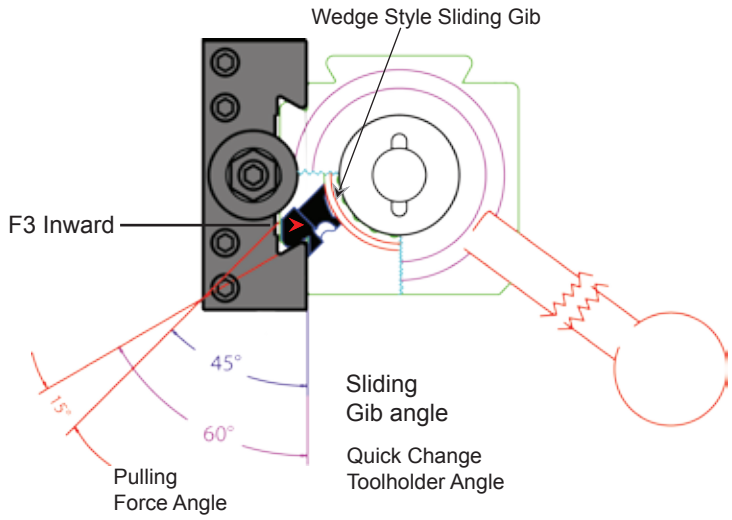
is a powerful combination of a downward, outward and inward force simultaneously locking the holder.

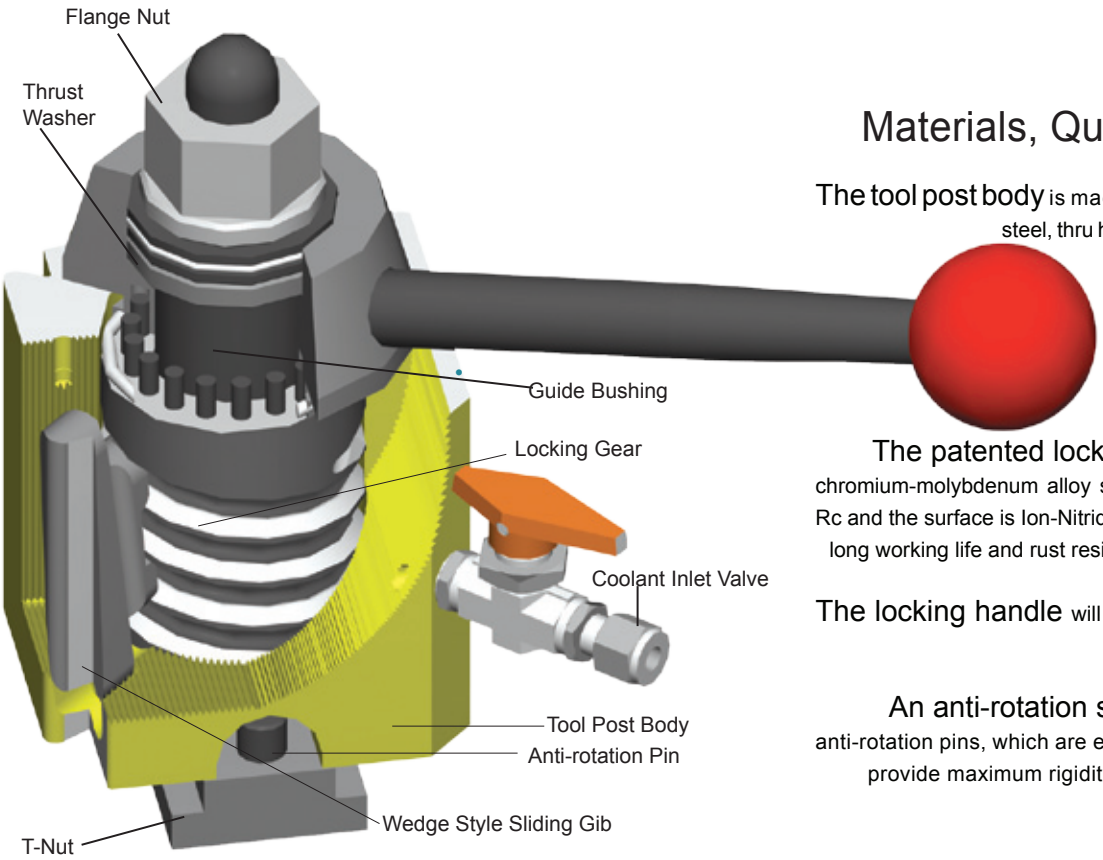


1. F1 Downward Force: (shown left) Rotating the locking gear moves the gib down, expanding the tool post dovetail to lock the toolholder.

2. F2 Outward Force: (shown left) 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 below) 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.





Materials, Quality & Workmanship

The tool post body is made from chromium-molybdenum alloy steel, thru hardened, ion-nitrited and Nickel-plated for protection and durability in machining environments. Precisely machined and ground with the most advanced technology & precision.

The patented locking gear and gibs are made from chromium-molybdenum alloy steel. The core thru hardness is 40-44 Rc and the surface is Ion-Nitrided to a hardeness 60-64Rc to ensure a long working life and rust resistance under harsh working conditions.

The locking handle will lock within 45º of travel and its position can be adjusted in 15º increments.

An anti-rotation system is built into the tool post with anti-rotation pins, which are engaged with a “T” Nut or compound to provide maximum rigidity and stability when performing drilling, boring and heavy roughing operations.

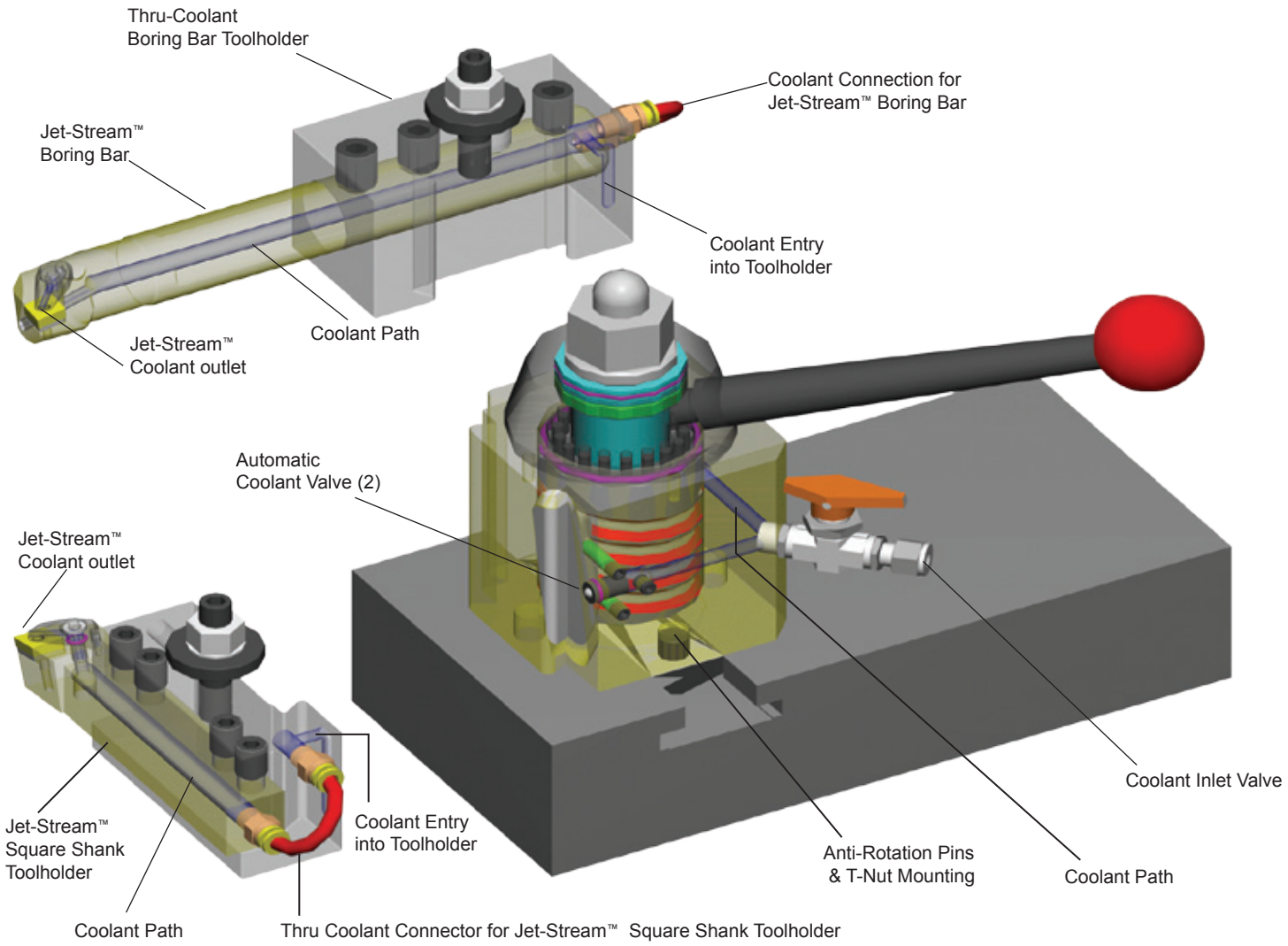
Thru-Coolant Toolholders Available

No.1 .....Turning and Facing
No. 2.....Turning, Facing and Boring
No. 4, 4M, 41, 41M, 41S, 41SM.....Boring Bar
No. 5.....Morse Taper
No. 7-71C.....Cut-Off and Grooving
No. 881.....Internal and External Threading
No. 10.....Knurling
No. 35.....Drill-Chuck
No. 36.....5C Collet

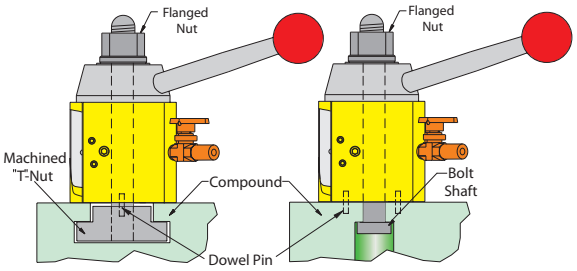
Features:

- Automatic thru-coolant system
- Lock the toolholder and coolant is on
- Release the toolholder and the coolant is off
- Thru coolant system on all toolholders

External Turning and Internal Boring with Automatic Thru Coolant

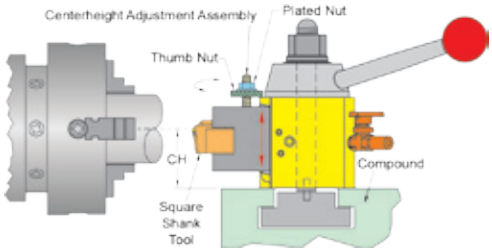


Tool Post Mounting



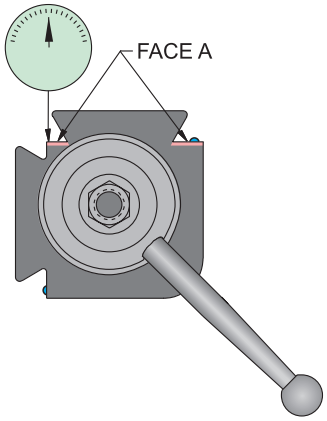
The tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flange Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using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



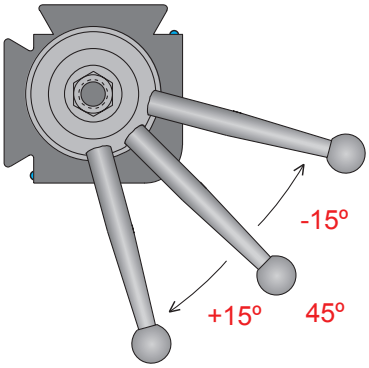
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool by rotating the Thumb Nut until the desired height is reached and locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool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

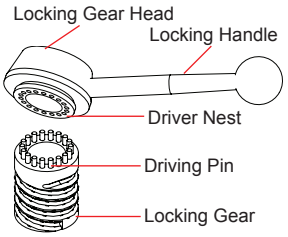
Indicating Position



The double dovetails are ground at 90° square (± .0002"). At 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



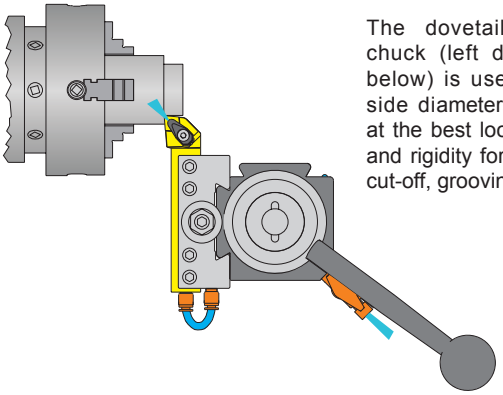


To change the position of the handle: remove the flange nut; remove the guide bushing; pull the locking gear head and place to the desired position.

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

O.D. Turning Operations with Thru Coolant

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

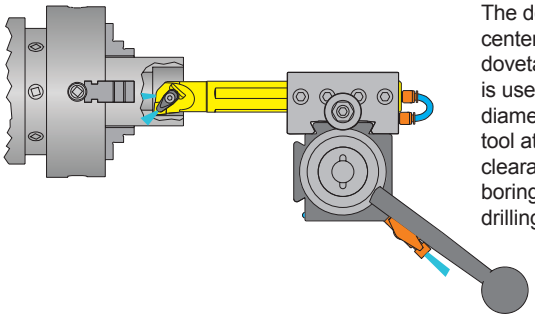


The dovetail closest to the chuck (left dovetail as shown below) is used for turning outside diameters. It holds the tool at the best location for clearance and rigidity for turning, threading, cut-off, grooving, and chamfering.

Using Jet-Stream™ Square Shank Tools made by Dorian Tool directs the coolant right onto the cutting edge and keeps the temperature constant to extend insert life and improve part quality. This also eliminates all the coolant splash to the surroundings associated with using conventional coolant hoses.

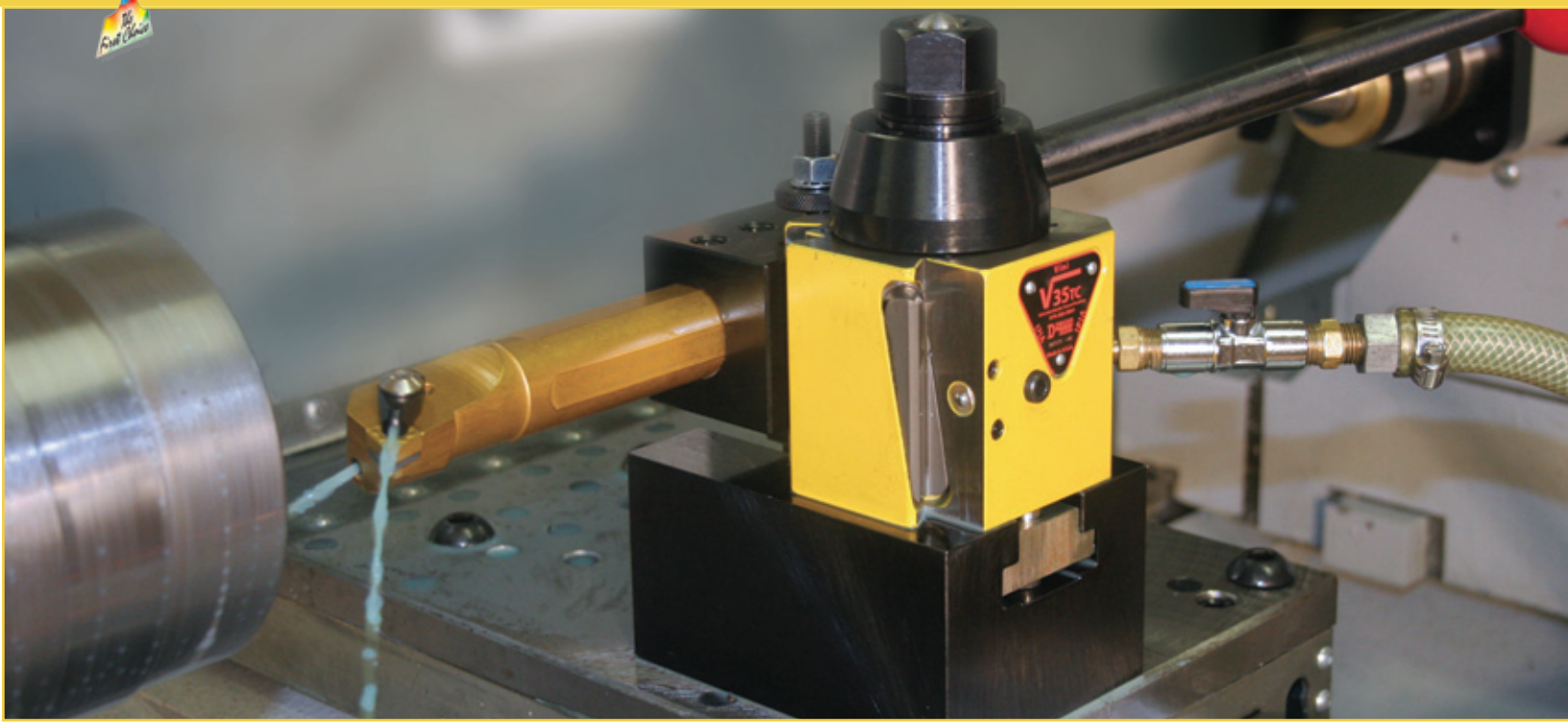
I.D. Turning Operations with Thru Coolant

Boring, Threading, Grooving, Drilling, & Center Drilling



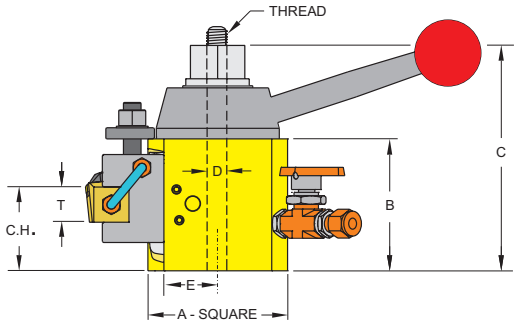
The dovetail closest to the center of the chuck (top dovetail as shown below) is used for turning inside diameters. It holds the tool at the best location for clearance and rigidity when boring, threading, grooving, drilling, and center drilling.

Using Jet-Stream™ Boring Bars made by Dorian Tool directs the coolant right onto the cutting edge and keeps the temperature constant to extend insert life and improve part quality. This also eliminates all the coolant splash to the surroundings associated with using conventional coolant hoses.



Identification System for Victory™ Automatic Thru Coolant Tool Post		
V	25	tc
Victory™	Tool Post Size	Thru Coolant

Identification System for Victory™ Automatic Thru Coolant Toolholders					
V	25	tc	4	CNC	COL
Victory™	Toolholder Size	Thru Coolant	Type of Toolholder	Boring Bar Locking System	Boring Bar Locking System



- Zero Backlash
- Triple Action Locking System
- Precise Repeatability within .0001

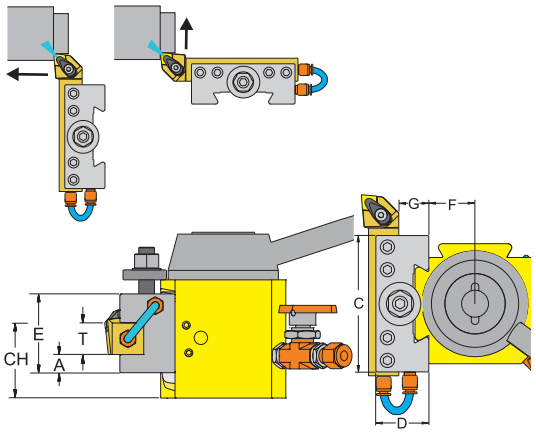
- 15º Locking Handle Position Adjustment
- Industry-Standard Interchangeable Holders
- Automatic Thru Coolant Activation and Shut-off

Description	V25tc		V30tc		V35tc		V40tc		V50tc		V60tc	
Part No. 733101-	04200		04201		04202		04203		04204		04205	
Size	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	2.500	63.5	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
Optimim 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 size of the tool capacity. If the higher size tool is to be used, add 1/8″ to the optimum center height.

No. V1 Thru-Coolant

Turning & Facing Toolholder

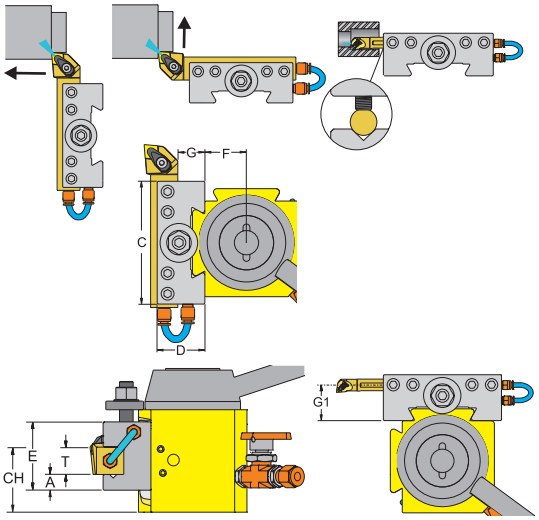


This toolholder is best used for holding square shank toolholders close to the tool post to maximize rigidity when turning, facing, and threading. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V25tc-1	04210	in	.375	0.750	2.750	1.240	1.740	.880	.790	⅛-27
		mm	9.53	20	69.85	31.50	44.20	22.35	20.07	
V30tc-1	04230	in	.437	1.000	3.250	1.490	2.240	1.115	.915	⅛-27
		mm	11.10	25	82.55	37.85	56.90	28.32	23.24	
V35tc-1	04250	in	.500	1.000	3.750	1.740	2.490	1.199	1.040	⅛-27
		mm	12.70	25	95.25	44.20	63.25	30.45	26.42	
V40tc-1	04270	in	.562	1.250	4.500	1.990	2.990	1.530	1.040	⅛-27
		mm	14.27	32	114.30	50.55	75.95	38.86	26.42	
V50tc-1	04290	in	.750	1.500	6.000	2.490	3.490	1.900	1.290	⅛-27
		mm	19.05	40	152.40	63.25	88.65	48.26	32.77	
V60tc-1	04305	in	1.000	1.500	7.000	2.990	3.990	2.207	1.540	⅛-27
		mm	25.40	40	177.80	75.95	101.35	56.06	39.12	

No. V2 Thru-Coolant

Turning, Facing & Boring Toolholder



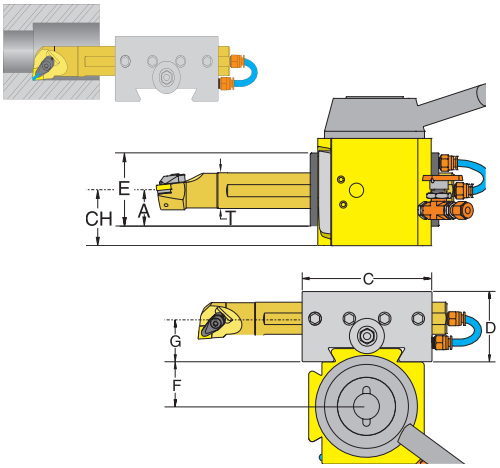
The "V" groove makes this holder more versatile so that it can hold either square shank toolholders or boring bars. Holds the tool close to the tool post to maximize rigidity when turning, facing, threading or boring. Fits industry standard toolposts. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	G1	NPT
V25tc-2	04211	in	.375	0.750	2.750	1.240	1.740	.880	.790	1.015	⅛-27
		mm	9.53	20	69.85	31.50	44.20	22.35	20.07	25.78	
V30tc-2	04231	in	.437	1.000	3.250	1.490	2.240	1.115	.915	1.205	⅛-27
		mm	11.10	25	82.55	37.85	56.90	28.32	23.24	30.61	
V35tc-2	04251	in	.500	1.000	3.750	1.740	2.490	1.199	1.040	1.390	⅛-27
		mm	12.70	25	95.25	44.20	63.25	30.45	26.42	35.31	
V40tc-2	04271	in	.562	1.250	4.500	1.990	2.990	1.530	1.040	1.515	⅛-27
		mm	14.27	32	114.30	50.55	75.95	38.86	26.42	38.48	
V50tc-2	04291	in	.750	1.500	6.000	2.490	3.490	1.900	1.290	1.890	⅛-27
		mm	19.05	40	152.40	63.25	88.65	48.26	32.77	48.01	
V60tc-2	04306	in	1.000	1.500	7.000	2.990	3.990	2.207	1.540	2.265	⅛-27
		mm	25.40	40	177.80	75.95	101.35	56.06	39.12	57.30	

No. V4-CNC Thru-Coolant

Heavy Duty Boring Bar Toolholder

Inch/Metric



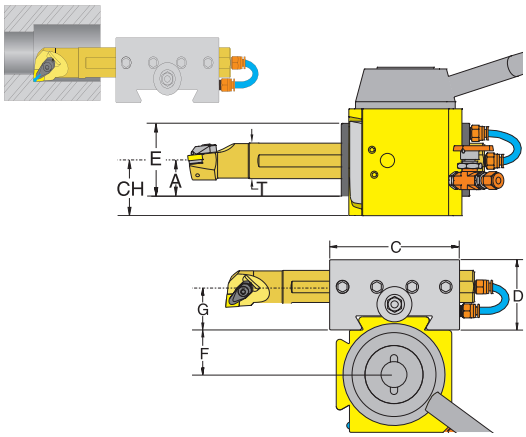
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the centerheight and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V25tc-4-CNC	04212	in	.745	.750	2.750	1.490	1.490	.880	.937	⅛-27
V25tc-4M-CNC	04213	mm	18.92	20	69.85	37.85	37.85	22.35	23.80	
V30tc-4-CNC	04232	in	.995	1.000	3.250	1.990	1.990	1.115	1.250	⅛-27
V30tc-4M-CNC	04233	mm	25.27	25	82.55	50.55	50.55	28.32	31.75	
V35tc-4-CNC	04252	in	1.120	1.000	3.750	2.240	2.240	1.199	1.375	⅛-27
V35tc-4M-CNC	04253	mm	28.45	25	95.25	56.90	56.90	30.45	34.93	
V40tc-4-CNC	04272	in	1.245	1.250	4.500	2.490	2.490	1.530	1.500	⅛-27
V40tc-4M-CNC	04273	mm	31.62	32	114.30	63.25	63.25	38.86	38.10	
V50tc-4-CNC	04292	in	1.495	1.500	5.500	2.990	2.990	1.900	2.000	⅛-27
V50tc-4M-CNC	04293	mm	37.97	40	139.70	75.95	75.95	48.26	50.80	
V60tc-4-CNC	04307	in	1.995	2.000	6.500	3.990	3.990	2.207	2.500	⅛-27
V60tc-4M-CNC	04308	mm	50.67	50	165.10	101.35	101.35	56.06	63.50	

No. V41-CNC Thru-Coolant

Extra Heavy Duty Boring Bar Toolholder

Inch/Metric



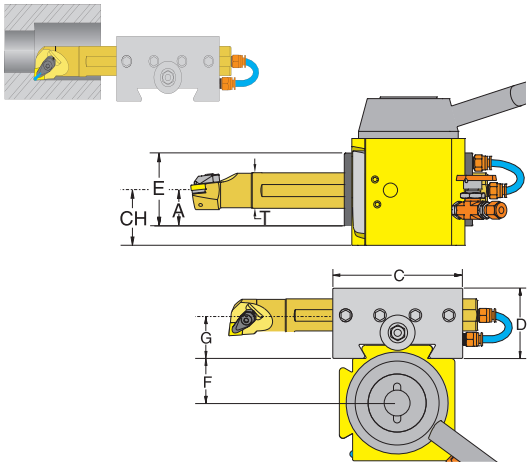
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V25tc-41-CNC	04214	in	.870	1.000	2.750	1.740	1.740	.880	1.062	⅛-27
V25tc-41M-CNC	04215	mm	22.10	25	69.85	44.20	44.20	22.35	26.97	
V30tc-41-CNC	04234	in	1.120	1.250	3.250	2.240	2.240	1.115	1.375	⅛-27
V30tc-41M-CNC	04235	mm	28.45	32	82.55	56.90	56.90	28.32	34.93	
V35tc-41-CNC	04254	in	1.120	1.250	3.750	2.240	2.240	1.199	1.375	⅛-27
V35tc-41M-CNC	04255	mm	28.45	32	95.25	56.90	56.90	30.45	34.93	
V40tc-41-CNC	04274	in	1.245	1.500	4.500	2.490	2.490	1.530	1.500	⅛-27
V40tc-41M-CNC	04275	mm	31.62	40	114.30	63.25	63.25	38.86	38.10	
V50tc-41-CNC	04294	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250	⅛-27
V50tc-41M-CNC	04295	mm	44.32	50	139.70	88.65	88.65	48.26	57.15	
V60tc-41-CNC	04309	in	1.995	2.500	6.500	3.990	3.990	2.207	2.375	⅛-27
V60tc-41M-CNC	04310	mm	50.67	60	165.10	101.35	101.35	56.06	60.33	

No. V41S-CNC Thru-Coolant

Super Oversized Boring Bar Toolholder

Inch/Metric



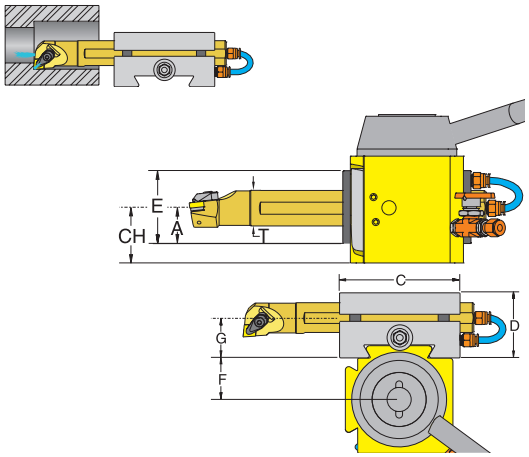
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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

Desc.	Part No. 733101-	Size	A	B	C	D	E	F	G	NPT
V35tc-41-150-CNC	04256	in	1.245	1.500	4.000	2.490	2.490	1.199	1.500	⅛-27
V35tc-41M-40-CNC	04257	mm	31.62	40	101.60	63.25	63.25	30.45	38.10	
V40tc-41-200-CNC	04276	in	1.495	2.000	4.500	2.990	2.990	1.530	1.750	⅛-27
V40tc-41M-50-CNC	04277	mm	37.97	50	114.30	75.95	75.95	38.86	44.45	
V50tc-41-250-CNC	04296	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250	⅛-27
V50tc-41M-60-CNC	04297	mm	50.67	60	165.10	101.35	101.35	48.26	57.15	
V60tc-41-300-CNC	04311	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625	⅛-27
V60tc-41M-80-CNC	04312	mm	57.02	80	177.80	114.05	114.05	56.06	66.68	

No. V41-COL Thru-Coolant

Extra Heavy Duty Boring Bar Toolholder

Inch/Metric



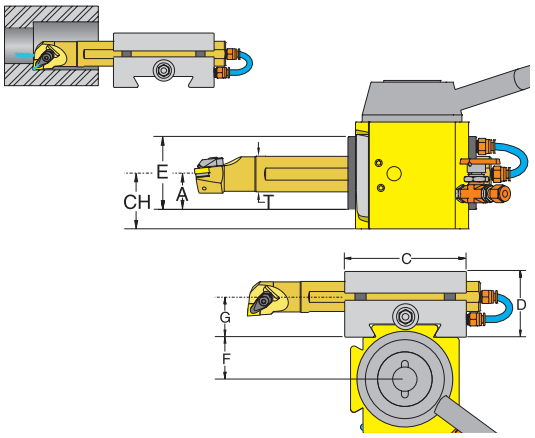
This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system providing the best rigidity in metal removing without scarring the boring bar. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V35tc -41-COL	04264	in	1.120	1.250	3.750	2.240	2.240	1.999	1.375	⅛-27
V40tc-41-COL	04284	in	1.245	1.500	4.500	2.490	2.490	1.530	1.500	⅛-27
V50tc-41-COL	04300	in	1.745	2.000	5.500	3.490	3.490	1.900	2.250	⅛-27
V60tc -41-COL	04315	in	1.995	2.500	6.500	3.990	3.990	2.207	2.375	⅛-27

No. V41S-COL Thru-Coolant

Super Oversized Boring Bar Toolholder

Inch/Metric

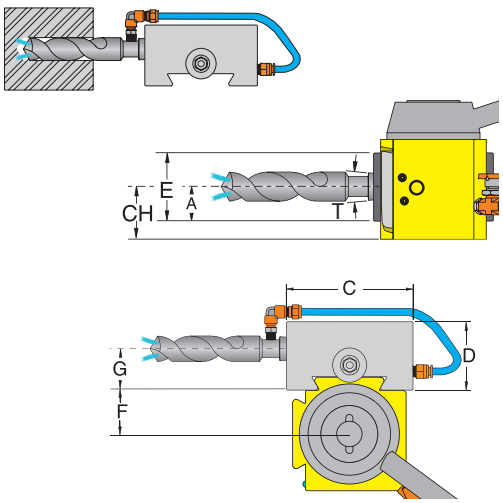


This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system providing the best rigidity in metal removing without scarring the boring bar. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V35tc-41-150-COL	04266	in	1.245	1.500	4.000	2.490	2.490	1.199	1.500	⅛-27
V40tc-41-200-COL	04286	in	1.495	2.000	4.500	2.990	2.990	1.530	1.750	⅛-27
V50tc-41-250-COL	04302	in	1.995	2.500	6.500	3.990	3.990	1.900	2.250	⅛-27
V60tc-41-300-COL	04317	in	2.245	3.000	7.000	4.490	4.490	2.207	2.625	⅛-27

No. V5 Thru-Coolant

Morse Taper Toolholder

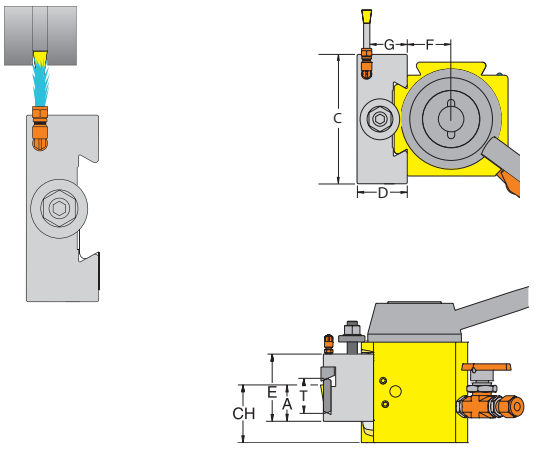


This holder is best used for holding morse taper tools. It can be used for drilling, boring, or reaming operations. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V25tc-5-2	04218	in	.745	MT2	2.750	1.490	1.490	.880	.937	⅛-27
		mm	18.92	MT2	69.85	37.85	37.85	22.35	23.80	
V30tc-5-3	04238	in	.995	MT3	3.500	1.990	1.990	1.115	1.250	⅛-27
		mm	25.27	MT3	88.90	50.55	50.55	28.32	31.75	
V35tc-5-4	04258	in	1.245	MT4	4.150	2.490	2.490	1.199	1.622	⅛-27
		mm	31.62	MT4	105.41	63.25	63.25	30.45	41.20	
V40tc-5-4	04278	in	1.245	MT4	4.500	2.490	2.490	1.530	1.622	⅛-27
		mm	31.62	MT4	114.30	63.25	63.25	38.86	41.20	
V50tc-5-5	04298	in	1.745	MT5	5.625	3.490	3.490	1.900	2.310	⅛-27
		mm	44.32	MT5	142.88	88.65	88.65	48.26	58.67	
V60tc-5-5	04313	in	1.745	MT5	6.000	3.490	3.490	2.207	2.310	⅛-27
		mm	44.32	MT5	152.40	88.65	88.65	56.06	58.67	

No. V7-71C Thru-Coolant

Extra Heavy Duty Cut-Off Blade Toolholder

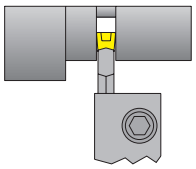


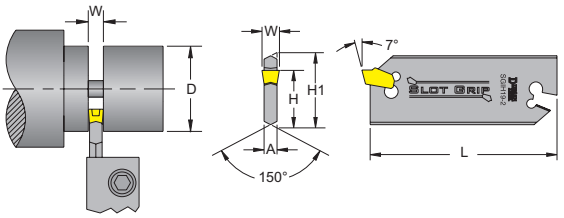
This holder is best used for holding cut-off blades. It has a taper locking system for maximum rigidity and performance in cut-off and face grooving operations. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.

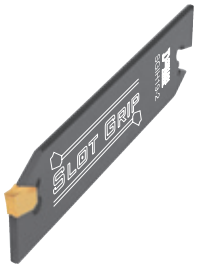
Desc.	Part No. 733101-	Size	A	Blade Size "T"	C	D	E	F	G	NPT
V25tc-7-71C	04219	in	.925	SGIH-19-2	2.750	1.240	1.990	.880	1.075	⅛-27
		mm	23.50		69.85	31.50	50.55	22.35	27.31	
V30tc-7-71C	04239	in	.925		3.250	1.240	1.990	1.115	1.075	⅛-27
		mm	23.50		82.55	31.50	50.55	28.32	27.31	
V35tc-7-71C	04259	in	1.230	SGIH-26-2 to 26-6	3.750	1.740	2.490	1.199	1.520	⅛-27
		mm	31.24		95.25	44.20	63.25	30.45	38.61	
V40tc-7-71C	04279	in	1.485		4.500	1.740	2.990	1.530	1.520	⅛-27
		mm	37.69		114.30	44.20	75.95	38.86	38.61	
V50tc-7-71C	04299	in	1.440	SGIH-32-3 to 32-9	6.000	1.990	2.990	1.900	1.710	⅛-27
		mm	36.60		152.40	50.55	75.95	48.26	43.43	
V60tc-7-71C	04314	in	1.760		7.000	2.240	3.490	2.207	1.960	⅛-27
		mm	44.65		177.80	56.90	88.65	56.06	49.78	

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 permits free chip flow, minimizing insert breakage due to chip build-up.

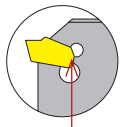






SLOT GRIP

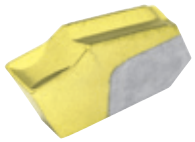
Improved design featuring a "Positive Stop". Inserts are securely held in Slot Grip Positive Stop Blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is firmly in place.



Positive Stop

Desc.	Part No. 733101-	Insert Used	W		D Max		A		L		H		H 1	
			in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
SGIH19-2	62950	SGT(N/R/L)-2	.087	2	1.57	39,9	.063	1,57	3.38	85,9	.618	15,7	0.75	19,1
SGIH26-2	62951	SGT(N/R/L)-2	.087	2	2.00	50,8	.063	1,57						
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



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. Insert Color: Yellow-Gold

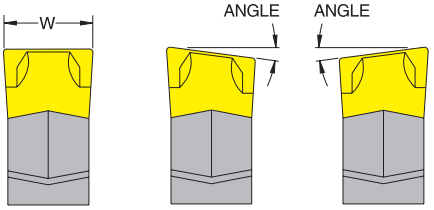
DC656 - (C5-C6 Substrate with CVD TiN/TiC-TiN coating) First Choice for general turning applications on ferrous metals and 400 series stainless steels, at medium cutting sfm and wet conditions. Multi Layer CVD carbide grade. Thermal deformation and abrasion resistant substrate with cobalt enriched periphery.

Chipbreaker Geometry

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

Application

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

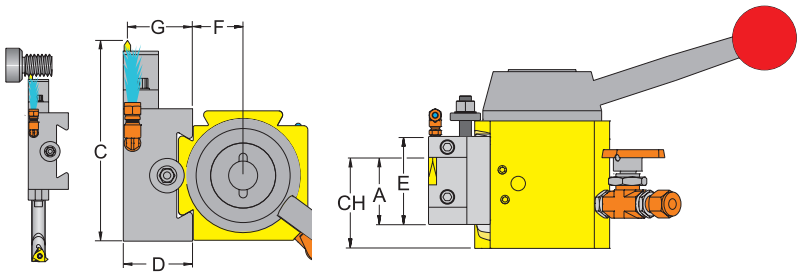


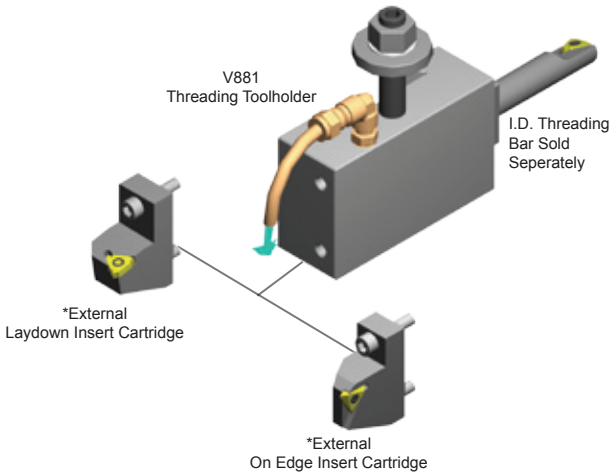
NEUTRAL LEFT HAND RIGHT HAND

Desc.	DASK25 First Choice for High Performance Machining	DC656 First Choice for General Turning Applications	Insert Size	Lead Angle	Width + .004	
					in	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

No. V881 Thru-Coolant

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. Supplied standard with Victory™ Thru-Coolant System.

Description	Part No. 733101-	Size	A	C	D	E	F	G	NPT	*External On Edge Insert Cartridge					*External Laydown Insert Cartridge						
										Desc.	Part No. 733101-	TNMC Insert	Torx Screw	Torx Key	Desc.	Part No. 733101-	Insert	Torx Screw	Torx Key	Pitch TPI	Pitch mm
V25tc-881-OE	04220	in	.875	4.135	1.240	1.990	.880	1.175	1/8-27	TIH253-32	03621	32	GTS-1	T-10	NL253-3R	03635	16ER-AG60	TS-16	T-10	8-48	0,5-3,5
V25tc-881-LD	04228	mm	22.23	104.88	31.50	50.55	22.35	29.85													
V30tc-881-OE	04240	in	1.000	4.510	1.240	1.990	1.115	1.175	1/8-27												
V30tc-881-LD	04248	mm	25.40	114.55	31.50	50.55	28.32	29.85													
V35tc-881-OE	04260	in	1.250	5.365	1.490	2.490	1.199	1.427	1/8-27												
V35tc-881-LD	04268	mm	31.75	136.27	37.85	63.25	30.45	36.25		TIH354-32	03623	32	GTS-1	T-10	NL354-3R	03637	16ER-AG60	TS-16	T-10	8-48	0,5-3,5
V40tc-881-OE	04280	in	1.500	5.760	1.490	2.490	1.530	1.427	1/8-27												
V40tc-881-LD	04288	mm	38.10	146.30	37.85	63.25	38.86	36.25													

*Part Descriptions ending in -OE come with External On Edge Insert Cartridge. Part Descriptions ending in -LD come with External Laydown Insert Cartridge. Inserts not included. Internal threading bar is not supplied with the holder.

On Edge Threading Insert
TNMC - NV "V" Thread



Laydown Threading Insert

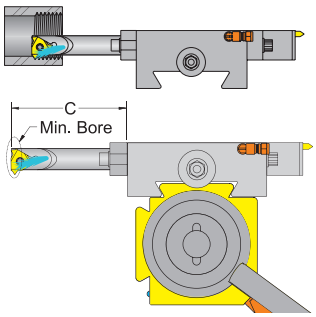


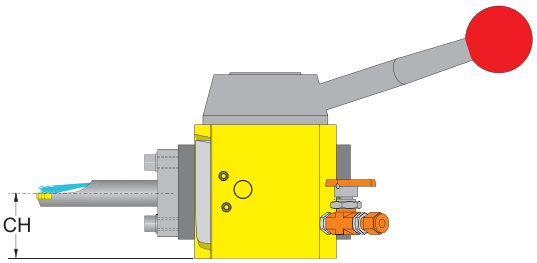
Desc.	Steel DVP656 Grade Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No. 733101-	I.C.		Thickness		Hole Dia.		Depth.	
			in	mm	in	mm	in	mm	in	mm
TNMC-32NV-	72003	72004	.375	9,5	.1250	3,18	.150	3,81	.150	3,81

Thru-Coolant Internal Threading Bar

For V881 Thru-Coolant 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. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.



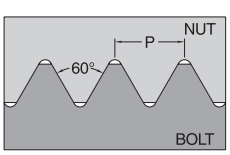


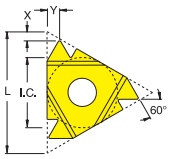


Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

Series	Right Hand			Left Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	Desc.	No. 733101-	Insert	in	mm	in	mm	TPI	mm			
25,30,35,40	NL50R	03661	11IR-A60	NL50L	03669	11IL-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	NL75L	03671	16IL-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	NL125L	03673	22IL-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



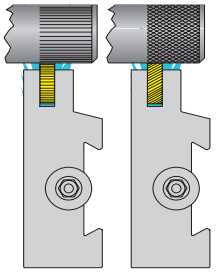


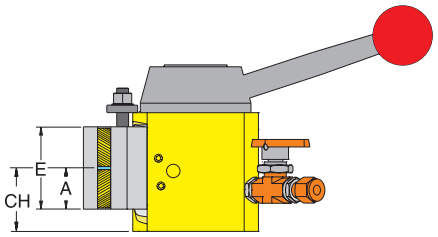
Internal Right Hand	Steel DVP656 Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No.733101-	Internal Left Hand	Steel DVP656 Part No. 733101-	Stainless Steel, Cast Iron & Aluminum DVK10 Grade Part No.733101-	L mm	I.C. in	Pitch TPI	Pitch MM	x mm	y mm
11IR-A60	74056	74057	11IL-A60	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

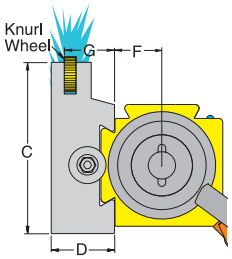
No. V10 Thru-Coolant

Knurling Toolholder & Wheels

This holder is best used for knurling diamond or straight patterns.
Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.



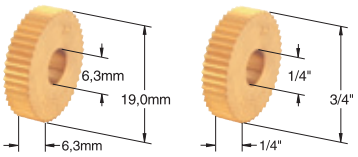




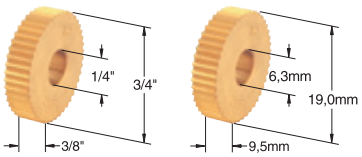
Supplied with one set of 25TPI diagonal knurl wheels for a diamond pattern.

Desc.	Part No. 733101-	Size	A	C	D	E	F	G	Knurling Wheel			Knurling Pin	
									Series	in	mm	Desc.	733101-
V25tc-10	04221	in	.745	3.125	.990	1.490	.880	.810	S	O.D. ¾	19,1	A60464	28620
		mm	18.92	79.38	25.15	37.85	22.35	20.57		I.D. ¼	6,35		
V30tc-10	04241	in	.870	4.000	1.240	1.740	1.115	1.060		T ¼	6,35		
		mm	22.09	101.60	31.50	44.20	28.32	26.92					
V35tc-10	04261	in	1.120	4.520	1.490	2.240	1.199	1.285	A	O.D. ¾	19,1	A60466	28630
		mm	28.45	114.81	37.85	56.90	30.45	32.64		I.D. ¼	9,52		
V40tc-10	04281	in	1.120	5.120	1.490	2.240	1.530	1.285		T ⅜	6,35		
		mm	28.45	130.05	37.85	56.90	38.86	32.64					

"S" Series



"A" Series



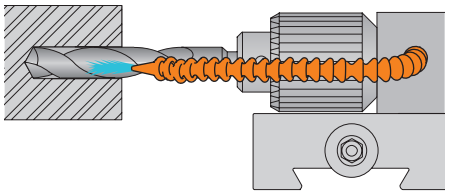
TPI Tooth Per In.	Metric Pitch	Included Tooth Angle	"S" Series-Circular Pitch			"A" Series-Circular Pitch		
			Straight	Diagonal Right	Diagonal Left	Straight	Diagonal Right	Diagonal Left
			High Speed Beveled			High Speed Beveled		
16	1,6mm	90°	SS-16-HSB-CP UPC No. 26839	SDR-16-HSB-CP UPC No. 26961	SDL-16-HSB-CP UPC No. 27085	AS-16-HSB-CP UPC No. 23541	ADR-16-HSB-CP UPC No. 23673	ADL-16-HSB-CP UPC No. 23805
20	1,2mm	90°	SS-20-HSB-CP UPC No. 26841	SDR-20-HSB-CP UPC No. 26963	SDL-20-HSB-CP UPC No. 27087	AS-20-HSB-CP UPC No. 23543	ADR-20-HSB-CP UPC No. 23675	ADL-20-HSB-CP UPC No. 23807
25	1,0mm	90°	SS-25-HSB-CP UPC No. 26843	SDR-25-HSB-CP UPC No. 26965	SDL-25-HSB-CP UPC No. 27089	AS-25-HSB-CP UPC No. 23545	ADR-25-HSB-CP UPC No. 23677	ADL-25-HSB-CP UPC No. 23809
30	0,8mm	90°	SS-30-HSB-CP UPC No. 26845	SDR-30-HSB-CP UPC No. 26967	SDL-30-HSB-CP UPC No. 27091	AS-30-HSB-CP UPC No. 23547	ADR-30-HSB-CP UPC No. 23679	ADL-30-HSB-CP UPC No. 23811

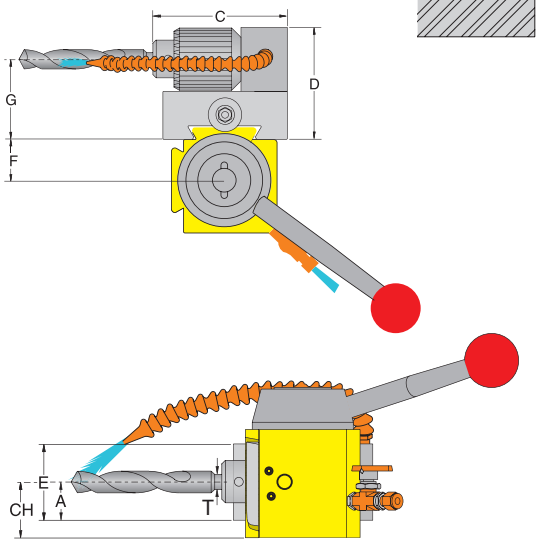
Call us for more information or to request a knurling catalog.

Solutions to Common Knurling Problems

Knurling Problem	Cause	Solution
Double Tracking	1.Circumference around blank is not an approximate multiple of the pitch of the knurl. 2. Shallow depth.	1. Force knurl in harder on the first revolution. 2. Change blank diameter ± .005". 3. Try slightly different pitch knurl. 4. Grind or stone approximately .003" off diameter of knurl tool. 5. Order special knurl.
Flaking	1. Rolling on stock with scale. 2. Over-rolling stock.	1. Turn off scale. 2. Reduce roll up part in 10-20 revolutions without over-rolling.
Slivered Part, Knurl Destruction	1. Knurl wheels too deep in the part. 2. Over-rolling stock.	1. Reset the depth of the knurl wheel shallower. 2. Reduce roll up part in 10-20 revolutions without over-rolling.
Knurl Wheel Poor Tool Life	1. Over-rolling, scale. 2. Knurling stainless (302, 303, 304, 316, & 174PH). 3. Rolling semi-hardened steels. 4. Stock run out excessive. 5. Knurls improperly hardened or of poor quality. 6. Poor lubrication.	1 Right number of revolutions, clean scale. 2 .Slow speeds and feeds. 3. Use Cobalt Titanium Nitrate knurl wheels. 4. Machine parts concentric. 5. Change knurl wheels. 6. Increase lubrication.

No. V35 Thru-Coolant
Drill Chuck Toolholder

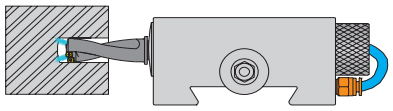


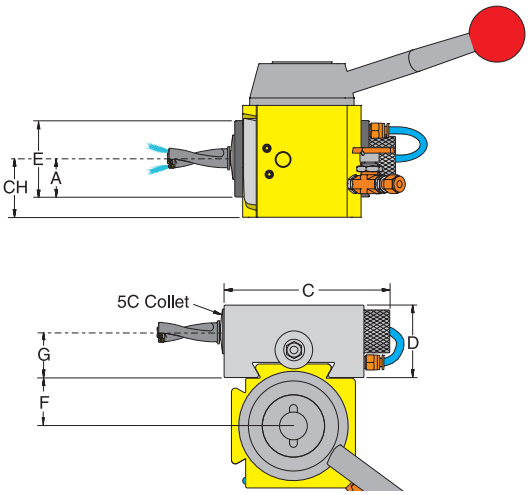


This holder is best used for holding drills, reamers, taps, etc., without tailstock mounting. It uses a drill chuck mounted directly to a quick change holder. This holder is supplied with a drill-chuck. Fits industry standard tool posts. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	T	C	D	E	F	G	NPT
V25tc-35	04222	in	.995	0-½	4.175	3.105	1.990	.880	2.050	⅛-27
		mm	25.27	0-12	106.05	78.87	50.55	22.35	52.07	
V30tc-35	04242	in	.995	0-½	4.175	3.105	1.990	1.115	2.050	⅛-27
		mm	25.27	0-12	106.05	87.87	50.55	28.32	52.07	
V35tc-35	04262	in	1.120	0-½	4.670	3.740	2.240	1.199	2.625	⅛-27
		mm	28.45	0-12	118.62	95.00	56.90	30.45	66.68	
V40tc-35	04282	in	1.120	0-½	4.670	3.740	2.240	1.530	2.625	⅛-27
		mm	28.45	0-12	118.62	95.00	56.90	38.86	66.68	

No. V36 Thru-Coolant
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. Supplied standard with Victory™ Thru-Coolant System.

Desc.	Part No. 733101-	Size	A	C	D	E	F	G	NPT
V25tc-36	04223	in	.995	4.250	2.240	1.990	.880	1.275	⅛-27
		mm	25.27	107.95	56.90	50.55	22.35	32.39	
V30tc-36	04243	in	1.120	4.500	2.240	2.240	1.115	1.375	⅛-27
		mm	28.45	114.30	56.90	56.90	28.32	34.93	
V35tc-36	04263	in	1.245	5.000	2.490	2.490	1.199	1.375	⅛-27
		mm	31.62	127.00	63.25	63.25	30.45	34.93	
V40tc-36	04283	in	1.245	5.500	2.490	2.490	1.530	1.375	⅛-27
		mm	31.62	139.70	63.25	63.25	38.86	34.93	

Victory™ Thru Coolant Turning Sets

(1) Tool Post
(4) Holders

Tooling Not Included



Vtc-1



Vtc-1



Vtc-2



Vtc-2



Part No. 733101-	04184	04185	04186	04187	04188	04189
Desc.	V25tc-TS	V30tc-TS	V35tc-TS	V40tc-TS	V50tc-TS	V60tc-TS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
5 Piece Turning Set Includes						
(1) Tool Post	V25tc	V30tc	V35tc	V40tc	V50tc	V60tc
(4) Holders	(2) V25tc-1 (2) V25tc-2	(2) V30tc-1 (2) V30tc-2	(2) V35tc-1 (2) V35tc-2	(2) V40tc-1 (2) V40tc-2	(2) V50tc-1 (2) V50tc-2	(2) V60tc-1 (2) V60tc-2

Victory™ Thru Coolant Standard Sets

(1) Tool Post
(4) Holders

NEW

Tooling Not Included



Vtc-1



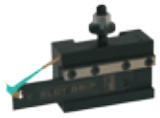
Vtc-2



Vtc-4-CNC



Vtc-7-71C



Part No. 733101-	04174	04175	04176	04177	04178	04179
Desc.	V25tc-INSS	V30tc-INSS	V35tc-INSS	V40tc-INSS	V50tc-INSS	V60tc-INSS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
5 Piece Standard Set Includes						
(1) Tool Post	V25tc	V30tc	V35tc	V40tc	V50tc	V60tc
(4) Holders	(1) V25tc-1 (1) V25tc-2 (1) V25tc-4-CNC (1) V25tc-7-71C	(1) V30tc-1 (1) V30tc-2 (1) V30tc-4-CNC (1) V30tc-7-71C	(1) V35tc-1 (1) V35tc-2 (1) V35tc-4-CNC (1) V35tc-7-71C	(1) V40tc-1 (1) V40tc-2 (1) V40tc-4-CNC (1) V40tc-7-71C	(1) V50tc-1 (1) V50tc-2 (1) V50tc-4-CNC (1) V50tc-7-71C	(1) V60tc-1 (1) V60tc-2 (1) V60tc-4-CNC (1) V60tc-7-71C

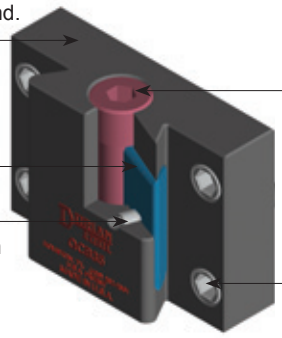
Dorian Quick Change FLAT Base



Quick Change Flat Base Body
with industry standard dovetail.
Heat treated and precision ground.
Maintenance Free.

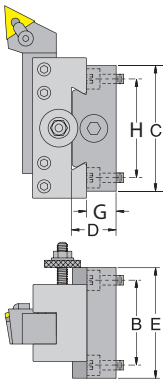
Gib
Repetitive accuracy of .0001". Heat treated and precision ground.

Gib Screw
prevents the gib from falling out.



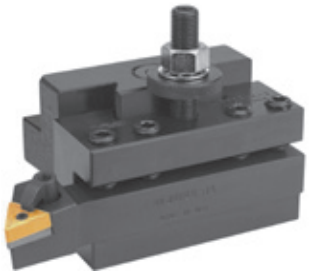
Locking Pin
positive lock with absolute zero backlash. Heat treated high tensile strength alloy steel.

Socket Head Cap Screw



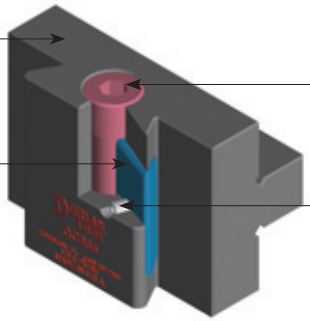
Description	Part No. 733101-	Quick Change Holder Series	C		D		E		G		H		I		Cap Screw	
			in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	inch	mm
DQCFB-20N	03120	MD20	2.062	52.4	0.970	24.6	1.750	44.5	0.685	17.4	1.625	41.3	0.876	22.3	3/16	5mm
DQCFB-25N	03122	D25AXA	2.500	63.5	0.980	24.9	2.000	50.8	0.620	15.7	1.875	47.6	1.250	31.8	3/16	5mm
DQCFB-30N	03124	D30BXA	3.000	76.2	1.105	28.1	2.250	57.2	0.735	18.7	2.250	57.2	1.750	44.5	1/4	6mm
DQCFB-35N	03126	D35CXA	3.500	88.9	1.330	33.8	2.500	63.5	0.800	20.3	2.750	69.9	1.875	47.6	5/16	8mm
DQCFB-40N	03128	D40CA	4.000	101.6	1.480	37.6	3.000	76.2	1.025	26.0	3.250	82.6	2.375	60.3	5/16	8mm
DQCFB-50N	03130	D50DA	5.000	127.0	2.043	51.9	4.000	101.6	1.475	37.5	4.000	101.6	3.250	82.6	5/16	8mm
DQCFB-60N	03132	D60EA	6.000	152.4	2.150	54.6	4.250	108.0	1.375	34.9	4.750	120.7	3.000	76.2	1/2	12mm

Dorian Quick Change Base



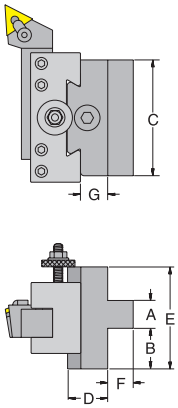
Quick Change Flat Base Body
with industry standard dovetail. Heat treated and precision ground.
Maintenance Free.

Gib
Repetitive accuracy of .0001". Heat treated and precision ground.

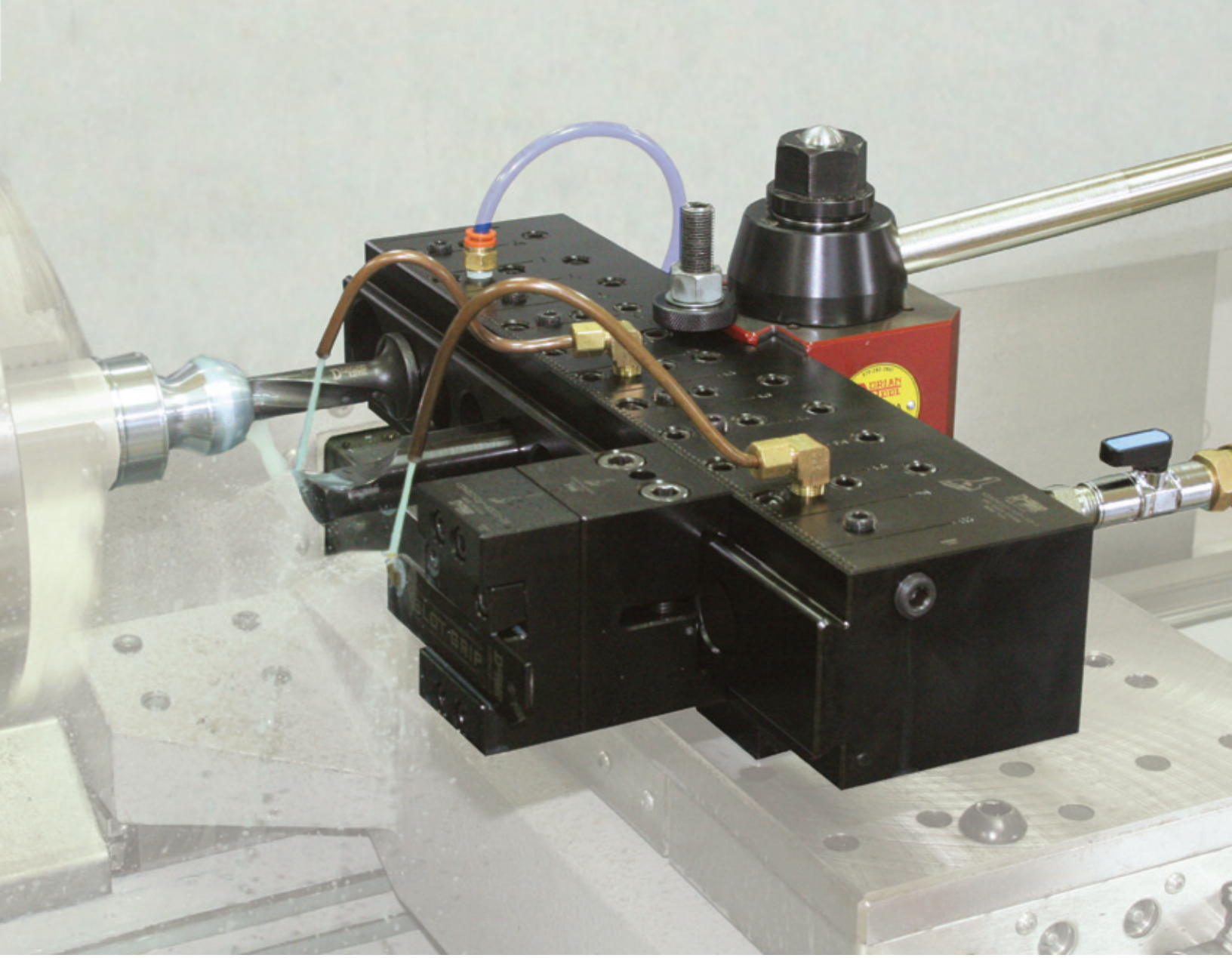


Locking Pin
positive lock with absolute zero backlash. Heat treated high tensile strength alloy steel.

Gib Screw
prevents the gib from falling out.



Description	Part No. 733101-	Square Index Turret	Quick Change Holder Series	A		B		C		D		E		F		G	
				inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm	inch	mm
DQCB-20N	03100	DSIT-25	MD20	0.375	9.5	0.688	17.5	2.062	52.4	0.970	24.6	1.750	44.5	0.375	9.5	0.685	17.4
DQCB-25N	03102	DSIT-35	D25AXA	0.500	12.7	0.750	19.1	2.500	63.5	0.980	24.9	2.000	50.8	0.500	12.7	0.620	15.7
DQCB-30N	03104	DSIT-35B	D30BXA	0.625	15.9	0.808	20.5	3.000	76.2	1.105	28.1	2.250	57.2	0.625	15.9	0.735	18.7
DQCB-35N	03106	DSIT-45 HDSIT-45	D35CXA	0.750	19.1	0.870	22.1	3.500	88.9	1.330	33.8	2.500	63.5	0.750	19.1	0.800	20.3
DQCB-40N	03108	DSIT-60 HDSIT-65	D40CA	1.000	25.4	1.000	25.4	4.000	101.6	1.480	37.6	3.000	76.2	1.000	25.4	1.025	26.0
DQCB-50N	03110	DSIT-70	D50DA	1.250	31.8	1.375	34.9	5.000	127.0	2.043	51.9	4.000	101.6	1.250	31.8	1.475	37.5
DQCB-60N	03112	HDSIT-80	D60EA	1.500	38.1	1.375	34.9	6.000	152.4	2.150	54.6	4.250	108.0	1.500	38.1	1.375	34.9

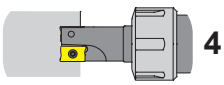


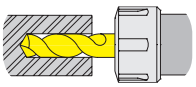
The Victory™
CNC Quick Change Gang Tool is Designed to

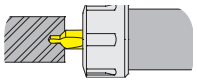
FULLY AUTOMATE

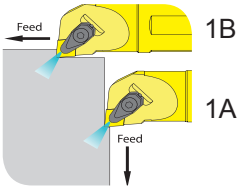
any Programmable Toolroom Lathe
In the Simplest and most Economical way Possible!

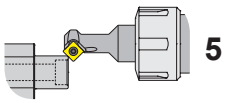
Available in Two Sizes and can be used with
any Dorian Tool Post in this catalog.

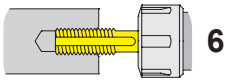


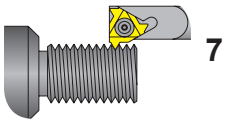


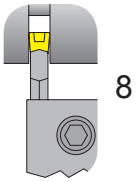




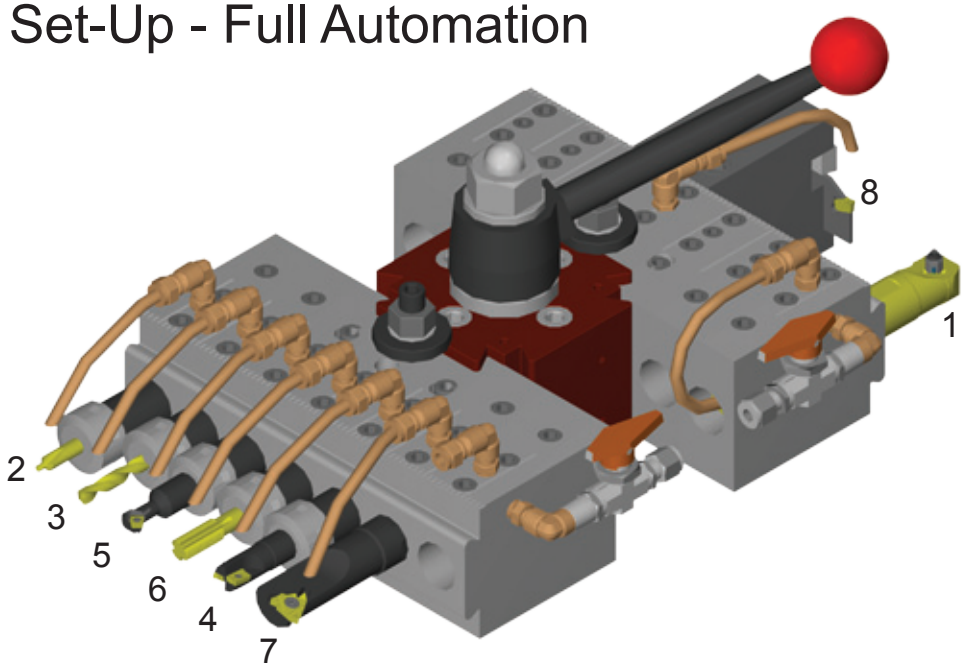


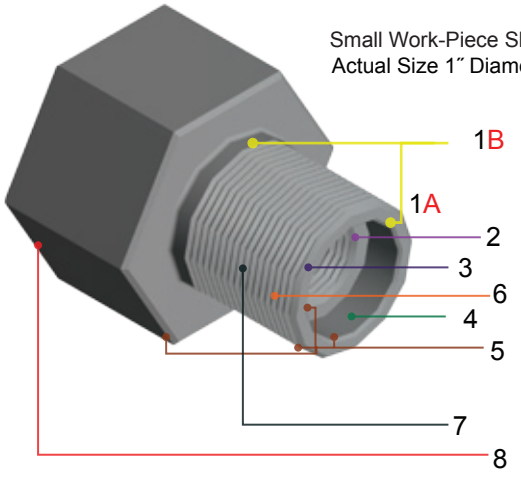






One Set-Up - Full Automation





Small Work-Piece Shown Left
Actual Size 1″ Diameter

9 Operations

1. A Facing
   B O.D. Turning
2. Center Drilling
3. Drilling
4. Counter Boring
5. Chamfering
6. Tapping
7. O.D. Threading
8. Cut-Off

The Victory™ CNC Quick Change Gang Tool *Is Designed to fully automate* any Programmable Toolroom lathe in the simplest and most economical way possible.

The CNC Quick Change Gang Tool holds up to 10 tools in a linear setup and eliminates the need of stopping the machine to change tools after each operation. No wiring or interfacing is required.

The Victory™ CNC Quick Change Gang Tool slides over the tool post dovetail just like a regular quick change toolholder and is locked in place with the pull of the tool post locking handle: simple and quick. The anti-rotation pins prevent any radial movement of the tool post under heavy drilling, boring, turning and threading operations.

The Center height of all tools can be simultaneously adjusted using the height adjustment screw, minimizing the setup/changeover time.

After removing the Victory™ CNC Quick Change Gang Tool by simply sliding it off the toolpost dovetail, the toolpost will remain on the machine immediately ready for shaft work or toolroom work.

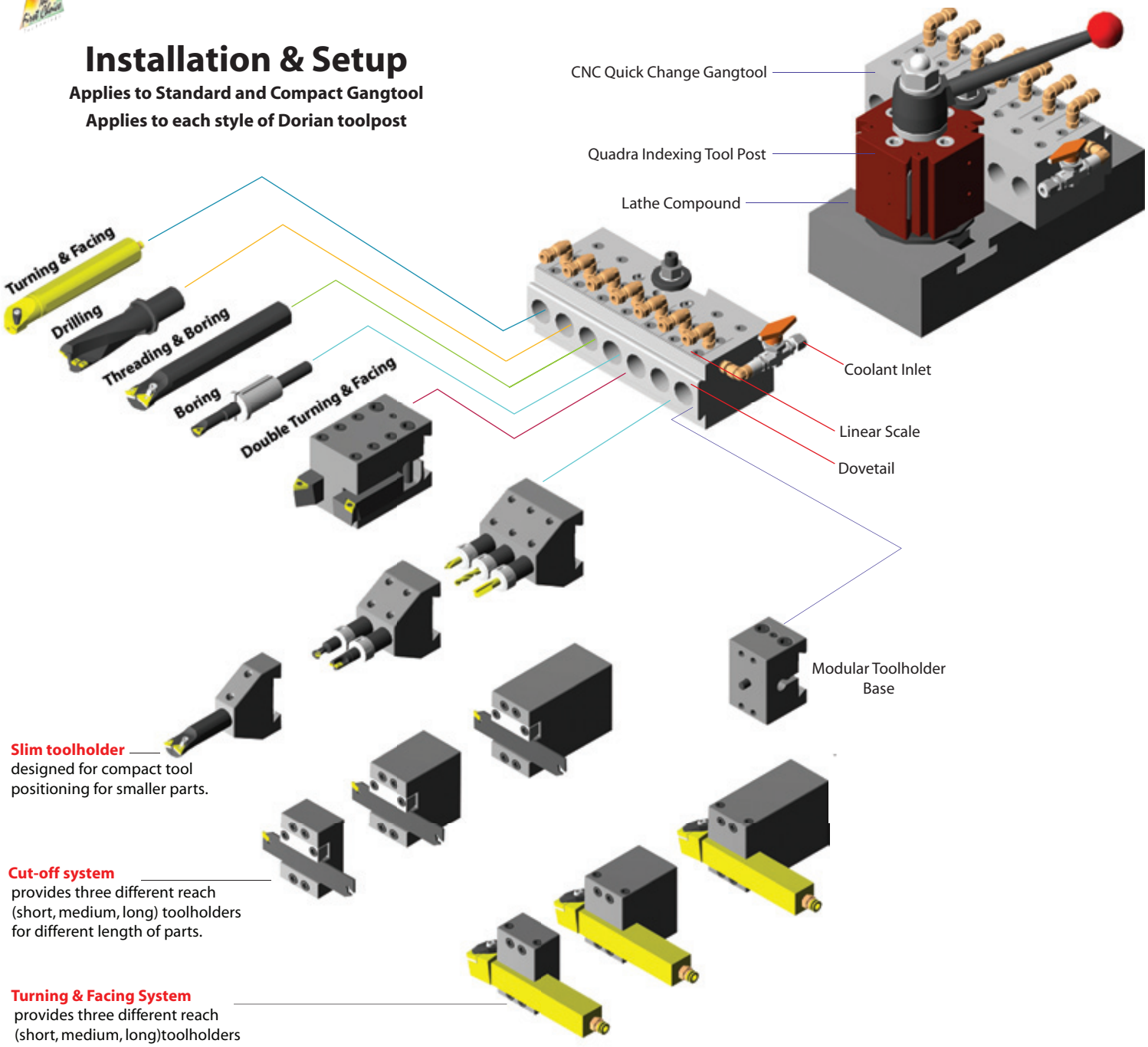
Victory™ CNC Quick Change Gang Tool is supplied with a standard thru coolant system and all coolant fittings.

The Victory™ CNC Quick Change Gang Tool is “The Right Tool” for a new CNC Programmable Tool Room Lathe and “The Right Tool” to up-grade thousands of CNC Programmable Tool Room Lathes that are in the field unable to perform to their full CNC capacity.

Installation & Setup

Applies to Standard and Compact Gangtool

Applies to each style of Dorian toolpost



Slim toolholder
designed for compact tool positioning for smaller parts.

Cut-off system
provides three different reach (short, medium, long) toolholders for different length of parts.

Turning & Facing System
provides three different reach (short, medium, long)toolholders for different length of parts.

How to Install

The CNC Quick Change Gang Tool

1. Align the toolpost on the cross-slide square with the x-axis.
2. Slide the CNC Quick Change Gang Tool onto the tool post dovetail. Lock in place with the tool post locking handle.
3. Connect the machine's coolant line to the coolant inlet valve of the CNC Quick Change Gang Tool.
4. Once the tools are installed, adjust the center height of the CNC Quick Change Gang Tool using the center height adjustment screw. The Modular Toolholder Base provides fine center height adjustment for cut-off, and turning and facing systems.

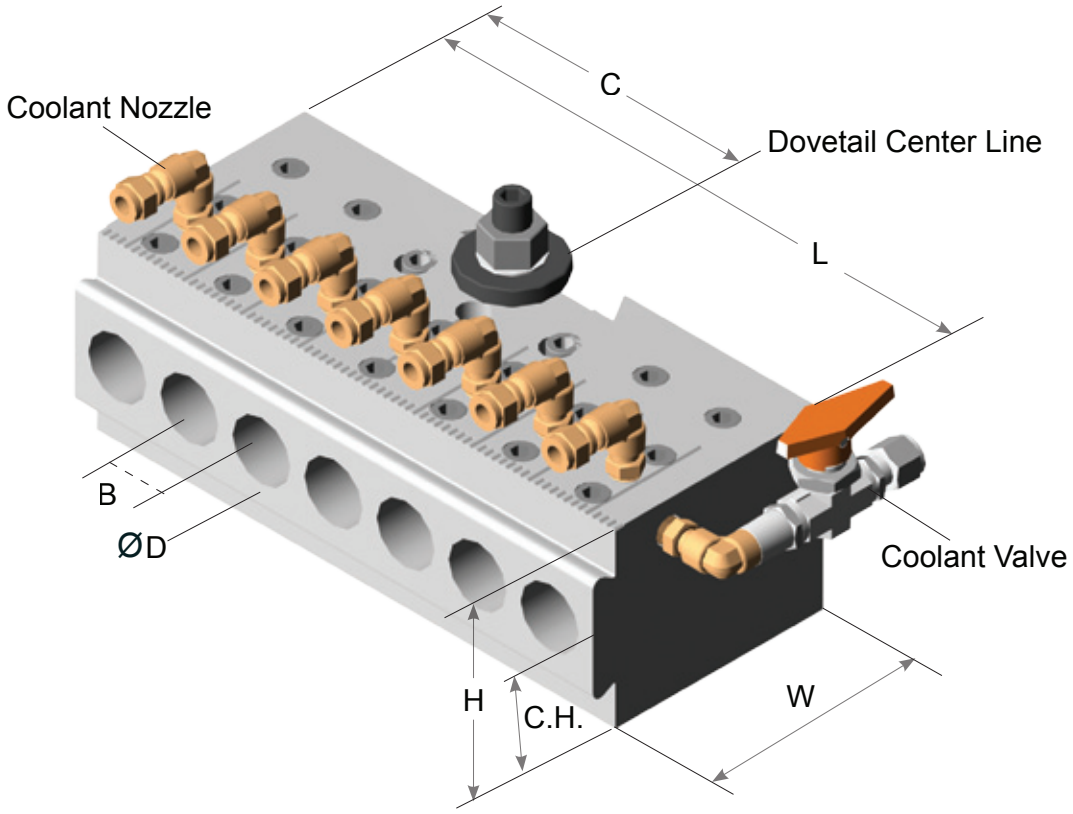
How to Setup

The CNC Quick Change Gang Tool

1. Install your tools onto the CNC Quick Change Gang Tool according to your machining operations. The size of the workpiece will dictate the spacing between the tools and the maximum number of tools that you can use.
2. A wide range of gang tool accessories are available for an unlimited range of machining operations. They all use the extremely rigid, proven dovetail quick-locking system. The CNC Quick Change Gang Tool has a Quick-Set Linear Scale for rapid tool positioning. Modular toolholders are used for cut-off, or turning and facing of different length parts. Slim toolholders are available for compact tool positioning for small and complicated parts that require several operations with different tools.
3. Double-insert boring bars should be used to minimize the number of tools and maximize the number of operations.
4. Assign offsets and set/touch-off each tool. The machine is now ready to run the part program in full CNC mode.
5. Removing the CNC Quick Change Gang Tool from the tool post leaves the machine immediately ready for other applications requiring just a quick change tool post and toolholders.

Compact CNC Quick Change Gang Tool

For 6 to 7 Tools

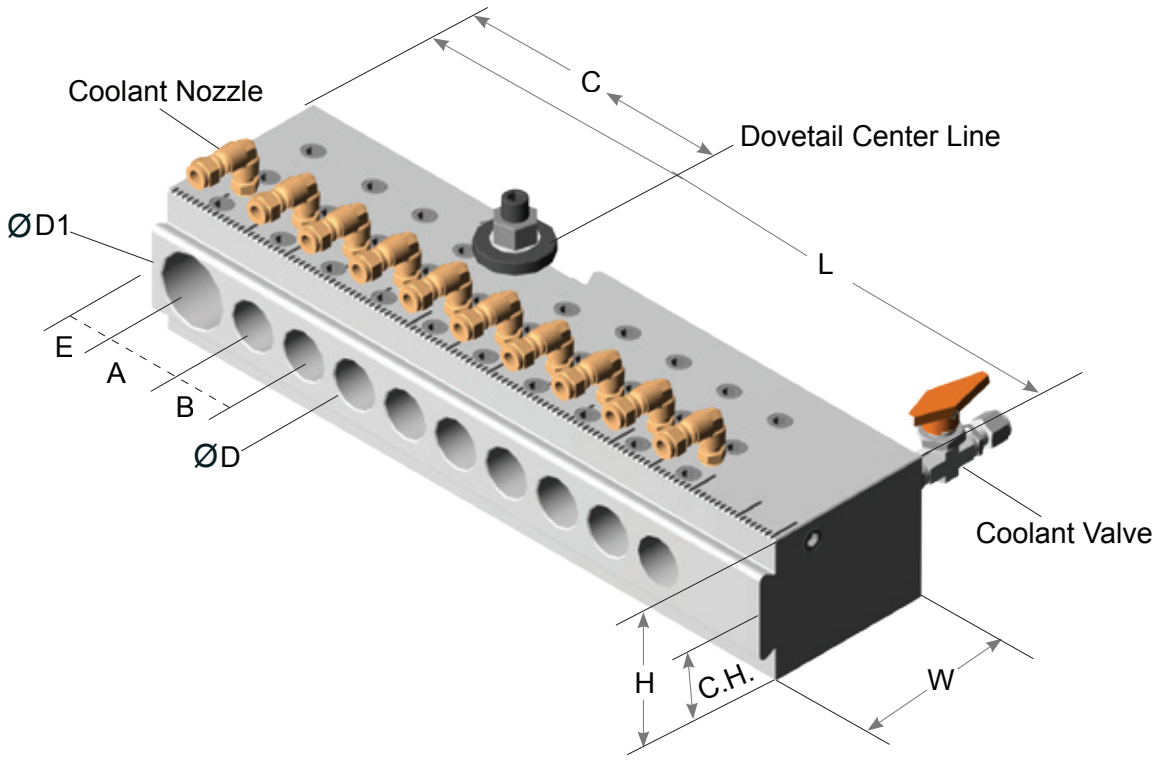


Identification System for Victory™ CNC Quick Change Gang Tool						
V	25	CNC	gt	075	7	I
Victory™ Style	Tool Post Series	Gang Tool System	Gang Tool	Tool Size	Number of Tool Stations	Unites I = inch M = Metric

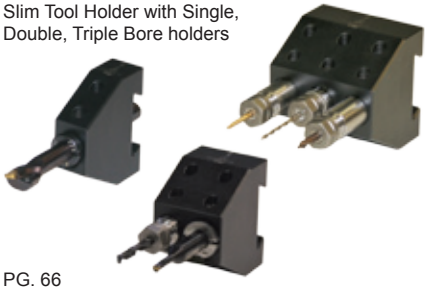
Description	V25CNCgt-		V30CNCgt-		V35CNCgt-		V40CNCgt-	
	075-6-I	020-6-M	075-6-I	020-6-M	100-7-I	025-7-M	100-7-I	025-7-M
Part No. 733101-	04351	04322	04352	04324	04355	04326	04358	04328
Inch and Metric Units	in	mm	in	mm	in	mm	in	mm
Lathe Swing Over Bed	<= 12	<=300	13-15	330-380	14-17	350-430	16-20	400-500
B	1	25	1	25	1.25	32	1.25	32
C	2.7	68.7	2.7	68.7	4.5	114.3	4.5	114.3
D	3/4	20	3/4	20	1	25	1	25
W	3.0	76.2	3.0	76.2	4.0	101.6	4.0	101.6
H	2.0	50.8	2.0	50.8	3.0	76.2	3.0	76.2
L	6.1	155.0	6.1	155.0	9.0	228.6	9.0	228.6
Center Height, C.H.	1.0	25.4	1.0	25.4	1.5	38.1	1.5	38.1
No.of Tools	6	6	6	6	7	7	7	7

Large CNC Quick Change Gang Tool

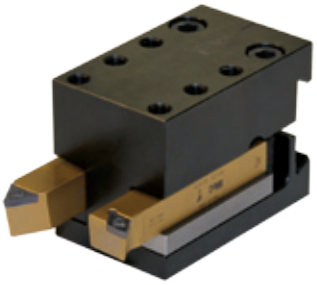
For 9 to 10 Tools



Description	V25CNCgt-		V30CNCgt-		V35CNCgt-		V40CNCgt-	
	075-9-I	020-9-M	075-9-I	020-9-M	100-10-I	025-10-M	100-10-I	025-10-M
Part No. 733101-	04350	04330	04353	04333	04356	04336	04359	04339
Inch and Metric Units	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
A	1.250	31.75	1.250	31.75	1.500	38.10	1.500	38.10
B	1.000	25.40	1.000	25.40	1.250	31.75	1.250	31.75
C	4.875	123.83	4.875	123.83	6.250	158.75	6.250	158.75
D	.750	20.00	.750	20.00	1.000	25.00	1.000	25.00
D1	1.250	32.00	1.250	32.00	1.500	40.00	1.500	40.00
E	.875	22.23	.875	22.23	1.000	25.40	1.000	25.40
W	3.000	76.20	3.000	76.20	4.000	101.60	4.000	101.60
H	2.000	50.80	2.000	50.80	3.000	76.20	3.000	76.20
L	11.000	279.40	11.000	279.40	15.000	381.00	15.000	381.00
T-TOOL CAP.	1/2-5/8	12 - 16	1/2-5/8	12 - 16	3/4-1.0	20 - 25	3/4-1.0	20 - 25
Center Height, C.H.	1.000	25.40	1.000	25.40	1.500	38.10	1.500	38.10
No.of Tools	9		9		10		10	

Style	Features	Application
CNC Quick Change Gang Tool  PG. 62-63	• True CNC Automation • Easy to Setup • Designed for Multi Turning, Drilling, Boring, Tapping, Threading, Grooving and Cut-Off operations. • No Wiring or Interfacing • Makes Productivity Easy, Affordable, and Profitable • Inline 10 Tool Stations • Thru Coolant System • Thru-Hardened and Ion-Nitrided Chromium-Molybdemum Alloy Steel • Presision Ground for Qualified Tool Alignment and Squareness • Honed Bores for Precise Tool Alignment and Squareness • Quick Move from Chip to Chip • Linear Scale for Quick Tool Setting • Quick Change Tool Post Mounting • Rigid Dovetail Locking System • Fine Centerheight Adjustment Mechanism • Supplied standard with Coolant Attachments, Valves and Connectors • Best Results and Efficiency Achieved when used with Double Insert Boring Bars • Production-Ready Turn Key Kits Available for Different Applications	• CNC Programmable Toolroom Lathes • Multi-Feature Parts Completed in one Cycle • Automatic, Un-Manned Machining on Toolroom Lathes • For Machining Small to Large Parts • High Production Applications • Applications where Live Center is not Required
Double Facing & Turning Toolholder  PG. 65	• Double Square Shank Toolholder • Compact and Rigid • Multi-Size Tool Slot • Slides on Gang Tool Rail for Quick Tool Positioning • Quick Setup and Lock • Rigid Dovetail Locking System • Thru Hardened and Ion-Nitrided Chromium-Molybdenum Alloy Steel • Precision Ground for Qualified Tool Centerheight, Alignment, and Squareness	• Finishing Applications • Roughing Applications • Multi-Tool Setup Applications • Turning • Facing • Threading
Slim Tool Holder with Single, Double, Triple Bore holders  PG. 66	• Slim Size For Maximum Number of Tool Positioning • For Small Boring Bars, Center Drills, Drills, Taps and Reamers • Compact and Rigid • Slides on Gang Tool Rail for Quick and Close Tool Positioning • Quick Setup and Lock • Rigid Dovetail Locking System • Thru Hardened and Ion-Nitrided Chromium-Molybdenum Alloy Steel • Precision Ground for Qualified Tool Centerheight, Alignment, and Squareness	• Small, Intricate, and Complex Parts • Multi-Tool Machining Applications • Drilling, Boring, Chamfering, Threading, Tapping, Center-drilling and Reaming
Modular Turning & Cut-Off Toolholder Base  PG. 67 , 68	• Allows for Centerheight Adjustment with a Center-Pin • One Toolholder Base for all Turning, Facing, and Cut-Off Toolholder Heads • Compact and Rigid • Slides on Gang Tool Rail for Quick Positioning • Quick Setup and Lock • Rigid Dovetail Locking System • Thru Hardened and Ion-Nitrided Chromium-Molybdenum Alloy Steel • Precision Ground for Qualified Tool Centerheight, Alignment, and Squareness	•Used for Mounting, Turning and Facing Cut-Off Toolholder Heads (see below)
Modular Short-Medium-Long Turning & Facing Holder  PG. 67	• Available in Three Lengths for Short, Medium and Long Parts • Modular Multi-Size Tool Slot • Tool Centerheight Fine Adjustment • Modular Turning, Contouring, Facing and Threading Holder • Compact and Rigid • Thru Hardened and Ion-Nitrided Chromium-Molybdenum Alloy Steel • Precision Ground for Qualified Tool Centerheight, Alignment, and Squareness	• For Small To Large Parts • For Short to Long Parts • Turning, Contouring, Facing, and Threading • Multi-Tool Machining Applications
Modular Short-Medium-Long Cut-Off Holder  PG. 68	• Available in Three Lengths for Short, Medium and Long Parts • Precision Ground Blade Dovetail Seat • Tool Centerheight Fine Adjustment • Rigid Cut-Off Applications • Compact and Rigid • Thru Hardened and Ion-Nitrided Chromium-Molybdenum Alloy Steel • Precision Ground for Qualified Tool Centerheight, Alignment, and Squareness	• For Small to Large Parts • For Short to Long Parts • Cut-Off • Grooving • Multi-Tool Machining Applications

Toolholder



Double Turning & Facing Toolholder

Round Toolholders



Compact Single Round Tool and Boring Bar Holder



Compact Double Round Tool and Boring Bar Holder

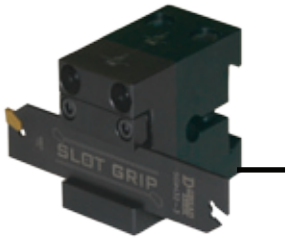


Compact Triple Round Tool and Boring Bar Holder

Modular Toolholders



Modular Short-Medium-Long Turning & Facing Toolholder



Modular Short-Medium-Long Cut-Off & Grooving Toolholders

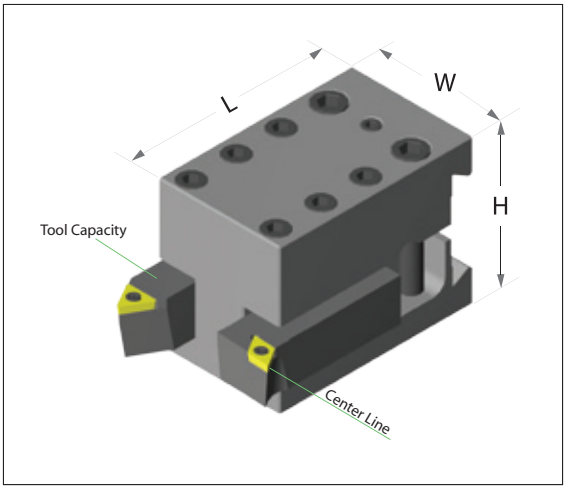
Modular Toolholder Base



Modular Turning & Facing and Cut-Off Toolholder Base

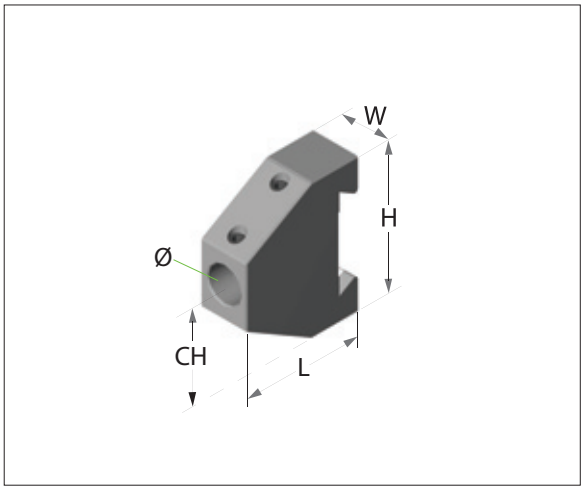
Identification System for Victory™ CNC Quick Change Gang Tool Toolholders						
V	3540	CNC	gt	TF	100	I
Victory™	Toolholder Series 35 & 40	Gang Tool System	Gang Tool	Tool Style	Tool Size	Units I = inch M = Metric

V-TF Toolholder - Double Turning & Facing Toolholder-Inch/Metric



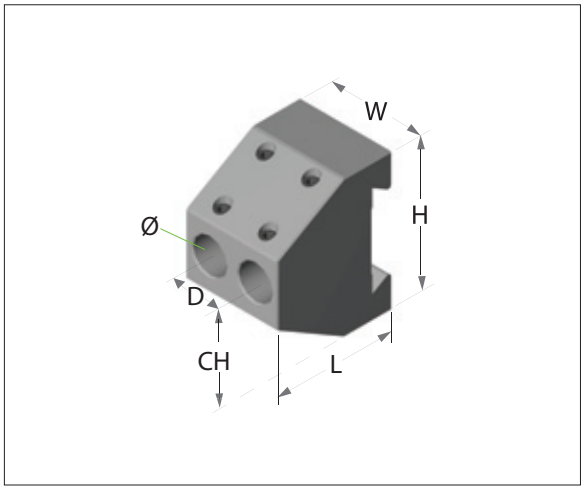
Description	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-TF-062-I	04370	in	3.000	1.625	2.250	1/2 - 5/8
V2530CNCgt-TF-16-M	04371	mm	76.20	41.28	57.15	12 - 16
V3540CNCgt-TF-100-I	04400	in	4.000	2.500	3.250	3/4 - 1.0
V3540CNCgt-TF-25-M	04401	mm	101.60	63.50	82.55	20 - 25

V-B1 Round Toolholder - Compact Single Round Tool and Boring Bar Holder-Inch/Metric



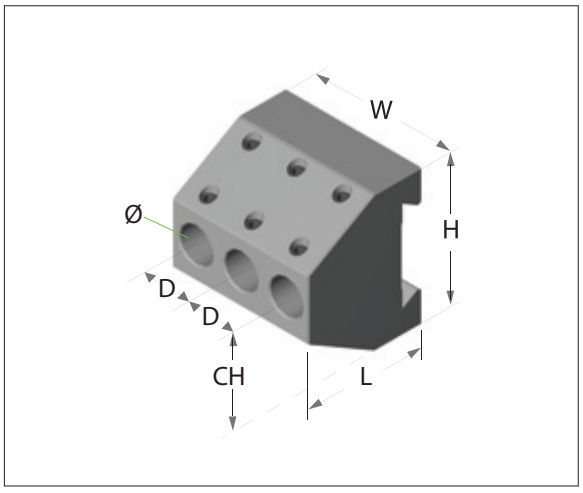
Description	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-B1-050-I	04372	in	2.000	.750	2.250	1/2
V2530CNCgt-B1-12-M	04373	mm	50.80	19.05	57.15	12
V3540CNCgt-B1-075-I	04402	in	2.500	1.000	3.000	3/4
V3540CNCgt-B1-20-M	04403	mm	63.50	25.40	76.20	20

V-B2 Round Toolholder - Compact Double Round Tool and Boring Bar Holder-Inch/Metric



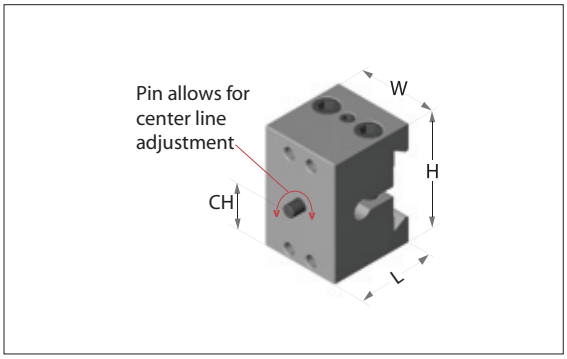
Description	Part No. 733101-	Units	L	W	H	D	Tool Capacity
V2530CNCgt-B2-050-I	04374	in	2.000	1.500	2.250	0.750	1/2
V2530CNCgt-B2-12-M	04375	mm	50.80	38.10	57.15	19.05	12
V3540CNCgt-B2-075-I	04404	in	2.500	2.000	3.000	1.000	3/4
V3540CNCgt-B2-20-M	04405	mm	63.50	50.80	76.20	25.40	20

V-B3 Round Toolholder - Compact Triple Round Tool and Boring Bar Holder-Inch/Metric



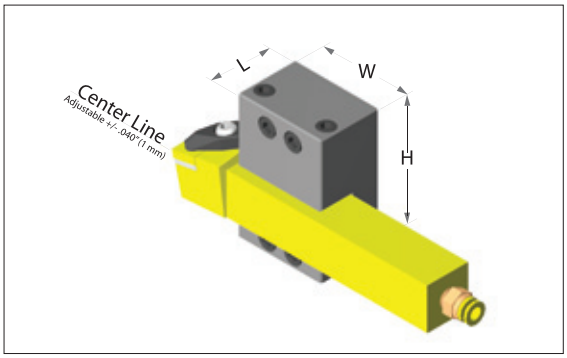
Description	Part No. 733101-	Units	L	W	H	D	Tool Capacity
V2530CNCgt-B3-050-I	04376	in	2.000	2.250	2.250	0.750	1/2
V2530CNCgt-B3-12-M	04377	mm	50.80	57.15	57.15	19.05	12
V3540CNCgt-B3-075-I	04406	in	2.500	3.000	3.000	1.000	3/4
V3540CNCgt-B3-20-M	04407	mm	63.50	76.20	76.20	25.40	20

V-MTB - Modular Toolholder Base: Assembled and used with Modular Turning and Facing (Toolholders) (MSTH, MMTH, MLTH), or Modular Cut-Off Toolholders (MSCO, MMCO, MLCO)



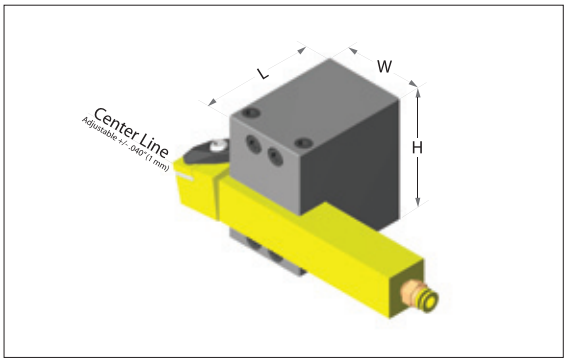
Desc.	Part No. 733101-	Units	L	W	H
V2530CNCgt-MTB	04378	in	1.750	1.500	2.250
		mm	44.45	38.10	57.15
V3540CNCgt-MTB	04408	in	2.125	2.000	3.000
		mm	53.98	50.80	76.20

V-MSTH - Modular Short Turning and Facing Toolholder: Assembled and used with Modular Toolholder Base (V-MTB)



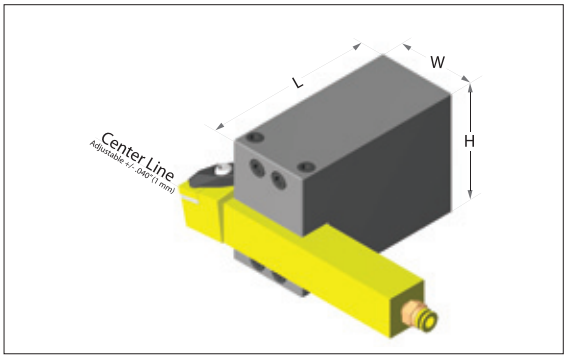
Desc.	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-MSTH-062-016	04379	in	1.000	1.500	2.250	1/2 - 5/8
		mm	25.40	38.10	57.15	12 - 16
V3540CNCgt-MSTH-100-025	04409	in	1.375	2.000	3.000	3/4 - 1
		mm	34.93	50.80	76.20	20 - 25

V-MMTH - Modular Medium Turning and Facing Toolholder: Assembled and used with Modular Toolholder Base (V-MTB)



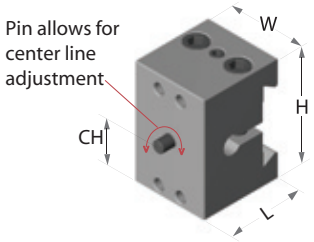
Description	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-MMTH-062-016	04381	in	2.500	1.500	2.250	1/2 - 5/8
		mm	63.50	38.10	57.15	12 - 16
V3540CNCgt-MMTH-100-025	04411	in	2.875	2.000	3.000	3/4 - 1
		mm	73.03	50.80	76.20	20 - 25

V-MLTH - Modular Long Turning and Facing Toolholder: Assembled and used with Modular Toolholder Base (V-MTB)



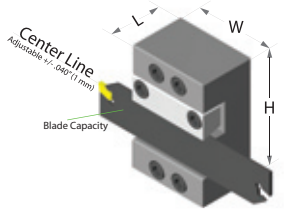
Description	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-MLTH-062-016	04383	in	4.000	1.500	2.250	1/2 - 5/8
		mm	101.60	38.10	57.15	12 - 16
V3540CNCgt-MLTH-100-025	04413	in	4.375	2.000	3.000	3/4 - 1
		mm	111.13	50.80	76.20	20 - 25

V-MTB - Modular Toolholder Base: Assembled and used with Modular Turning and Facing Toolholders (MSTH, MMTH, MLTH), or Modular Cut-Off & Grooving Toolholders (MSCO, MMCO, MLCO)



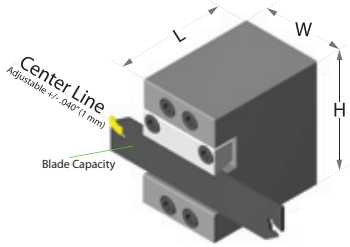
Desc.	Part No. 733101-	Units	L	W	H
V2530CNCgt-MTB	04378	in	1.750	1.500	2.000
		mm	44.45	38.10	50.80
V3540CNCgt-MTB	04408	in	2.125	2.000	3.000
		mm	53.98	50.80	76.20

V-MSCO - Modular Short Cut-Off & Grooving Toolholder: Assembled and used with Modular Toolholder Base (V-MTB)



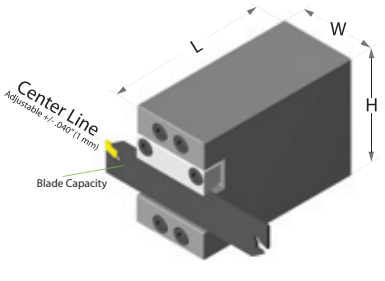
Desc.	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-MSCO-19	04385	in	1.000	1.500	2.000	19-2
		mm	25.40	38.10	50.80	
V3540CNCgt-MSCO-26	04415	in	1.375	2.000	3.000	26-2 to 26-6
		mm	34.93	50.80	76.20	

V-MMCO - Modular Medium Cut-Off & Grooving Toolholder: Assembled and used with Modular Toolholder Base (V-MTB)



Desc.	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-MMCO-19	04386	in	2.500	1.500	2.000	19-2
		mm	63.50	38.10	50.80	
V3540CNCgt-MMCO-26	04416	in	2.875	2.000	3.000	26-2 to 26-6
		mm	73.03	50.80	76.20	

V-MLCO - Modular Long Cut-Off & Grooving Toolholder: Assembled and used with Modular Toolholder Base (V-MTB)



Desc.	Part No. 733101-	Units	L	W	H	Tool Capacity
V2530CNCgt-MLCO-19	04387	in	4.000	1.500	2.000	19-2
		mm	101.60	38.10	50.80	
V3540CNCgt-MLCO-26	04417	in	4.375	2.000	3.000	26-2 to 26-6
		mm	111.13	50.80	76.20	

Victory™ CNC Quick Change Gang Tool SETS

Supplied Complete with Toolholders and Indexable Tools

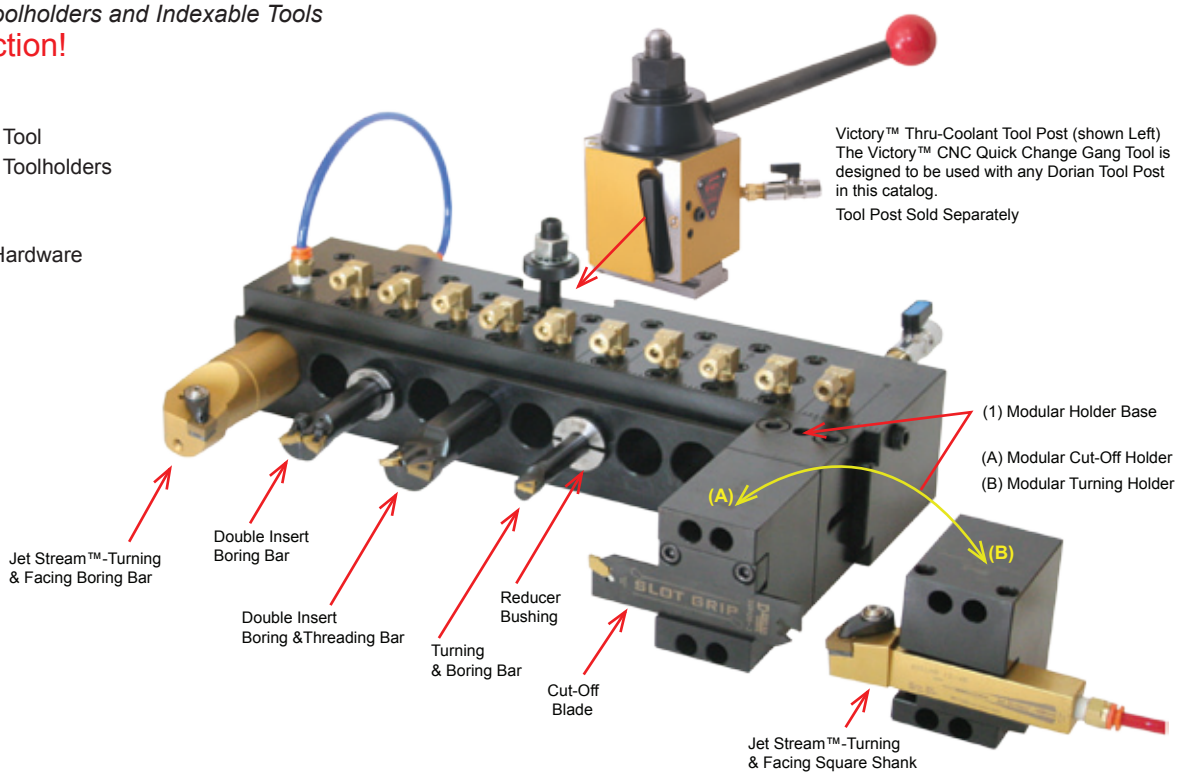
Ready for High Production!

Sets Include:

(1) CNC Quick Change Gang Tool
(3) CNC Quick Change Gang Toolholders
(6) Cutting Tools
(2) Reducer Bushings
(1) Complete Set of Coolant Hardware

Sets Feature:

- Super Precision
- Easy Tool Set-up
- Quick Mounting
- Heavy Duty Roughing
- Thru Coolant
- Linear Scale
- Dovetail Locking
- 10 Tool Stations



Inch

Victory™ 35 CNC Quick Change Gang Tool Set		
Part No. 733101-	04491	
Description	V35CNCgt-100-10-IK	
(1) Victory™ 35 CNC Gang Tool		
Description	Tool Size	Qty
V35CNCgt-100-10-I	3/4"-1"	1
(3) Victory™ Gang Tool Holders		
Description	Tool Size	Qty
V3540CNCgt-MTB		1
V3540CNCgt-MMTH-100-025	3/4"-1"	1
V3540CNCgt-MMCO-26	26 mm	1
(2) Reducer Bushings		
Description	Tool Size	Qty
THB100-50	1" to 1/2"	1
THB100-75	1" to 3/4"	1
(6) Cutting Tools		
Description	Tool Size	Qty
AS-24S-ADCLNR-4	1.500"	1
ADCLNR-12-4B	0.75"	1
S12M-DWLN-3	0.75"	1
S16Q-DTUC-3-T16	1.00"	1
S08M-STUCR-2	0.50"	1
SGIH26-3	26-3	1

Metric

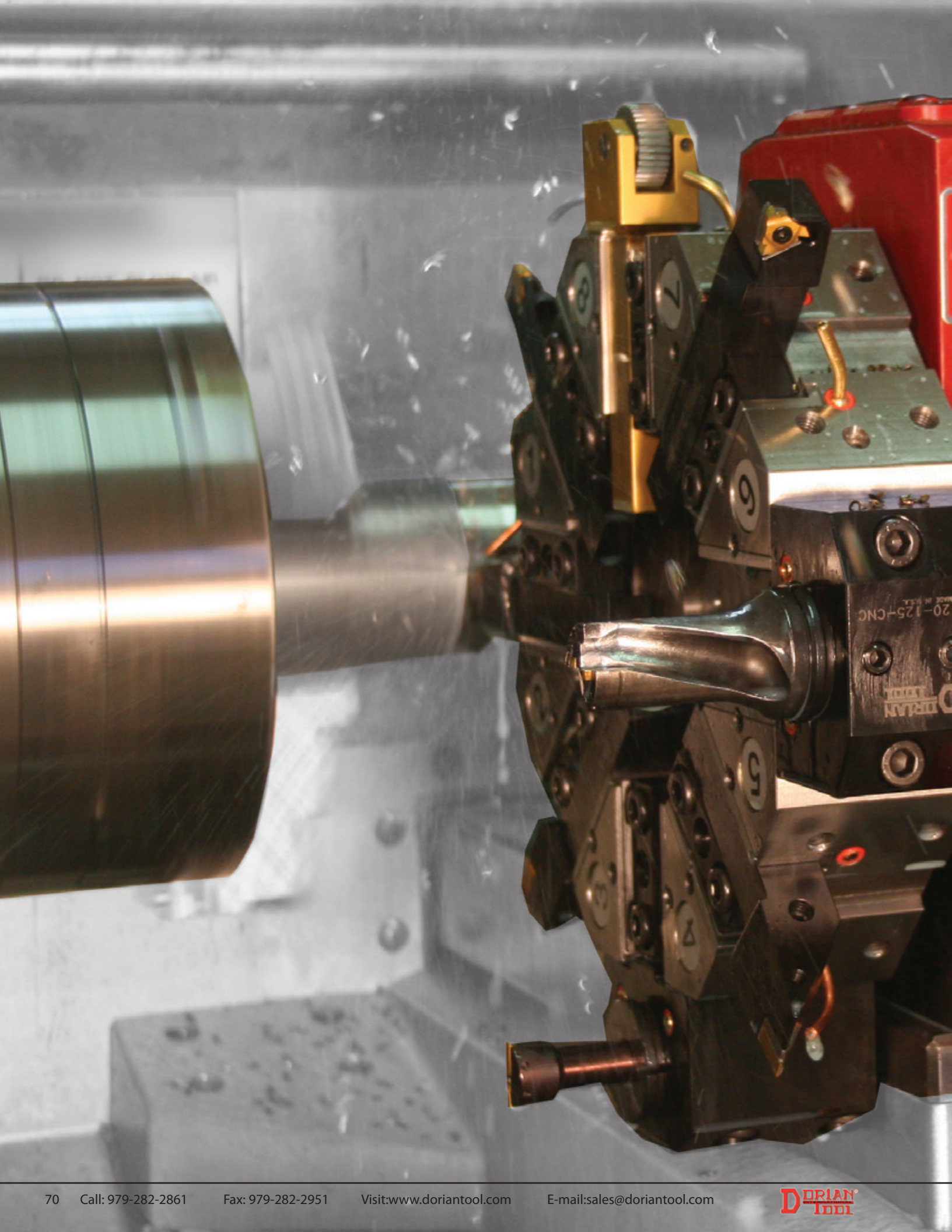
Victory™ 35 CNC Quick Change Gang Tool Set.		
Part No. 733101-	04481	
Description	V35CNCgt-025-10-MK	
(1) Victory™ 35 CNC Gang Tool		
Description	Tool Size	Qty
V35CNCgt-025-10-M	20-25 mm	1
(3) Victory™ Gang Tool Holders		
Description	Tool Size	Qty
V3540CNCgt-MTB		1
V3540CNCgt-MMTH-100-025	20-25 mm	1
V3540CNCgt-MMCO-26	26 mm	1
(2) Reducer Bushings		
Description	Tool Size	Qty
THB25-12	25 to 12 mm	1
THB25-20	25 to 20 mm	1
(6) Cutting Tools		
Description	Tool Size	Qty
AS-40S-ADCLNR-12	40 mm	1
ADCLNR-2020-K12	20 mm	1
S20M-DWLN-06	20 mm	1
S25Q-DTUC-16-T16	25 mm	1
12K-STUCR-11	12 mm	1
SGIH26-3	26-3	1

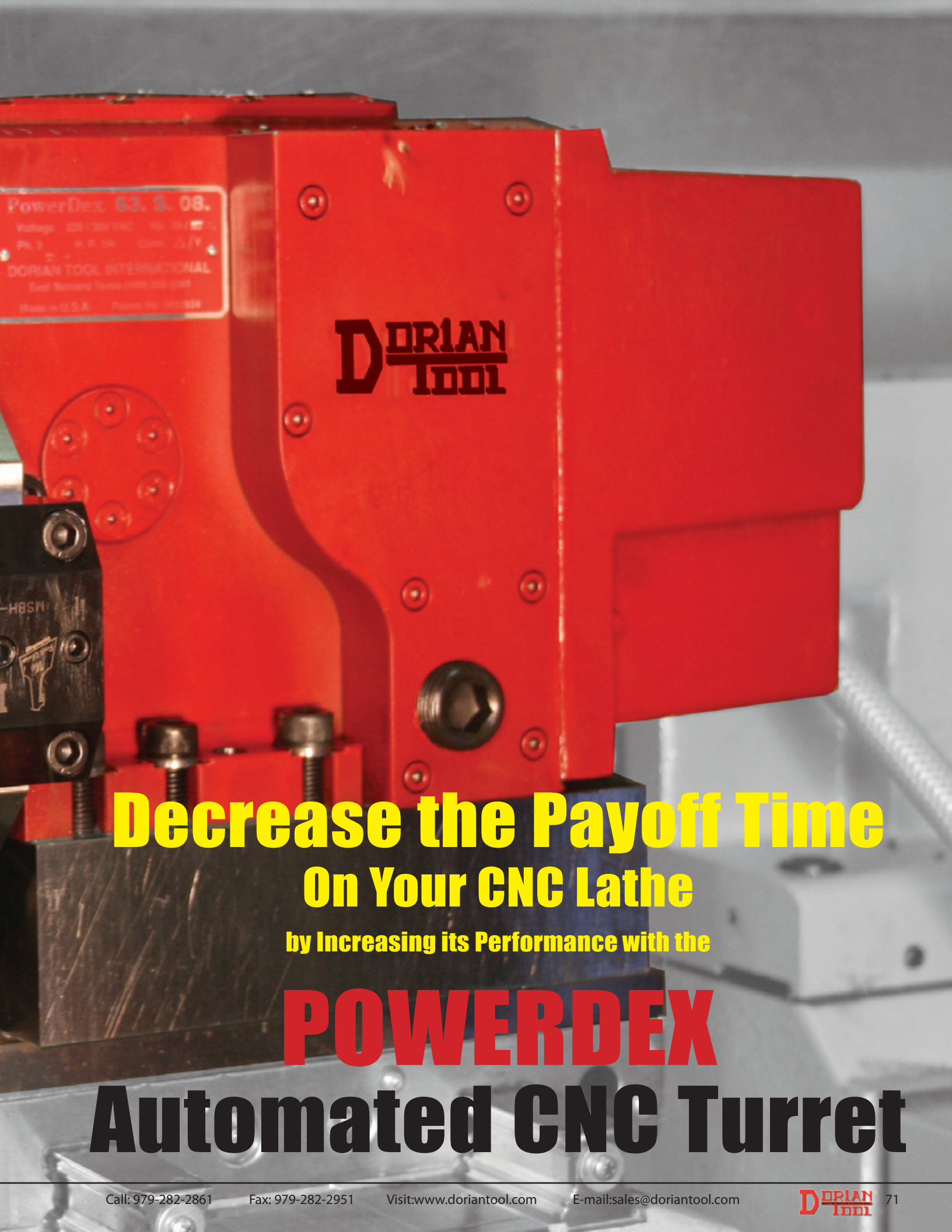
Inch

Victory™ 40 CNC Quick Change Gang Tool Set		
Part No. 733101-	04492	
Description	V40CNCgt-100-10-IK	
(1) Victory™ 40 CNC Gang Tool		
Description	Tool Size	Qty
V40CNCgt-100-10-I	3/4"-1"	1
(3) Victory™ Gang Tool Holders		
Description	Tool Size	Qty
V3540CNCgt-MTB		1
V3540CNCgt-MMTH-100-025	3/4"-1"	1
V3540CNCgt-MMCO-26	26 mm	1
(2) Reducer Bushings		
Description	Tool Size	Qty
THB100-50	1" to 1/2"	1
THB100-75	1" to 3/4"	1
(6) Cutting Tools		
Description	Tool Size	Qty
AS-24S-ADCLNR-4	1.500"	1
ADCLNR-12-4B	0.75"	1
S12M-DWLN-3	0.75"	1
S16Q-DTUC-3-T16	1.00"	1
S08M-STUCR-2	0.50"	1
SGIH26-3	26-3	1

Metric

Victory™ 40 CNC Quick Change Gang Tool Set		
Part No. 733101-	04482	
Description	V40CNCgt-025-10-MK	
(1) Victory™ 40 CNC Gang Tool		
Description	Tool Size	Qty
V40CNCgt-025-10-M	20-25 mm	1
(3) Victory™ Gang Tool Holders		
Description	Tool Size	Qty
V3540CNCgt-MTB		1
V3540CNCgt-MMTH-100-025	20-25 mm	1
V3540CNCgt-MMCO-26	26 mm	1
(2) Reducer Bushings		
Description	Tool Size	Qty
THB25-12	25 to 12 mm	1
THB25-20	25 to 20 mm	1
(6) Cutting Tools		
Description	Tool Size	Qty
AS-40S-ADCLNR-12	40 mm	1
ADCLNR-2020-K12	20 mm	1
S20M-DWLN-06	20 mm	1
S25Q-DTUC-16-T16	25 mm	1
12K-STUCR-11	12 mm	1
SGIH26-3	26-3	1





Decrease the Payoff Time

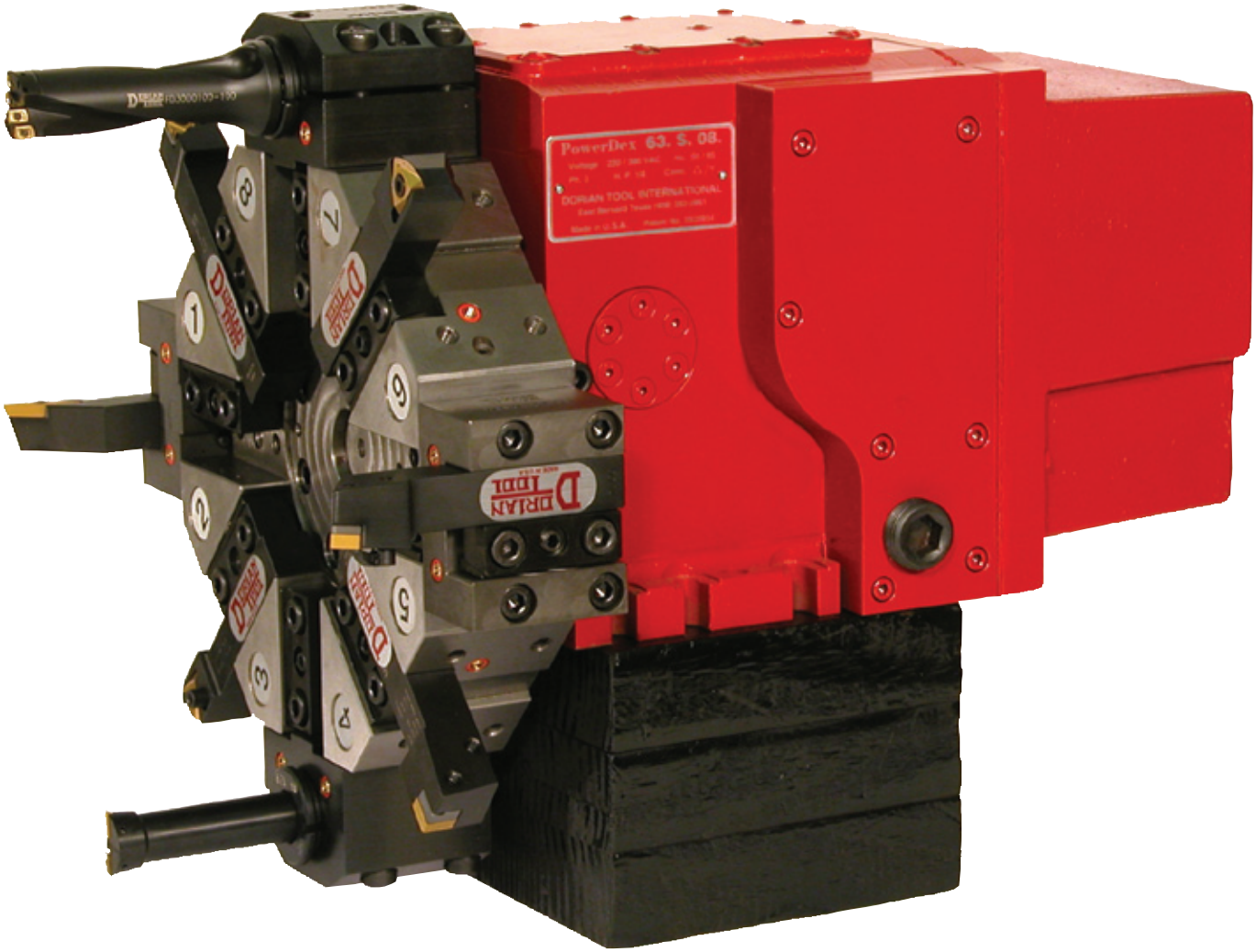
On Your CNC Lathe

by Increasing its Performance with the

POWERDEX

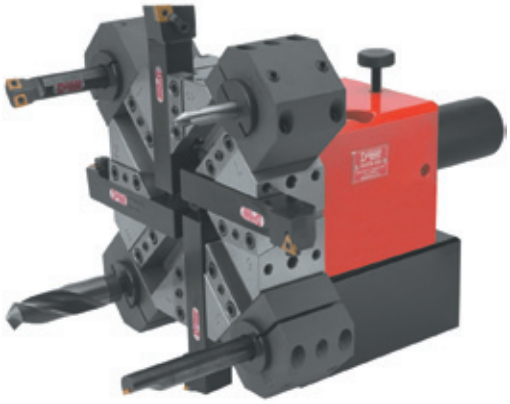
Automated CNC Turret

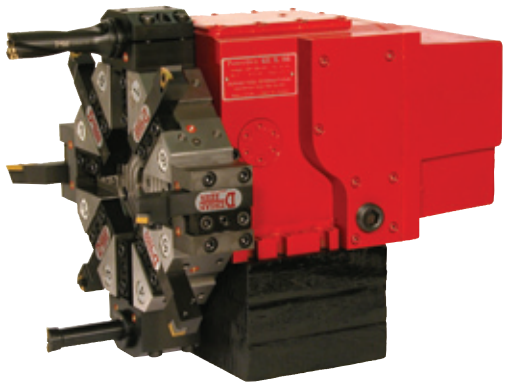
Manual & Automated CNC Turrets

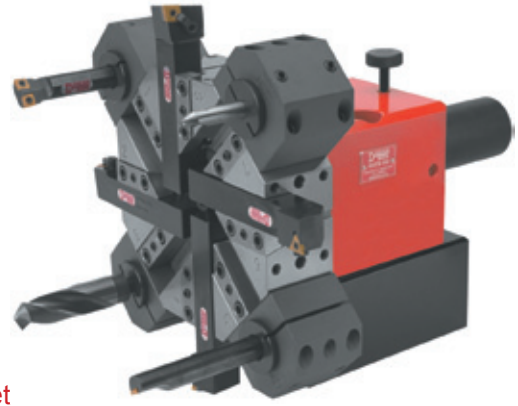


POWERDEX Automated CNC Turret

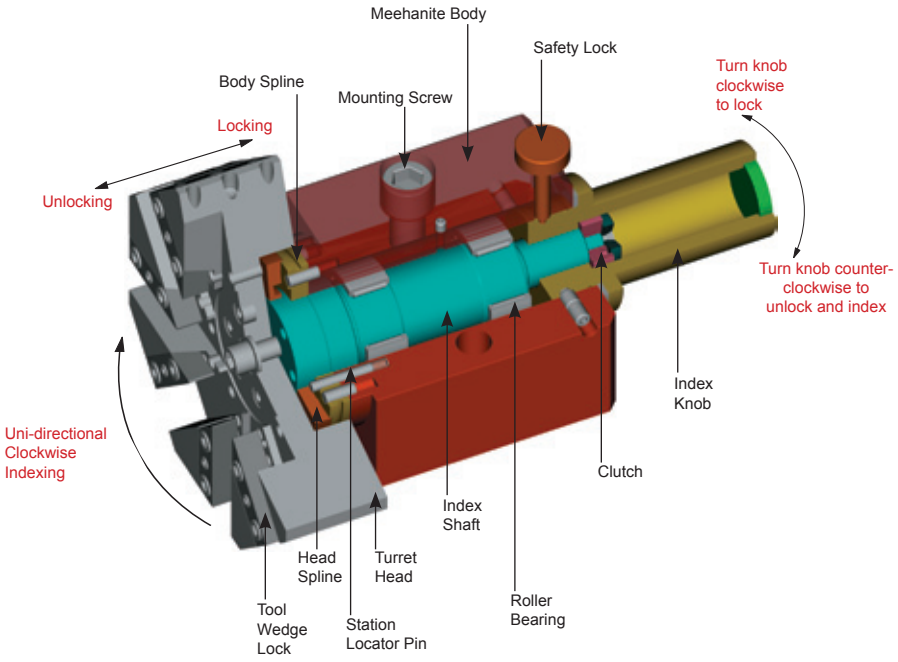
- 8 Station Bi-Directional Indexing
- Fast Cycle Times
- +/- .0005 Positioning Accuracy
- +/- .0002” Repeatability
- Automatic Thru Coolant System
- Meehanite Body, Heavy Duty Construction
- Cartridge- Style, simple, reliable design
- No maintenance necessary

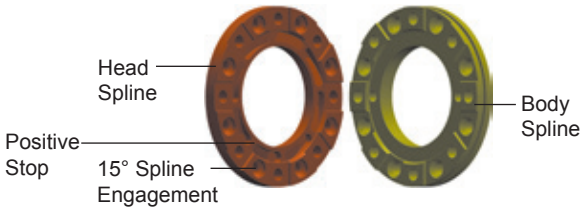
NVIT Manual Turret	Application	Type of machine	Turret Selection Data			Page
			Turret Size	Tool Size		
	• Back-up for automated Turret • Multi-operation applications • Prototype production • Tool room work • High Precision Applications • Uni-Directional Indexing	CNC Lathe Manual Lathe	NVIT8-50	.500"	12 mm	75
			NVIT8-58	.625"	16 mm	75
			NVIT8-75	.750"	20 mm	75
			NVIT8-100	1.000"	25 mm	75
			NVIT8-125	1.250"	32 mm	75

POWERDEX Automated CNC Turret	Application	Type of machine	Turret Selection Data			Page
			Turret Size	Tool Size		
	• Fast indexing cycles • Multi-operation applications • Fully interfaced with CNC lathe • Bi-Directional Indexing • Absolute Encoder • Ultra-precision applications	CNC Lathe	POWERDEX 50N	750"	20mm	79
			POWERDEX 63N	.750"	20mm	79
			POWERDEX 80N	1.000"	25mm	79
			POWERDEX 100N	1.250"	32mm	79
			POWERDEX 125N	1.500"	40mm	79



Dorian NVIT Manual Turret





The Dorian NVIT Manual Turret is designed and built to deliver the highest accuracy, the fastest tool change, and the greatest rigidity every found in any other manual tool system. In maximizing quality, productivity and profitability TRUE CNC PERFORMANCE is ACHIEVED with the Dorian NVIT Turret.

• Easy Mounting - The NVIT turret is very easy and fast to install. It is directly mounted on to the lathe.

• Minimum Vibration - The turret body is made from MEEHANITE-40 casting to deliver high dampening capability.

• Safety - The turret features a safety lock eliminating the possibility of the turret head getting loose under extra heavy or interrupted cuts.

• Easy Removable Boring Bar Holder - Boring bar holders are easily mounted and quickly removed.

• Minimum Friction - The turret is indexed with the assistance of two roller bearings between the body and the shaft, reducing the friction by 75%. This reduction of friction makes the turret easier to index.

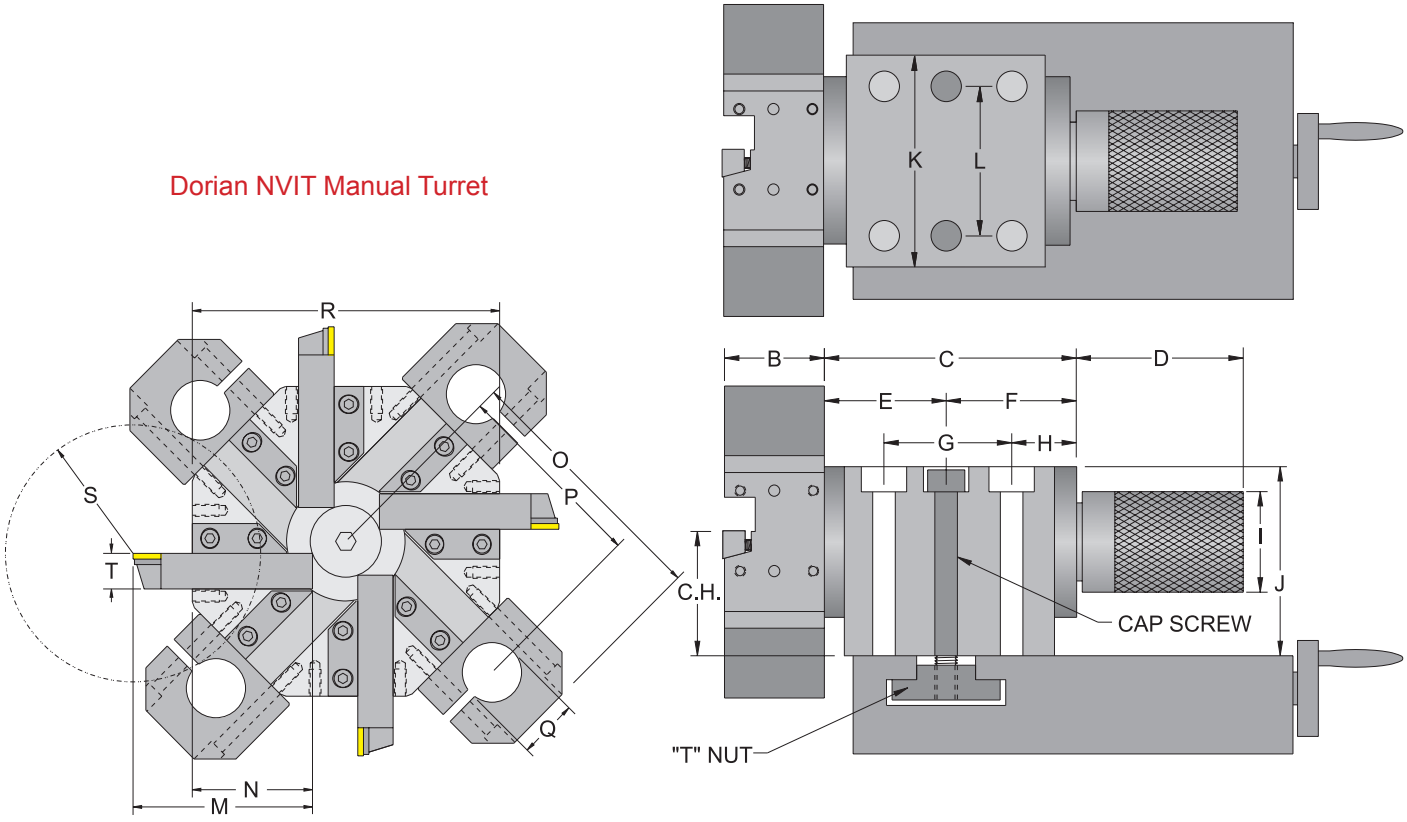
• Positive Indexing - The clutch engages positively with the indexing knob offering maximum transmission from indexing to locking.

• Simple and Fast Indexing - The indexing knob's length and grip diameter makes indexing convenient with minimum operator effort. Turning the knob counterclockwise unlocks and indexes the turret. Turning the knob clockwise, when the desired tool station is reached, locks the tool head in position.

• Five Tool Capacities Available -
Inch: .500" to 1.250", Metric: 12 mm to 32 mm

• Precision, Repeatability and Rigidity - The Indexing face splines (shown Left) are Ion Nitrated and precision ground for maximum precision, repeatability and rigidity. The special iron Nitrade treatment decreases the wear of the face splines over years and years of operation and hence increases the life of the turret, resulting in great cost savings. 15º engagement between the teeth of the face splines provide maximum rigidity and extra heavy interrupted cuts and a repeatability of ± .0001".

Dorian NVIT Manual Turret



NVIT Manual Turret - Specifications

Description	NVIT8-50		NVIT8-58		NVIT8-75		NVIT8-100		NVIT8-125	
Part No. 733101-	07505		07510		07515		07520		07525	
Unit of measurment	in	mm	in	mm	in	mm	in	mm	in	mm
No. of stations	8	8	8	8	8	8	8	8	8	8
Lathe swing over bed †	Up-12	300	13-15	320	14-17	400	17-24	500	XHD	XHD
Center height † †	1.375	34,22	1.750	44,58	2.000	51,75	2.500	63,1	3.000	76,45
Center height Min.	0.875	22,20	1.000	25,40	1.437	36,5	2.000	50,8	2.500	63,50
Max. square shank size	0.500	12	0.625	16	0.750	20	1.000	25	1.250	32
B	1.500	38,1	2.000	50,8	2.250	57,2	2.500	63,5	3.000	76,2
C	4.000	101,6	4.000	101,6	5.500	139,7	6.500	165,1	8.000	203,2
D	3.500	88,9	3.500	88,9	3.625	92,1	3.625	92,1	3.625	92,1
E	2.000	50,8	2.000	50,8	2.750	69,9	3.250	82,6	4.000	101,6
F	2.000	50,8	2.000	50,8	2.750	69,9	3.250	82,6	4.000	101,6
G	-	-	-	-	-	-	-	-	4.500	1114,3
H	-	-	-	-	-	-	-	-	1.750	44,5
I	2.250	57,2	2.250	57,2	2.250	57,2	2.250	57,2	2.250	57,2
J	3.250	82,6	3.500	88,9	4.500	114,3	5.000	127,0	6.000	152,4
K	3.250	82,6	3.500	88,9	4.500	114,3	5.000	127,0	6.000	152,4
L	2.250	57,2	2.250	57,2	3.000	76,2	3.500	88,9	4.500	114,3
M	3.125	79,4	3.375	85,7	3.812	96,8	4.562	115,9	5.625	142,9
N	2.125	54,0	2.250	57,2	2.562	65,1	3.312	84,1	4.875	123,8
O	3.875	98,4	4.375	111,1	5.125	130,2	6.375	161,9	8.000	203,2
P	3.125	79,4	3.500	88,9	4.125	104,8	5.125	130,2	6.500	165,1
Q*	0.750	20	1.000	25	1.250	32	1.500	40	2.000	50
R	5.000	127,0	5.500	139,7	6.500	165,1	8.250	209,6	10.500	266,7
S	1.937	49,2	2.500	63,5	2.687	68,3	3.375	85,7	4.125	104,8
T**	0.500	12	0.625	16	0.750	20	1.000	25	1.250	32
Cap screw	3/8-16	M10	3/18-16	M10	1/2-13	M12	3/4-10	M20	3/4-10	M20
Index time from tool to tool	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.	0.5 Sec.
Positioning accuracy	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"
Repeatability	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"	±0°0'6"
Weight of standard turret	10.0 kg	22 lbs	10.9 kg	24 lbs	24.9 kg	55 lbs	44.5 kg	98 lbs	80.3 kg	177 lbs

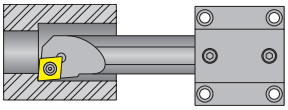
† Lathe swing dimensions listed above are for reference only.

†† Standard turret only, tools are sold seperately. Turret is supplied with standard center height, a blank "T" nut, and two Allen head cap screws. Any modifications to turret are done to custom specifications.

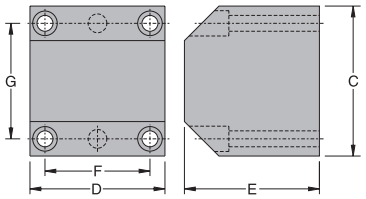
* Maximum Boring Bar Capacity
** Maximum Tool Capacity

Tooling not included

Blank Boring Bar Holder







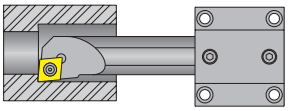
Tool Tips

This boring bar holder is best used when super precise boring is required. The holder is supplied without a bore so that it can be bored, honed, or ground to precise tolerance or for special diameters.

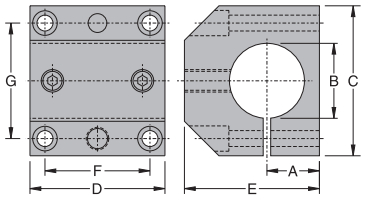
Inch Description	Part No. 733101-	C		D		E		F		G		Reference Turret
		in	mm	in	mm	in	mm	in	mm	in	mm	
BBH12-1	07600	2.000	50,8	1.500	38,1	1.375	34,9	1.000	25,4	1.300	78,7	NVIT8-50
BBH16-1	07602	2.250	57,2	2.000	50,8	1.625	41,3	1.500	38,1	1.600	40,6	NVIT8-58
BBH20-1	07604	2.500	63,5	2.250	57,2	1.875	47,6	1.750	44,5	1.800	45,7	NVIT8-75
BBH25-1	07606	3.200	46,5	2.500	63,5	2.250	57,2	1.800	45,7	2.500	63,5	NVIT8-100
BBH32-1	07608	3.750	95,3	3.000	76,2	2.750	69,9	2.250	57,2	3.000	76,2	NVIT8-125

Tooling not included

Boring Bar Holder







Tool Tips

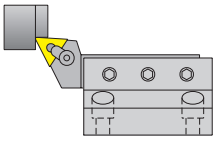
This holder is best used for holding boring bars. It has a precision ground bore with a 360° locking system giving it the best rigidity in metal removing without scarring the bar.

Inch Description	Part No. 733101-	A	B	C	D	E	F	G	Reference Turret
		in	in	in	in	in	in	in	
BBH12-075-2	07620	0.625	0.750	2.000	1.500	1.375	1.000	1.300	NVIT8-50
BBH16-100-2	07622	0.750	1.000	2.250	2.000	1.625	1.500	1.600	NVIT8-58
BBH20-125-3	07644	0.875	1.250	2.500	2.250	1.875	1.750	1.800	NVIT8-75
BBH25-150-3	07646	1.000	1.500	3.200	2.500	2.250	1.800	2.500	NVIT8-100
BBH32-200-2	07628	1.250	2.000	3.750	3.000	2.750	2.250	3.000	NVIT8-125

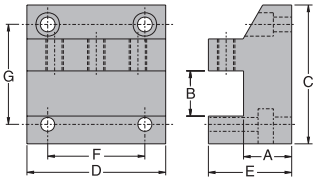
Tooling not included. For bushings see page P-33

Metric Description	Part No. 733101-	A	B	C	D	E	F	G	Reference Turret
		mm	mm	mm	mm	mm	mm	mm	
BBH12-20-2	07680	15,9	20	50,8	38,1	34,9	25,4	78,7	NVIT8-50
BBH16-25-2	07682	19,1	25	57,2	50,8	41,3	38,1	40,6	NVIT8-58
BBH20-32-3	07704	22,2	32	63,5	57,2	47,6	44,5	45,7	NVIT8-75
BBH25-40-3	07706	25,4	40	46,5	63,5	57,2	45,7	63,5	NVIT8-100
BBH32-50-2	07688	31,8	50	95,3	76,2	69,9	57,2	76,2	NVIT8-125

Face Tool Holder







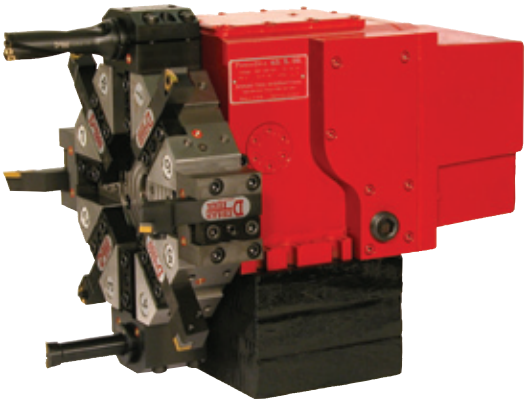
Tool Tips

This holder is best used for holding toolholders in a facing application. A set screw locking system insures that the tool is locked rigidly in the holder.

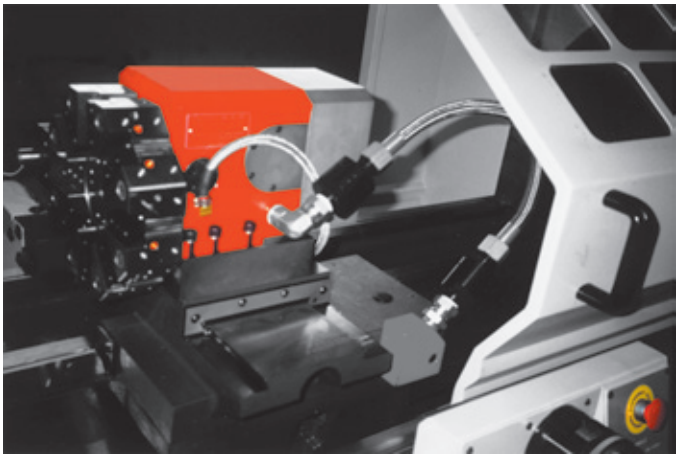
Inch Description	Part No. 733101-	A		B		C		D		E		F		G		Reference Turret
		in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	
FTH12-2	07740	0.600	15,2	0.500	12	2.000	50,8	1.625	41,3	1.100	27,9	1.000	25,4	1.300	78,7	NVIT8-50
FTH16-2	07742	0.625	15,9	0.625	16	2.250	57,2	2.200	55,9	1.250	31,8	1.500	38,1	1.600	40,6	NVIT8-58
FTH20-3	07760	0.867	22,0	0.750	20	2.500	63,5	2.500	63,5	1.500	38,1	1.750	44,5	1.800	45,7	NVIT8-75
FTH25-3	07762	0.935	23,7	1.000	25	3.200	46,5	2.730	69,3	1.875	47,6	1.800	45,7	2.500	63,5	NVIT8-100
FTH32-2	07748	1.000	25,4	1.250	32	3.750	95,3	3.250	82,6	2.250	57,2	2.250	57,2	3.000	76,2	NVIT8-125

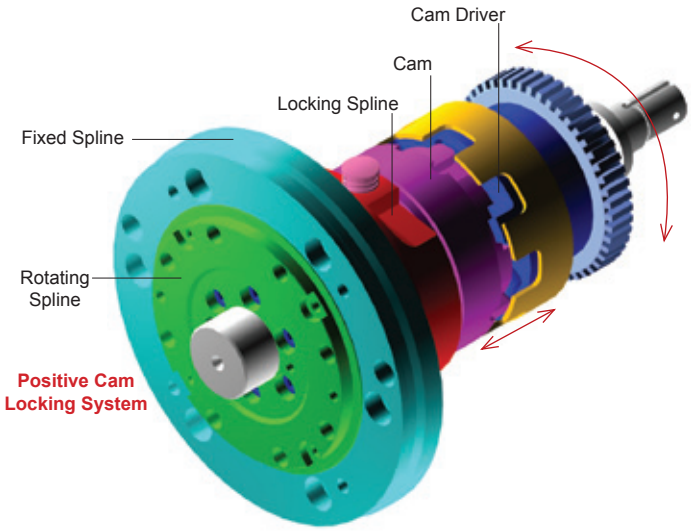
Tooling not included

Dorian POWERDEX Automated CNC Turret -

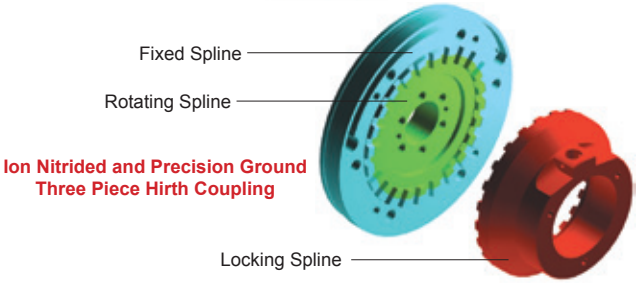


Tool Capacity:
Inch: 1/2", 5/8", 3/4", 1.0", 1-1/4" ,1-1/2"
metric: 12mm, 16mm, 20mm, 25mm, 32mm, 40mm





Positive Cam Locking System



Ion Nitrided and Precision Ground Three Piece Hirth Coupling

Decrease The Payoff Time On Your CNC Lathe By Increasing Its Performance with a PowerDex

The turret is a vital component of the CNC lathe. The operation and performance levels of the turret are crucial to the overall performance of the CNC lathe to achieve the optimum precision, efficiency, and reliability.

The PowerDex turret was designed and built by Dorian Tool to deliver the highest accuracy and repeatability, the fastest tool change, and the greatest rigidity ever found in any other electro-mechanical automated tool system.

By maximizing quality, productivity, and profitability, absolute CNC performance is achieved with the PowerDex.

- Electro-mechanical
- 8 & 12 stations
- Bi-directional (Shortest Path)
- Automated indexing
- Fast indexing cycle
- Milled Seat or VDI Tool Head
- Easy to remove boring bar holders
- Positive Locking Force
- Three piece Hirth coupling
- Precision, rigidity, and re-peatability
- Thru coolant system
- Meehanite body
- Heavy duty construction
- Intefaceable with virtually any CNC

- PowerDex turrets can be interfaced with virtually any CNC lathe.
- Reliable operation and the high performance of the PowerDex series turrets, increases the effective performance of your CNC lathe to achieve maximum efficiency and profitability.
- PowerDex turrets require minumum maintenance during years of operation and their cartridge style design makes servicing or troubleshooting very easy in case of a crash.
- The turrets have two easy-access lubrication windows to lubricate the internal parts from time to time.

- Positive Cam Locking System with three piece hirth coupling (splines) creates the most rigid turret locking mechanism (cam driver pushes the cam and therefore the locking spline to lock positively against the fixed and rotating splines).
- Internal parts, such as splines, shaft, cam, cam driver, are made from high alloy steel, thru hardened, ion nitrided and precision ground.
- Only highest quality, high precision and heavy duty bearings from first-class bearing manufacturers are being used on all Dorian Turrets
- Choice of Milled Seat or VDI turret discs (for both metric and inch tools)

1. Body
Meehanite-40 casting body delivers very high dampening capabilities.

2, 3, 4. Three Piece Hirth Coupling
The three-piece hirth coupling is comprised of a fixed spline (2) mounted to the body of the turret, a rotating spline (3) mounted to the turret head and the indexing shaft, and a locking spline (4) mounted to the locking mechanism of the turret. This system allows the tool head to be indexed without lifting; therefore, eliminating chip and swarf contamination.

Each one of the splines is specially hardened by the Ion Nitriding process and precision ground in order to make the splines more resistant to wear and increase the usable life of the turret, resulting in great savings.

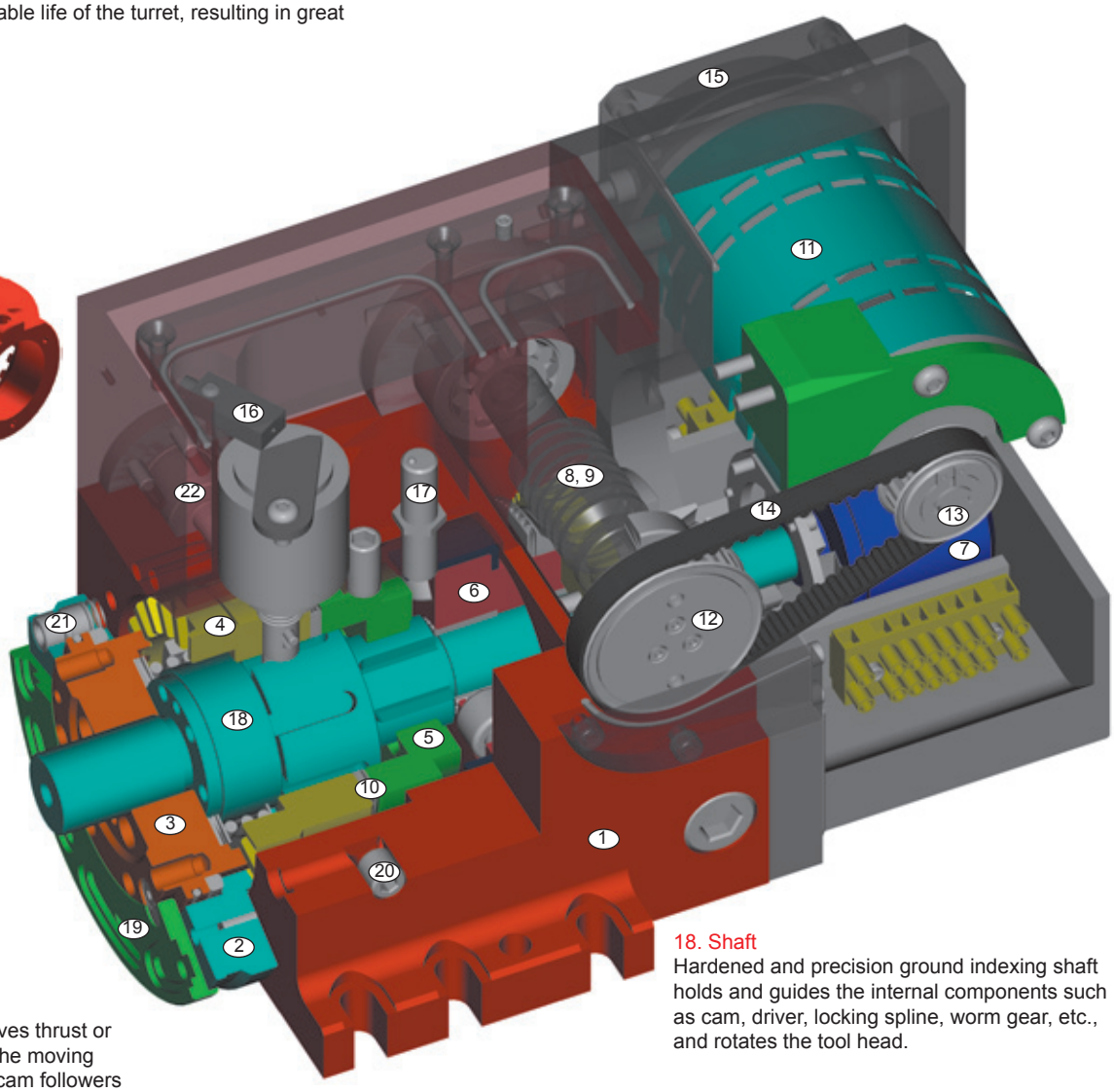


Ion Nitrided and Precision Ground Three Piece Hirth Coupling

5, 6. Positive Locking
Hardened and precision ground cam and driver (with extra heavy duty cam followers) provide the most rigid locking mechanism in the industry by creating a positive locking force.

7. New Absolute Encoder
The new, state of the art encoder utilizes the latest technology in the optical rotary encoder industry. The encoder mounting mechanism and the flexible coupling isolate the encoder from vibrations and shocks due to interrupted cuts and crashes.

8, 9. Worm and Worm Gear
Heat treated alloy steel worm shaft and aluminum bronze worm gear provide a smooth and quite indexing mechanism for the turret.



10. Bearings
The PowerDex design involves thrust or roller bearings between all the moving parts and extra heavy duty cam followers in the locking mechanism to eliminate wear due to friction.

11, 12, 13, 14. Motor, Pulleys and Timing Belt
Three phase, powerful, and high rpm motor coupled with a durable timing belt and pulley system provide lightning fast indexes.

15. Brake
Powerful brake helps stop the motor at the right location to prevent any overshoot.

16, 17. Sensors
Rugged and reliable proximity sensors are used to monitor the indexing and locking processes of the turret.

18. Shaft
Hardened and precision ground indexing shaft holds and guides the internal components such as cam, driver, locking spline, worm gear, etc., and rotates the tool head.

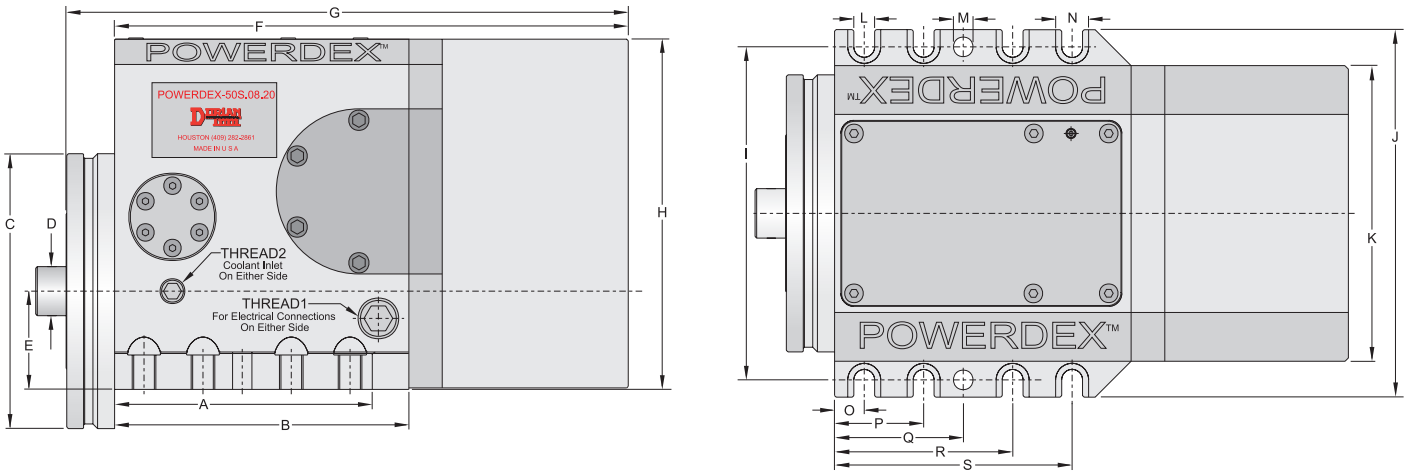
19, 20, 21. Thru Coolant System
The thru coolant system allows the coolant to be distributed through the toolhead to the working tools.

22. Damping Rod
Hardened damping rods (with urethane springs) guide the locking spline on the indexing shaft to enable a perfect engagement of the three piece hirth coupling without any misalignment.

POWERDEX Automated CNC Turret - Specifications

				50N	63N	80N	100N	125N
Description				*PDEX50N.08	PDEX63N.08	*PDEX80N.08	PDEX100N.08	PDEX125N.08
UPC No.				11011	11021	11031	11041	11051
Number of Stations				8	8	8	8	8
Recommended Square Shank Tooling Size		in.		.750	.750	1.000	1.250	1.500
		mm		20	20	25	32	40
Center Height		in.		1.969	2.480	3.150	3.937	4.921
		mm		50	63	80	100	125
Index Time with Locking	60 Hz	30°	Sec.	0.180	0.220	0.240	0.370	0.410
		45°	Sec.	0.220	0.260	0.300	0.440	0.500
		180°	Sec.	0.410	0.480	0.800	1.060	1.240
Max. Overturning Torque		Ft. lbs.		553	885	1,623	3,540	6,638
		Nm.		750	1,200	2,200	4,800	9000
Positioning Accuracy		in.		±.0005"	±.0005"	±.0005"	±.0005"	±.0005"
Repeatability		in.		±.0002"	±.0002"	±.0002"	±.0002"	±.0002"
Weight of Standard Turret		lbs.		90	110	150	300	375
		Kgs.		41	150	68	136	170

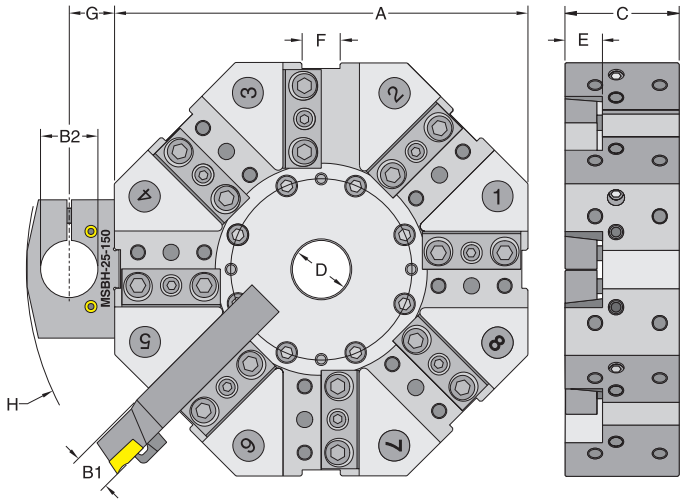
*PDEX50N & PDEX80N can be ordered, but are not a stock item.



POWERDEX Automated CNC Turret - Dimensions

Description	No. of Stations	Units	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	Thread 1 NPT	Thread 2 NPT
PDEX50N.08	8	in.	4.13	5.90	5.50	0.984	1.968	10.37	11.48	7.00	6.625	7.31	5.89	.414	.3937	.656	.59	1.77	2.560	3.54	-	3/4"-14"	1/4"-18"
		mm	105,0	150,0	140,0	25	50	236,4	291,7	177,8	168,3	185,7	150,0	10,5	10	16,6	4,16	45,00	65,00	90,0	-		
PDEX63N.08	8	in.	4.35	6.12	6.06	1.181	2.480	10.59	11.71	7.51	6.625	7.31	5.89	.414	.3937	.656	.81	1.99	2.780	3.76	-	3/4"-14"	1/4"-18"
		mm	110,0	155,4	153,9	30	63	269,0	297,4	190,8	168,3	185,7	150,0	10,5	10	16,6	20,57	50,60	70,50	95,6	-		
PDEX80N.08	8	in.	5.53	6.44	7.59	1.574	3.149	11.39	12.65	9.00	8.250	9.16	7.35	.414	.3937	.656	.60	1.75	2.625	3.50	4.875	3/4"-14"	1/4"-18"
		mm	140,5	163,5	192,8	40	80	289,3	321,2	228,6	209,5	232,6	186,4	10,5	10	16,6	15,24	44,45	66,67	88,9	124		
PDEX100N.08	8	in.	6.50	7.10	8.66	1.968	3.937	12.89	14.07	10.04	9.500	10.40	8.40	.530	.3937	.780	.70	1.75	2.750	4.00	5.00	3/4"-14"	1/4"-18"
		mm	165,1	180,3	220,0	50	100	327,4	357,4	255,0	241,3	264,1	213,4	13,4	10	19,8	17,80	44,45	69,80	101,6	127		
PDEX125N.08	8	in.	6.50	7.30	11.02	2.480	4.921	13.65	15.62	11.41	10.60	11.60	9.65	.530	.3937	.780	.70	1.95	3.000	4.00	5.00	3/4"-14"	1/4"-18"
		mm	165,1	185,4	280,0	63	125	346,7	396,7	289,8	269,2	294,6	245,1	13,4	10	19,8	17,80	44,45	69,80	101,6	127		

Milled Seat Turret Head



Milled Seat Turret Head Eight (8) Station INCH	INCH Description	Part No. 733101-	A	B1	B2	C	D	E	F	G	H	Reference Turret
	MS.050.S.08.750.190	11508	7.480	0.750	1.250	2.402	0.984	0.787	0.787	1.024	11.831	PDEX50N.08
	MS.050.S.08.750.220	11510	8.661	0.750	1.250	2.402	0.984	0.787	0.787	0.984	12.283	PDEX50N.08
	MS.063.S.08.750.220	11512	8.661	0.750	1.250	2.402	1.181	0.787	0.787	0.984	12.283	PDEX63N.08
	MS.080.S.08.100.275	11514	10.827	1.000	1.500	2.992	1.574	0.984	0.984	1.181	15.276	PDEX80N.08
	MS.100.S.08.125.350	11516	13.780	1.250	2.000	3.780	1.968	1.260	1.260	1.378	19.370	PDEX100N.08
	MS.125.S.08.150.450	11520	13.780	1.250	2.000	3.780	1.968	1.260	1.260	1.378	19.370	PDEX125N.08

Milled Seat Turret Head Eight (8) Station METRIC	METRIC Description	Part No. 733101-	A	B1	B2	C	D	E	F	G	H	Reference Turret
	MS.050.S.08.20.190	11568	190	20	32	61	25	20	20	26	300	PDEX50N.08
	MS.050.S.08.20.220	11570	220	20	32	61	25	20	20	25	312	PDEX50N.08
	MS.063.S.08.20.220	11572	220	20	32	61	30	20	20	25	312	PDEX63N.08
	MS.080.S.08.25.275	11574	275	25	40	76	40	25	25	30	388	PDEX80N.08
	MS.100.S.08.32.350	11576	350	32	50	96	50	32	32	35	492	PDEX100N.08
	MS.125.S.08.40.450	11580	450	40	60	126	63	40	40	40	612	PDEX125N.08

Tooling not Included

POWERDEX Installation Option 1: With PowerDex Control Box & M-Codes PowerDex Turrets can be interfaced to any CNC or Programmable Lathe with the use of 5 M-Codes. PowerDex Control Box (UPC# 733101-12160) is required.

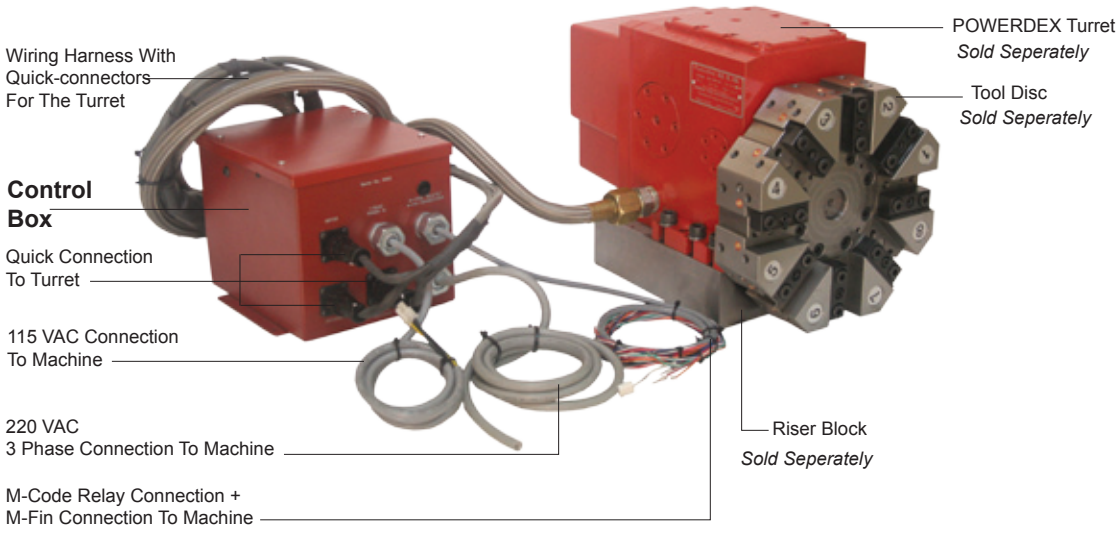
Most machines come with spare M-Codes for additional accessory installations. If the machine does not have 5 spare M-Codes, then additional M-Codes can be purchased from the machine tool manufacturer as an option.

The PowerDex Control Box (Shown Below) includes:

1. Control Box
2. Wiring Harness with Quick-Connects to the PowerDex Turret
3. 115 VAC Cable to power the Control Box
4. 220 VAC 3 Phase Cable to power the 3 Phase 220 VAC motor of the PowerDex Turret
5. M-Code Connection Cables. These cables are labeled as Bit 0, 1, 2, 3, and START. Bits 0 thru 3 are to be connected to M Code Relays 1 thru 4 respectively. **START Bit** is to be connected to M Code Relay 5. A subroutine program is to be written for each tool station change to call up the appropriate M Codes for the tool change according to the chart below. The appropriate tool change subroutine needs to be called by the main part program to change to the desired tool station.

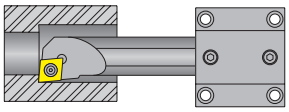
Turret Index Chart								
Tool Station	**1**	**2**	**3**	**4**	**5**	**6**	**7**	**8**
Bit 0 (M Code 1)	1	0	1	0	1	0	1	0
Bit 1 (M Code 2)	0	1	1	0	0	1	1	0
Bit 2 (M Code 3)	0	0	0	1	1	1	1	0
Bit 3 (M Code 4)	0	0	0	0	0	0	0	1
START (M Code 5)	1	1	1	1	1	1	1	1

6. M-Fin Connection Cables. This cable is to be connected to the M-Fin terminal for the M-Codes. This is a safety feature that is recommended by Dorian Tool.



POWERDEX Installation Option 2: Interfacing directly into the CNC Controls of the CNC or Programmable Lathe. This requires PLC program modification in the PLC of the CNC Controls. Dorian Tool can provide sample PLC program with explanation. Also some wiring (encoder feedback, 2 proximity sensors, solenoid, 3 Phase AC Motor with Thermal Overload, and Brake) directly into the I/O board of the machine is necessary.

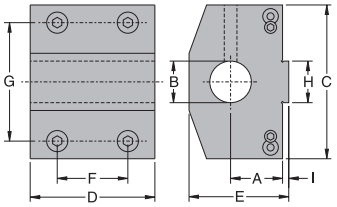
Milled Seat Boring Bar Holder





Tool Tips

This holder is best used for holding inch boring bars. It has a precision ground bore with a 360° locking system giving it the best rigidity in metal removing without scarring the bar. It also has a nozzle for directing coolant to the tool during machining.

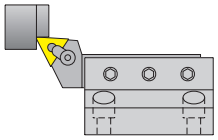


INCH Description	Part No. 733101-	A	B	C	D	E	F	G	H	I	Reference Milled Seat Tool Head
MSBH-16-100	12015	0.906	1.000	2.402	1.969	1.693	1.102	1.831	0.630	0.118	MS.50.S.08.750.190
MSBH-20-125	12025	1.024	1.250	2.913	2.362	2.126	1.339	2.244	0.787	0.118	MS.50.S.08.750.220 MS.63.S.08.750.220
MSBH-25-150	12030	1.181	1.500	3.622	2.953	2.283	1.693	2.795	0.984	0.118	MS.80.S.08.100.275
MSBH-32-200	12035	1.378	2.000	4.528	3.740	2.874	2.244	3.543	1.260	0.118	MS.100.S.08.125.350
MSBH-40-250	12040	1.575	2.500	5.591	4.921	3.346	3.031	4.370	1.575	0.118	MS.125.S.08.150.450

METRIC Description	Part No. 733101-	A	B	C	D	E	F	G	H	I	Reference Milled Seat Tool Head
MSBH-16-25	12050	23	25	61	50	43	28	46,5	16	3	MS.50.S.08.20.190
MSBH-20-32	12060	26	32	74	60	54	34	57	20	3	MS.50.S.08.20.220 MS.63.S.08.20.220
MSBH-25-40	12070	30	40	92	75	58	43	71	25	3	MS.80.S.08.25.275
MSBH-32-50	12080	35	50	115	95	73	57	90	32	3	MS.100.S.08.32.350
MSBH-40-60	12090	40	60	142	125	85	77	111	40	3	MS.100.S.08.32.350

Tooling not included

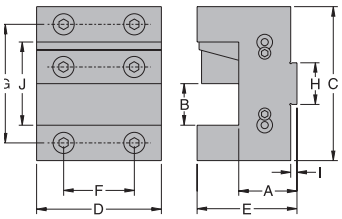
Milled Seat Face Tool Holder





Tool Tips

This holder is best used for holding toolholders in a facing application. A set screw locking system ensures that the tool is locked rigidly in the holder. It also has a nozzle for directing coolant to the tool during machining.



INCH Description	Part No. 733101-	A	B	C	D	E	F	G	H	I	J	Reference Milled Seat Tool Head
MSFH-20-75	12110	0.906	0.750	2.913	2.362	1.693	1.339	2.244	0.787	.128	1.575	MS.50.S.08.750.190 MS.50.S.08.750.220 MS.63.S.08.750.220
MSFH-25-100	12115	1.103	1.000	3.622	2.953	2.087	1.693	2.795	0.984	.128	1.969	MS.80.S.08.100.275
MSFH-32-125	12120	1.220	1.250	4.528	3.740	2.480	2.244	3.543	1.260	.128	2.520	MS.100.S.08.125.350
MSFH-40-150	12125	1.378	1.500	5.591	4.921	2.953	3.031	4.370	1.575	.128	3.150	MS.125.S.08.150.450

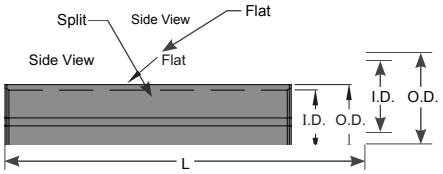
METRIC Description	Part No. 733101-	A	B	C	D	E	F	G	H	I	J	Reference Milled Seat Tool Head
MSFH-20-20	12140	23	20	74	60	43	34	57	20	3	40	MS.50.S.08.20.190 MS.50.S.08.20.220 MS.63.S.08.20.220
MSFH-25-25	12145	28	25	92	75	53	43	71	25	3	50	MS.80.S.08.25.275
MSFH-32-32	12150	31	32	115	95	63	57	90	32	3	64	MS.100.S.08.32.350
MSFH-40-40	12155	35	40	142	125	75	77	111	40	3	80	MS.125.S.08.40.450

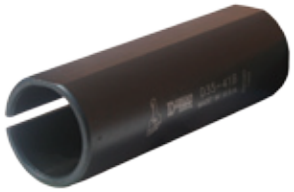
Tooling not included

Type A

Boring Bar Bushings
Inch/Metric

Split-style design provides 360° surface area locking for maximum rigidity. They are made from Chromium-Molybdenum Alloy Steel, and are heat treated and precision ground for concentricity. Used for holding drills, reamers, small boring bars, and other round tools.





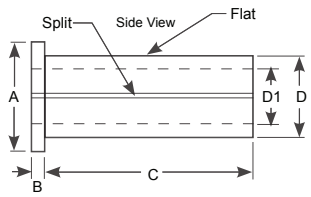
INCH Description	Part No. 733101-	O.D.	I.D.	L
D25-4B	03705	0.750	0.500	2.750
D30-4B	03707	1.000	0.750	3.250
D35-4B	03709	1.000	0.750	3.750
D40-4B	03711	1.250	1.000	4.500
D50-4B	03713	1.500	1.250	5.500
D60-4B	03715	2.000	1.500	6.500
D25-41B	03719	1.000	0.750	2.750
D30-41B	03721	1.250	1.000	3.250
D35-41B	03723	1.250	1.000	3.750
D40-41B	03725	1.500	1.250	4.500
D50-41B	03727	2.000	1.500	5.500
D60-41B	03729	2.500	2.000	6.500
D25-41SB	03733	1.250	1.000	3.000
D30-41SB	03735	1.500	1.250	3.500
D35-41SB	03737	1.500	1.250	4.000
D40-41SB	03739	2.000	1.500	4.500
D50-41SB	03741	2.500	2.000	6.500
D60-41SB	03743	3.000	2.500	7.000

METRIC Description	Part No. 733101-	O.D.	I.D.	L
D25-4BM	03747	20	12	69.85
D30-4BM	03749	25	20	82.55
D35-4BM	03751	25	20	95.25
D40-4BM	03753	32	25	114.30
D50-4BM	03755	40	32	139.70
D60-4BM	03757	50	40	165.10
D25-41BM	03761	25	20	69.85
D30-41BM	03763	32	25	82.55
D35-41BM	03765	32	25	95.25
D40-41BM	03767	40	32	114.30
D50-41BM	03769	50	40	139.70
D60-41BM	03771	60	50	165.10
D25-41SBM	03775	32	25	76.20
D30-41SBM	03777	40	32	88.90
D35-41SBM	03779	40	32	101.60
D40-41SBM	03781	50	40	114.30
D50-41SBM	03783	60	50	165.10
D60-41SBM	03785	80	60	177.80

Type B

Reducer Bushings
Inch/Metric

Type B Reducer Bushings' split-style design provides 360° surface area locking for maximum rigidity. They are made from Chromium-Molybdenum Alloy Steel, and are heat treated and precision ground for concentricity. Used for holding drills, reamers, small boring bars, and other round tools.





INCH Description	Part No. 733101-	D1	A	B	C	D
THB75-25	93106	.250	1.00	0.25	1.50	0.75
THB75-31	93107	.321				
THB75-38	93108	.375				
THB75-50	93109	.500				
THB100-38	93110	.375	1.25	0.25	1.75	1.00
THB100-50	93111	.500				
THB100-62	93112	.625				
THB100-75	93113	.750				
THB125-38	93114	.375	1.50	0.25	2.00	1.25
THB125-50	93115	.500				
THB125-62	93116	.625				
THB125-75	93117	.750				
THB125-100	93118	1.00				
THB150-50	93119	.500	1.75	0.25	2.50	1.50
THB150-62	93120	.625				
THB150-75	93121	.750				
THB150-100	93122	1.00				
THB150-125	93123	1.25				
THB200-50	93124	.500	2.25	0.25	3.50	2.00
THB200-62	93125	.625				
THB200-75	93126	.750				
THB200-100	93127	1.00				
THB200-125	93128	1.25				
THB200-150	93129	1.50				
THB200-175	93130	1.75				
THB250-50	93131	.500	2.75	0.25	4.00	2.50
THB250-62	93132	.625				
THB250-75	93133	.750				
THB250-100	93134	1.00				
THB250-125	93135	1.25				
THB250-150	93136	1.50				
THB250-175	93137	1.75				
THB250-200	93138	2.00				
THB250-225	93139	2.25				

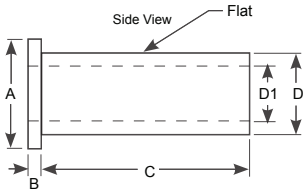
METRIC Description	Part No. 733101-	D1	A	B	C	D
THB20-6	93140	6	25,4	6,35	38,1	20
THB20-8	93141	8				
THB20-10	93142	10				
THB20-12	93143	12				
THB25-10	93144	10	38,1	6,35	44,5	25
THB25-12	93145	12				
THB25-16	93146	16				
THB25-20	93147	20				
THB32-10	93148	10	38,1	6,35	50,8	32
THB32-12	93149	12				
THB32-16	93150	16				
THB32-20	93151	20				
THB32-25	93152	25				
THB40-12	93153	12	44,5	6,35	63,5	40
THB40-16	93154	16				
THB40-20	93155	20				
THB40-25	93156	25				
THB40-32	93157	32				
THB50-12	93158	12	57,2	6,35	88,9	50
THB50-16	93159	16				
THB50-20	93160	20				
THB50-25	93161	25				
THB50-32	93162	32				
THB50-40	93163	40				
THB60-20	93164	20	69,9	6,35	127	60
THB60-25	93165	25				
THB60-32	93166	32				
THB60-40	93167	40				
THB60-45	93168	45				
THB60-50	93169	50				

Type LBF

Reducer Bushings
Inch/Metric



Type LBF Reducer Bushings' are designed with two set screws for clamping drills, boring bars, and round shank tools.

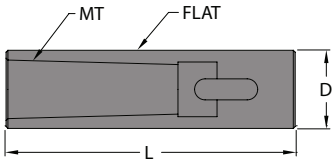


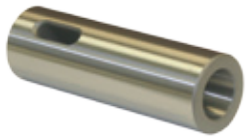
INCH Description	Part No. 733101-	D1	A	B	C	D
LBF125-0250	93215	0.250				
LBF125-0375	93216	0.375				
LBF125-0500	93217	0.500				
LBF125-0625	93218	0.625	1.50	.625	2.813	1.25
LBF125-0750	93219	0.750				
LBF125-0875	93220	0.875				
LBF125-1000	93221	1.000				
LBF150-0250	93222	0.250				
LBF150-0375	93223	0.375				
LBF150-0500	93224	0.500				
LBF150-0625	93225	0.625	1.75	.625	3.156	1.50
LBF150-0750	93226	0.750				
LBF150-0875	93227	0.875				
LBF150-1000	93228	1.000				
LBF150-1000	93229	1.250				
LBF200-0500	93230	0.500				
LBF200-0625	93231	0.625				
LBF200-0750	93232	0.750				
LBF200-0875	93233	0.875	2.25	.750	3.750	2.00
LBF200-1000	93234	1.000				
LBF200-1250	93235	1.250				
LBF200-1500	93236	1.250				

METRIC Description	Part No. 733101-	D1	A	B	C	D
LBF032-008	93238	08				
LBF032-010	93239	10				
LBF032-012	93240	12	38,1	15,88	71,45	32
LBF032-016	93241	16				
LBF032-020	93242	20				
LBF032-025	93243	25				
LBF040-010	93244	10				
LBF040-012	93245	12				
LBF040-016	93246	16	44,5	15,88	80,16	40
LBF040-020	93247	20				
LBF040-025	93248	25				
LBF040-032	93249	32				
LBF050-010	93250	10				
LBF050-012	93251	12				
LBF050-016	93252	16				
LBF050-020	93253	20	57,2	19,05	95,25	50
LBF050-025	93254	25				
LBF050-032	93255	32				
LBF050-040	93256	40				
LBF050-045	93257	45				

Type A

Morse Taper Bushings





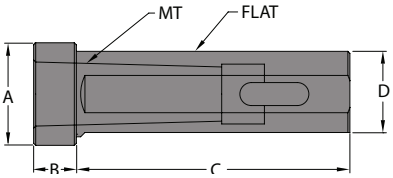
The hardened, precision ground style A Morse Taper Bushing is held with set screws on flat surface, so it will never push back or turn, and is concentric within 0.0002".

These bushings fit directly into the toolholders and turrets to positively drive all morse taper shank tools, drills, reamers and counterbores.

INCH Description	Part No. 733101-	Morse Taper	D	L
MTB75-1-A	93197	MT1	0.75	1.500
MTB100-2-A	93198	MT2	1.00	3.750
MTB125-3-A	93199	MT3	1.25	4.000
MTB150-3-A	93200	MT3	1.50	5.000
MTB150-4-A	93201	MT4	1.50	5.750
MTB200-4-A	93202	MT4	2.00	6.125
MTB250-5-A	93203	MT5	2.50	7.375

Type B

Morse Taper Bushings
Inch/Metric





Style B Morse Taper Bushings are designed with a shoulder to ensure position stop and correct depth of the drilling operations and to provide safety for secondary operations, such as boring and reaming.

The hardened, precision ground bushing is held with set screws on flat surface, so it will never push back or turn, and is concentric within 0.0002".

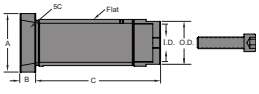
These bushings fit directly into the toolholders and turrets to positively drive all morse taper shank tools, drills, reamers and counterbores.

INCH Description	Part No. 733101-	Morse Taper	A	B	C	D
MTB100-2-B	93174	MT2	1.25	0.63	3.13	1.00
MTB125-3-B	93179	MT3	1.50	0.00	4.00	1.25
MTB150-3-B	93180	MT3	1.75	0.63	4.38	1.50
MTB150-4-B	93184	MT4	1.75	1.38	4.38	1.50
MTB200-4-B	93185	MT4	2.25	0.63	5.50	2.00
MTB250-5-B	93187	MT5	2.75	0.63	7.00	2.50

METRIC Description	Part No. 733101-	Morse Taper	A	B	C	D
MTB25-2-B	93191	MT2	31,8	16,0	79,50	25
MTB32-3-B	93192	MT3	38,1	0,00	101,6	32
MTB40-3-B	93193	MT3	44,5	16,0	111,3	40
MTB40-4-B	93194	MT4	44,5	35,1	111,3	40
MTB50-4-B	93195	MT4	57,2	16,0	139,7	50
MTB65-5-B	93196	MT5	69,9	16,0	177,8	60

5C Collet Holder

Bushings
Inch/Metric





5C Collet Holder Bushings are Flexible, versitle and reduce set-up time.

These bushings are used to adapt drills, reamers, counter bores, and end mills.

INCH Description	Part No. 733101-	A	B	C	D	D1
5CHB-150	93265	2.00	.50	3.13	1.50	1.250
5CHB-200	93266	2.50	.50	3.13	2.00	1.250
5CHB-250	93267	3.00	.50	3.13	2.50	1.250

METRIC Description	Part No. 733101-	A	B	C	D	D1
5CHB-040	93260	50,8	12,7	79,5	40	31,75
5CHB-050	93269	63,5	12,7	79,5	50	31,75
5CHB-060	93270	76,2	12,7	79,5	60	31,75

Precision ER Collets 11,16,20,25,32 Inch/Metric



- Maximum TIR -Standard: 0.0006
- Maximum TIR -High Precision: 0.0003
- Maximum Tightening Torque:20lbs.ft (27Nm)

Precision ER 11 Collets

Manufactured to DIN 6499 Specifications

- Size Range: 0.019”-0.275”; 0.5-7mm
- Grip Range: 0.019”;0.5mm



Description	Part No. 733101-	Holding Capacity	
		Inch	Metric
ER11-STIMC-10	46236	0.019-0.039	0.5-1
ER11-STIMC-15	46237	0.039-0.059	1-1.5
ER11-STIMC-20	46238	0.059-0.078	1.5-2
ER11-STIMC-25	46239	0.078-0.098	2-2.5
ER11-STIMC-30	46240	0.098-0.118	2.5-3
ER11-STIMC-35	46241	0.118-0.137	3-3.5
ER11-STIMC-40	46242	0.137-0.157	3.5-4
ER11-STIMC-45	46243	0.157-0.177	4-4.5
ER11-STIMC-50	46244	0.177-0.197	4.5-5
ER11-STIMC-55	46245	0.197-0.216	5-5.5
ER11-STIMC-60	46246	0.216-0.236	5.5-6
ER11-STIMC-65	46247	0.236-0.255	6-5
ER11-STIMC-70	46248	0.255-0.275	6.5-7

Precision ER 16 Collets

Manufactured to DIN 6499 Specifications

- Size Range: 0.019”-0.393”; 0.5 - 10mm
- Grip Range: 0.019”;0.5mm



Description	Part No. 733101-	Holding Capacity	
		Inch	Metric
ER16-STMC-10	46290	0.019-0.039	0.5-1
ER16-STMC-20	46291	0.039-0.078	1-2
ER16-STMC-30	46292	0.098-0.118	2-3
ER16-STMC-40	46293	0.118-0.157	3-4
ER16-STMC-50	46294	0.157-0.197	4-5
ER16-STMC-60	46295	0.197-0.236	5-6
ER16-STMC-70	46296	0.236-0.275	6-7
ER16-STMC-80	46297	0.275-0.314	7-8
ER16-STMC-90	46298	0.314-0.354	8-9
ER16-STMC-100	46299	0.354-0.393	9-10

Precision ER 32 Collets

Manufactured to DIN 6499 Specifications

- Size Range: 0.078”-0.787”; 2-20mm
- Grip Range: 0.078”; 2mm



Description	Part No. 733101-	Holding Capacity	
		Inch	Metric
ER32-STIMC-30	46522	0.078-0.118	2-3
ER32-STIMC-35	46523	0.098-0.137	3-3.5
ER32-STIMC-40	46524	0.098-0.157	3-4
ER32-STIMC-50	46525	0.157-0.197	4-5
ER32-STIMC-60	46526	0.197-0.236	5-6
ER32-STIMC-70	46527	0.236-0.275	6-7
ER32-STIMC-80	46528	0.275-0.314	7-8
ER32-STIMC-90	46529	0.314-0.354	8-9
ER32-STIMC-100	46530	0.354-0.393	9-10
ER32-STIMC-110	46531	0.393-0.433	10-11
ER32-STIMC-115	46532	0.433-0.452	11.5-12
ER32-STIMC-120	46533	0.433-0.472	11-12
ER32-STIMC-130	46534	0.472-0.511	12-13
ER32-STIMC-140	46535	0.511-0.551	13-14
ER32-STIMC-150	46536	0.551-0.590	14-15
ER32-STIMC-160	46537	0.590-0.629	15-16
ER32-STIMC-170	46538	0.629-0.669	16-17
ER32-STIMC-180	46539	0.669-0.708	17-118
ER32-STIMC-190	46540	0.708-0.748	18-19
ER32-STIMC-195	46541	0.748-0.768	19-19.5
ER32-STIMC-200	46542	0.748-0.787	19-120

ER Collet Straight Holder Inch/Metric

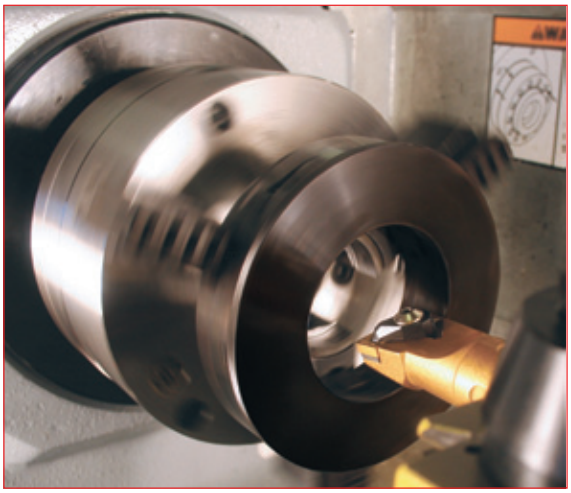
Description	Part No. 733101-	Size	Specifications			
			Collet Series	Collet Range	Collet Holder	Gage Length
CCER11-0500-500	45773	in	ER11	.019-0.275	0.500	6.11
CCER11-M012-100	49807	metric		0.5-7	12.0	125.0
CC ER11-0750-500	45775	in		.019-0.275	0.750	6.11
CCER11-M020-100	49827	metric		0.5-7	20.0	125.0
CCER16-0750-500	45777	in	ER16	0.019-0.409	0.750	6.28
CCER16-M020-100	49813	metric		0.5-10	20.0	157.0
CCER16-1000-500	45778	in		0.019-0.409	1.000	6.28
CCER16-M025-100	49815	metric		0.5-10	25.0	157.0
CCER32-1000-500	45785	in	ER32	0.078-0.787	1.000	6.85
CCER32-M025-100	49837	metric		2.0-20	25.0	167.00
CCER32-1250-500	45786	in		0.078-0.787	1.250	6.85
CCER32-M032-120	49841	metric		2.0-20	32.0	167.00



TruJaws® Soft Jaw Machining Adapter

Re-machine soft top jaws on power and manual chucks to improve machining quality and productivity.

- Minimum stock removal
- Perfect concentricity & squareness of jaw
- Maximum rigity of jaws
- Replaces thousands of rings and spiders



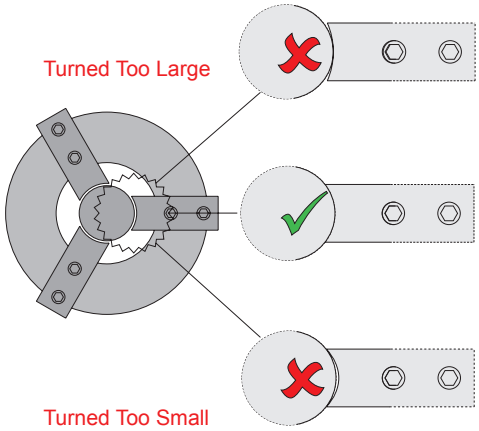
Working Principle

TruJaws chuck adapter is designed to hold the soft top jaws in a positive position while being remachined.

The TruJaws operation is based on the principle of a manual chuck.

The scroll gear opens and closes the pronged jaws, giving infinite adjustment for machining any required diameter.

For maximum capability of the TruJaws adapter, the jaws are reversible.



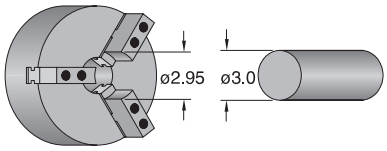
Trouble Shooting

The chuck jaw diameter is **turned too large**, causing the jaws to hold the part with only the inside edge. This reduces the holding pressure and can mar the part surface.

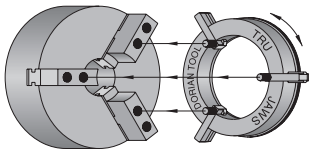
Chuck jaws are **turned to the correct diameter**, so that the part is held with the maximum surface area. This increases the holding force and reduces marring of the part surface.

The chuck jaw diameter is **turned too small**, causing the jaws to hold the part with only the outside edges. This reduces the holding pressure and can mar the part surface.

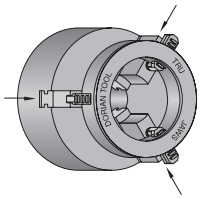
Using the TruJaws® is easy and requires very few steps



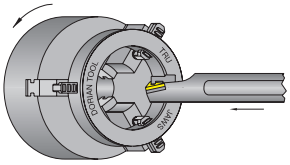
(1) Set the jaws for the required job. The diameter of the jaws must be set smaller than the part diameter.



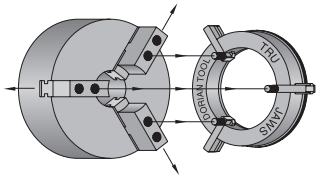
(2) Adjust the TruJaws to fit into the bolt holes of the soft jaws. Then, rotate the body of the TruJaws until snug, pulling the jaws rigid in the opposite direction of the clamping force (away from the part to be held).



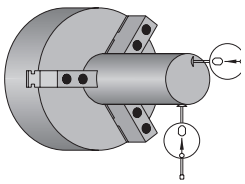
(3) Lock the chuck. Jaws must be locked in the direction of the part to be held. The soft jaws will then be held rigidly by the TruJaws as if holding the part.



(4) Machine the diameter desired. The bore diameter must be precise with the diameter of the part to be held.



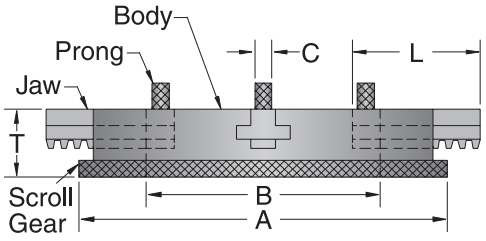
(5) Remove the TruJaws. Unlock the chuck opposite to the locking direction.



(6) Chuck the part. If these steps are followed correctly, the part will be true within .0002" T.I.R.

TruJaws® Soft Jaw Machining Adapter Technical Specifications:

UPC No. 733101-	Desc.	Thick T	Weight Lbs	Weight Kg	Prong Dia. C	Max. Boring Range B	Min. Outside Range A	Length of Jaws L	Chuck Range	Max. Load Capacity Lbs	Max. Load Capacity Kg	Max. RPM Use
03540	TJP47-3	1.250	12	5,40	.500	3.250	6.125	3.00	UP-8"	8,000	3.360	900
03542	TJP52-3	1.750	28	12,7	.750	6.625	10.625	4.75	8-14"	20,000	9,070	600
03544	TJP57-3	1.750	43	19,5	.750	11.50	16.000	4.75	14-26"	15,000	6,800	250



The CNC Marker will replace punches, hammers, presses and secondary operations!

You can stamp numbers, letters, and logos onto any material on your Manual or CNC Machine. Automatic Stamping Eleminates Secondary Operations & Labor Costs.



Shank Sizes
- 0.75" and 1.0" Diameters

Sealed Against Chips & Coolant
The CNC Marker is sealed to protect against chips and coolant to ensure smooth performance and long tool life.

Internal Inertia System
Advancing the CNC Marker into the work piece charges and launches the internal inertia system, which triggers the movement of the marking head. There is absolute zero recoil due to the advanced dampening system.

Adjustable Force
The depth of marking is adjustable by the clockwise or counterclockwise rotation of the outer body, which increases or decreases the depth for various materials and hardnesses.

Two Models
Available in two models, the DKN-10 series and the DKN-15 series.

Steel Stamp
- Industry Standard
- Wide Character Range
- Up To (25) Character Capacity
- .062" (1.5mm) to 0.250" (6mm) Character Height

Steel Stamp Holder
- Multi-Character Marking
- Uniform Marking Depth
- Accurate Stamp Location
- Positive Locking
- Rapid Changeability
- Accepts Blank Spacers

Safety Pins
Safety pins for the steel stamps assure that the steel stamps never come loose during operation when the CNC Marker is used on a CNC machine.

The CNC Marker is a mechanical multi-character marking tool, engineered to operate in conjunction with Manual Machines or CNC Machining Centers and CNC Turning Centers.

The CNC Marker is easy, simple, and quick to set-up and safe to operate. The CNC Marker can be utilized for single piece marking to high-production marking operations.

The compact design of The CNC Marker makes the tool easy to install in the tool magazine of a CNC Machining Center or CNC Turning Center without interference with the machine components or the workpiece.

The accessibility of having The CNC Marker tooled up in the machine facilitates marking the workpiece while still in the machine, eliminating secondary operations as well as expensive stamping machines and operators.

The CNC Marker is available in two models, the DKN-10 series with a maximum steel stamp capacity of 15 and the DKN-15 series with a maximum steel stamp capacity of 25.

The CNC Marker is loaded in the CNC Machining Center's spindle or the CNC Turning Center's turret, then aligned and positioned on the workpiece.

There is zero recoil due to the advanced dampening system.

The marking depth is adjustable by the clockwise or counterclockwise rotation of the outer body, which increases or decreases the depth for various materials and hardness.

Safety pins for the steel stamp will assure that the steel stamps never come loose during operation when The CNC Marker is used on the CNC machine.

The Stamp Holder provides accurate stamp location, positive locking, and durability with rapid steel stamp changeability.

The Stamp Holder accepts industry standard steel stamps with character heights from .062" (1.5mm) to 0.250" (6mm).

The application of The CNC Marker is not limited to CNC Machining Centers and Turning Centers.

The CNC Marker can be used in conjunction with virtually any Manual Turning, Milling, or Drilling Machines, as well.

The CNC Marker Working Principle:

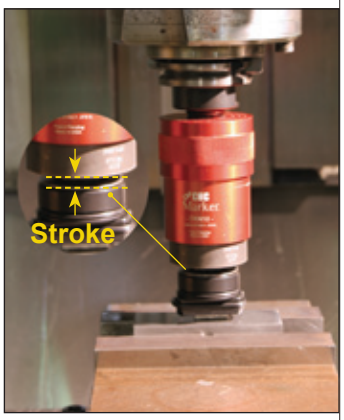
Step 1:

Move (rapid) the CNC Marker towards to workpiece until the stamps make contact with the surface to be marked.



Step 2:

From the position where the CNC Marker makes contact with the workpiece, advance the CNC Marker into the workpiece by a certain distance called “loading stroke” which is specified in the instructions manual of the CNC Marker.



Step 3:

At the end of the “loading stroke”, the spring loaded mechanism of the CNC Marker triggers and stamps the workpiece. Do not advance the CNC Marker into the workpiece after stamping.



Step 4:

Retract the CNC Marker up. It automatically re-charges itself and at this point is ready for the next stamp.



CNC Marker’s Compact Design and Light Weight allows for use in:

CNC Lathe



CNC Vertical Machining Center



CNC Horizontal Machining Center



Drill Press



CNC Marker Stores in Machine’s Tool Magazine for Automatic Tool Change*

Carrousel



Side Mount - Vertical

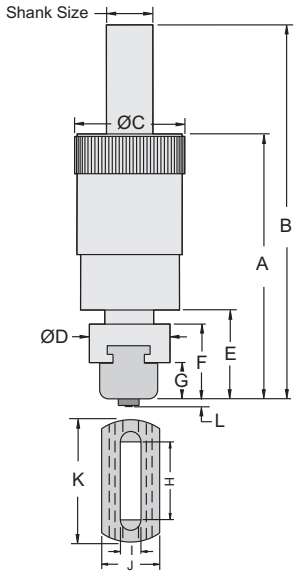


Side Mount - Horizontal



*Check machine’s tool magazine specifications for maximum size & weight for tool storage & automatic tool change.





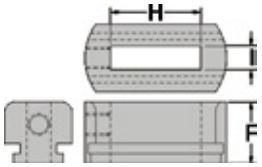
- **Adjustable Force**
- **Absolute Zero Recoil**
- **Interchangeable Stamping Head**
- **Uniform & Consistant Stamp Depth and Pattern**
- **Easy Loading & Unloading of Stamps**
- **Industry Standard Steel Stamps with a Notch**

CNC Marker - Spring Loaded Mechanical Marking Device															
UPC 733101-	Description	Shank in	A in	B in	C in	D in	E in	F in	G in	H in	I in	J in	K in	L in	Weight (lbs)
35003	DKN-10-075	3/4	5.300	7.425	2.500	1.625	1.395	1.090	0.480	0.955	0.251	1.062	2.080	0.200	3.5
35021	DKN-15-100	1	7.500	9.900	3.550	2.235	2.055	0.460	0.485	1.520	0.251	1.250	2.700	0.200	9.5

Special Heads: with custom logos, website addresses, emails, non-standard characters can be quoted and made for specific applications. Call or email us for more information.

Single & Double Row Stamping Head

- Quick change feature for faster change over
- Accepts standard steel types
- Accomodates special stamps

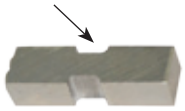


Single & Double Row Stamping Head								
UPC 733101-	Description	F in	F mm	H in	H mm	I in	I mm	Max. Capacity
Single Row Stamping Head								
35052	DKN-10HD-1-250	.650	16,5	0.965	24,5	.252	6,4	15
35060	DKN-15HD-1-250	.650	16,5	1.575	40,0	.252	6,4	25
35063	DKN-15HD-1-375	.525	13,3	1.575	40,0	.377	9,6	25
Double Row Stamping Head								
35053	DKN-10HD-2-250	.650	16,5	0.965	24,5	.504	12,8	2 x 15
35061	DKN-15HD-2-250	.650	16,5	1.575	40,0	.504	12,8	2 x 50

Caution: Depending on the material, marking depth may deteriorate as more marking characters are used and / or larger character sizes are used because more marking force is required.

Steel Stamps

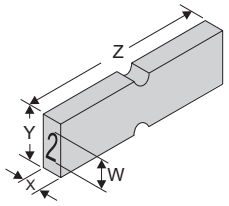
Notch for safety pin



- Every steel stamp gives a clear impression, perfect alignment and uniform depth
- Steel stamps maintain the non-wearing qualities of the special Sheffield steel
- Industry Standard (modified with **notch**)
- Wide Character Range
- Part numbers, logos, etc. can be marked with uniformity in one stroke
- Steel stamps may be purchased individually or as a complete set furnished with a case
- .062" (1.5 mm) to .250" (6mm) character height
- Special Stamping Heads such as logos and special patterns can be quoted

Standard Steel Stamps

- Sizes from 1/16" to 1/4"
- Letters (A-Z)
- Numbers (0-9)
- Blank (spacers)
- Symbols (&, /, -, ., and ,)



When ordering single steel stamps, add the steel stamp letter/number/symbol to the description.

example 1: .125" high character "**A**" would be **SS0300A**

example 2: .125" high symbol "**&**" would be **SS0300&**

example 3: .125" high word **"spacer"** would be **SS0300spacer**

Standard Steel Stamps

Description	W Character Height		X Character Width		Y Character Height		Z Character Length		Max. Capacity			
									Single Row		Double Row	
	in	mm	in	mm	in	mm	in	mm	DK-10	DK-15	DK-10	DK-15
*SS0150	.063	1,5	.063	1,6	.250	6,4	.875	22,2	15	25	2 x 15	2 x 25
*SS0250	.094	2,5	.094	2,4	.250	6,4	.875	22,2	10	16	2 x 10	2 x 16
*SS0300	.125	3	.126	3,2	.250	6,4	.875	22,2	7	12	2 x 7	2 x 12
*SS0500	.187	5	.189	4,8	.250	6,4	.875	22,2	5	8	2 x 5	2 x 8
*SS0600	.250	6	.250	6,4	.375	9,5	.750	19,1	-	6	-	-

*When ordering single steel stamps, add the steel stamp letter/number/symbol to the description that matches the size you need. See examples above.

Steel Stamp Set

Sets include
- Letters (A-Z)
- Numbers (0-9)
- Blank (spacers)
- Symbols (&, /, -, ., and ,)
- Storage Case

The steel stamp sets will create a variety of marking combinations!



Standard Steel Stamps

Description	UPC No. 733101-	Total Pieces in Set	W Character Height		Set Includes	
			in	mm	100 Characters Per Set	Spacers
SS0150	35092	112	.063	1,5	A A A B C C D D E E E E F F G G H H I I I J J K K L L L M M N N	12ea.
SS0250	35093	112	.094	2,5	N O O O P P Q R R R S S T T U U U V W W X X Y Z & / / . . , , -	12ea.
SS0300	35095	112	.125	3	- 1 1 1 1 2 2 2 2 3 3 3 4 4 4 4 5 5 5 6 6 6 7 7 7 8 8 8 9 9 9 0	12ea.
SS0500	35096	106	.187	5	0 0	6ea.
SS0600	35098	106	.250	6		6ea.

Quadra® Indexing Tool Post		
Description	Part No. 733101-	Page
Quadra® Indexing Tool Post		
QITP25N	00000	15
QITP30N	00002	15
QITP35N	00004	15
QITP40N	00006	15
QITP50N	00008	15
QITP60N	00010	15
Quadra® Indexing Toolholders		
Turning & Facing Toolholder		
QITP25N-1	00100	18
QITP30N-1	00250	18
QITP35N-1	00400	18
QITP40N-1	00550	18
QITP50N-1	00700	18
QITP60N-1	00850	18
Turning , Facing & Boring Toolholder		
QITP25N-2	00104	18
QITP30N-2	00254	18
QITP35N-2	00404	18
QITP40N-2	00554	18
QITP50N-2	00704	18
QITP60N-2	00854	18
Turning & Facing EXTENDED Toolholder		
QITP25N-3R	00106	18
QITP30N-3R	00256	18
QITP35N-3R	00406	18
QITP40N-3R	00556	18
QITP50N-3R	00706	18
QITP60N-3R	00856	18
Heavy Duty Boring Bar Toolholder		
QITP25N-4-CNC	00110	19
QITP25N-4M-CNC	00112	19
QITP30N-4-CNC	00260	19
QITP30N-4M-CNC	00262	19
QITP35N-4-CNC	00410	19
QITP35N-4M-CNC	00412	19
QITP40N-4-CNC	00560	19
QITP40N-4M-CNC	00562	19
QITP50N-4-CNC	00710	19
QITP50N-4M-CNC	00712	19
QITP60N-4-CNC	00860	19
QITP60N-4M-CNC	00862	19
EXTRA HD Boring Bar Toolholder		
QITP25N-41-CNC	00114	19
QITP25N-41M-CNC	00116	19
QITP30N-41-CNC	00264	19
QITP30N-41M-CNC	00266	19
QITP35N-41-CNC	00414	19
QITP35N-41M-CNC	00416	19
QITP40N-41-CNC	00564	19
QITP40N-41M-CNC	00566	19
QITP50N-41-CNC	00714	19
QITP50N-41M-CNC	00716	19
QITP60N-41-CNC	00864	19
QITP60N-41M-CNC	00866	19
SUPER Oversized Boring Bar Toolholder		
QITP35N-41-150-CNC	00418	19
QITP35N-41M-40-CNC	00420	19
QITP40N-41-200-CNC	00568	19
QITP40N-41M-50-CNC	00570	19
QITP50N-41-250-CNC	00718	19
QITP50N-41M-60-CNC	00720	19
QITP60N-41-300-CNC	00868	19
QITP60N-41M-80-CNC	00870	19
EXTRA HD Boring Bar Toolholder		
QITP35N-41-COL	00456	20
QITP40N-41-COL	00604	20
QITP50N-41-COL	00746	20
QITP60N-41-COL	00896	20
SUPER Oversized Boring Bar Toolholder		
QITP35N-41-150-COL	00458	20
QITP40N-41-200-COL	00606	20
QITP50N-41-250-COL	00748	20
QITP60N-41-300-COL	00898	20

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QITP25N-5-2	00122	20
QITP30N-5-3	00272	20
QITP35N-5-4	00424	20
QITP40N-5-4	00572	20
QITP50N-5-5	00722	20
QITP60N-5-5	00872	20
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QITP25N-7-71C	00126	21
QITP30N-7-71C	00276	21
QITP35N-7-71C	00428	21
QITP40N-7-71C	00576	21
QITP50N-7-71C	00726	21
QITP60N-7-71C	00876	21
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QITP30N-71-26	00278	21
QITP35N-71-32	00430	21
QITP40N-71-32	00578	21
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QITP25N-881-OE	00132	23
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QITP30N-881-OE	00282	23
QITP30N-881-LD	00283	23
QITP35N-881-OE	00434	23
QITP35N-881-LD	00435	23
QITP40N-881-OE	00582	23
QITP40N-881-LD	00583	23
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QITP25N-10	00134	24
QITP30N-10	00284	24
QITP35N-10	00436	24
QITP40N-10	00584	24
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QITP25N-35	00140	24
QITP30N-35	00290	24
QITP35N-35	00442	24
QITP40N-35	00590	24
5C Collet Toolholder		
QITP25N-36	00142	25
QITP30N-36	00292	25
QITP35N-36	00444	25
QITP40N-36	00592	25
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QITP30N-FTB	00058	25
QITP35N-FTB	00060	25
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QITP35N-TS	00016	26
QITP40N-TS	00017	26
QITP50N-TS	00018	26
QITP60N-TS	00019	26
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QITP25N-INSS	00020	26
QITP30N-INSS	00021	26
QITP35N-INSS	00022	26
QITP40N-INSS	00023	26
QITP50N-INSS	00024	26
QITP60N-INSS	00025	26

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SDN35CXA	01004	32
SDN40CA	01006	32
SDN50DA	01008	32
SDN60EA	01010	32

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Turning & Facing Toolholder		
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D25AXA-1MS	01101	33
D30BXA-1	01250	33
D30BXA-1MS	01251	33
D35CXA-1	01400	33
D35CXA-1MS	01401	33
D40CA-1	01550	33
D40CA-1MS	01551	33
D50DA-1	01700	33
D50DA-1MS	01701	33
D60EA-1	01850	33
D60EA-1MS	01851	33
Turning , Facing & Boring Toolholder		
D25AXA-2	01104	33
D25AXA-2MS	01105	33
D30BXA-2	01254	33
D30BXA-2MS	01255	33
D35CXA-2	01404	33
D35CXA-2MS	01405	33
D40CA-2	01554	33
D40CA-2MS	01555	33
D50DA-2	01704	33
D50DA-2MS	01705	33
D60EA-2	01854	33
D60EA-2MS	01855	33
Heavy Duty Boring Bar Toolholder		
D25AXA-4-CNC	01110	33
D25AXA-4M-CNC	01112	33
D30BXA-4-CNC	01260	33
D30BXA-4M-CNC	01262	33
D35CXA-4-CNC	01410	33
D35CXA-4M-CNC	01412	33
D40CA-4-CNC	01560	33
D40CA-4M-CNC	01562	33
D50DA-4-CNC	01710	33
D50DA-4M-CNC	01712	33
D60EA-4-CNC	01860	33
D60EA-4M-CNC	01862	33
EXTRA HD Boring Bar Toolholder		
D25AXA-41-CNC	01114	34
D25AXA-41M-CNC	01116	34
D30BXA-41-CNC	01264	34
D30BXA-41M-CNC	01266	34
D35CXA-41-CNC	01414	34
D35CXA-41M-CNC	01416	34
D40CA-41-CNC	01564	34
D40CA-41M-CNC	01566	34
D50DA-41-CNC	01714	34
D50DA-41M-CNC	01716	34
D60EA-41-CNC	01864	34
D60EA-41M-CNC	01866	34
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D35CXA-41-150-CNC	01418	34
D35CXA-41M-40-CNC	01420	34
D40CA-41-200-CNC	01568	34
D40CA-41M-50-CNC	01570	34
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D50DA-41M-60-CNC	01720	34
D60EA-41-300-CNC	01868	34
D60EA-41M-80-CNC	01870	34
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D40CA-41-COL	01608	34
D50DA-41-COL	01752	34
D60EA -41-COL	01896	34
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D50DA-41-250-COL	01754	35
D60EA-41-300-COL	01898	35
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D30BXA-5-3	01272	35
D35CXA-5-4	01424	35
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D50DA-5-5	01722	35
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D50DA-7-71C	01726	35
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D30BXA-71-26	01278	35
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D30BXA-881-OE	01282	37
D30BXA-881-LD	01283	37
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D35CXA-881-LD	01435	37
D40CA-881-OE	01582	37
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D30BXA-10	01284	38
D35CXA-10	01436	38
D40CA-10	01584	38
Drill Chuck Toolholder		
D25AXA-35	01140	38
D30BXA-35	01290	38
D35CXA-35	01442	38
D40CA-35	01590	38
5C Collet Toolholder		
D25AXA-36	01142	39
D30BXA-36	01292	39
D35CXA-36	01444	39
D40CA-36	01592	39
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SDN30BXA-FTB	01058	39
SDN35CXA-FTB	01060	39
SDN40CA-FTB	01062	39
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SDN30BXA-TS	01015	40
SDN35CXA-TS	01016	40
SDN40CA-TS	01017	40
SDN50DA-TS	01018	40
SDN60EA-TS	01019	40
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V35tc-1	04250	50
V40tc-1	04270	50
V50tc-1	04290	50
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D35-41BM	03765	84
D40-41BM	03767	84
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D25-41SBM	03775	84
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LBF150-0625	93225	85
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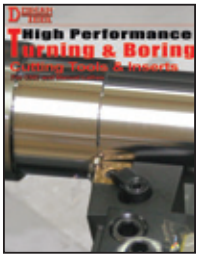
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Catalog	Quantity	Catalog	Quantity
Tool Guide for Everyday Machining ***Vol.No 3*** **Our most current Volume will be sent to you. Products offered per volume may vary depending on demand and featured items.** Inside this Tool Guide You will find High Performance cutting tools, inserts and machine tool accessories for every day machining. Additionally this catalog will give you an excellent overview of our complete line of tooling. 		**NEW 2011 Jet-Stream Thru Coolant System** ***Vol.No 3*** Dorian Tool's Jet-Stream™ Thru Coolant Cutting Tools use a patented thru-coolant locking clamp which is precisely aimed to direct high pressure, high velocity coolant exactly onto the cutting edge of the carbide insert, from a short distance of ¼"(6mm). This catalog offers a vass range Jet-Stream™ Thru Coolant Cutting Tools for Turning, Boring and Threading applications. 	
NEW 2011 Turning & Boring Cutting Tools & Inserts Dorian Tool offers a complete selection of indexable cutting tools. Our wide variety of Turning, Boring tools and inserts provide solutions for all your Turning, Facing, Boring, Chamfering, I.D. & O.D. Profiling, Chuck Work and Between Center Work Machining Operations. ***For Milling, Cut-off and Drilling Indexable Tools see our 2003 Indexable catalog online.*** 		**NEW 2011 Threading, Grooving & API Cutting Tools & Inserts** Dorian Tool offers a complete selection of indexable cutting tools. Our wide variety of Turning, Boring, threading tools and inserts provide solutions for all your Turning, Facing, Boring, Chamfering, I.D. & O.D. Profiling, Chuck Work and Between Center Work Machining Operations. 	
2008 CNC Adjustable Angle Heads Choose from two styles (Universal and 90°) and six models for any milling, drilling, tapping and face milling operations. The Universal CNC Adjustable Angle Heads have two positioning axes and are offered in ER25 and ER32 collet toolholding systems. The use of the Universal CNC Adjustable Angle Heads increases productivity and quality by eliminating secondary operations and the need for more expensive 4th & 5th axis rotary tables. The 90° CNC Adjustable Angle Heads have one positioning axis and are offered in ER16, ER25 and ER32 collet toolholding systems as well as CAT/ISO/BT 40 taper toolholding system. 		**2007 knurling Tools & Wheels** Dorian Tool offers a wide range of knurling tools to cover most knurling applications. Since the introduction of Dorian's modular knurling tool system, knurling has never been easier. The knurl tools range from cutting to forming a knurling pattern. The cutting style knurl tools have revolutionized knurling. It is faster and requires less pressure to create a knurl over forming. A wide range of knurl wheel pitches are also available. 	
2006 Perfetta **Live Centers & Bull Nose** These live centers, which have already been recognized throughout the rest of the industrial world as the most precise live centers ever built, are now available to the American machine tool industry. Designed for turning on a CNC lathe or for use on a CNC grinding machine, the Perfetta™ Live Center has over 50 years of proven workmanship. Where speed, precision and dependability are the requirements, these tools guarantee quality and performance. 		**NEW Lathe Accessories Catalog** With a full line of Victory Automatic Thru Coolant, Super Quick Change and Quadra™ Indexing Quick Change tool posts and holders as well as manual, electro-pneumatic, and electro-mechanical turrets, Dorian Tool has all that is needed to improve efficiency on both manual and CNC lathes. In addition, the Dorian Tru-Jaws system makes for easy remachining of soft jaws. **This catalog replaces all three Dorian Tool post catalogs as well as the 2005 MTA (Machine Tool Accessories) catalog.** 	
Swiss Screw Machine **Tools and Advanced Technology Catalog** Featuring Jet-Stream™ Thru Coolant System for Turning, Threading and Cut-off Toolholders. Designed for Swiss Screw Machines. This catalog will be available in a U.S.A. and European Version. 	**COMING SOON in 2011/2012**	**Indexable Turning Grooving And Parting-Off** Toolholders Catalog **For CNC and Manual Lathes** Featuring Jet-Stream™ Thru Coolant System, multi-application tools, modular face grooving system, and high performance inserts. 	**COMING SOON in 2011/2012**

Sales Policy

Conditions of Sale: All sales are made in accordance with our standard conditions of sale, current at the time orders are accepted. Specifications and prices are subject to change without notice.

Terms of Payment: Standard payment terms for all products is (1% 10 Net 30 days) upon credit approval. Dorian reserves the right to hold shipments or to ship on a C.O.D. basis, any orders received from any purchaser whose account is delinquent. Invoices not paid timely are subject to 1.5% interest per month, not to exceed 18%. However, purchasers who default on terms agreed upon, Dorian reserves the right to add collection and/or attorney fees to the total amount of the invoice or total amount of all invoices. No order will be processed if any invoices are over 45 days old. All taxes, duties, or other expenses arising out of, or in connection with the sale of product shall be the sole liability of purchaser.

No Minimum Order: There will be a $5.00 handling fee for orders drop shipped with a value under $50.00 net.

Delivery Terms: F.O.B. East Bernard, Texas. All shipments are made by regular UPS, Parcel Post, or truck. Full transportation costs will be charged to the buyer. Specify shipment to be made by other than regular means of transportation.

Defective Product Claim: If within 30 days from shipping date, customer claims that product is defective and requires an immediate replacement, a distributor can issue a purchase order for a new product and return the defective product to Dorian for inspection. Upon inspection, if the product is found to be defective a credit will be issued for the replacement. If the product is not found to be defective, an invoice will be issued for the replacement. Freight to and from Dorian will be at the customer's expense.

Claims: Any claim discrepancies in shipments are to be made within 7 days of receipt of merchandise. Any in transit claim for damaged and lost goods must be made against the transportation company only. The foregoing shall constitute the sole and exclusive remedies of the customer and are in lieu of all other warranties, expressed, implied, or statutory, including but not limited to any implied warranty of merchantablity or fitness.

Satisfaction Guaranteed: If you are not fully satisfied with a Dorian product, simply return it within 30 days of shipping date and you will receive full CREDIT if the merchandise is received in resalable condition.

Product Limited Warranty: Dorian extends to the purchaser for resale, use in their own business, or original equipment manufacturing, a limited warranty, that products made by DORIAN will be free from any defects in material and workmanship for one year after the date of purchase when used under normal intended applications. No other guarantee is made by this policy, nor does it apply to any product which has been altered, misused, or used in applications other than its normal intended use. Request for a Return Goods Authorization (RGA) number from Dorian and return freight pre-paid to Dorian any part or product which is determined by Dorian to be defective in material or workmanship will be repaired or replaced at Dorian's option.

Special Product Quotations: All special product quotations are valid for thirty days from the date of quotation unless otherwise specified. Orders for special products must be confirmed in writing before manufacturing can begin, along with payment for 50% of the quoted price, with the remaining 50% to be paid upon delivery of the special products. Special products and non-stock standard products cannot be canceled or returned for exchange or credit.

Cancellations: Customer may not cancel or modify any purchase order once a purchase order has been expressly accepted by Dorian, unless (a) customer has given Dorian reasonable notice to stop work, (b) customer pays for all work -in-progress and any raw materials or supplies used or consumed by Dorian in connection with the order, at the time work is stopped (or for which commitments have been made by Dorian at such time) in connection with the order (c) customer pays all costs and expenses otherwise incurred by Dorian in connection with the order, and (d) customer pays a cancellation charge of fifteen percent (15%) of the initial quoted price.

Returns: Return undamaged product within 30 days of the ship date, if the merchandise is received in resalable condition you will receive full CREDIT on your account,.- Product(s) returned after 30 days but prior to 90 days after the ship date is subject to a 20% restocking fee.- Unless otherwise specified, no material will be accepted for returned after 90 days of the ship date.- If the Distributor or End User, within 30 days of the ship date, claims a product is defective and needs immediate replacement, the customer must place a new order, and a RMA number will be issued for the defective product. The Distributor will be advised upon completion of inspection if credit will be issued.- Any product returned for repair, under warranty or warranty expired, will not be accepted without a RMA number.- Customer will be advised of any charges before repairs are made.- All returns must be authorized by Dorian Tool with a official RMA number.- Dorian Tool does not constitute acceptance of the product when a RMA number is issued.- The RMA number must be visible on the outside of the box and a copy of the RMA form must be placed inside the original box along with the returned product.- Any package received without an official RMA number visible on the outside of the box will be refused and returned to the sender at their expense.- The customer is responsible for the freight to and from Dorian Tool.- NO PRODUCT WILL BE ACCEPTED FOR RETURN WHEN RECEIVED IN NON-RESALABLE CONDITION. This includes, but is not limited to: damaged packages, non Dorian labels and marking, missing parts, cosmetic damages, used and/or obsolete product(s).- Quality Control must inspect and accept product before credit will be issued.- RMAs are processed daily by RMA Service Center at X 260.- RMA numbers are valid for 30 days from the date is issued. All product(s) requested for return must be received by Dorian Tool within 30 days of the RMA date.- In the event the RMA is denied, the customer has 30 days from the date of notification to respond with shipping instructions for their product. If shipping instructions are not provided by the customer within 30 days from the RMA denial notification, the product will be disposed at the customers expense.- By writing the RMA number on the outside of the box and shipping product to Dorian against this number constitutes acceptance of Dorian's terms and conditions.

Conditions, terms and specifications are subject to change without notice.
Any typographical error in any printing matter is subject to correction.


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