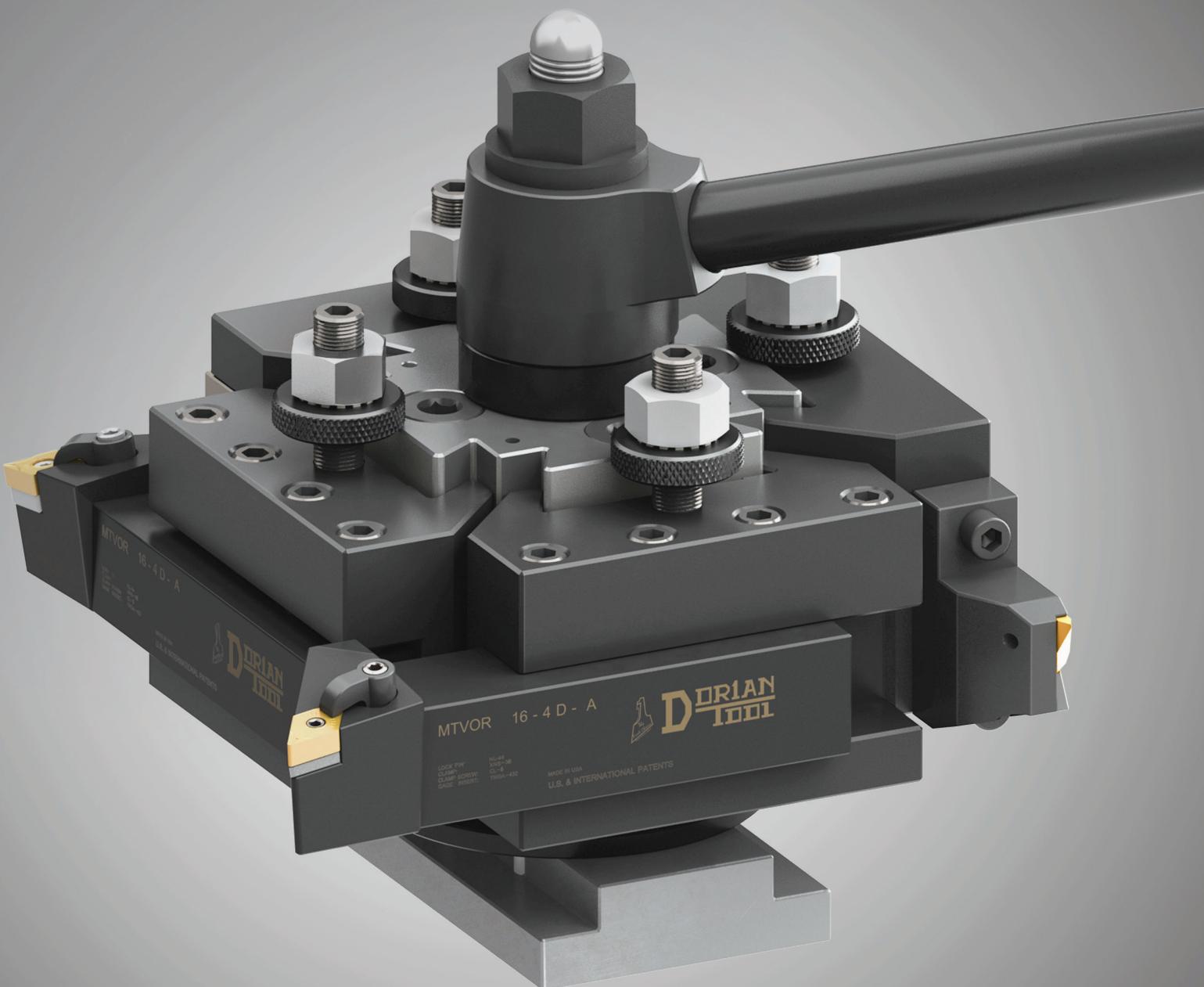




# Tool Post & Tool Holders



**TECHNOLOGY,  
QUALITY &  
PERFORMANCE**

# Quadra® Indexing Quick Change Tool Post



## Features

- Built With High Strength Alloy Steel
- Multi Heat Treat Process
- 4 Quick Change Toolholders
- Indexing Flexibility every 15°
- Multi Directional Indexability
- 24 Locking Position
- Anti Rotation Pins

## Performance

- Simple, Easy to Use & Operate
- Quick, Precise, Rigid & Heavy Duty
- From Prototypes to High Production Application
- Super Precise for Finishing Operation
- Heavy Duty for Roughing Operation

## QITP Tool Post and Toolholders Reference

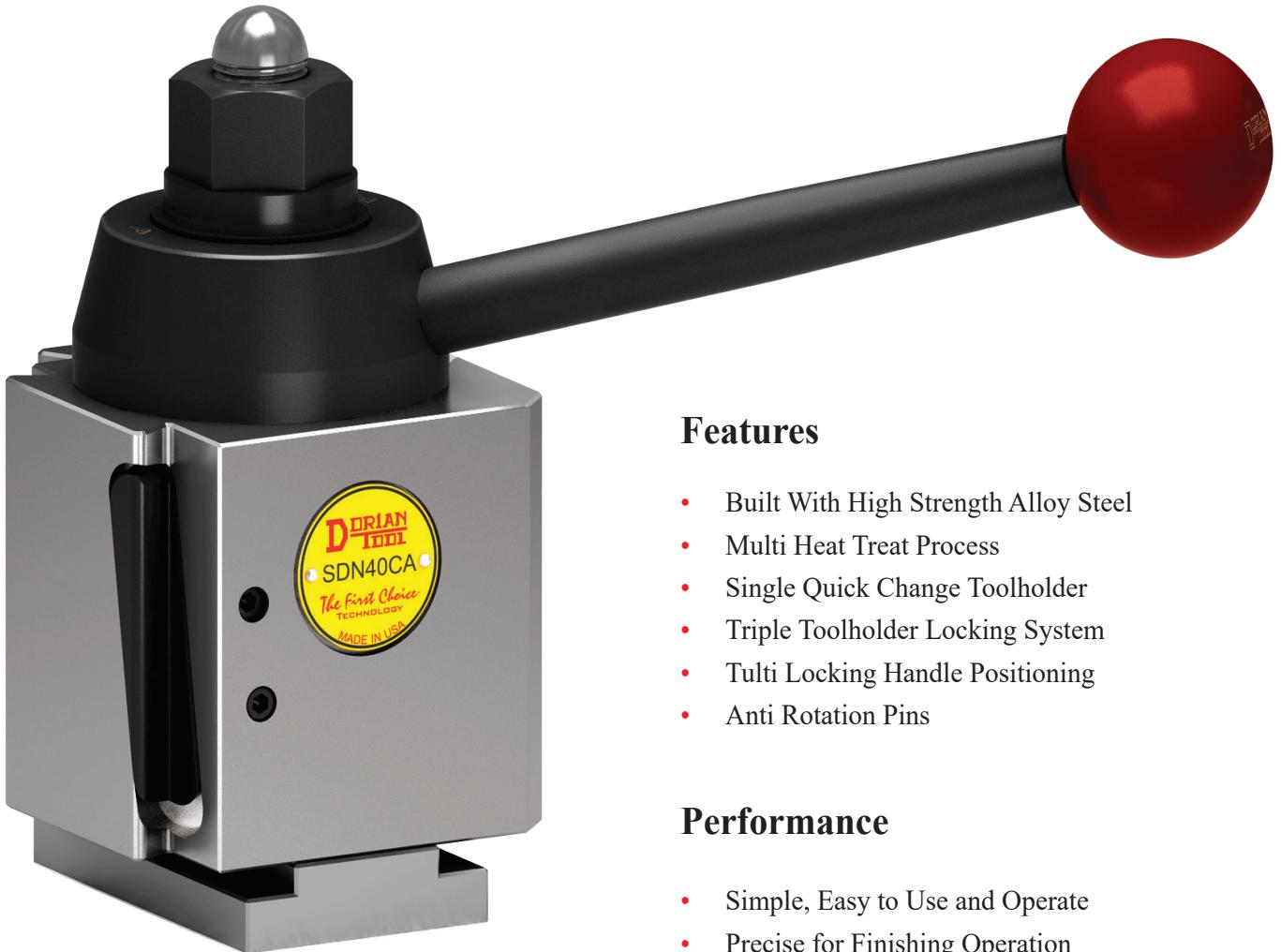
Technical Support see pages:

6 to 17

Tool Post & Toolholders Ordering Information see pages:

18 to 31

# Super Quick Change Tool Post



## Features

- Built With High Strength Alloy Steel
- Multi Heat Treat Process
- Single Quick Change Toolholder
- Triple Toolholder Locking System
- Tulti Locking Handle Positioning
- Anti Rotation Pins

## Performance

- Simple, Easy to Use and Operate
- Precise for Finishing Operation
- Extra Heavy Duty Roughing Operation
- Toolholders Repetibility  $\pm .0001"$  / .00254mm

### SDN Tool Post and Toolholders Reference

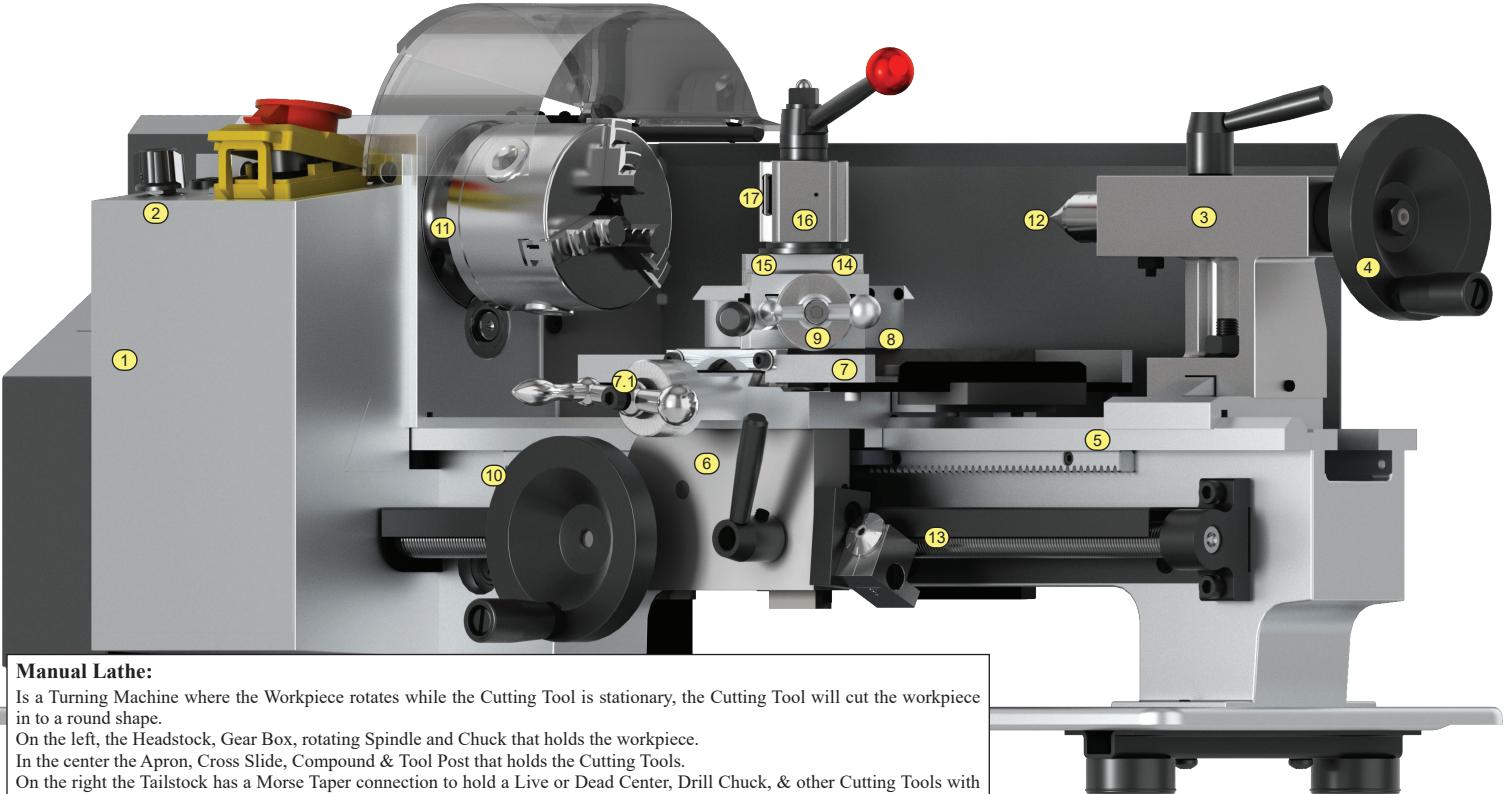
Technical Support see pages:

4 to 5 & 33 to 44

Tool Post & Holders Ordering Information see pages:

45 to 59

# Terminology of a Manual Lathe



## Manual Lathe:

Is a Turning Machine where the Workpiece rotates while the Cutting Tool is stationary, the Cutting Tool will cut the workpiece in to a round shape.  
On the left, the Headstock, Gear Box, rotating Spindle and Chuck that holds the workpiece.  
In the center the Apron, Cross Slide, Compound & Tool Post that holds the Cutting Tools.  
On the right the Tailstock has a Morse Taper connection to hold a Live or Dead Center, Drill Chuck, & other Cutting Tools with Morse Taper Shank.

1. Headstock  
Is the Part of the Manual Lathe, that holds the Gear Box system that controls the speed and cutting feed of the lathe, the Rotating Spindle that holds the Chuck where the Workpiece is held.
2. Speed & Feed Adjustment  
Controls that allow the user to adjust the speed and feed of the lathe.
3. Tailstock  
on the right the Tailstock slides over the Bedway of the lathe, and has a Morse Taper connection to hold a Live or Dead Center to support long workpieces, and or Drill Chuck, & other Cutting Tools with Morse Taper Shank
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. Apron  
In the center the Apron, from where the operator controls all the machining functions of the lathe. Cross Slide built on top of the Apron, controls the cutting depth on the workpiece. The Compound attached over the cross slide, swings and locks in both directions, allows manually to cut short angles, taper & special operation. The Tool Post a single or multi tool holder, mounts over the compound, holds the Square Cutting Tools as well Rounds Tool for drilling & Boring and I.D. Threading.
7. Cross-Slide  
The part of the lathe that moves across the bed. It also holds the compound where the tool holding device is mounted.
- 7.1. Cross-Slide Dial  
This dial moves the cross slide in the "X" axis (toward and away from the operator).
8. Compound  
The part of a lathe set on the carriage that carries the tool post and holder. It is designed to swing in any direction and to provide feed for turning short angles or tapers.
9. Compound Dial  
This dial moves the compound toward and away from the handle itself.
10. Cross Feed Handle  
This handle moves the cross slide and compound in the "Z" axis (towards and away from the chuck).
11. Chuck  
A device on a lathe to hold the workpiece.
12. Dead or Live Center  
A tool that is inserted into the tailstock to support long workpieces where the cutting force would deflect the part excessively.
13. Lead Screw  
The long, precision screw located in front of the lathe bed, geared to the spindle and used for cutting threads.
14. T-Slot  
Inverted T-shaped slot on the compound of a lathe. Used for securing a toolpost onto the compound.
15. T-Nut  
A T-shaped nut that is slid into the T-Slot of the compound. It is used to secure a tool holding device to the compound.
16. Quick Change Tool Post  
A device for holding tooling on the compound of a lathe. It can be as simple as a fixed system for holding one tool or as complex as an indexing quick change system.
17. Quick Change Holder  
A device to hold a cutting tool on a lathe that uses a system to allow for quick changing of tooling from one operation to the next. It is generally applied by using a dovetail slot that is slid over a male dovetail on a toolpost.
18. Center Height  
The distance from the centerline of the chuck to the top of the compound.
19. Lathe Swing  
The dimension of a lathe determined by the maximum diameter of the workpiece that can be rotated over the ways of the bed.
20. Shank System  
The diameter of a round cutting tool or the height of a square shank cutting tool.

# Terminology of a CNC Tool Room Lathe

## CNC Tool Room Lathe:

Is a Turning Machine where the Workpiece rotates while the Cutting Tool is stationary, the Cutting Tool will cut the workpiece in to a round shape.

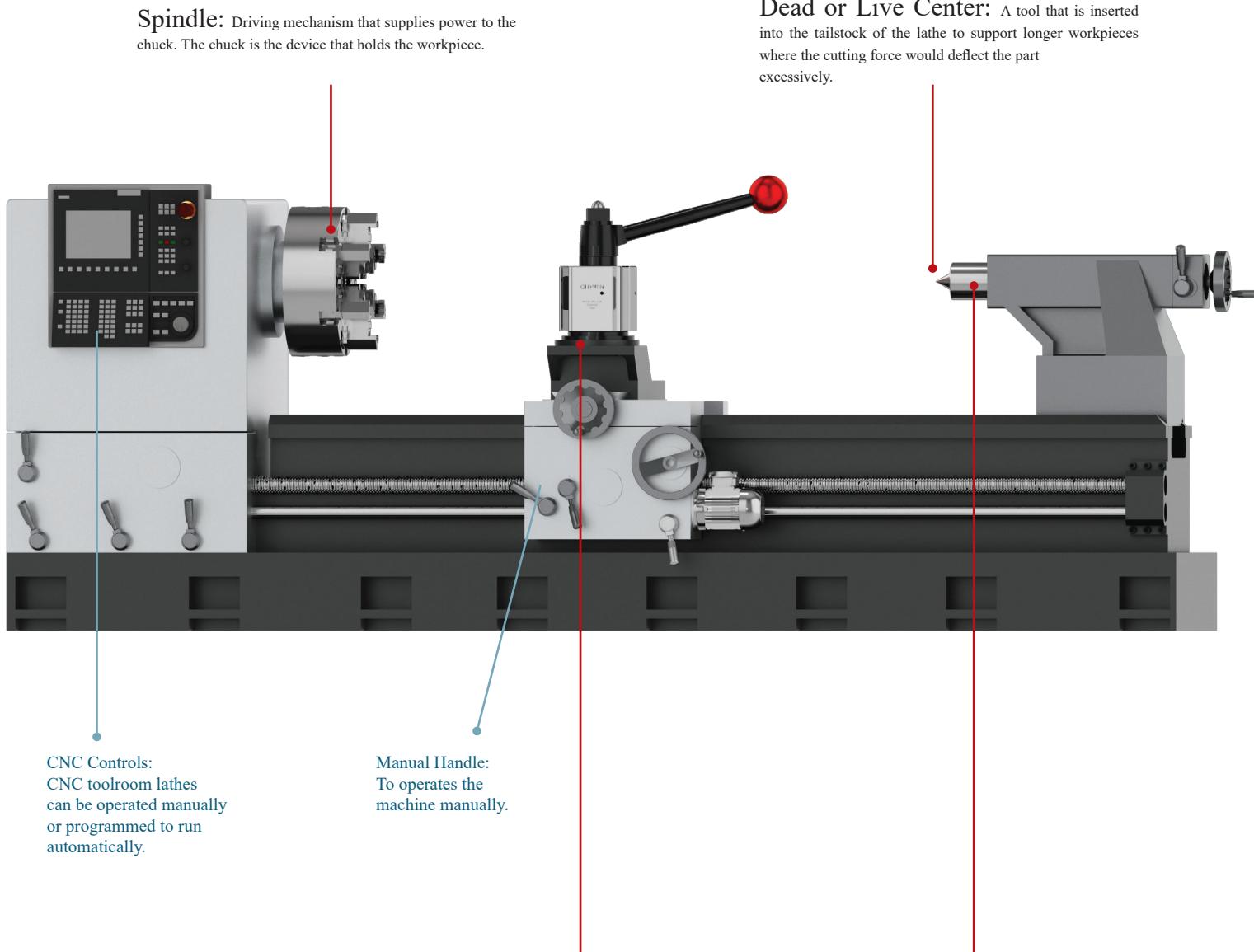
The lathe can be operated with the CNC Control as well in manual mode.

On the left, is the Headstock, Driving Motor, Rotating Spindle and the Chuck that holds the workpiece.

In the center the Apron and Tool Post that holds the Cutting Tools.

On the right the Tailstock has a Morse Taper connection to hold a Live or Dead Center.

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



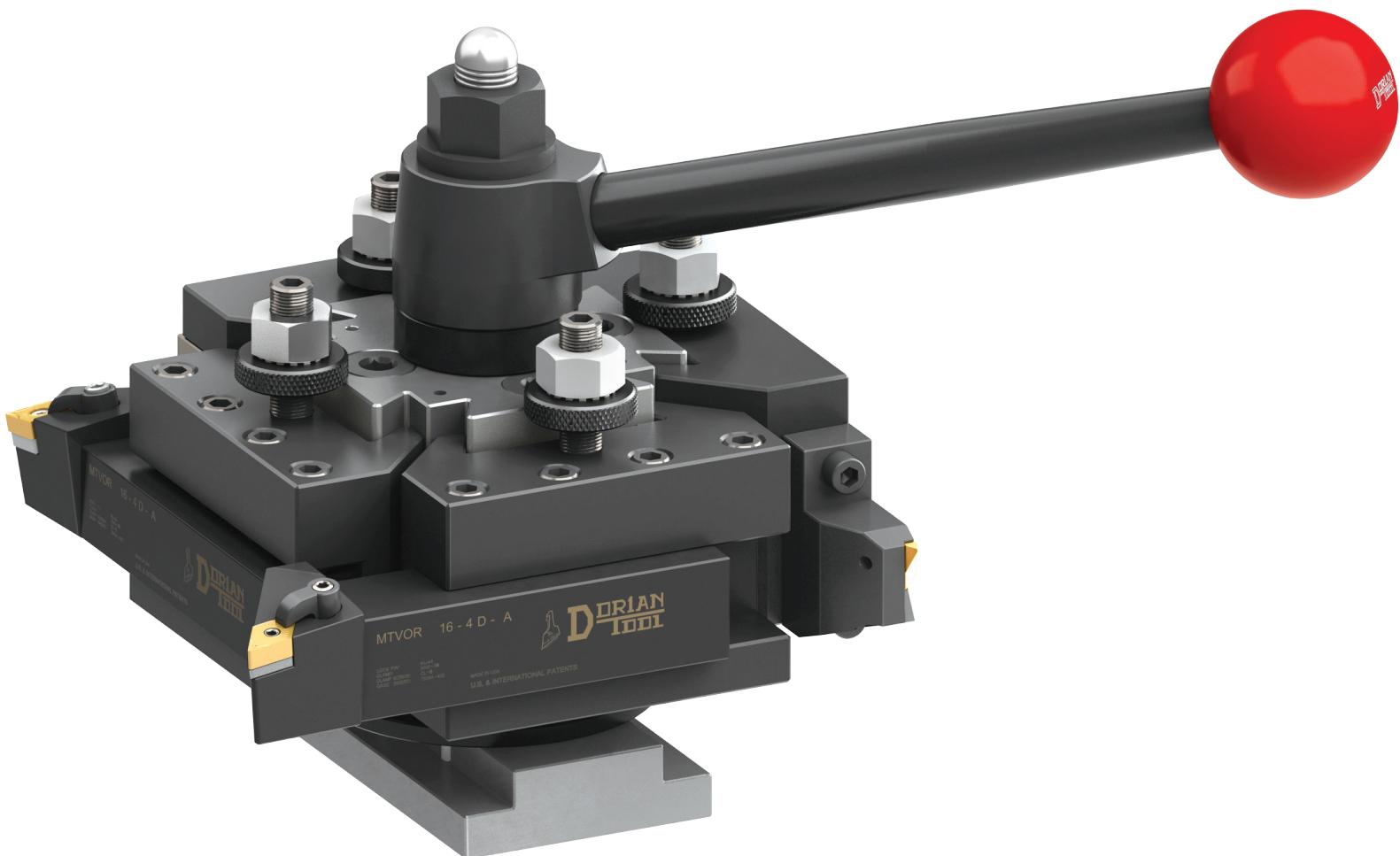
Quadra® Tool Post and Toolholders

# Quadra® Indexing Quick Change Tool Post & Toolholders

*QITP with 4 Toolholders*

*&*

*24 Positions Indexability*



*Performance is not an Option!*

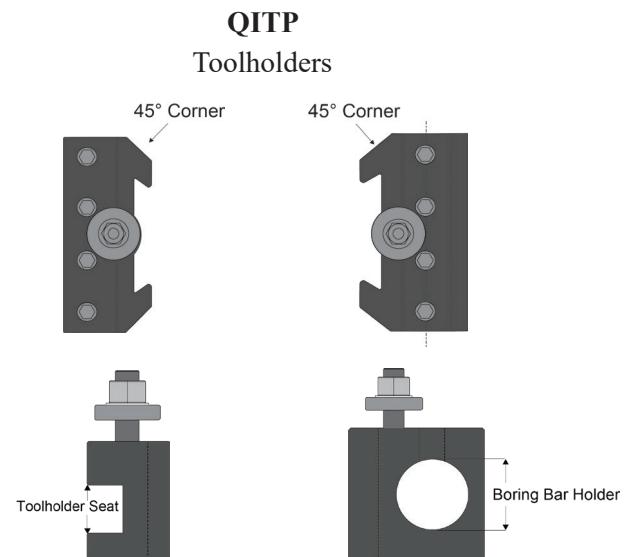
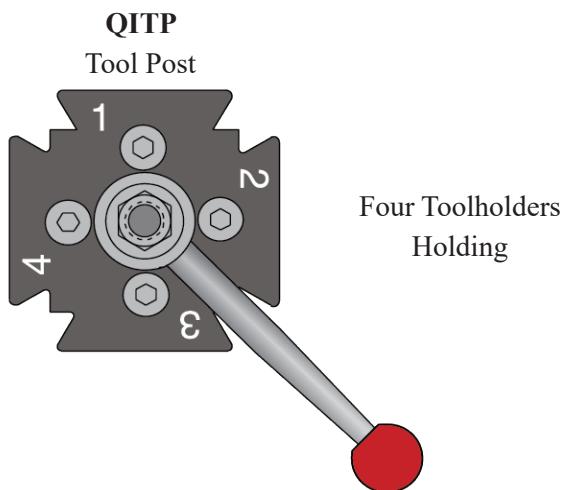
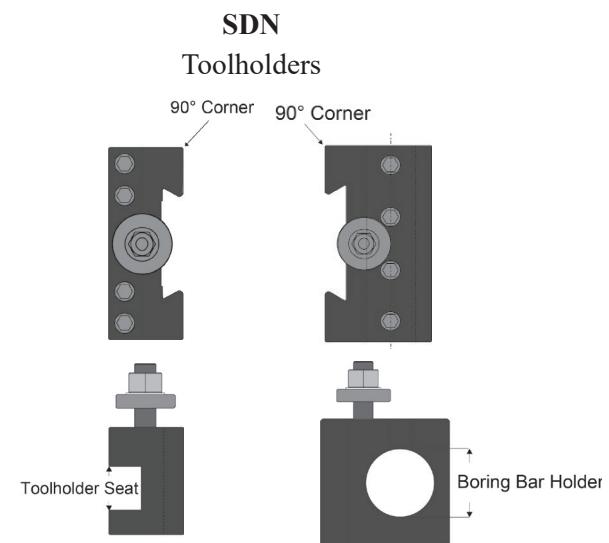
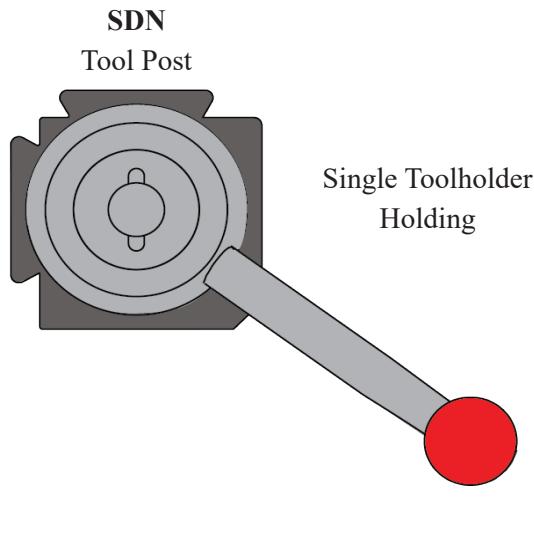
# Quadra® Tool Post and Toolholders Sizes & Crossover

All the Quadra and SDN Quick Change Toolholders, are built with 4140 Chromium-Molybdenum High Strength Alloy Steel, for Rigidity, Stability & Performance.

The Toolholders, are treated with a Special Low Temperature Heat Treading Process, to Protect the Toolholders Surface, while reducing to the minimum Cutting Vibration.

The Toolholders, Number 1 & 2, as Standard, are built larger than the industry's standard, to hold a wider range of oversize Cutting Tools

All the Quadra & SDN Boring Bar Holders, Features a DUAL Locking System for Maximum Rigidity, Stability & Performance in the Roughing Operation, and High Surface Finishing & Close Tolerances for finishing Operation



| SDN & QITP Crossover |          | Tool Post Size Nominal Dimension |        | Toolholder Capacity |         | Boring Toolholder |
|----------------------|----------|----------------------------------|--------|---------------------|---------|-------------------|
| Super Quick™ Change  | Quadra ® | Inch                             | mm     | Inch                | mm      |                   |
| SDN25AXA             | QITP25N  | 2.500                            | 63.5   | 1/2 - 3/4           | 12 - 20 |                   |
| SDN30BXA             | QITP30N  | 3.000                            | 76.2   | 5/8 - 1.0           | 16 - 25 |                   |
| SDN35CXA             | QITP35N  | 3.500                            | 88.9   | 3/4 - 1.0           | 20 - 25 |                   |
| SDN40CA              | QITP40N  | 4.000                            | 101.60 | 1.0 - 1 1/4         | 25 - 32 |                   |
| SDN50DA              | QITP50N  | 5.000                            | 127.0  | 1 1/4 - 1 1/2       | 32 - 40 |                   |
| SDN60EA              | QITP60N  | 6.000                            | 152.4  | 1 1/2               | 40.0    |                   |

See Boring Bar Holders

# Quadra® Tool Post Indexing System & Multi Operation Set-Up

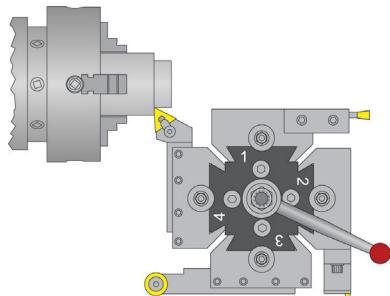
## The Multi-Patented Tool Post with The Most Advanced Indexing and Locking Technology

2 Pre-Loaded Positioning Index Pins

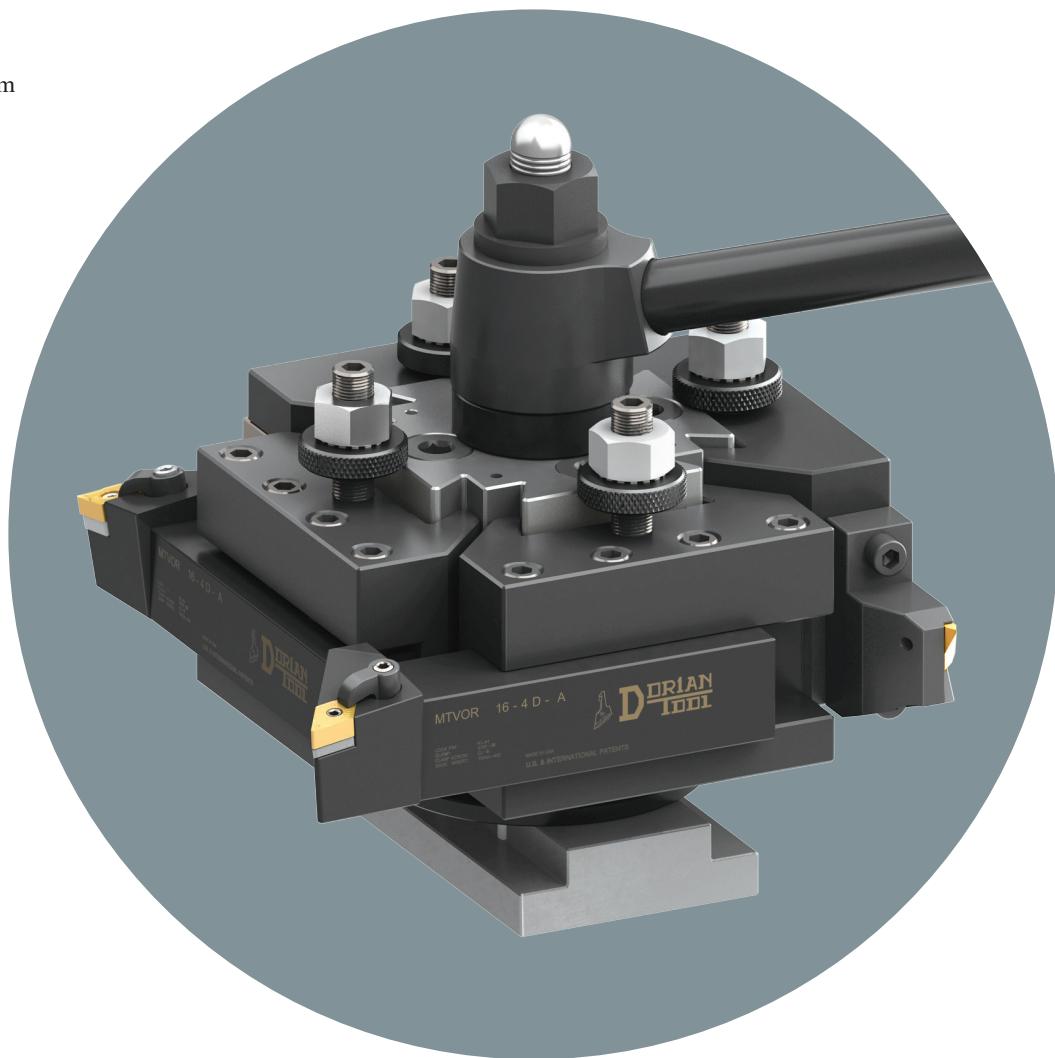
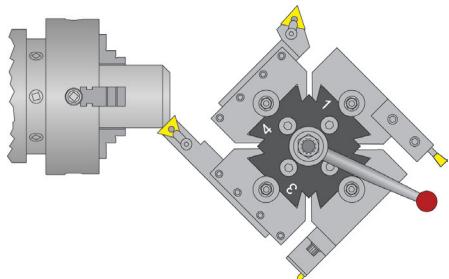
24 Super Precise Ball Bearing Locking System

Strong - Rigid - Precise!

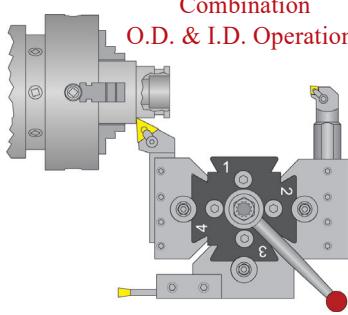
### O.D. Turning Operations



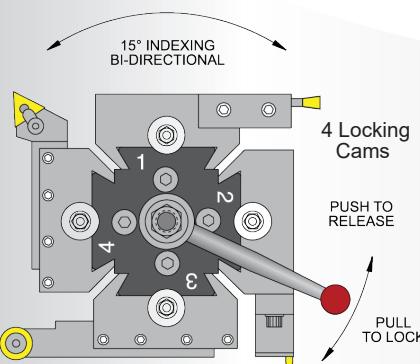
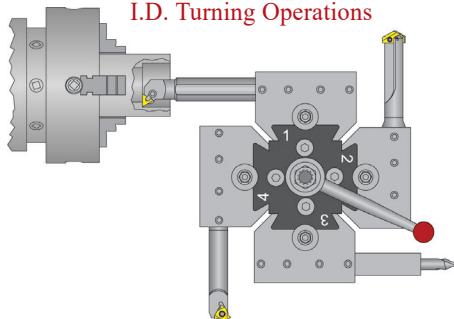
### O.D. Chamfering Operations 15° Increments



### 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.

# Quadra® Tool Post and Toolholders Turning Application

## Features

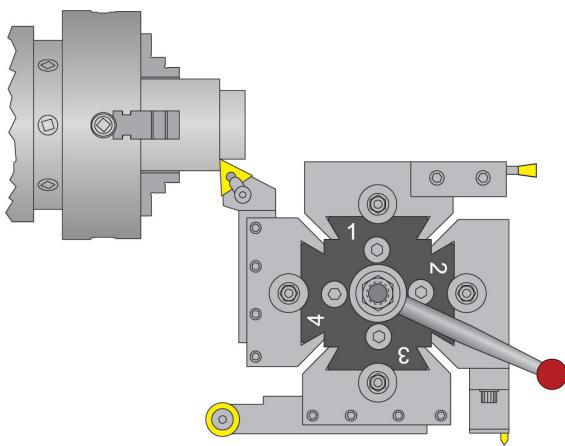
Heavy Duty Construction  
Heat Treated High Strength Alloy Steel  
Precision Ground Toolholder Locking Stations  
"T Nut" Mounting System with Anti Rotatin Pin  
Custom "T Nut" Available  
Ready to Install and Use  
Highest Locking Forces for Regidity & Accuracy

Positive Locking Systems, with Obsolete Zero Backlash  
24 Super Pricise Ball Bearing Locking System  
4 Quick Change Toolholders locked Indipendebility  
Wide range of Toolholders avaible  
Heavy Duty Toolholders for Larger Cutting Tool Capacity

1 to 4 Toolholders Ready to Use  
Instant Toolholder Repositioning  
Precise Toolholder Repeatability of .0001"/.00254mm  
Indexing Flexibility of every 15°  
Indexing Repetability of .00005"/.00127

## O.D. Turning Operations

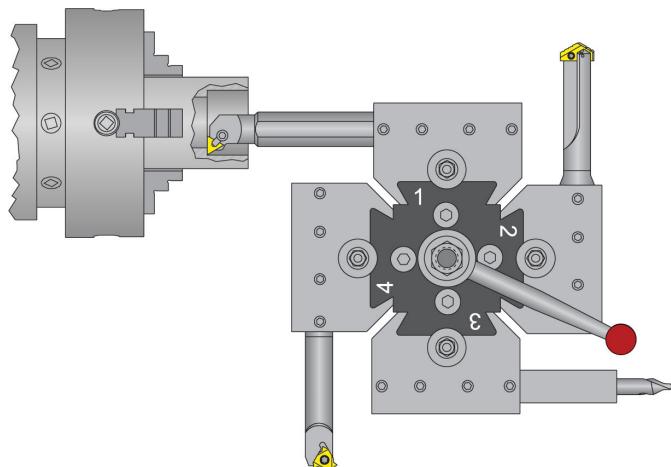
### Finishing to Roughing or Threading



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

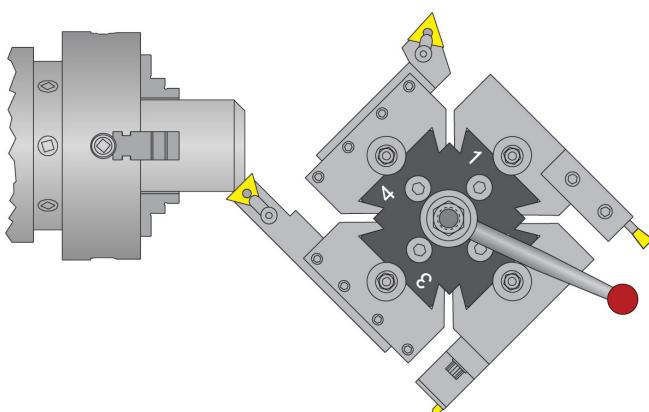
### Finishing to Roughing or Threading



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

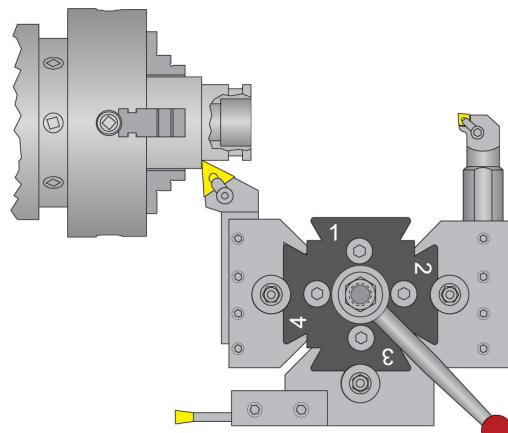
### 15° Increments



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.

# Quadra® Tool Post Cross Section

**The Holding post and Flange Nut;**  
Secures the Tool Post on the lathe

## Index Post;

Is a precision ground and threaded shaft, that makes the epicenter of all the mechanical functions of the Quadra Indexing Tool Post, dictating the precise repeatability, performance and rigidity of the Tool Post

## QITP Tool Post Body;

Is built with AISI 4140 Alloy Steel, a Chromium Molybdenum, Manganese, known for its Toughness, High Fatigue & Torsional Strength. The material is throughout Heat Treated and Stress Relieved. To Increase wear and fatigue resistance of the Tool Post working surface, a Plasma Nitriding process is applied to the Tool Post before grinding, making its life almost endless under any working condition

## Tool Post Holders Station:

- 4 Super Precision Dovetail Holding Stations
- From 1 to 4 Toolholders locked independently

## The Tool Post;

is equipped with six O-Ring seals, to protect most of the coolant, chips, and debris from getting inside the Tool Post.

## Pre-loaded indexing pins;

locates the preset positioning of the Tool Post.

## The Large Base Plate;

Holds the Tool Post in a fixed and precise position, providing a mounting surface with rigidity, stability and the precise repeatability of the Tool Post.

## Tool Post;

Is provided with a T-nut for American mounting style or with a bolt shaft for European mounting style.

**The Indexing Locking Handle;**  
engages and disengages the Locking System of the Tool Post.

## Locking Nut;

Is threaded in to the index post, and locks the Tool Post down once it is to a specific position, and releases it before is indexed to the next position.

**The Eccentric Toolholder Locking Cam;**  
exercises over 20,000 lbs of positive locking force on the sliding gib with absolute zero backlash.

**Patented quick change holder Locking System;**  
The quick change toolholder 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 toolholder against the precision ground dovetail of the Tool Post within .0001" of repeatability.

## Disengaging springs;

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

## Patented Indexing System;

24 indexing positions  
15° increments  
Reindexing Repeatability within .00005" / .00127 mm

## Indexing System Performance;

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

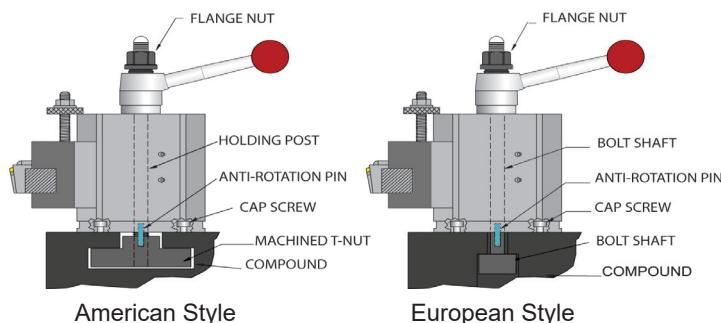
## Anti Rotation System;

Consists of a set of pins to engage on the T-Nut, or Cap Screw to engage on the compound of the lathe.

# Quadra® Tool Post Technical Information

## Tool Post Mounting

Quick, Simple, & Rigid



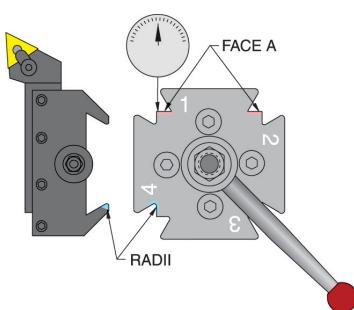
American Style

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.

## Indicating Position

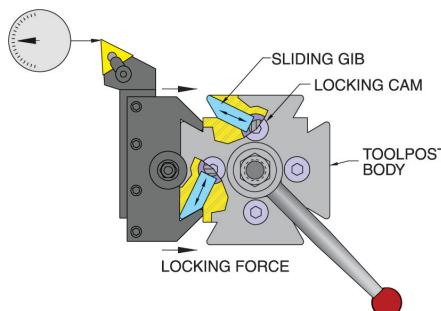
Squareness within .0005"



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

## Holder Locking System

20,000 lbs Locking Force

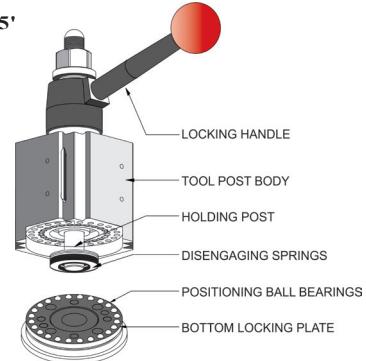


The holder locking system of the Quadra Indexing Tool Post is based on the four Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam style Locking Pin, locking it positively. The cam rotates from 0° (Release Position) to approximately 45° (Locking Position).

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

## Indexing System

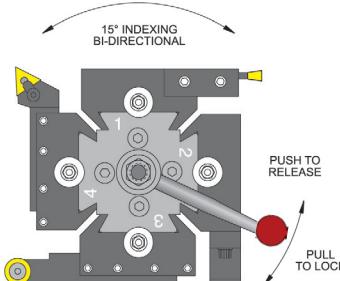
Repeatability within .00005"



With the locking handle in unlocked position, the disengaging spring set lifts the tool post 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.

## Operation

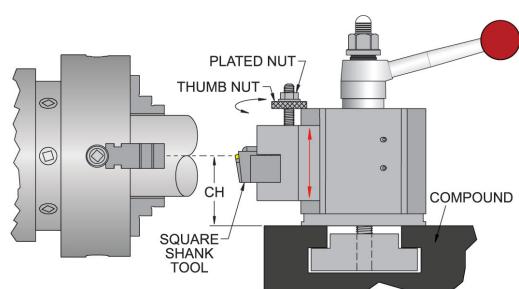
Index from Tool to Tool in Seconds



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

## Holder Center Height Adjustment

Positive Center Height Adjustment

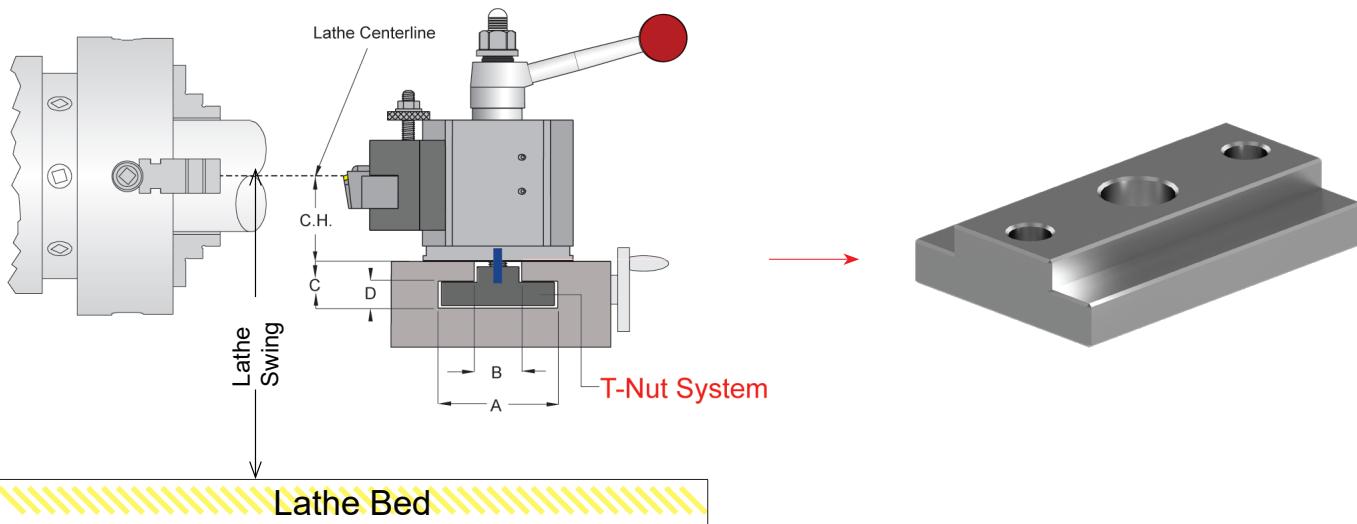


The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool height, first, by screwing or unscrewing the Thumb Nut until the desired height is reached, and next, by locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder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

# Quadra® Tool Post Mounting System

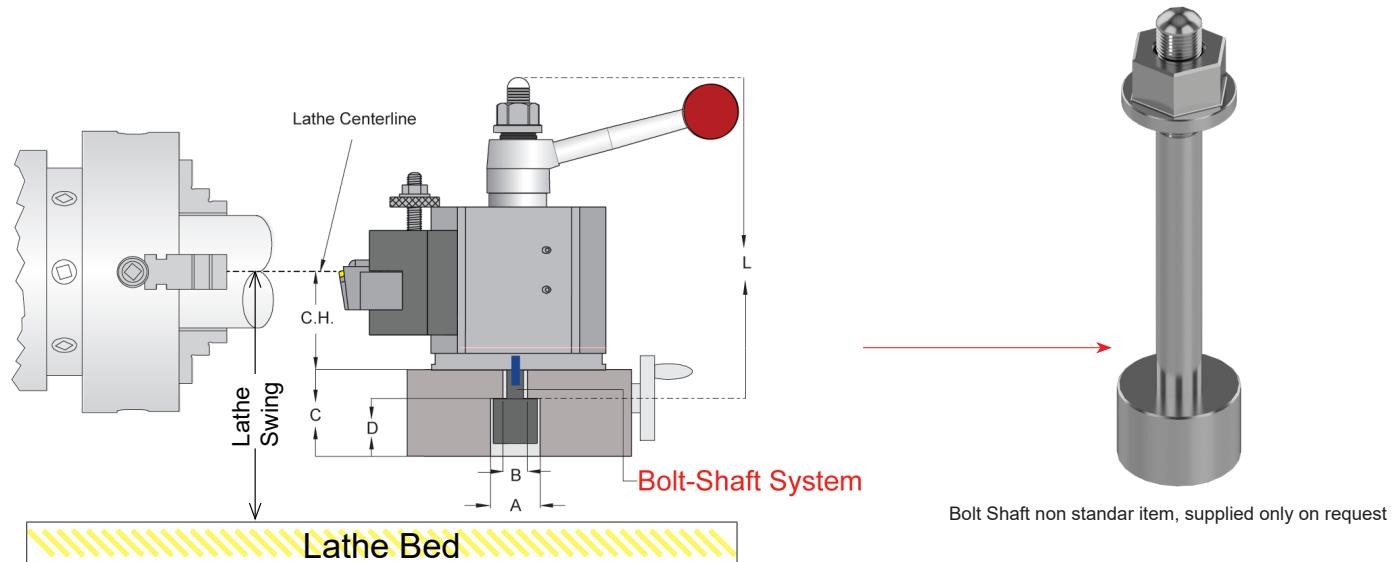
## American Mounting System

A customized T-Nut is used to Lock Down the Tool Post.  
For T-Nut Specification, See pages 8 & 9



## European Mounting System

A customized Bolt-Shaft is used to Lock Down the Tool Post  
For T-Nut Specification, See pages 8 & 9



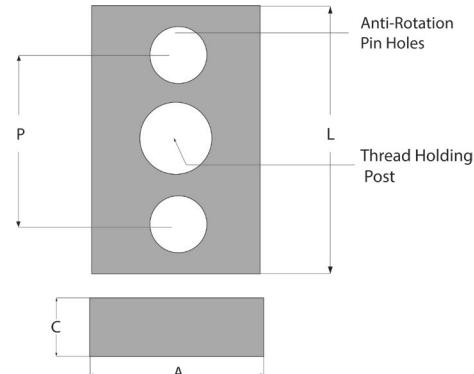
Bolt Shaft non standard item, supplied only on request

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.

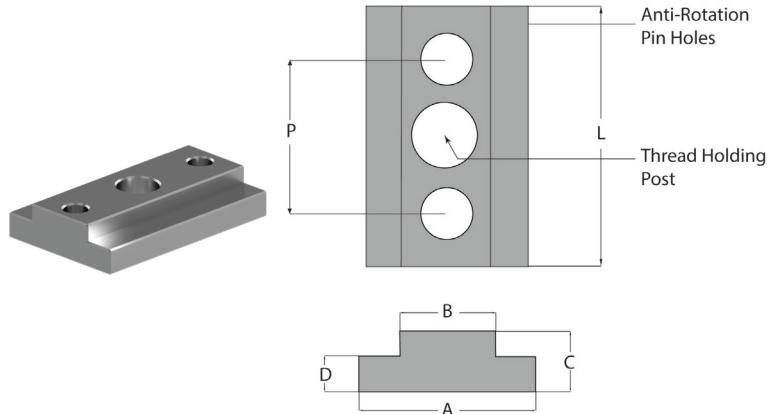
\* Please place an X for American or European mounting Style in the boxes above.

# Quadra® T-Nut Data

## Blank T-Nut



## Machined T-Nut



### QITP Blank T-Nut Description

| Reference Tool Post | Blank T-Nut UPC No. | A     | C     | L    | Thread Size | Anti-Rotation Pin Size | P      |
|---------------------|---------------------|-------|-------|------|-------------|------------------------|--------|
| QITP25N             | 73310105761         | 1.5"  | 1/2"  | 2.5" | 1/2 - 20    | 6mm                    | 1.200" |
| QITP30N             | 73310105796         | 2"    | 5/8"  | 3"   | 1/2 - 20    | 6mm                    | 1.700" |
| QITP35N             | 73310105830         | 2.25" | 3/4"  | 3.5" | 5/8 - 18    | 8mm                    | 2.000" |
| QITP40N             | 73310105865         | 2.5"  | 3/4"  | 4"   | 3/4 - 16    | 8mm                    | 2.500" |
| QITP50N             | 73310105900         | 3."   | 1.25" | 5"   | 1 - 14      | 10mm                   | 3.000" |
| QITP60N             | 73310105935         | 4"    | 1.5"  | 6"   | 1-1/8 - 12  | 10mm                   | 4.000" |

### QITP Machined T-Nut

| Reference Tool | Machined T-Nut | A | B | C | D | L    | Thread Size | Anti-Ro- | P      |
|----------------|----------------|---|---|---|---|------|-------------|----------|--------|
| QITP25N        | 73310105762    |   |   |   |   | 2.5" | 1/2 - 20    | 6mm      | 1.200" |
| QITP30N        | 73310105797    |   |   |   |   | 3"   | 1/2 - 20    | 6mm      | 1.700" |
| QITP35N        | 73310105831    |   |   |   |   | 3.5" | 5/8 - 18    | 8mm      | 2.000" |
| QITP40N        | 73310105866    |   |   |   |   | 4"   | 3/4 - 16    | 8mm      | 2.500" |
| QITP50N        | 73310105901    |   |   |   |   | 5"   | 1 - 14      | 10mm     | 3.000" |
| QITP60N        | 73310105936    |   |   |   |   | 6"   | 1-1/8 - 12  | 10mm     | 4.000" |

### Machined T-Nut Dimensions

| Reference Tool Post | Unit | A | B | C | D | L | Make & Model of Lathe | Lathe Swing Over Bed | CH | Tool Size |
|---------------------|------|---|---|---|---|---|-----------------------|----------------------|----|-----------|
| QITP                | Inch |   |   |   |   |   |                       |                      |    |           |
|                     | mm   |   |   |   |   |   |                       |                      |    |           |

For Machined T-Nut Dimensions, fill in the blanks. Sizes to be specified.

# Quadra® Tool Post Cutting Tool Center Height Set-Up

## Factors that determine the proper Tool Post for a specific lathe:

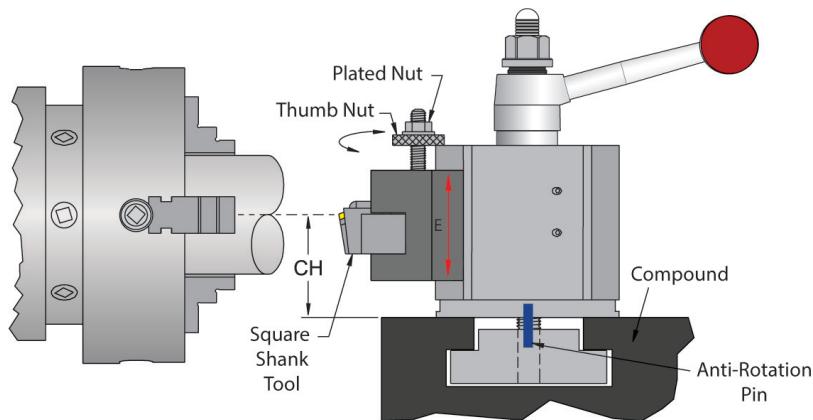
- |                            |                      |                            |
|----------------------------|----------------------|----------------------------|
| 1. Lathe Swing             | 5. Motor Horse power | 9. Prototype or Production |
| 2. Tool Center Height      | 6. Maximum Chuck RPM | 10. Light Duty Work        |
| 3. Tool Size               | 7. Type of Lathe     | 11. Heavy Duty Work        |
| 4. Tool Post Mounting type | 8. Type of Work      |                            |

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

"CH" = Center Height is measured from top of compound to lathe center line  
 "P" = Toolholder bottom lip  
 "B" = Tool Post Height (See page 17)

"E" = Tool Post Toolholder Height (See page )  
 "T" = Turning Toolholder  
 "C.H." = Tool Center Height

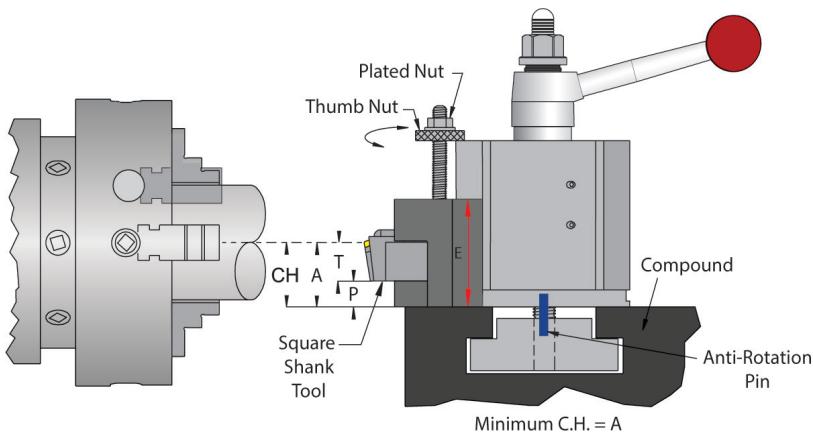
**Optimum**  
Center Height



## Tool Post Mounting Technical Notes

- Mount the Tool Post T-Nut into the Compound
- For Best Rigidity Install Anti Rotation Pins.
- Set the Tool Post Square with the Lathe Bedway
- Lock Tool Post Properly

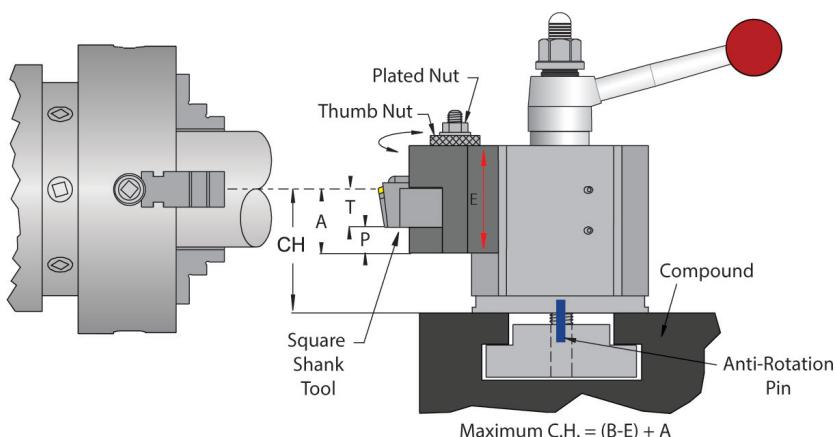
**Minimum**  
Center Height



## Toolholder Center Height Technical Notes

- Place the Toolholder on the Tool post, but not locked.
- Loose the Locking Nut.
- Turn the Thumb Nut up or down till the Insert tip is centered with the Lathe Center Line.
- Lock the Toolholder.

**Maximum**  
Center Height



## Center and Cutting Tool Capacity Technical Notes

- The recommended cutting tool size should be used.
- The Minimum Center Height, is when the Toolholder is all the way down.
- If the Insert is above the Lathe C.L. use a Small Cutting Tool.
- The Maximum Center Height, is when the Toolholder is all the way up.
- If the insert is below the Lathe C.L., use a Large Cutting Tool.

# Quadra® Tool Post & Toolholders Structure Specification

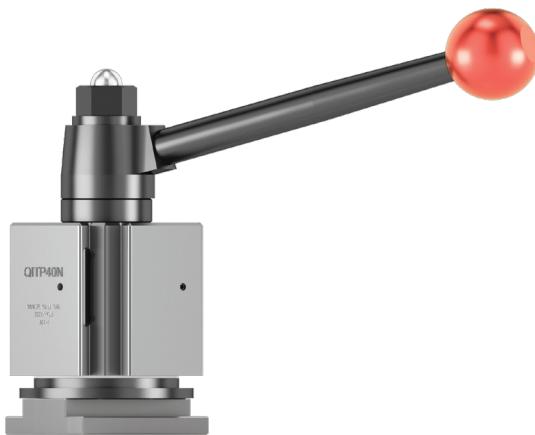
## Structure Specifications

## Features

## Application

### QITP\_N Quadra Indexing Quick Change Tool Post

Page B-15



6 sizes of the Tool Post are available

2.5"/63mm, 3.0"/76mm, 35"/88mm,  
4.0"/101mm, 5.0"/126mm, 6.0"/152mm

Toolholders Capacity, from 3/8"/10mm to  
1-1/2"/40mm

Designed with the most Advanced  
Technology

Manufactured with the Highest Quality

The Best Turning Performance of any  
Tool Post

For all the Multi Turning  
Application

From Prototype to High  
Production

From High Precision to Heavy  
Roughing

### No. QITP\_N-1 Turning & Facing Holder

Page B-16



Holder are Built with 4140 Chromium-Molybdenum Alloy Steel

Special Heat Treat Process to protect Surface, & minimize Cutting Vibration

Quick Change Mounting

Toolholder Interchangeability within  
.0001"/.00127mm

Toolholder Squareness and Parallel  
.0005" x inch/.00127 mm

Over size Capacity for large Indexable Square Shank

For Multi Turning Operation, when a Square Shank is used

### No. QITP\_N-2 Turning, Facing & Boring Holder

Page B-16



Holder are Built with 4140 Chromium-Molybdenum Alloy Steel

Special Heat Treat Process to protect Surface, & minimize Cutting Vibration  
Quick Change Mounting

Toolholder Flat, has a "V" Groove to hold a Round Boring Bar

Toolholder Interchangeability within  
.0001"/.00127mm

Toolholder Squareness and Parallel  
.0005" x inch/.00127 mm

Over size Capacity for large Indexable Square Shank

Capable to hold Square Shank & Boring Bar

Wide Range Turning Operation, when a Square Shank & Boring Bar are used

### No. QITP\_N-4,41,41S CNC DUAL Extra Heavy Duty Boring Bar Holder

Page B-17 -B-18



Holders are Built with 4140 Chromium-Molybdenum Alloy Steel

Special Heat Treat Process to protect Surface, & minimize Cutting Vibration

Quick Change Mounting

Built with DOUBLE Boring Bar Locking System

360° Collar Locking System

Self Centering Screw Lock System

For Boring Bar with & without Flats

Toolholder Interchangeability within  
.0001"/.00127mm

Toolholder Squareness and Parallel  
.0005" x inch/.00127 mm

For All the Boring Operation when a Round Tool is used

**NEW**

## 360 ° Double Locking System

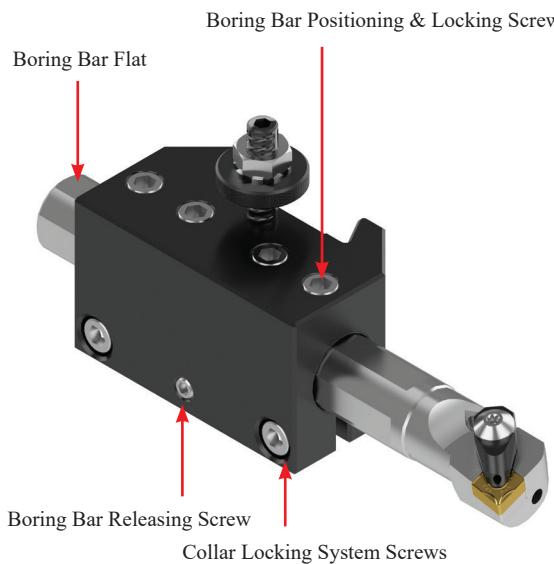
### For Quick & Precise Set-Up with the Maximum Rigidity

The new DUAL Boring Bar Holder, has been engineered to maximize the holding force of the Boring Bar, in achieving the most possible Boring rigidity for Heavy Duty Roughing, and Stability for High Surface Finishing and Close Boring Tolerances.

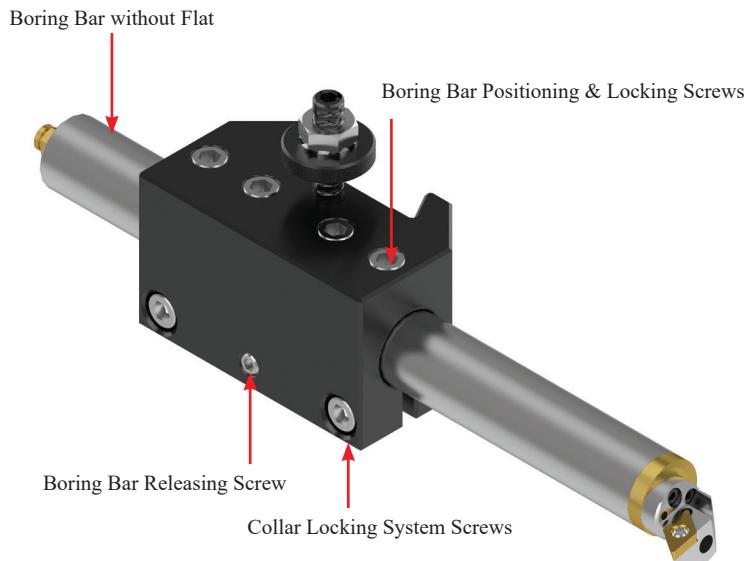
#### Features:

|                            |                              |                                 |
|----------------------------|------------------------------|---------------------------------|
| Dual Locking System        | Longer Inserts Life          | Higher Productivity             |
| Set Screws Locking System  | Maximum Locking Force        | Best Roughing Performance       |
| 360° Collar Locking System | Maximum Rigidity & Stability | Best Surface Finish & Tolerance |

### Mounting of a Boring Bar with Flats

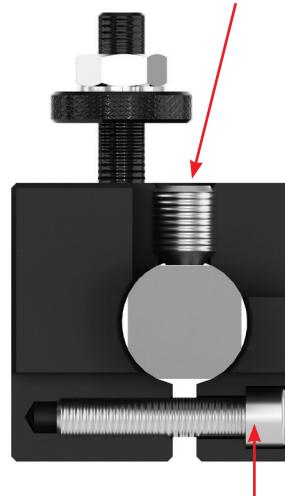


### Mounting of a Boring Bar without Flats



### Locking Instruction

Boring Bars with **flats**, Lock the Position Screws gently to set the Boring Bar on Center Line

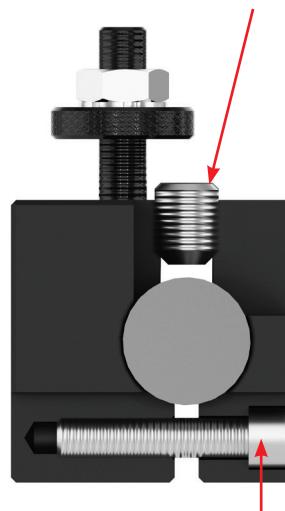


Once The Boring is on center line, lock the holder side screws.

The Boring Bar, is locked 360° around the Diameter in to the Holder, tight down the position screws.

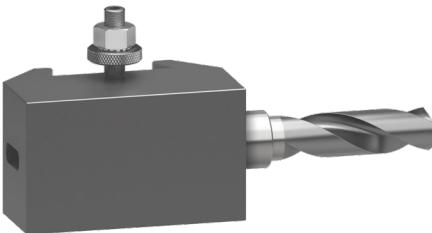
The **DUAL** locking System, will fuse the Boring Bar with the Holder in One Unit, achieving the best possible Boring Rigidity & Stability.

Boring Bars without **flats**, Turn the Position Screws up, do not touch the Boring Bar Surface.



Set-Up the Boring on center line, lock the holder side screws, The Boring Bar, is locked 360° around the Diameter in to the Holder, fusing in One the Boring Bar with the Holder, achieving the best possible Boring Rigidity & Stability

# Quadra® Tool Post & Toolholders Structure Specification

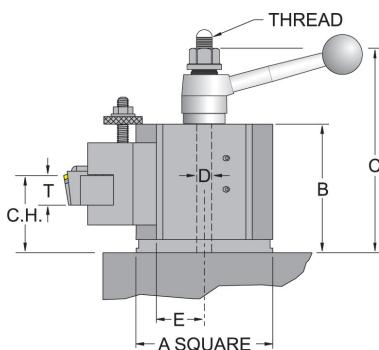
|  | Structure Specifications  | Features  | Application  |
|--|---|---|--|
| <b>No. QITPN-5 Morse Taper Holder</b>  |   |   |  |
| Page B-19  |   |   |  |
|   | <p>Holder are Built with 4140 Chromium-Molybdenum Alloy Steel</p> <p>Special Heat Treat Process to protect Surface, &amp; minimize Cutting Vibration</p> <p>Quick Change Mounting</p> | <p>Toolholder Interchangeability within .0001"/.00127mm</p> <p>Toolholder Squareness and Parallel .0005" x inch/.00127 mm</p>   | <p>All the Drilling, Reaming,Tapping, Operation using Drill Chuck or Morse Taper</p> <p>Heavy Duty Drilling Operation</p>        |
| <b>No. QITPN-36 5C Collet Holder</b>   |   |   |  |
| Page B-19  |   |   |  |
|    | <p>Holder are Built with 4140 Chromium-Molybdenum Alloy Steel</p> <p>Special Heat Treat Process to protect Surface, &amp; minimize Cutting Vibration</p> <p>Quick Change Mounting</p> | <p>Toolholder Interchangeability within .0001"/.00127mm</p> <p>Toolholder Squareness and Parallel .0005" x inch/.00127 mm</p> <p>Holds 5 C Collets Series</p> <p>Accept, Round, Square &amp; Hexagonal Collets</p>  | <p>Versatile for Multi Operation</p> <p>Drilling, Boring, Reaming, Threading, Turning</p> <p>Using Standard or Special Tools</p> |
| <b>No. QITPN-7-71C Reversible Cut-Off Blade Holder</b>                             |   |   |  |
| Page B-19  |   |   |  |
|  | <p>Holder are Built with 4140 Chromium-Molybdenum Alloy Steel</p> <p>Special Heat Treat Process to protect Surface, &amp; minimize Cutting Vibration</p> <p>Quick Change Mounting</p> | <p>Toolholder Interchangeability within .0001"/.00127mm</p> <p>Toolholder Squareness and Parallel .0005" x inch/.00127 mm</p> <p>Holds Industry Standard Sizes Cut-Off Blades</p>   | <p>Cut-Off Operation</p> <p>Grooving Operation</p>   |
| <b>No. QITPN-881 O.D. or I.D. Threading Holder</b>                                 |   |   |  |
| Page B-21  |   |   |  |
|  | <p>Holder are Built with 4140 Chromium-Molybdenum Alloy Steel</p> <p>Special Heat Treat Process to protect Surface, &amp; minimize Cutting Vibration</p> <p>Quick Change Mounting</p> | <p>Toolholder Interchangeability within .0001"/.00127mm</p> <p>Toolholder Squareness and Parallel .0005" x inch/.00127 mm</p> <p>Holds OD Threading Cartridge</p> <p>Holds 1D Threading Bar</p> <p>Easy to Set-Up, Simple to Use</p> <p>Uses Industry Style Threading Inserts</p> | <p>O.D .and I.D. Threading</p>   |

# Quadra® Indexing Quick Change Tool Post

by  
Dorian Tool



The TRUE Solution for  
every turning application



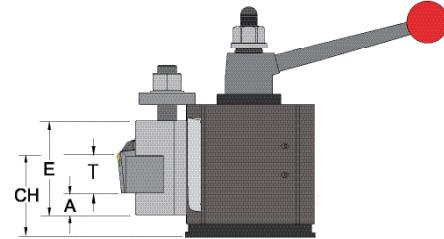
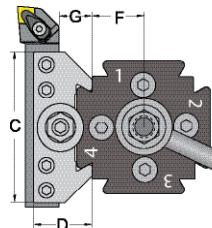
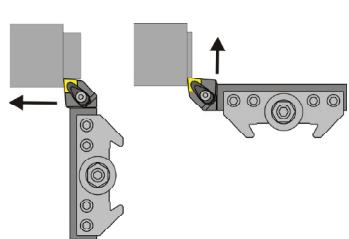
| Description<br>UPC No. 733101- | QITP25N<br>00000 |          | QITP30N<br>00002 |          | QITP35N<br>00004 |         | QITP40N<br>00006 |         | QITP50N<br>00008 |         | QITP60N<br>00010 |         |
|--------------------------------|------------------|----------|------------------|----------|------------------|---------|------------------|---------|------------------|---------|------------------|---------|
|                                | in               | mm       | in               | mm       | in               | mm      | in               | mm      | in               | mm      | in               | mm      |
| System                         |                  |          |                  |          |                  |         |                  |         |                  |         |                  |         |
| 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       | 3.000            | 76       | 3.500            | 88      | 4.000            | 101     | 5.000            | 126     | 6.000            | 152     |
| 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                | 3/8-3/4          | 10-20    | 1/2-1.0          | 12-25    | 3/4-1.0          | 20-25   | 1.0-1 1/4        | 25-32   | 1 1/4 - 1 1/2    | 32-40   | 1 1/2            | 40.0    |
| Optimum C.H.*                  | 1.422            | 36.1     | 1.747            | 44.4     | 1.835            | 46.6    | 2.202            | 55.9    | 2.995            | 76.1    | 3.440            | 87.4    |
| C.H. MIN.                      | 0.995            | 25.3     | 1.213            | 30.8     | 1.445            | 36.7    | 1.757            | 44.6    | 2.245            | 57.0    | 2.750            | 69.9    |
| C.H. MAX.                      | 1.849            | 50.0     | 2.282            | 58.0     | 2.225            | 56.5    | 2.646            | 67.2    | 3.744            | 95.1    | 4.129            | 104.9   |
| Thread                         | 1/2-20           | M12x1.75 | 1/2-20           | M12x1.75 | 5/8-18           | M16x2.0 | 3/4-16           | M18x2.5 | 1.0-14           | M24x3.0 | 1 1/8-12         | M27x3.0 |

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

# Quadra® Quick Change-Toolholder Ordering Specification

## No. QITPN-1 Turning & Facing Toolholder

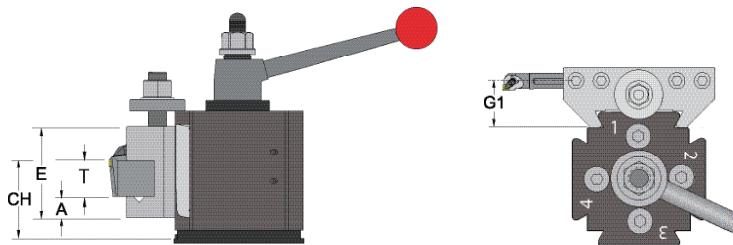
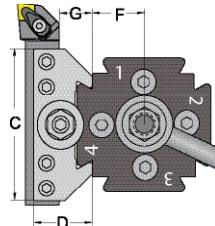
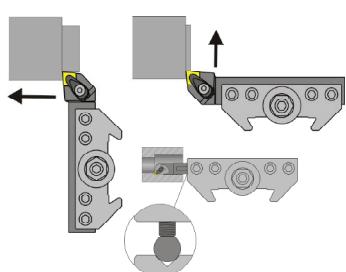
This Toolholder is best used for holding square shank Cutting Tools close to the Tool Post to maximize Rigidity, Stability & Performance, in turning, facing, and threading Operation.



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

## No. QITPN-2 Turning, Facing & Boring Toolholder

The “V” groove makes this Toolholder more versatile, to hold either square shank Cutting Tools or Boring Bars, held close to the Tool Post to maximize Rigidity, Stability & Performance in turning, facing, threading and boring Operation.

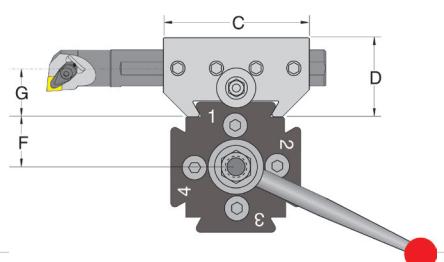
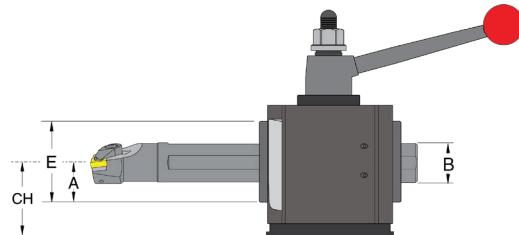
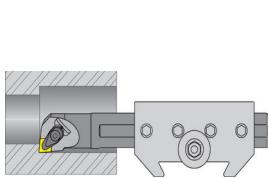


| Description | UPC No.733101- | System | A     | T     | C      | D     | E      | F     | G     | G1    |
|-------------|----------------|--------|-------|-------|--------|-------|--------|-------|-------|-------|
| QITP25N-2   | 00104          | in     | 0.375 | .750  | 2.750  | 1.240 | 1.740  | 0.880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

# Quadra® Quick Change-Toolholder Ordering Specification

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

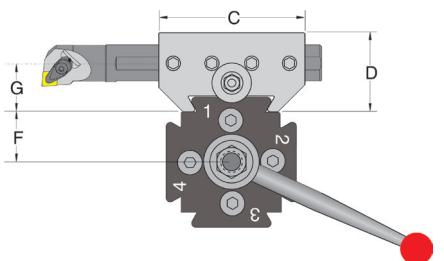
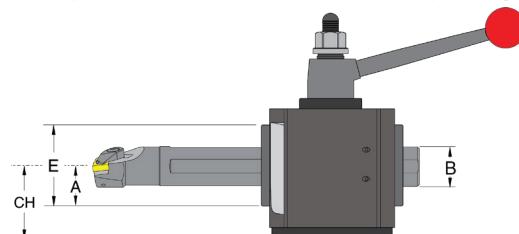
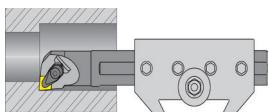
This Toolholder with DUAL Locking System, is best used for holding Round Tools and Boring Bars with or without flats. The Boring Bar, is locked 360° around the Diameter in to the Toolholder, The DUAL locking System, will fuse the Boring Bar with the Toolholder in One Unit, achieving the best possible Boring Operation for Rigidity, Stability & Performance.



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

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

This Toolholder with DUAL Locking System, is best used for holding Round Tools and Boring Bars with or without flats. The Boring Bar, is locked 360° around the Diameter in to the Toolholder, The DUAL locking System, will fuse the Boring Bar with the Toolholder in One Unit, achieving the best possible Boring Operation for Rigidity, Stability & Performance.

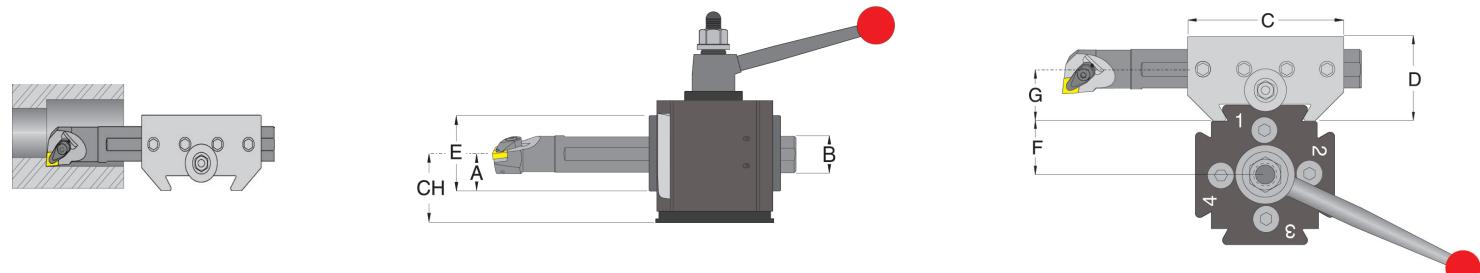


| Description     | UPC No.733101- | System | A     | Boring Bar Capacity | C      | D      | E      | F     | G     |
|-----------------|----------------|--------|-------|---------------------|--------|--------|--------|-------|-------|
| QITP35N-41-CNC  | 00414          | in     | 1.120 | 1.250   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

# Quadra® Quick Change-Toolholder Ordering Specification

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

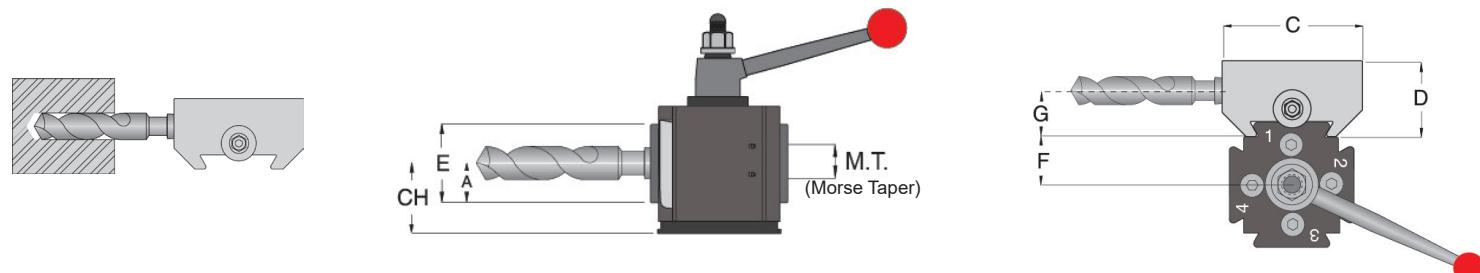
This Toolholder with DUAL Locking System, is best used for holding Round Tools and Boring Bars with or without flats. The Boring Bar, is locked 360° around the Diameter in to the Toolholder, The DUAL locking System, will fuse the Boring Bar with the Toolholder in One Unit, achieving the best possible Boring Operation for Rigidity, Stability & Performance



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

## No. QITPN-5 Morse Taper Toolholder

This Toolholder best used for holding Morse Taper Cutting Tools, for heavy drilling, boring, reamer and tapping,

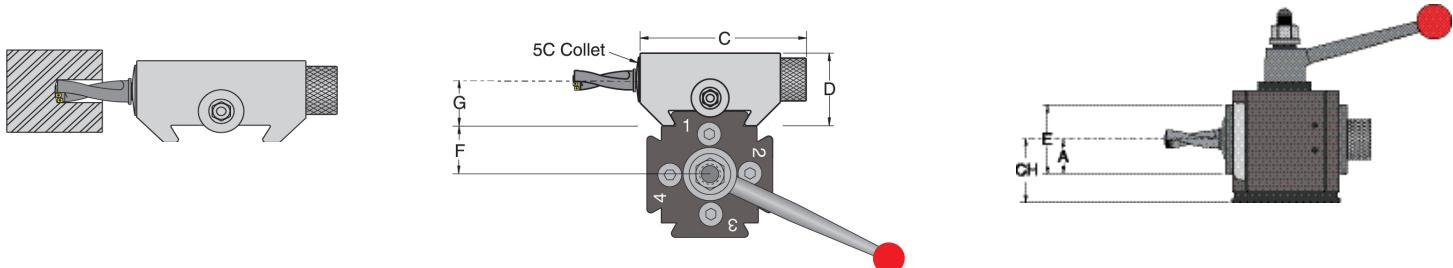


| Description | UPC No. 733101- | System | A     | Morse Taper | C      | D     | E     | F     | G     |
|-------------|-----------------|--------|-------|-------------|--------|-------|-------|-------|-------|
| QITP35N-5-4 | 00424           | in     | 1.250 | MT4         | 4.150  | 2.500 | 2.500 |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

# Quadra® Quick Change-Toolholder Ordering Specification

## No. QITPN-36 5C Collet Toolholder

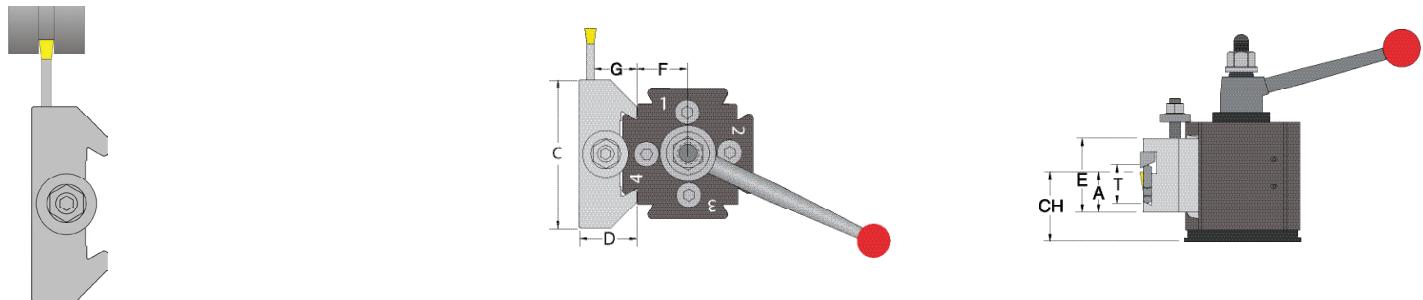
This holder's wide range of collet adaptability makes this tool ideal for holding drills, taps, chucks, & boring bars. It holds the tools with extreme rigidity without scarring them. Fits industry standard tool posts.



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

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

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



| Dual Blade Capacity |                 |        |       |                   |                     |        |       |       |
|---------------------|-----------------|--------|-------|-------------------|---------------------|--------|-------|-------|
| Description         | UPC No. 733101- | System | A     | Slot Grip Blade   | Twin Edge Blade     | C      | D     | E     |
| QITP25N-7-71C       | 00126           | in     | 0.933 | SGIH-19-2         | TWECOB-19-2         | 2.750  | 1.250 | 2.000 |
|                     |                 | mm     | 23.70 |                   |                     | 69.85  | 31.75 | 50.80 |
| QITP30N-7-71C       | 00276           | in     | 0.933 |                   |                     | 3.250  | 1.250 | 2.000 |
|                     |                 | mm     | 23.70 |                   |                     | 82.60  | 31.80 | 50.80 |
| QITP35N-7-71C       | 00428           | in     | 1.255 | SGIH-26-2 to 26-6 | TWECOB-26-2 to 26-6 | 3.750  | 1.750 | 2.500 |
|                     |                 | mm     | 31.88 |                   |                     | 95.25  | 44.45 | 63.50 |
| QITP40N-7-71C       | 00576           | in     | 1.255 | SGIH-26-2 to 26-6 | TWECOB-26-2 to 26-6 | 4.500  | 1.750 | 3.000 |
|                     |                 | mm     | 31.88 |                   |                     | 114.30 | 44.45 | 76.20 |
| QITP50N-7-71C       | 00726           | in     | 1.483 | SGIH-32-3 to 32-9 | TWECOB-32-2 to 32-6 | 6.000  | 2.000 | 3.000 |
|                     |                 | mm     | 37.67 |                   |                     | 152.40 | 50.80 | 76.20 |
| QITP60N-7-71C       | 00876           | in     | 2.050 | SGIH-32-3 to 32-9 | TWECOB-32-2 to 32-6 | 7.000  | 2.250 | 3.500 |
|                     |                 | mm     | 52.07 |                   |                     | 177.80 | 57.15 | 88.90 |
|                     |                 |        |       |                   |                     |        |       | 56.06 |
|                     |                 |        |       |                   |                     |        |       | 54.61 |

# Slot Grip Cut-Off Blades Ordering Specification

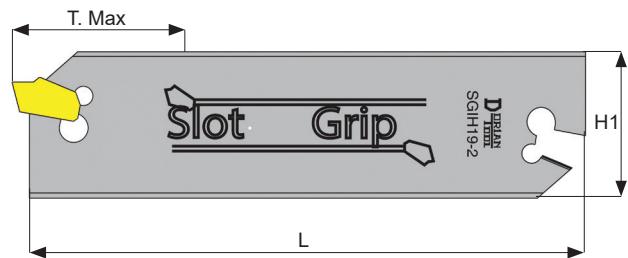
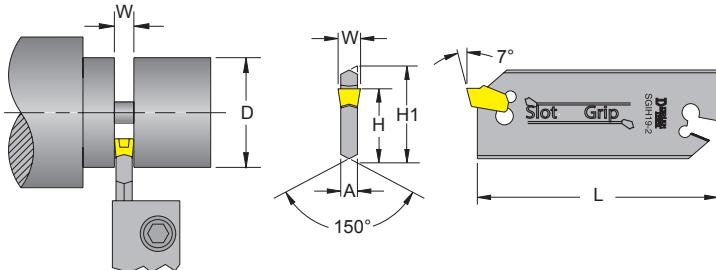


## Positive Stop Blades



### Positive Stop

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.



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

### 19mm (3/4") Slot Grip Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | H     | H1    | Insert Description | Insert Width |
|--------------------|-------|--------|-------|-------|-------|-------|-------|--------------------|--------------|
| SGIH19-2           | 62950 | 0.785  | 0.063 | 1.570 | 3.380 | 0.618 | 0.750 | SGT(N/R/L)-2       | .079"        |

### 26mm (1") Slot Grip Blades

|          |       |       |       |       |       |       |       |              |       |
|----------|-------|-------|-------|-------|-------|-------|-------|--------------|-------|
| SGIH26-2 | 62951 | 1.000 | 0.063 | 2.000 | 4.330 | 0.842 | 1.020 | SGT(N/R/L)-2 | .079" |
| SGIH26-3 | 62952 | 1.500 | 0.094 | 3.000 |       |       |       | SGT(N/R/L)-3 | .118" |
| SGIH26-4 | 62953 | 1.575 | 0.125 | 3.150 |       |       |       | SGT(N/R/L)-4 | .157" |

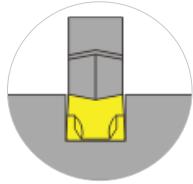
### 32mm (1 1/4") Slot Grip Blades

|          |       |       |       |       |       |       |       |              |       |
|----------|-------|-------|-------|-------|-------|-------|-------|--------------|-------|
| SGIH32-3 | 62956 | 1.970 | 0.094 | 3.940 | 5.900 | 0.984 | 1.250 | SGT(N/R/L)-3 | .118" |
| SGIH32-4 | 62957 | 1.970 | 0.125 | 3.940 |       |       |       | SGT(N/R/L)-4 | .157" |
| SGIH32-5 | 62958 | 2.355 | 0.156 | 4.710 |       |       |       | SGT(N/R/L)-5 | .197" |
| SGIH32-6 | 62959 | 2.355 | 0.203 | 4.710 |       |       |       | SGT(N/R/L)-6 | .236" |
| SGIH32-8 | 62960 | 2.755 | 0.268 | 5.510 |       |       |       | SGT(N/R/L)-8 | .315" |
| SGIH32-9 | 62961 | 2.755 | 0.312 | 5.510 |       |       |       | SGT(N/R/L)-9 | .354" |

# Slot Grip Cut-Off Inserts Ordering Specification



## SG\_ Inserts for Cut-Off & Grooving Operations

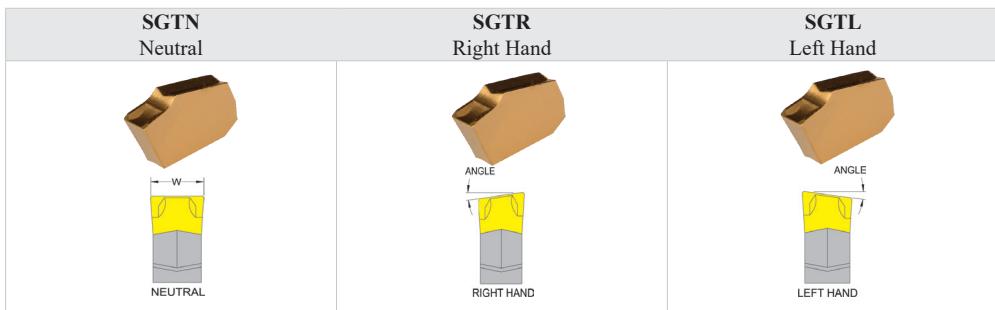


### Chip breaker Geometry

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

### Cut-Off & Grooving

Inserts are 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.



### Application

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

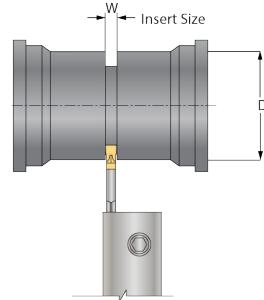
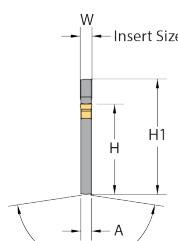
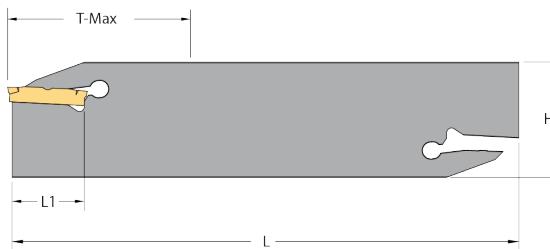
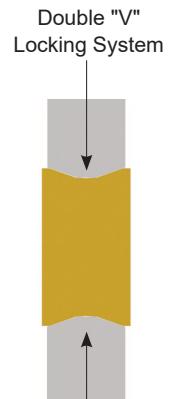
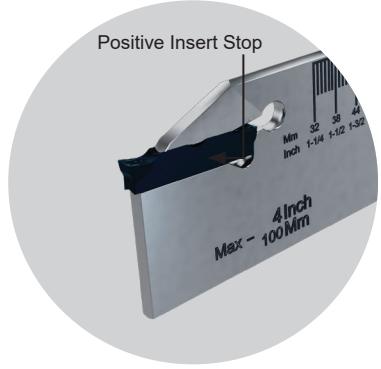
| Material | Carbon & Alloy Steel | Aluminum & Non-Ferrous Metals & Materials | Carbon & Alloy Steel | 300 & 400 Series Stainless Steel | Cast Iron, Copper/Brass | Aluminum & Non-Ferrous Materials | High Temp Alloys | Hard Steel to 58 HRC |
|----------|----------------------|---|----------------------|----------------------------------|-------------------------|----------------------------------|------------------|----------------------|
|          | P35                  | K25 N25                                   |                      |                                  | K25 P25 M25             |                                  |                  |                      |

| Insert Grade | Insert Coating |            |              | CVD TiN Coated |       | Uncoated |       | PVD TiAlN Coated |
|--------------|----------------|------------|--------------|----------------|-------|----------|-------|------------------|
|              | Insert Size mm | Lead Angle | Width + 0,05 |                | UPC # | UPC #    | UPC # |                  |
|              |                |            | inch         | mm             |       |          |       |                  |
| SGTN-2       | 2              | 0°         | .087         | 2              | 82222 | 82220    |       | 82223            |
| SGTN-2.4     | 2,4            | 0          | .094         | 2,4            | 82306 | 82304    |       | 82307            |
| SGTN-3       | 3              | 0°         | .122         | 3              | 82226 | 82224    |       | 82227            |
| SGTN-4       | 4              | 0°         | .161         | 4              | 82230 | 82228    |       | 82231            |
| SGTN-4.8     | 4,8            | 0          | .189         | 4,8            | 82318 | 82316    |       | 82319            |
| SGTN-5       | 5              | 0°         | .201         | 5              | 82234 | 82232    |       | 82235            |
| SGTN-6       | 6              | 0°         | .252         | 6              | 82238 | 82236    |       | 82239            |
| SGTN-8       | 8              | 0°         | .315         | 8              | 82242 | -        |       | -                |
| SGTN-9       | 9              | 0°         | .378         | 9              | 82246 | 82244    |       | 82247            |
| SGTR-2-8     | 2              | 8°         | .087         | 2              | 82250 | 82248    |       | 82251            |
| SGTR-2.4-8   | 2,4            | 8          | .094         | 2,4            | 82310 | 82308    |       | 82311            |
| SGTR-3-8     | 3              | 8°         | .122         | 3              | 82254 | 82252    |       | 82255            |
| SGTR-4-8     | 4              | 8°         | .161         | 4              | 82258 | 82256    |       | 82259            |
| SGTR-4.8-8   | 4,8            | 8          | .189         | 4,8            | 82322 | 82320    |       | 82323            |
| SGTR-5-8     | 5              | 8°         | .201         | 5              | 82262 | 82260    |       | 82263            |
| SGTR-6-8     | 6              | 8°         | .252         | 6              | 82266 | -        |       | -                |
| SGTR-9-8     | 9              | 8°         | .378         | 9              | 82274 | -        |       | -                |
| SGTL-2-8     | 2              | 8°         | .087         | 2              | 82278 | 82276    |       | 82279            |
| SGTL-4-8     | 4              | 8°         | .161         | 4              | -     | 82284    |       | 82287            |
| SGTL-5-8     | 5              | 8°         | .201         | 5              | 82290 | -        |       | -                |

# Kool-Cut™ Twin Edge Blade Ordering Specification

## Twin Edge Blades

- Double Cutting Edge
- High Rigidity
- Better Finish
- Straight Cut



Insert Extraction Key  
Sold Separately

### 19mm (3/4") Twin Edge Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | L1    | H     | H1    | Insert Description | Insert Width | Insert Extraction Key Description | UPC # |
|--------------------|-------|--------|-------|-------|-------|-------|-------|-------|--------------------|--------------|-----------------------------------|-------|
| TWECOB-DNTF-19-20  | 61973 | .785   | 0.063 | 1.570 | 3.380 | 0.866 | 0.618 | 0.750 | DNTQ-22 2002-3EU-N |              | KCIK-DN                           |       |
|                    |       |        |       |       |       |       |       |       | DNPG-22 2002-1SR-N |              | 61204                             |       |

### 26mm (1") Twin Edge Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | L1    | H     | H1    | Insert Description | Insert Width | Insert Extraction Key Description | UPC # |
|--------------------|-------|--------|-------|-------|-------|-------|-------|-------|--------------------|--------------|-----------------------------------|-------|
| TWECOB-DNTF-26-20  | 61965 | 1.000  | 0.063 | 2.000 | 4.331 | 0.866 | 0.842 | 1.024 | DNTQ-22 2002-3EU-N | 0.079        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |
| TWECOB-DNTF-26-30  | 61966 | 1.550  | 0.094 | 3.100 | 4.331 | 0.866 | 0.842 | 1.024 | DNTQ-22 3003-3EU-N | 0.118        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |
| TWECOB-DNTF-26-40  | 61967 | 1.650  | 0.125 | 3.300 | 4.331 | 0.866 | 0.842 | 1.024 | DNTQ-25 4004-3EU-N | 0.157        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |

### 32mm (1 1/4") Twin Edge Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | L1    | H     | H1    | Insert Description | Insert Width | Insert Extraction Key Description | UPC # |
|--------------------|-------|--------|-------|-------|-------|-------|-------|-------|--------------------|--------------|-----------------------------------|-------|
| TWECOB-DNTF-32-20  | 61968 | 1.150  | 0.063 | 2.300 | 5.906 | 0.866 | 0.984 | 1.260 | DNTQ-22 2002-3EU-N | 0.079        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |
| TWECOB-DNTF-32-30  | 61969 | 1.750  | 0.094 | 3.500 | 5.906 | 0.866 | 0.984 | 1.260 | DNTQ-22 3003-3EU-N | 0.118        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |
| TWECOB-DNTF-32-40  | 61970 | 1.950  | 0.125 | 3.900 | 5.906 | 0.984 | 0.984 | 1.260 | DNTQ-25 4004-3EU-N | 0.157        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |
| TWECOB-DNTF-32-50  | 61971 | 2.350  | 0.157 | 4.700 | 5.906 | 0.984 | 0.984 | 1.260 | DNTQ-25 5004-3EU-N | 0.197        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |
| TWECOB-DNTF-32-60  | 61972 | 2.750  | 0.203 | 5.500 | 5.906 | 0.984 | 0.984 | 1.260 | DNTQ-25 6004-3EU-N | 0.236        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       |                    |              |                                   |       |

# Kool-Cut™ Twin Edge Insert Turning & Grooving Application

| Insert Specification  |        |  |  |        | Insert Application |         |  |
|---|--------|--|--|--------|--------------------|---------|--|
| <b>Double-End Cutting Edge DNTQ-N- DUP35UG</b>                                |        |  |  |        |                    |         |  |
| <b>Neutral Straight Nose Multi-Cutting Direction Right Hand and Left Hand</b> |        |  |  |        |                    |         |  |
| <b>Cutting Data</b>   |        |  |  |        |                    |         |  |
| Insert Dimension  |        | Maximum $a_p$<br>Depth of Cut<br>for Turning | Maximum $f_n$<br>Feed Rate for<br>Turning, Grooving<br>and Parting-off | in/ch. | in/rev.            | Turning |  |
| Width   | Length | Corner Radius                                |  |        |                    |         |  |
| .079" (2mm)   | .866"  | .008"  | .039"  |        | .006 in/rev        |         |  |
| .118" (3mm)   | .866"  | .012"  | .059"  |        | .008 in/rev        |         |  |
| .157" (4mm)   | .984"  | .016"  | .079"  |        | .009 in/rev        |         |  |
| .197" (5mm)   | .984"  | .016"  | .098"  |        | .010 in/rev        |         |  |
| .236" (6mm)   | .984"  | .016"  | .118"  |        | .012 in/rev        |         |  |

| <b>Double-End Cutting Edge DNTR-N- DUP35UG</b>                             |        |  |  |        | Insert Application |           |  |
|--|--------|--|--|--------|--------------------|-----------|--|
| <b>Neutral Round Nose Multi-Cutting Direction Right Hand and Left Hand</b> |        |  |  |        |                    |           |  |
| <b>Cutting Data</b>  |        |  |  |        |                    |           |  |
| Insert Dimension   |        | Maximum $a_p$<br>Depth of Cut<br>for Turning | Maximum $f_n$<br>Feed Rate for<br>Turning, Grooving<br>and Parting-off | in/ch. | in/rev.            | Profiling |  |
| Width  | Length | Radius                                       |  |        |                    |           |  |
| .118" (3mm)  | .866"  | .059"<br>(1.5mm)                             | .059"  |        | .012 in/rev        |           |  |
| .157" (4mm)  | .984"  | .079"<br>(2.0mm)                             | .079"  |        | .014 in/rev        |           |  |
| .197" (5mm)  | .984"  | .098"<br>(2.5mm)                             | .098"  |        | .016 in/rev        |           |  |

| <b>Double-End Cutting Edge DNPG-N- DPP40SG</b>                        |        |   |        |             | Insert Application |  |             |  |
|---|--------|---|--------|-------------|--------------------|--|-------------|--|
| <b>Neutral Straight Nose Uni-Direction Parting Off &amp; Grooving</b> |        |   |        |             |                    |  |             |  |
| <b>Cutting Data</b>   |        |   |        |             |                    |  |             |  |
| Insert Dimension  |        | Maximum $f_n$<br>Feed Rate for<br>Parting-off | in/ch. | in/rev.     | Grooving           |  | Parting-Off |  |
| Width   | Length | Corner Radius                                 |        |             |                    |  |             |  |
| .079" (2mm)   | .866"  | .008"   |        | .006 in/rev |                    |  |             |  |
| .118" (3mm)   | .866"  | .008"   |        | .008 in/rev |                    |  |             |  |
| .157" (4mm)   | .984"  | .012"   |        | .009 in/rev |                    |  |             |  |
| .197" (5mm)   | .984"  | .016"   |        | .010 in/rev |                    |  |             |  |
| .236" (6mm)   | .984"  | .016"   |        | .012 in/rev |                    |  |             |  |

# Kool-Cut™ Twin Edge Inserts Ordering Specification

| DUP35UG  |                     |                      |        |         |
|----------|---------------------|----------------------|--------|---------|
| Material |                     | V <sub>c</sub> (SFM) |        |         |
|          | Steel               | F/min.               | m/min. |         |
| P        | Carbon Steel        | 363                  | 627    | 110 190 |
|          | Low Alloy Steel     | 363                  | 594    | 110 180 |
|          | High Temp Alloys    | 231                  | 528    | 70 160  |
| M        | Ferritic            | 396                  | 660    | 120 200 |
|          | Austenitic          | 330                  | 561    | 100 170 |
|          | Duplex              | 231                  | 363    | 70 110  |
|          | Martensitic         | 198                  | 297    | 60 90   |
| K        | Gray Cast Iron      | 330                  | 660    | 100 200 |
|          | Modular Cast Iron   | 330                  | 594    | 100 180 |
|          | Malleable Cast Iron | 264                  | 528    | 80 160  |
| N        | Unleaded Copper     | 373                  | 825    | 113 250 |
|          | Brass               | 663                  | 1472   | 201 446 |
|          | Unleaded Bronze     | 287                  | 495    | 87 150  |
| S        | Iron Base           | 86                   | 172    | 26 52   |
|          | Nickel Base         | 53                   | 116    | 16 35   |
|          | Titanium            | 198                  | 429    | 60 130  |

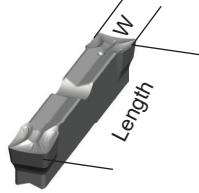
| DPP40SG  |                     |                      |        |         |
|----------|---------------------|----------------------|--------|---------|
| Material |                     | V <sub>c</sub> (SFM) |        |         |
|          | Steel               | F/min.               | m/min. |         |
| P        | Carbon Steel        | 264                  | 495    | 80 150  |
|          | Low Alloy Steel     | 231                  | 396    | 70 120  |
|          | High Temp Alloys    | 198                  | 330    | 60 100  |
| M        | Ferritic            | 330                  | 594    | 100 180 |
|          | Austenitic          | 264                  | 495    | 80 150  |
|          | Duplex              | 231                  | 363    | 70 110  |
|          | Martensitic         | 198                  | 297    | 60 90   |
| K        | Gray Cast Iron      | 264                  | 561    | 80 170  |
|          | Modular Cast Iron   | 297                  | 495    | 90 150  |
|          | Malleable Cast Iron | 231                  | 462    | 70 140  |
| N        | Unleaded Copper     |                      |        |         |
|          | Brass               |                      |        |         |
|          | Unleaded Bronze     |                      |        |         |
| S        | Iron Base           |                      |        |         |
|          | Nickel Base         |                      |        |         |
|          | Titanium            |                      |        |         |

| DUP35UG                             | HC-P25/M25 K30 N30 S30  | Coated | PVD-TiAlN 4µm |
|-------------------------------------|---|--------|---------------|
| Insert Characteristics              | Hard, Wear, Abrasive and Impact Resistant   |        |               |
| First Choice Application            | Universal Multi Purpose Turning and Grooving Application; for carbon steel, alloy steel, stainless steel, cast iron, high-temp alloys & non-ferrous materials |        |               |
| Cutting Speed SFM (V <sub>c</sub> ) | High Cutting Speed in stable turning and grooving conditions, light interrupted cut   |        |               |
| Cutting Condition                   | Wet   |        |               |

| DPP40SG                             | HC-P45/M45   | Multi Coated | PVD-TiAlN 7µm |
|-------------------------------------|--|--------------|---------------|
| Insert Characteristics              | Extremely Tough and Impact Resistant Substrate   |              |               |
| First Choice Application            | For Heavy or Interrupted Part Off and Grooving Applications; for Forgings and Castings of Carbon Steel, Alloy Steel, Stainless Steel and Cast Iron |              |               |
| Cutting Speed SFM (V <sub>c</sub> ) | Low to Medium Cutting Speed in unstable conditions and heavy interrupted cut   |              |               |
| Cutting Condition                   | Wet  |              |               |

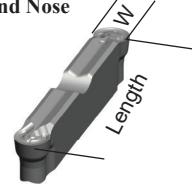
## Insert Specifications

“T” Square Nose



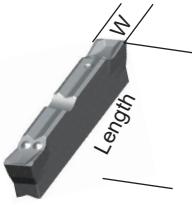
| UPC # | Application                        | Part Number                | Insert Size Width | Length | Corner Radius | Grade |
|-------|------------------------------------|----------------------------|-------------------|--------|---------------|-------|
| 82440 | Turning<br>Grooving<br>Parting-Off | DNTQ-22 2002-3EU-N DUP35UG | .079" (2mm)       | .866"  | .008"         | ●     |
| 82442 |                                    | DNTQ-22 3003-3EU-N DUP35UG | .118" (3mm)       | .866"  | .012"         | ●     |
| 82443 |                                    | DNTQ-25 4004-3EU-N DUP35UG | .157" (4mm)       | .984"  | .016"         | ●     |
| 82444 |                                    | DNTQ-25 5004-3EU-N DUP35UG | .197" (5mm)       | .984"  | .016"         | ●     |
| 82445 |                                    | DNTQ-25 6004-3EU-N DUP35UG | .236" (6mm)       | .984"  | .016"         | ●     |

“R” Round Nose



| UPC # | Application                      | Part Number                | Insert Size Width | Length | Radius           | Grade |
|-------|----------------------------------|----------------------------|-------------------|--------|------------------|-------|
| 82459 | Profiling<br>Turning<br>Grooving | DNTR-22 3015-3EU-N DUP35UG | .118" (3mm)       | .866"  | .059"<br>(1.5mm) | ●     |
| 82460 |                                  | DNTR-25 4020-3EU-N DUP35UG | .157" (4mm)       | .984"  | .079"<br>(2.0mm) | ●     |
| 82461 |                                  | DNTR-25 5025-3EU-N DUP35UG | .197" (5mm)       | .984"  | .098"<br>(2.5mm) | ●     |

“G” Square Nose



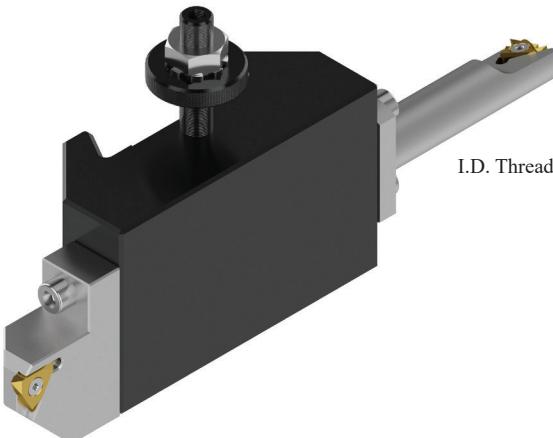
| UPC # | Application             | Part Number                | Insert Size Width | Length | Corner Radius | Grade |
|-------|-------------------------|----------------------------|-------------------|--------|---------------|-------|
| 82475 | Grooving<br>Parting-Off | DNPG-22 2002-1SR-N DPP40SG | .079" (2mm)       | .866"  | .008"         | ●     |
| 82476 |                         | DNPG-22 3002-1SR-N DPP40SG | .118" (3mm)       | .866"  | .008"         | ●     |
| 82477 |                         | DNPG-25 4003-1SR-N DPP40SG | .157" (4mm)       | .984"  | .012"         | ●     |
| 82478 |                         | DNPG-25 5004-1SR-N DPP40SG | .197" (5mm)       | .984"  | .016"         | ●     |
| 82479 |                         | DNPG-25 6004-1SR-N DPP40SG | .236" (6mm)       | .984"  | .016"         | ●     |

# Quadra® Quick Change-Toolholder Ordering Specification

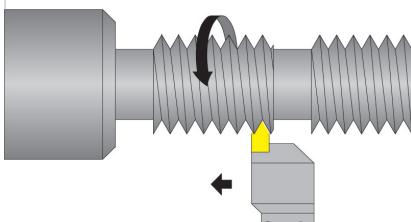
## No. QITPN-881 O.D. and I.D. Threading Toolholder

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.

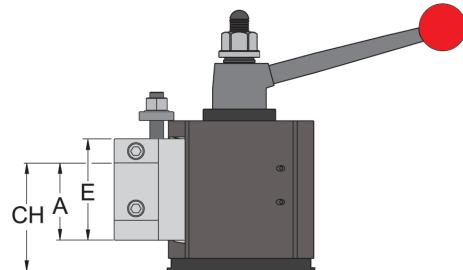
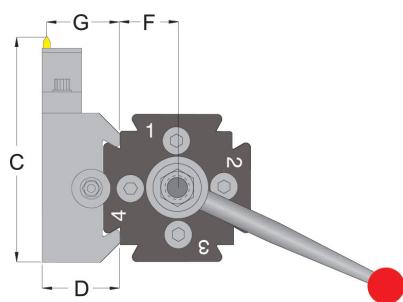
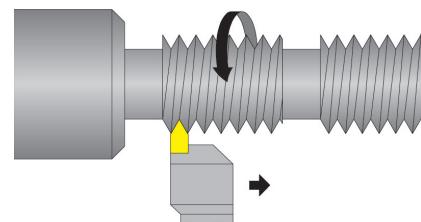
O.D. Threading Cartridge, for TNMC-32 NV inserts



I.D. Threading Bar, for \_IR-A60 Lay Down Insert



\*O.D. Cartridge for TNMC-32 insert



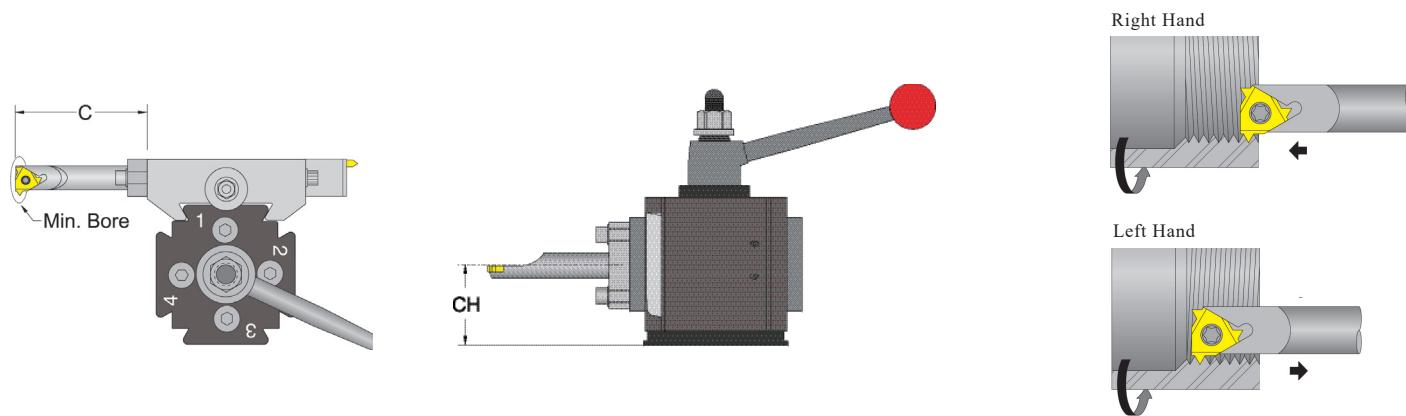
| Description    | UPC No. | *O.D. Cartridge for TNMC-32 insert |       |       |       |       |       |       | Desc.     | UPC No. | TNMC Insert | Torx Screw | Torx Key |
|----------------|---------|------------------------------------|-------|-------|-------|-------|-------|-------|-----------|---------|-------------|------------|----------|
|                |         | System                             | A     | C     | D     | E     | F     | G     |           |         |             |            |          |
| QITP25N-881-OE | 00132   | in                                 | 0.875 | 4.130 | 1.250 | 1.750 | 0.880 | 1.000 | TIH253-32 | 03621   | 32          | GTS-1M     | T-10     |
|                |         | mm                                 | 22.20 |       | 31.80 | 44.50 | 22.40 | 25.40 |           |         |             |            |          |
| QITP30N-881-OE | 00282   | in                                 | 1.000 | 4.630 | 1.500 | 2.000 | 1.115 | 1.250 | TIH354-32 | 03623   | 32          | GTS-1M     | T-10     |
|                |         | mm                                 | 25.40 |       | 38.10 | 50.80 | 28.30 | 31.80 |           |         |             |            |          |
| QITP35N-881-OE | 00434   | in                                 | 1.250 | 5.630 | 1.750 | 2.500 | 1.245 | 1.435 | TIH354-32 | 03623   | 32          | GTS-1M     | T-10     |
|                |         | mm                                 | 31.80 |       | 44.50 | 63.50 | 31.60 | 36.40 |           |         |             |            |          |
| QITP40N-881-OE | 00582   | in                                 | 1.500 | 6.130 | 1.750 | 2.500 | 1.530 | 1.435 | TIH354-32 | 03623   | 32          | GTS-1M     | T-10     |
|                |         | mm                                 | 38.10 |       | 44.50 | 63.50 | 38.90 | 36.40 |           |         |             |            |          |

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

# Quadra® Quick Change-Toolholder Ordering Specification

## 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.



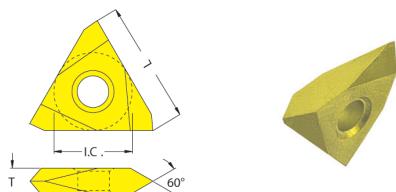
| Series      | Right Hand |             |           | Min. Bore |      | C     |      | Pitch |         | Insert I.C. | Torx Screw   | Torx Key |
|-------------|------------|-------------|-----------|-----------|------|-------|------|-------|---------|-------------|--------------|----------|
|     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

## Laydown Threading Insert 60° Partial Profile



| Lay-Down Internal Right Hand                |   |       |       |       | Lay-Down Internal Left Hand                 |   |       |       |       | Insert Specification |       |       |          |          |
|---|---|-------|-------|-------|---|---|-------|-------|-------|----------------------|-------|-------|----------|----------|
| Part No.                                    | Grade   | UPC   | Grade | UPC   | Part No.                                    | Grade   | UPC   | Grade | UPC   | L                    | I.C.  | TPI   | x        | y        |
| 11IR-A60                                    | DVP656  | 74056 | DVK10 | 74057 | 11IL-A60                                    | DVP656  | 74060 | DVK10 | 74061 | 11 mm                | 0.250 | 16-48 | 0,5-1,5  | 0,8, 0,9 |
| 16IR-A60                                    |   | 74064 |       | 74065 | 16IL-A60                                    |   | 74068 |       | 74069 | 16 mm                | 0.375 | 16-48 | 0,5-1,5  |          |
| 16IR-G60                                    |   | 74072 |       | 74073 | 16IL-G60                                    |   | 74076 |       | 74077 | 16 mm                | 0.375 | 8-14  | 1,75-3,0 | 1,2, 1,7 |
| 16IR-AG60                                   |   | 74080 |       | 74081 | 16IL-AG60                                   |   | 74084 |       | 74085 | 16 mm                | 0.375 | 8-48  | 0,5-3,0  |          |
| Carbon Steel, Alloy Steel & Stainless Steel | Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron |       |       |       | Carbon Steel, Alloy Steel & Stainless Steel | Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron |       |       |       |                      |       |       |          |          |

## On Edge TNMC 60° Negative Rake Threading Insert



| On Edge TNMC 60° Negative Rake Threading Insert |   |       |       |       | Insert Specification |      |      |         |       |      |           |        |        |        |
|---|---|-------|-------|-------|----------------------|------|------|---------|-------|------|-----------|--------|--------|--------|
| Part No.  | Grade   | UPC   | Grade | UPC   | I.C.                 |      | TPI  |         | T     |      | Hole Dia. |        | Depth. |        |
|   |   |       |       |       | I.C.                 | L    |      |         |       |      |           |        |        |        |
| TNMC-32NV-                                      | DVP656  | 72003 | DVK10 | 72004 | 0.375                | 16mm | 8-48 | 0.5-3.0 | 0.125 | 3,18 | 0.150     | 3,81mm | 0.150  | 3,81mm |
| Carbon Steel, Alloy Steel & Stainless Steel     | Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron |       |       |       |                      |      |      |         |       |      |           |        |        |        |

# Quadra® Indexing Quick Change Tool Post & Toolholders Sets

## Quadra® Indexing Quick Change Tool Post First Time Buyer Set

### Quadra® First Time Buyer SET Includes FREE TOOLING

Set Includes:

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



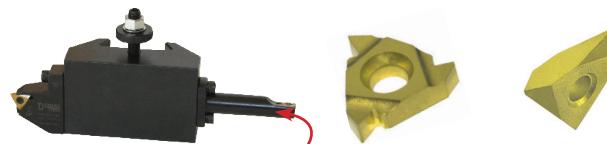
1ea. QITPN-1 + **Free** Square Shank Toolholder & 1 **Free** Turning Insert



1ea. QITPN-2 + **Free** Boring Bar & 1 **Free** Insert



1ea. QITPN-7-71C + **Free** Twin Edge Blade & 1 **Free** Insert Insert



1ea. QITPN-881 + **Free** threading boring bar & 1 **Free** TNMC OnEdge Insert & 1 **Free** Laydown Threading Insert

| UPC No. 733101-     | 00056  | 00058  | 00060  | 00062  |
|---------------------|--|--|--|--|
| Description         | QITP25N-FTB  | QITP30N-FTB  | QITP35N-FTB  | QITP40N-FTB  |
| Lathe Swing         | Up to 12"  | 13" to 15"   | 14" to 17"   | 16" to 20"   |
| <b>Set Includes</b> |  |  |  |  |
| (1) Tool Post       | QITP25N  | QITP30N  | QITP35N  | QITP40N  |
| (4) Holders         | QITP25N-1<br>QITP25N-2<br>QITP25N-7-71C<br>QITP25N-881-OE  | QITP30N-1<br>QITP30N-2<br>QITP30N-7-71C<br>QITP30N-881-OE  | QITP35N-1<br>QITP35N-2<br>QITP35N-7-71C<br>QITP35N-881-OE  | QITP40N-1<br>QITP40N-2<br>QITP40N-7-71C<br>QITP40N-881-OE  |
| <b>Free Tooling</b> |  |  |  |  |
| (4)Toolholders      | STNCR08-2J<br>STCMB06-2<br>TWECOB-DNTF-19-20<br>NL50R  | STNCR10-2A<br>STCMB08-2<br>TWECOB-DNTF-19-20<br>NL50R  | STNCR12-3B<br>STCMB10-2<br>TWECOB-DNTF-26-30<br>NL75R  | STNCR64-3D<br>STCMB12-3<br>TWECOB-DNTF-26-30<br>NL75R  |
| (5) Inserts         | TCMT-21.51-PEM-DPC25UT<br>TCMT-21.52-PEM-DPC25UT<br>DNTQ-222002-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>11IR-A60-DVP656 | TCMT-21.51-PEM-DPC25UT<br>TCMT-21.52-PEM-DPC25UT<br>DNTQ-222002-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>11IR-A60-DVP656 | TCMT-21.51-PEM-DPC25UT<br>TCMT-32.52-PEM-DPC25UT<br>DNTQ-223003-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>16IR-A60-DVP656 | TCMT-32.51-PEM-DPC25UT<br>TCMT-32.52-PEM-DPC25UT<br>DNTQ-223003-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>16IR-A60-DVP656 |

# Quadra® Indexing Quick Change Tool Post & Toolholders Sets

## Quadra® Indexing Quick Change Tool Post Turning Set

### Turning Set Includes

(1) Tool Post

(4) Holders

Tooling Not Included



QITPN-1



QITPN-1



QITPN-2



QITPN-2

| UPC No. 733101-     | <b>00014</b>                   | <b>00015</b>                   | <b>00016</b>                   | <b>00017</b>                   | <b>00018</b>                   | <b>00019</b>                   |
|---------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| 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"                          |
| <b>Set Includes</b> |                                |                                |                                |                                |                                |                                |
| (1) Tool Post       | QITP25N                        | QITP30N                        | QITP35N                        | QITP40N                        | QITP50N                        | QITP60N                        |
| (4) Holders         | (2) QITP25N-1<br>(2) QITP25N-2 | (2) QITP30N-1<br>(2) QITP30N-2 | (2) QITP35N-1<br>(2) QITP35N-2 | (2) QITP40N-1<br>(2) QITP40N-2 | (2) QITP50N-1<br>(2) QITP50N-2 | (2) QITP60N-1<br>(2) QITP60N-2 |

## Quadra® Indexing Quick Change Tool Post Standard Set

### Standard Set Includes

(1) Tool Post

(4) Holders

Tooling Not Included



QITPN-1



QITPN-2



QITPN-4-CNC



QITPN-7-71C

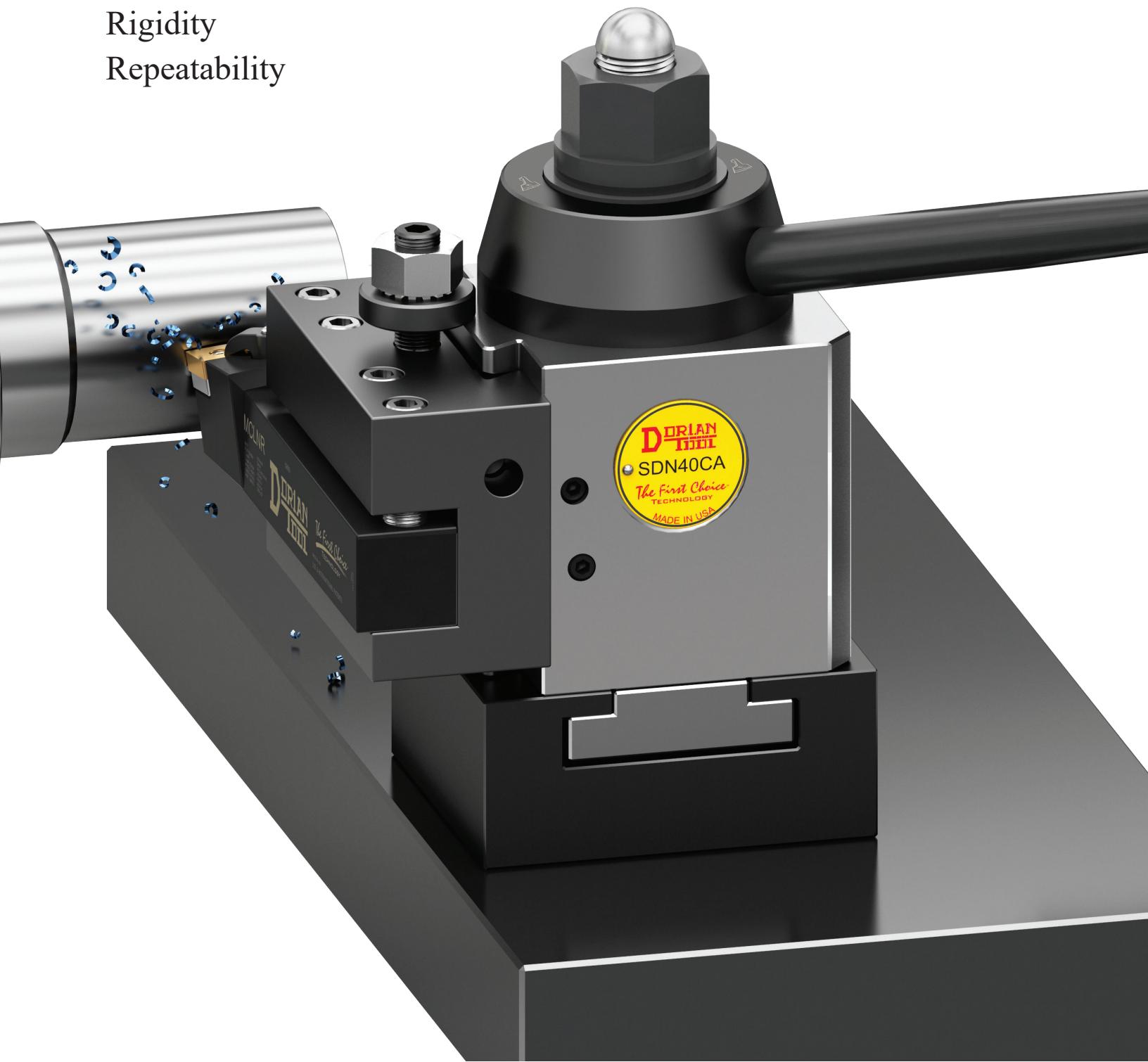
| UPC No. 733101-     | <b>00020</b>   | <b>00021</b>   | <b>00022</b>   | <b>00023</b>   | <b>00024</b>   | <b>00025</b>   |
|---------------------|--|--|--|--|--|--|
| Desc.               | QITP25N-INSS   | QITP30N-INSS   | QITP35N-INSS   | QITP40N-INSS   | QITP50N-INSS   | QITP60N-INSS   |
| Lathe Swing         | Up to 12"  | 13" to 15"   | 14" to 17"   | 16" to 20"   | 17" to 32"   | ≥ 25"  |
| <b>Set Includes</b> |  |  |  |  |  |  |
| (1) Tool Post       | QITP25N  | QITP30N  | QITP35N  | QITP40N  | QITP50N  | QITP60N  |
| (4) Holders         | (1) QITP25N-1<br>(1) QITP25N-2<br>(1) QITP25N-4-CNC<br>(1) QITP25N-7-71C | (1) QITP30N-1<br>(1) QITP30N-2<br>(1) QITP30N-4-CNC<br>(1) QITP30N-7-71C | (1) QITP35N-1<br>(1) QITP35N-2<br>(1) QITP35N-4-CNC<br>(1) QITP35N-7-71C | (1) QITP40N-1<br>(1) QITP40N-2<br>(1) QITP40N-4-CNC<br>(1) QITP40N-7-71C | (1) QITP50N-1<br>(1) QITP50N-2<br>(1) QITP50N-4-CNC<br>(1) QITP50N-7-71C | (1) QITP60N-1<br>(1) QITP60N-2<br>(1) QITP60N-4-CNC<br>(1) QITP60N-7-71C |

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## Notes

# Super Quick Change Tool Post

Quality  
Performance  
Rigidity  
Repeatability



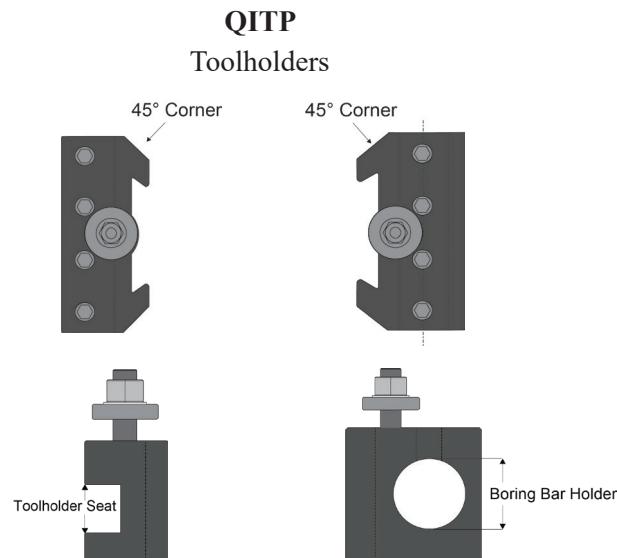
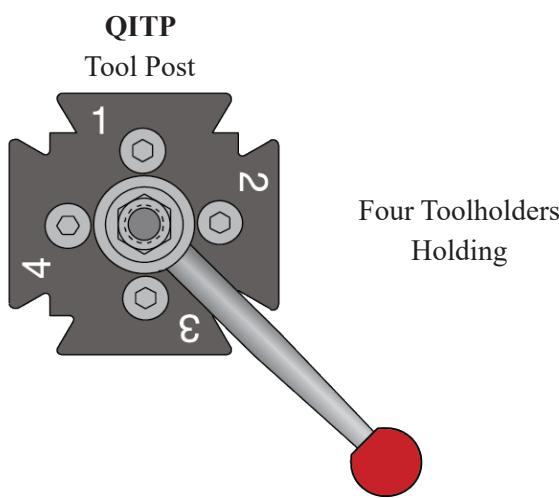
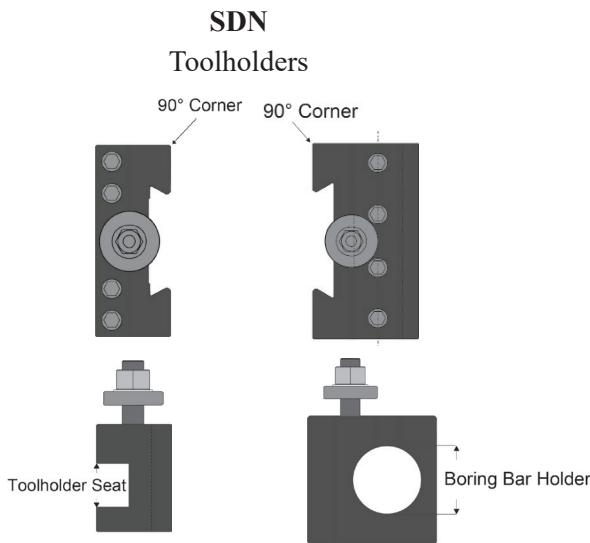
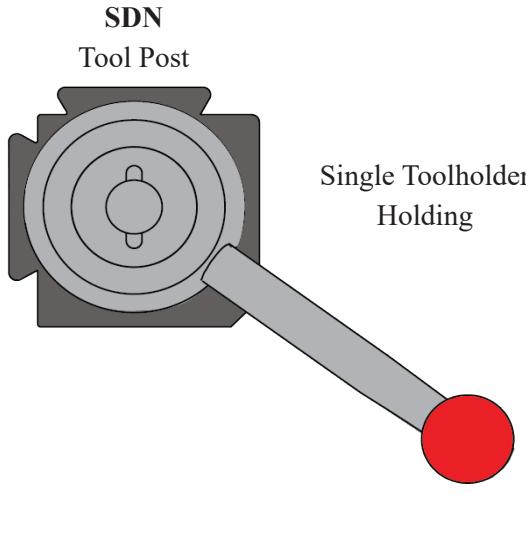
# SDN Tool Post and Toolholders Sizes & Crossover

All the Quadra and SDN Quick Change Toolholders, are built with 4140 Chromium- Molybdenum Hight Strength Alloy Steel, for Rigidity, Stability & Performance.

The Toolholders, are treated with a Special Low Temperature Heat Treading Process, to Protect the Toolholders Surface, while reducing to the minimum Cutting Vibration.

The Toolholders, Number 1 & 2, as Standard, are built larger then the industry's standard, to hold a wider range of oversize Cutting Tools

All the Quadra & SDN Boring Bar Holders, Features a DUAL Locking System for Maximum Rigidity, Stability & Performance in the Roughing Operation, and High Surface Finishing & Close Tolerances for finishing Operation

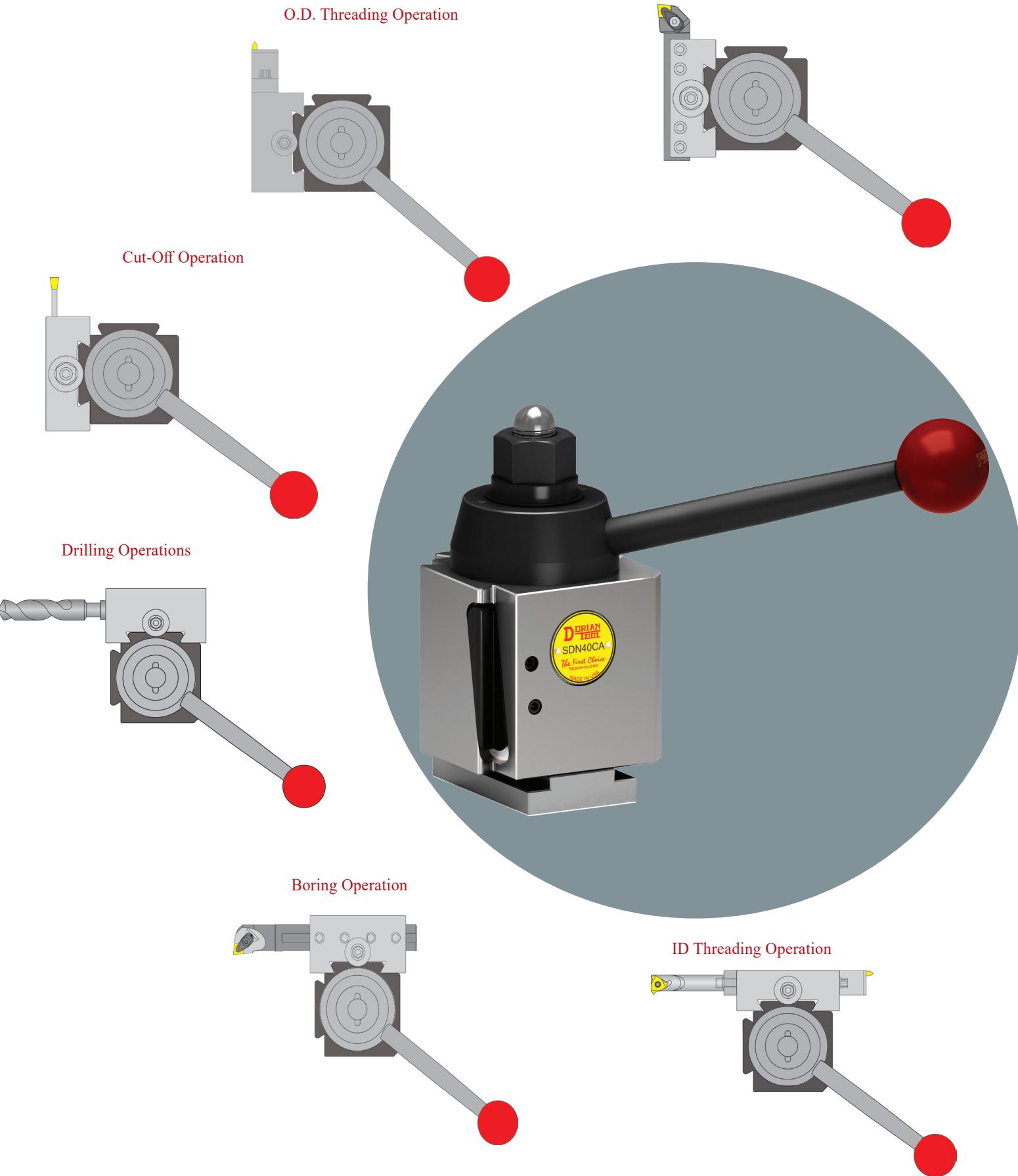


Boring Bar Capacity  
See Boring Bar Holder Chart pages xx to xx

| SDN & QITP Crossover |          | Tool Post Size Nominal Dimension |        | Toolholder Capacity |         | Boring Toolholder      |
|----------------------|----------|----------------------------------|--------|---------------------|---------|------------------------|
| Super Quick Change   | Quadra ® | Inch                             | mm     | Inch                | mm      | See Boring Bar Holders |
| SDN25AXA             | QITP25N  | 2.500                            | 63.5   | 1/2 - 3/4           | 12 - 20 |                        |
| SDN30BXA             | QITP30N  | 3.000                            | 76.2   | 5/8 - 1.0           | 16 - 25 |                        |
| SDN35CXA             | QITP35N  | 3.500                            | 88.9   | 3/4 - 1.0           | 20 - 25 |                        |
| SDN40CA              | QITP40N  | 4.000                            | 101.60 | 1.0 - 1 1/4         | 25 - 32 |                        |
| SDN50DA              | QITP50N  | 5.000                            | 127.0  | 1 1/4 - 1 1/2       | 32 - 40 |                        |
| SDN60EA              | QITP60N  | 6.000                            | 152.4  | 1 1/2               | 40.0    |                        |

# SDN Tool Post and Toolholders Turning Application

Turning Operations



# SDN Quick Change Tool Post Cross Section

## Holding Post;

The Holding Post, go thru the guide bushing, and threads in to the T-Nut, the flange nut, threads in to the upper end, locking the Tool Post in place.

## Flange Nut;

Threads in to the Holding Post, to lock the Tool Post in position over the lathe compound

## Locking Gear Head;

Engages in to the locking gear, and moved by the locking handle, to lock and unlock the Toolholder

## O Rings;

To seal the locking system from chips and debris

## Tool Post Body;

Is built with AISI 4140 Alloy Steel, a Chromium Molybdenum, Manganese, known for its Toughness, High Fatigue & Torsional Strength. The material is throughout Heat Treated and Stress Relieved. To Increase wear and fatigue resistance of the Tool Post working surface, a Plasma Nitriding process is applied to the Tool Post before grinding, making its life almost endless under any working condition

## Sliding Taper Gibs;

The sliding taper Gibs, move up and down with the locking gear, to lock and unlock the Toolholder

## Anti Rotation Pins;

Two Pins, are connect between the Tool Post and the T-Nut, to prevent the Tool to rotate under heavy duty cutting operation

## Locking handle;

The function of the Tool Post, is to hold a Toolholder to perform the machining operation with the maximum rigidity and repeatability, in pulling the Locking Handle the sliding gibbs, will pull and lock the Toolholder against the Tool Post ready to cut.

## O Rings;

To seal the locking system from chips and debris

## Bottom Thrust Washer;

Is calibrate to minimize the backlash between the locking gear and the sliding gibbs when in locking and unlocking the Toolholder.

## Guide Bushings;

A stationery Bushing threaded in to the tool post Body and locked down with a flange nut to hold the Tool Post in place

## Locking Gear;

A double lead thread gear, engaged to the sliding taper gibbs, that locks and unlocks the Toolholder

## T-Nut;

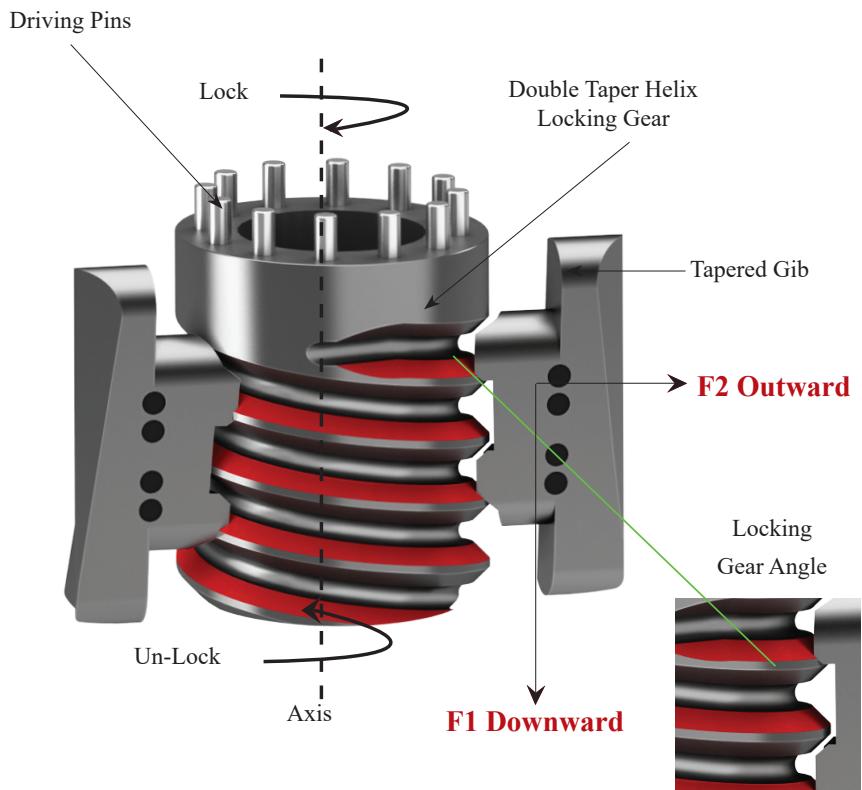
The T-Nut fits in to the compound slot, and through the holding post flange nut, will lock the Tool Post down rigidly.

## Guiding Pins & Set Screws;

To hold sliding gibbs in place

# SDN Quick Change Tool Post Cross Section

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



## 1. F1 Downward Force:

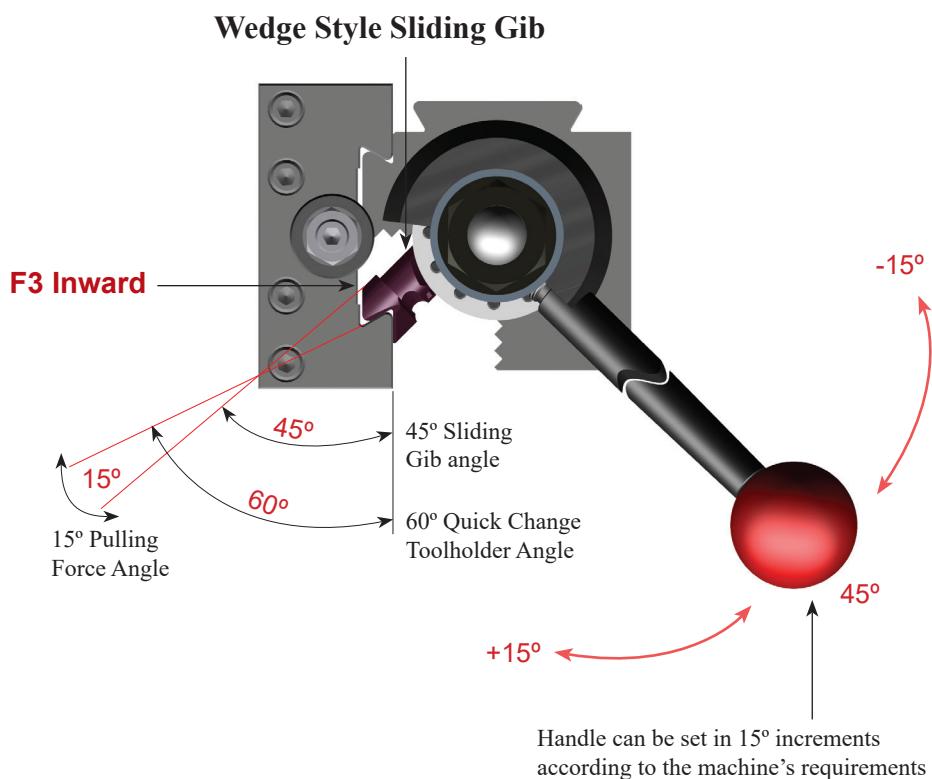
(shown right) Rotating the locking gear moves the gib down, expanding the tool post dovetail to lock the toolholder.

## 2. F2 Outward Force:

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

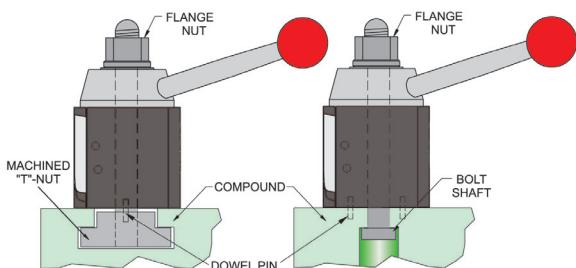
## 3. F3 Inward Force:

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



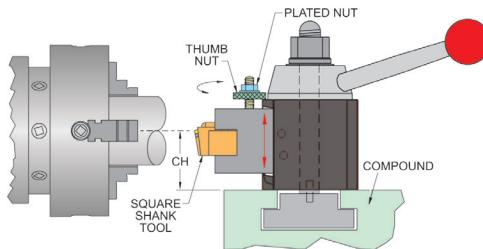
# SDN Quick Change Tool Post Technical Information

## Tool Post Mounting



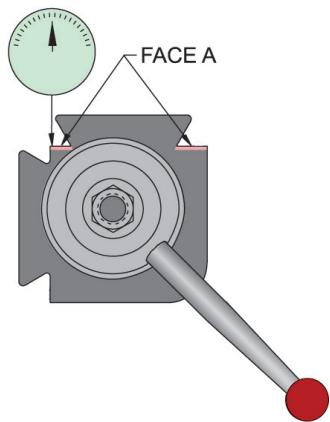
The tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flange Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using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

## Center Height Adjustment



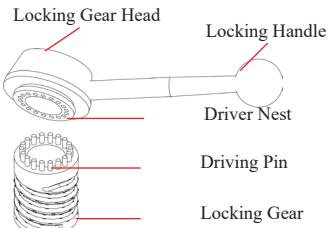
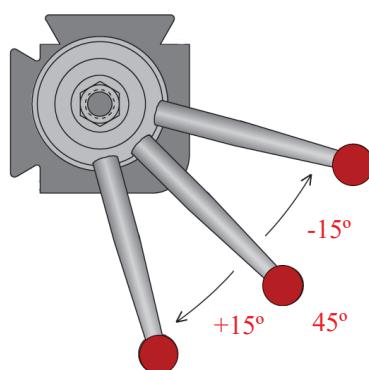
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool by rotating the Thumb Nut until the desired height is reached and locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool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

## Indicating Position



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

## Locking Handle Positioning

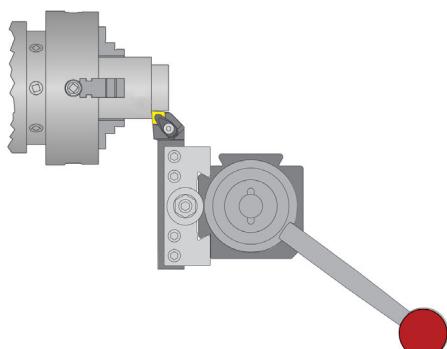


To change the position of the handle: remove the \*flange nut; remove the \*guide bushing; pull the locking gear head and place to the desired position.

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

## O.D. Turning Operations

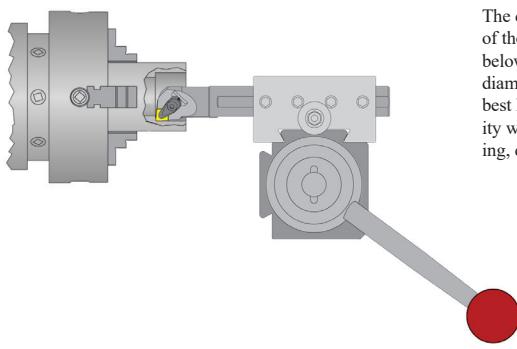
Turning, Threading, Cut-Off, Grooving, & Chamfering



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

## I.D. Turning Operations

Boring, Threading, Grooving, Drilling, & Center Drilling



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

# SDN Quick Change Tool Post Cutting Tool Center Height Set-Up

## Factors that determine the proper Tool Post for a specific lathe:

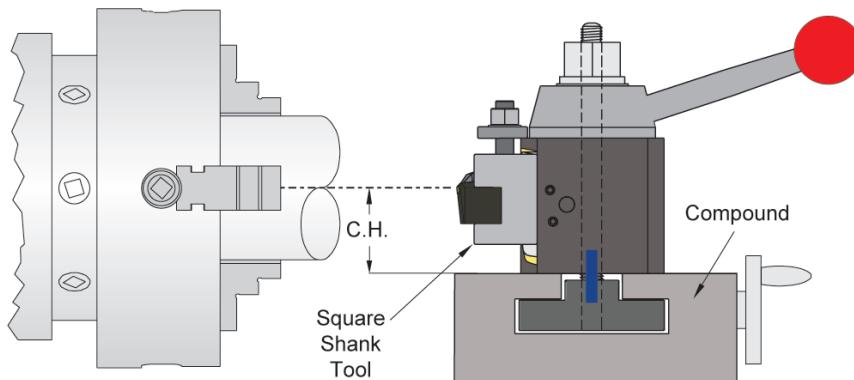
- |                            |                      |                            |
|----------------------------|----------------------|----------------------------|
| 1. Lathe Swing             | 5. Motor Horse power | 9. Prototype or Production |
| 2. Tool Center Height      | 6. Maximum Chuck RPM | 10. Light Duty Work        |
| 3. Tool Size               | 7. Type of Lathe     | 11. Heavy Duty Work        |
| 4. Tool Post Mounting type | 8. Type of Work      |                            |

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

"CH" = Center Height is measured from top of compound to lathe center line  
 "P" = Toolholder bottom lip  
 "B" = Tool Post Height (See page 17)

"E" = Tool Post Toolholder Height (See page )  
 "T" = Turning Toolholder  
 "C.H." = Tool Center Height

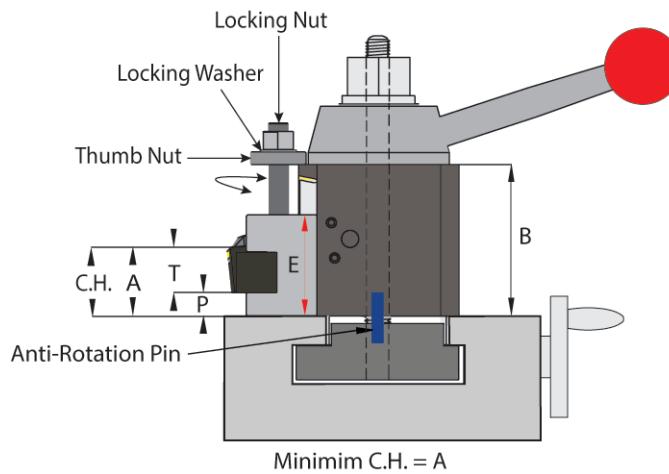
**Optimum**  
Center Height



## Tool Post Mounting Technical Notes

Mount the Tool Post T-Nut into the Compound  
 For Best Rigidity Install Anti Rotation Pins.  
 Set the Tool Post Square with the Lathe Bedway  
 Lock Tool Post Properly

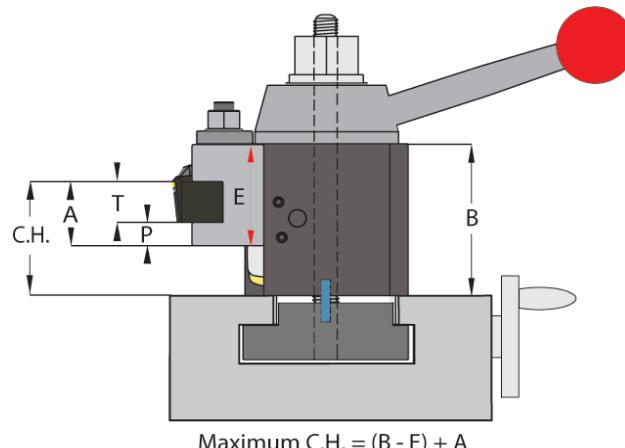
**Minimum**  
Center Height



## Toolholder Center Height Technical Notes

Place the Toolholder on the Tool post, but not locked.  
 Loose the Locking Nut.  
 Turn the Thumb Nut up or down till the Insert tip is centered with the Lathe Center Line.  
 Lock the Toolholder.

**Maximum**  
Center Height



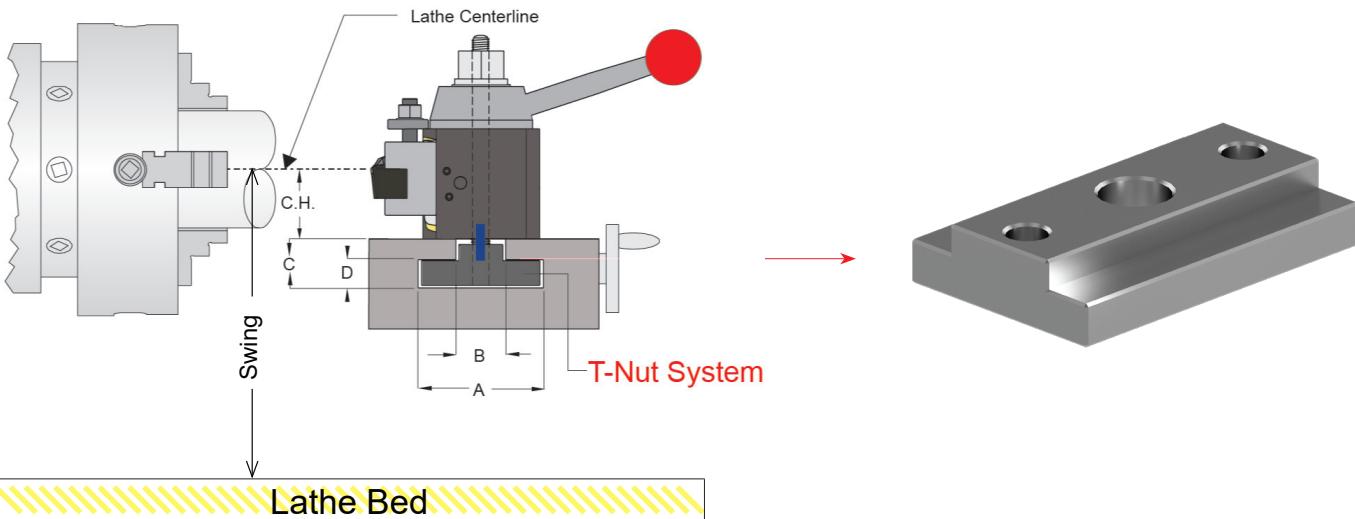
## Center and Cutting Tool Capacity Technical Notes

The recommended cutting tool size should be used.  
 The Minimum Center Height, is when the Toolholder is all the way down.  
 If the Insert is above the Lathe C.L. use a Small Cutting Tool.  
 The Maximum Center Height, is when the Toolholder is all the way up.  
 If the insert is below the Lathe C.L., use a Large Cutting Tool.

# SDN Quick Change Tool Post Mounting System

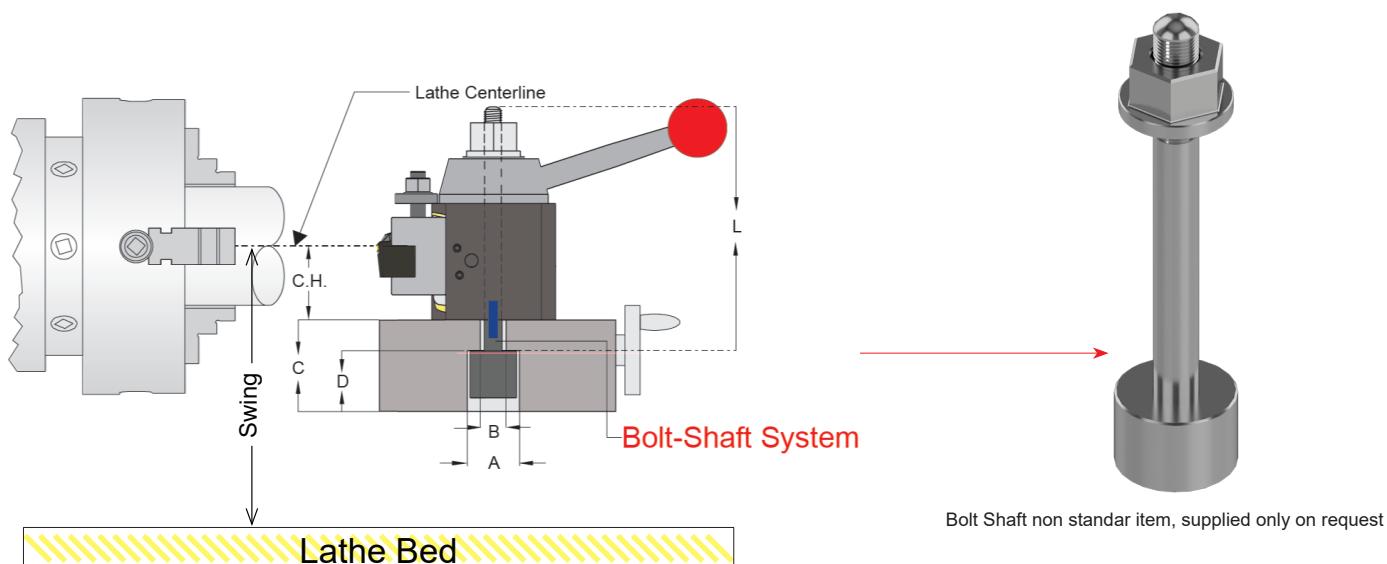
## American Mounting System

A customized T-Nut is used to Lock Down the Tool Post.  
For T-Nut Specification, See pages 8 & 9



## European Mounting System

A customized Bolt-Shaft is used to Lock Down the Tool Post  
For T-Nut Specification, See pages 8 & 9

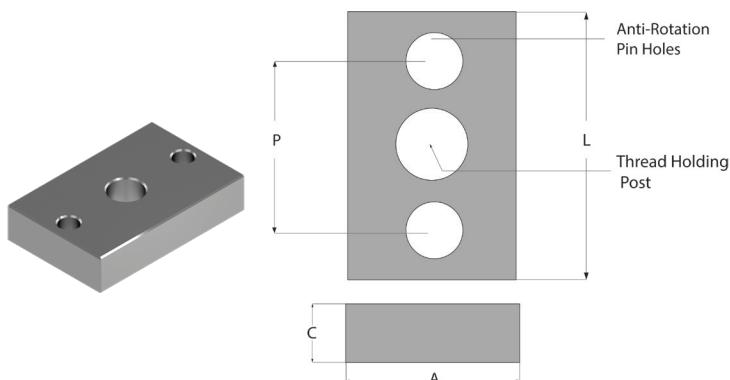


Each Tool Post is supplied with a Blank T-Nut or Bolt Shaft that the customer machines to their required dimensions. For custom machined T-Nut or Bolt Shaft, please specify the dimensions A, B, C, and D precise within +/- .003in.

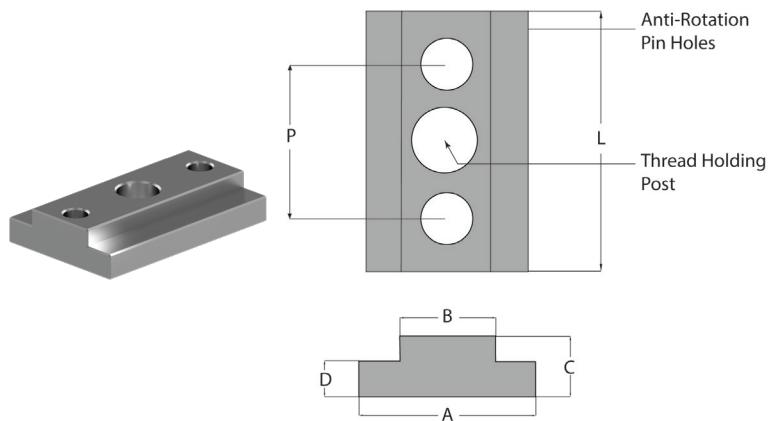
\* Please place an X for American or European mounting Style in the boxes above.

# SDN T-Nut Data

## Blank T-Nut



## Machined T-Nut



### SDN Tool Post

#### Blank T-Nut

| Reference Tool Post | Blank T-Nut UPC No. | A     | C     | L    | Thread Size | Anti-Rotation Pin Size | P     |
|---------------------|---------------------|-------|-------|------|-------------|------------------------|-------|
| SDN25AXA            | 73310106009         | 1.5"  | 1/2"  | 2.5" | 1/2 - 20    | 10mm                   | 50mm  |
| SDN30BXA            | 73310106027         | 2"    | 5/8"  | 3"   | 5/8 - 18    | 10mm                   | 60mm  |
| SDN35CXA            | 73310106060         | 2.25" | 3/4"  | 3.5" | 3/4 - 16    | 10mm                   | 70mm  |
| SDN40CA             | 73310106073         | 2.5"  | 3/4"  | 4"   | 7/8 - 14    | 12mm                   | 80mm  |
| SDN50DA             | 73310106088         | 3."   | 1.25" | 5"   | 1 - 14      | 12mm                   | 100mm |
| SDN60EA             | 73310106107         | 4"    | 1.5"  | 6"   | 1-1/8 - 12  | 12mm                   | 120mm |

The Blank T-Nut is supplied with the Tool Post at no extra charge.

### SDN Tool Post

#### Machined T-Nut

| Reference Tool Post | Machined T-Nut UPC No. | A | B | C | D | L    | Thread Size | Anti-Rotation Pin Size | P     |
|---------------------|------------------------|---|---|---|---|------|-------------|------------------------|-------|
| SDN25AXA            | 73310101187            |   |   |   |   | 2.5" | 1/2 - 20    | 10mm                   | 50mm  |
| SDN30BXA            | 73310101337            |   |   |   |   | 3"   | 5/8 - 18    | 10mm                   | 60mm  |
| SDN35CXA            | 73310101487            |   |   |   |   | 3.5" | 3/4 - 16    | 10mm                   | 70mm  |
| SDN40CA             | 73310101637            |   |   |   |   | 4"   | 7/8 - 14    | 12mm                   | 80mm  |
| SDN50DA             | 73310101787            |   |   |   |   | 5"   | 1 - 14      | 12mm                   | 100mm |
| SDN60EA             | 73310101937            |   |   |   |   | 6"   | 1-1/8 - 12  | 12mm                   | 120mm |

Dimensions to be specified.

#### Machined T-Nut Dimensions (Fill the blanks)

| Reference Tool Post | Unit | A | B | C | D | L | Make & Model of Lathe | Lathe Swing Over Bed | CH | Tool Size |
|---------------------|------|---|---|---|---|---|-----------------------|----------------------|----|-----------|
| SDN                 | Inch |   |   |   |   |   |                       |                      |    |           |
|                     | mm   |   |   |   |   |   |                       |                      |    |           |

# SDN Quick Change Tool Post & Toolholders Structure Specification

## Structure Specifications

## Features

## Application

### SUPER Quick Change Tool Post

Page B-30



6 sizes of the Tool Post are available

2.5"/63mm, 3.0"/76mm, 35"/88mm,  
4.0"/101mm, 5.0"/126mm, 6.0"/152mm

Toolholders Capacity, from 3/8"/10mm  
to 1-1/2"/40mm

Designed with the most Advanced Technology

Manufactured with the Highest Quality

The Best Turning Performance of any Tool Post

For all the Multi Turning Application

From Prototype to High Production

From High Precision to Heavy Roughing

### No. D-1 Turning & Facing Holder

Page B-31



Holder are Built with 4140 Chromium-Molybdenum Alloy Steel

Special Heat Treat Process to protect Surface, & minimize Cutting Vibration

Quick Change Mounting

Toolholder Interchangeability within .0001"/.00127mm

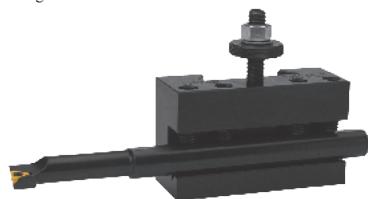
Toolholder Squareness and Parallel .0005" x inch/.00127 mm

Over size Capacity for large Indexable Square Shank

For Multi Turning Operation, when a Square Shank is used

### No. D2 Turning, Facing & Boring Holder

Page B-31



Holder are Built with 4140 Chromium-Molybdenum Alloy Steel

Special Heat Treat Process to protect Surface, & minimize Cutting Vibration  
Quick Change Mounting

Toolholder Flat, has a "V" Groove to hold a Round Boring Bar

Toolholder Interchangeability within .0001"/.00127mm

Toolholder Squareness and Parallel .0005" x inch/.00127 mm

Over size Capacity for large Indexable Square Shank

Capable to hold Square Shank & Boring Bar

Wide Range Turning Operation, when a Square Shank & Boring Bar are used

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

Page B-32 - B-33



Holders are Built with 4140 Chromium-Molybdenum Alloy Steel

Special Heat Treat Process to protect Surface, & minimize Cutting Vibration

Quick Change Mounting

Built with DOUBLE Boring Bar Locking System

360° Collar Locking System

Self Centering Screw Lock System

For Boring Bar with & without Flats

Toolholder Interchangeability within .0001"/.00127mm

Toolholder Squareness and Parallel .0005" x inch/.00127 mm

For All the Boring Operation when a Round Tool is used

**NEW**

## 360 ° Double Locking System

### For Quick & Precise Set-Up with the Maximum Rigidity

The new DUAL Boring Bar Holder, has been engineered to maximize the holding force of the Boring Bar, in achieving the most possible Boring rigidity for Heavy Duty Roughing, and Stability for High Surface Finishing and Close Boring Tolerances.

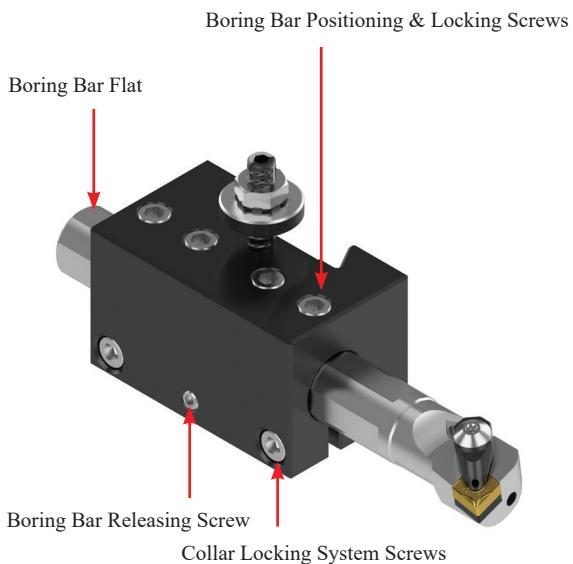
#### Features:

- Dual Locking System
- Set Screws Locking System
- 360° Collar Locking System

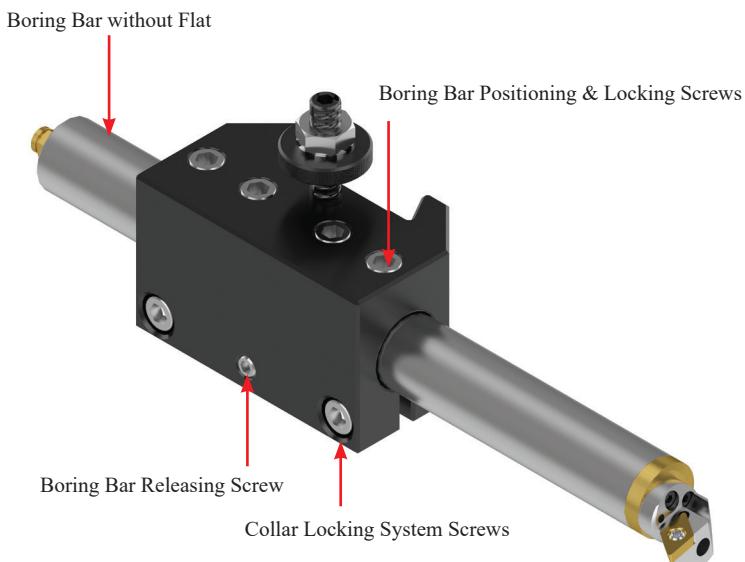
- Langer Inserts Life
- Maximum Locking Force
- Maximum Rigidity & Stability

- Higher Productivity
- Best Roughing Performance
- Best Surface Finish & Tolerance

### Mounting of a Boring Bar with Flats

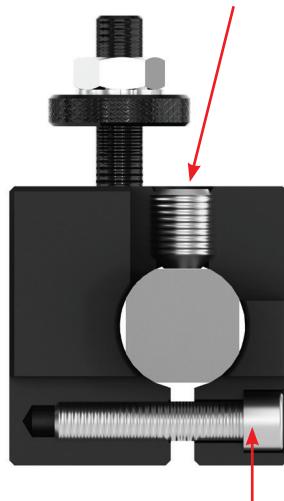


### Mounting of a Boring Bar without Flats



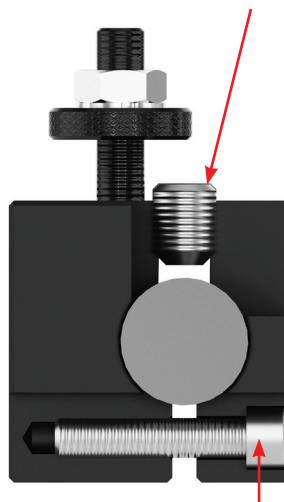
### Locking Instruction

Boring Bars with **flats**, Lock the Position Screws gently to set the Boring Bar on Center Line



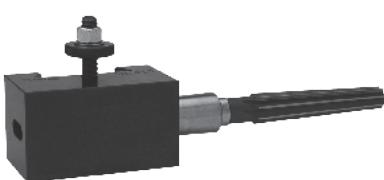
Once The Boring is on center line, lock the holder side screws. The Boring Bar, is locked 360° around the Diameter in to the Holder, tight down the position screws. The **DUAL** locking System, will fuse the Boring Bar with the Holder in One Unit, achieving the best possible Boring Rigidity & Stability.

Boring Bars without **flats**, Turn the Position Screws up, do not touch the Boring Bar Surface.

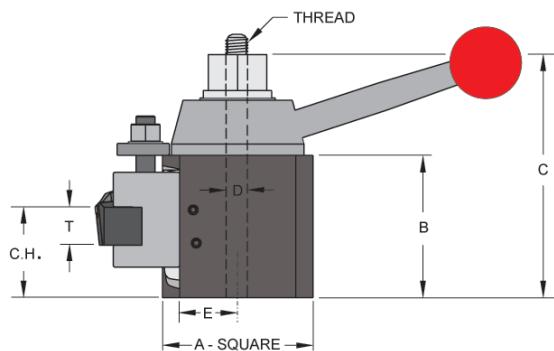
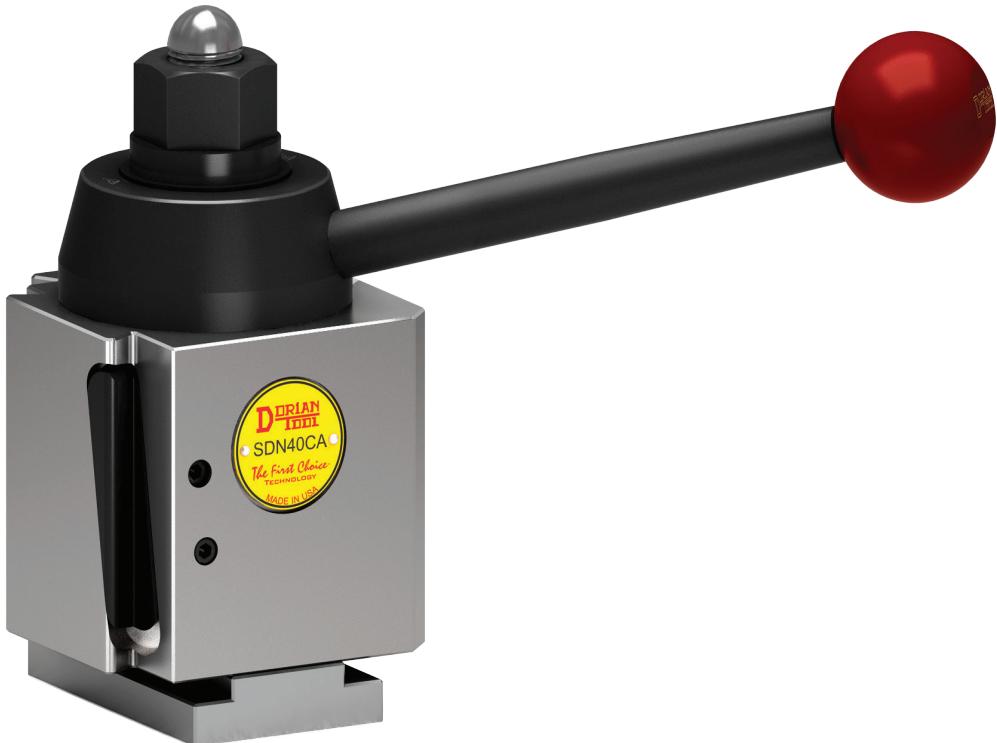


Set-Up the Boring on center line, lock the holder side screws, The Boring Bar, is locked 360° around the Diameter in to the Holder, fusing in One the Boring Bar with the Holder, achieving the best possible Boring Rigidity & Stability

# SDN Quick Change Tool Post & Toolholders Structure Specification

|  | Structure Specifications  | Features  | Applications                                  |
|--|---|---|---|
| <b>No. D5 Morse Taper Holder</b>   |   |   |   |
| Page B-33  |   |   |   |
|    |   |   |   |
|  | Holder are Built with 4140 Chromium-Molybdenum Alloy Steel                  | Toolholder Interchangeability within .0001"/.00127mm              | All the Drilling, Reaming, Tapping, Operation |
|  | Special Heat Treat Process to protect Surface, & minimize Cutting Vibration | Toolholder Squareness and Parallel .0005" x inch/.00127 mm        | using Drill Chuck or Morse Taper              |
|  | Quick Change Mounting   |   | Heavy Duty Drilling Operation                 |
| <b>No. D7-71C Reversible Twin Cut-Off Blade Holder</b>                             |   |   |   |
| Page B-34  |   |   |   |
|   |   |   |   |
|  | Holder are Built with 4140 Chromium-Molybdenum Alloy Steel                  | Toolholder Interchangeability within .0001"/.00127mm              | Cut-Off Operation                             |
|  | Special Heat Treat Process to protect Surface, & minimize Cutting Vibration | Toolholder Squareness and Parallel .0005" x inch/.00127 mm        | Grooving Operation                            |
|  | Quick Change Mounting   | Holds Industry Standard Sizes Cut-Off Blades                      |   |
| <b>No. D881 O.D. or I.D. Threading Holder</b>                                      |   |   |   |
| Page B-36  |   |   |   |
|  |   |   |   |
|  | Holder are Built with 4140 Chromium-Molybdenum Alloy Steel                  | Toolholder Interchangeability within .0001"/.00127mm              | O.D. and I.D. Threading                       |
|  | Special Heat Treat Process to protect Surface, & minimize Cutting Vibration | Toolholder Squareness and Parallel .0005" x inch/.00127 mm        |   |
|  | Quick Change Mounting   | Holds OD Threading Cartridge                                      |   |
|  |   | Holds ID Threading Bar  |   |
|  |   | Easy to Set-Up, Simple to Use                                     |   |
|  |   | Uses Industry Style Threading Inserts                             |   |
| <b>No. D35 Dovetail Drill Chuck Holder</b>   |   |   |   |
| Page B-38  |   |   |   |
|  |   |   |   |
|  | Holder are Built with 4140 Chromium-Molybdenum Alloy Steel                  | Toolholder Interchangeability within .0001"/.00127mm              | Versatile for Multi Operation                 |
|  | Special Heat Treat Process to protect Surface, & minimize Cutting Vibration | Toolholder Squareness and Parallel .0005" x inch/.00127 mm        | Drilling, Boring, Reaming, Threading          |
|  | 2 Pieces Construction, for Precise Parallelism Calibration                  | Holds a 1/2"/12.7mm capacity, precise, Strong & Rigid Drill Chuck | Using Standard Tools or Special Tool          |
|  | Supplied with Rohm Drill Chuck  |   |   |
|  | Quick Change Mounting   |   |   |
| <b>No. D36 5C Collet Holder</b>  |   |   |   |
| Page B-38  |   |   |   |
|  |   |   |   |
|  | Special Heat Treat Process to protect Surface, & minimize Cutting Vibration | Toolholder Interchangeability within .0001"/.00127mm              | Versatile for Multi Operation                 |
|  |   | Toolholder Squareness and Parallel .0005" x inch/.00127 mm        | Drilling, Boring, Reaming, Turning            |
|  |   | Holds 5 C Collets Series  | Using Standard Tools or Special Tool          |
|  |   | Accept, Round, Square & Hexagonal Collets                         |   |

# Super Quick Change Tool Post



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

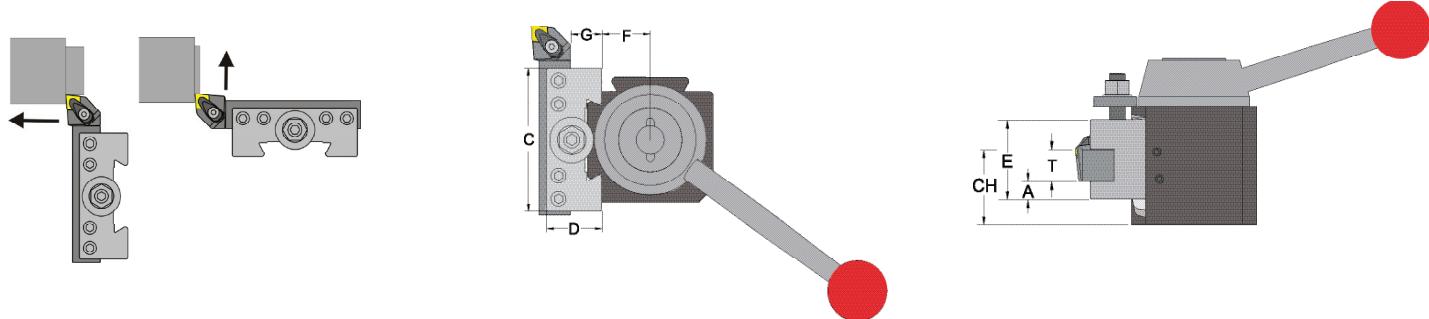
| Description          | SDN25AXA |       | SDN30BXA |         | SDN35CXA |         | SDN40CA |         | SDN50DA |         | SDN60EA |         |
|----------------------|----------|-------|----------|---------|----------|---------|---------|---------|---------|---------|---------|---------|
| UPC No.              | 01000    |       | 01002    |         | 01004    |         | 01006   |         | 01008   |         | 01010   |         |
| System               | in       | mm    | in       | mm      | in       | mm      | in      | mm      | in      | mm      | in      | mm      |
| Lathe Swing Over Bed | ≤12      | ≤300  | 13-15    | 330-380 | 14-17    | 350-430 | 16-20   | 400-500 | 17-32   | 430-810 | ≥25     | ≥635    |
| A                    | 2.500    | 63    | 3.000    | 76      | 3.500    | 88      | 4.000   | 101     | 5.000   | 126     | 6.000   | 152     |
| 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      | 3/8-3/4  | 10-20 | 1/2-1.0  | 12-25   | 3/4-1.0  | 20-25   | 1.0-1½  | 25-32   | 1¼ - 1½ | 32-40   | 1 ½     | 40.0    |
| Optimum C.H.*        | 1.250    | 31.75 | 1.312    | 33.32   | 1.625    | 41.28   | 1.937   | 49.20   | 2.562   | 65.07   | 3.000   | 76.20   |
| C.H. MIN.            | 0.875    | 22.2  | 1.062    | 27.0    | 1.250    | 31.8    | 1.562   | 39.7    | 2.000   | 50.80   | 2.500   | 63.5    |
| C.H. MAX.            | 1.875    | 47.63 | 1.937    | 49.20   | 2.250    | 57.75   | 2.562   | 65.07   | 3.575   | 85.73   | 3.500   | 88.90   |
| Thread               | 1/2-20   |       | 5/8-18   | M16x2,0 | 3/4-16   | M18x2,5 | 7/8-14  | M20x1,5 | 1.0-14  | M24x3,0 | 1 ½-12  | M27x3,0 |

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

# SDN-Toolholder Ordering Specification

## No. D1 Turning & Facing Toolholder

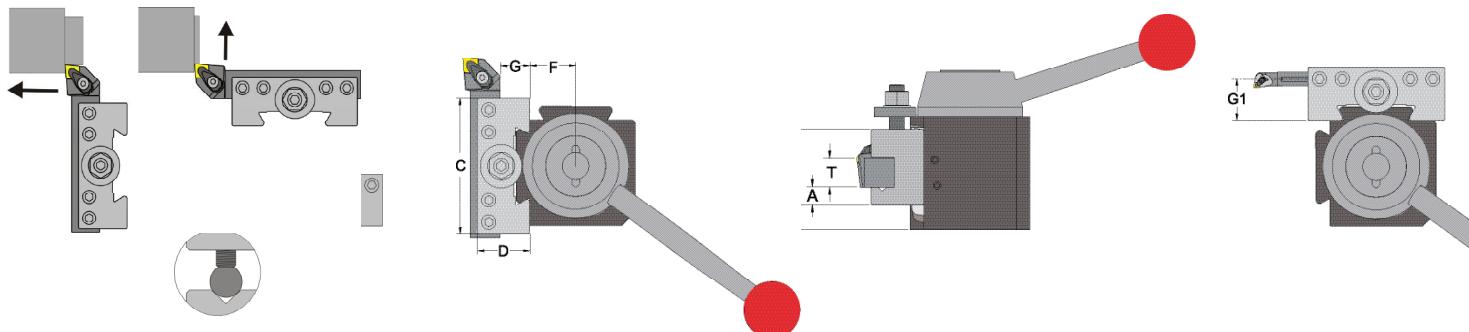
This toolholder is best used for holding square shank toolholders close to the tool post to maximize rigidity when turning, facing, and threading. Fits industry standard tool posts.



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

## No. D2 Turning, Facing & Boring Toolholder

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

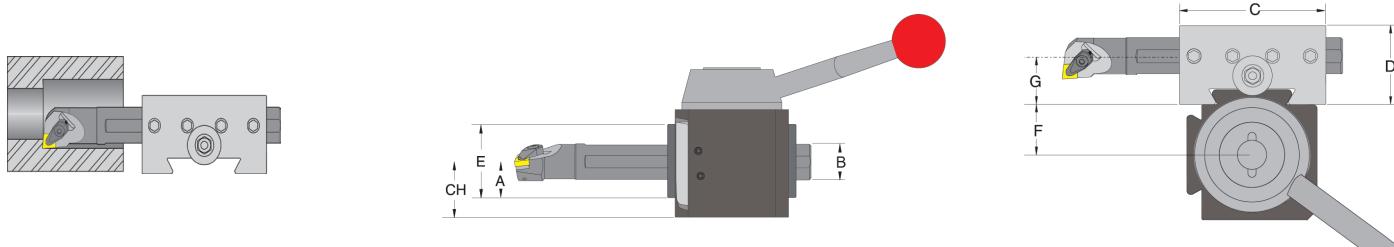


| Description | UPC No.733101- | System | A     | T     | C      | D     | E      | F     | G     | G1    |
|-------------|----------------|--------|-------|-------|--------|-------|--------|-------|-------|-------|
| D25AXA-2    | 01104          | in     | 0.375 | 0.750 | 2.750  | 1.250 | 1.750  | 0.880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

# SDN-Toolholder Ordering Specification

## No. D4-CNC-DUAL Heavy Duty Boring Bar Toolholder

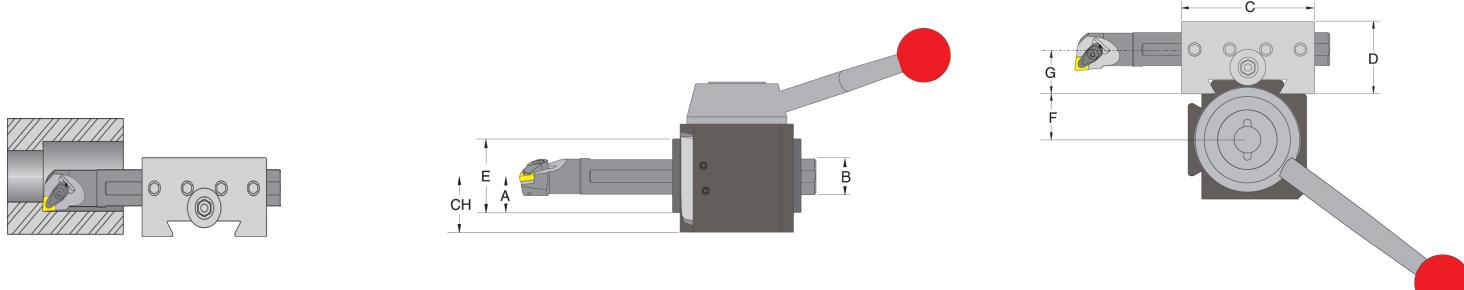
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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



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

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

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

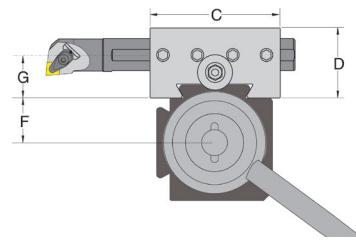
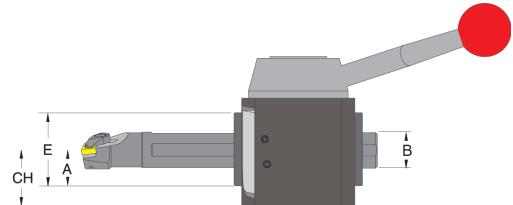
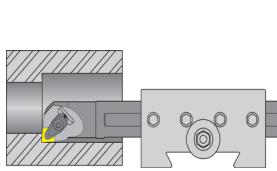


| Description    | UPC No.733101- | System | A     | B<br>Boring Bar Capacity | C      | D      | E      | F     | G     |
|----------------|----------------|--------|-------|--------------------------|--------|--------|--------|-------|-------|
| D25AXA-41-CNC  | 01114          | in     | .870  | 1.000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

# SDN-Toolholder Ordering Specification

## No. D41S-DUAL Super Universal Over Sized Boring Bar Toolholder

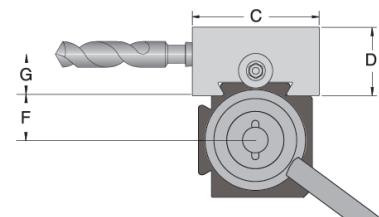
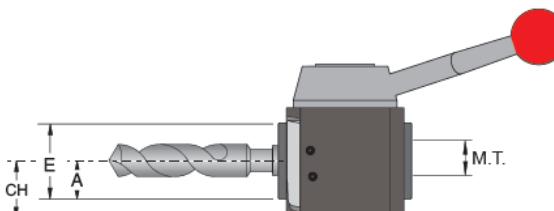
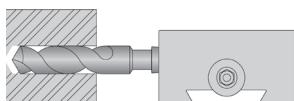
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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



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

## No. D5 Morse Taper Toolholder

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

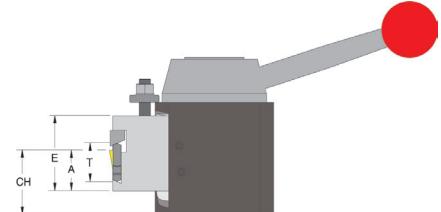
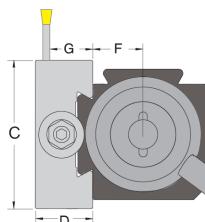


| Description | UPC No. 733101- | System | A     | Morse Taper | C      | D     | E     | F     | G     |
|-------------|-----------------|--------|-------|-------------|--------|-------|-------|-------|-------|
| D35CXA-5-4  | 01424           | in     | 1.125 | MT4         | 4.150  | 2.500 | 2.250 | 1.199 | 1.615 |
|             |                 | mm     | 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 |

# SDN-Toolholder Ordering Specification

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

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



| Description  | UPC No.733101- | System | A     | Slot Grip Blade   | C      | D     | E     | F     | G     |
|--------------|----------------|--------|-------|-------------------|--------|-------|-------|-------|-------|
|              |                |        |       | T                 |        |       |       |       |       |
| D25AXA-7-71C | 01126          | in     | 0.933 | SGIH-19-2         | 2.750  | 1.250 | 2.000 | 0.880 | 1.127 |
|              |                | mm     | 23.70 |                   | 69.85  | 31.75 | 50.80 | 22.35 | 28.63 |
| D30BXA-7-71C | 01276          | in     | 0.933 | SGIH-26-2 to 26-6 | 3.250  | 1.250 | 2.000 | 1.115 | 1.127 |
|              |                | mm     | 23.70 |                   | 82.60  | 31.80 | 50.80 | 28.30 | 28.60 |
| D35CXA-7-71C | 01428          | in     | 1.255 | SGIH-32-3 to 32-9 | 3.750  | 1.750 | 2.500 | 1.245 | 1.520 |
|              |                | mm     | 31.88 |                   | 95.25  | 44.45 | 63.50 | 31.62 | 38.61 |
| D40CA-7-71C  | 01576          | in     | 1.255 | SGIH-32-3 to 32-9 | 4.500  | 1.750 | 3.000 | 1.530 | 1.520 |
|              |                | mm     | 31.88 |                   | 114.30 | 44.45 | 76.20 | 38.86 | 38.61 |
| D50DA-7-71C  | 01726          | in     | 1.483 | SGIH-32-3 to 32-9 | 6.000  | 2.000 | 3.000 | 1.900 | 1.710 |
|              |                | mm     | 37.67 |                   | 152.40 | 50.80 | 76.20 | 48.26 | 43.43 |
| D60EA-7-71C  | 01876          | in     | 2.050 | SGIH-32-3 to 32-9 | 7.000  | 2.250 | 3.500 | 2.207 | 2.150 |
|              |                | mm     | 52.07 |                   | 177.80 | 57.15 | 88.90 | 56.06 | 54.61 |

# Slot Grip Cut-Off Blades Ordering Specification

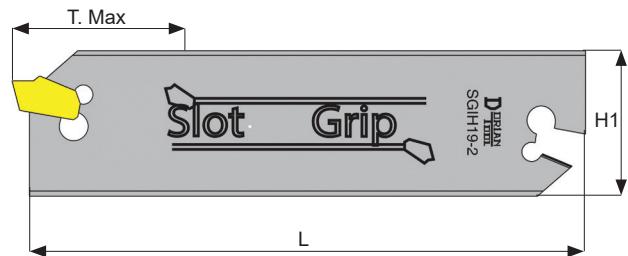
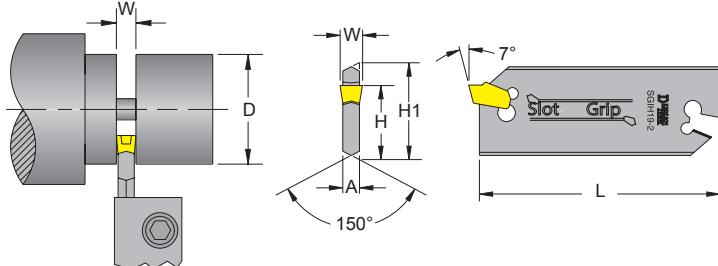


## Positive Stop Blades



### Positive Stop

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.



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

### 19mm (3/4") Slot Grip Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | H     | H1    | Insert Description | Insert Width |
|--------------------|-------|--------|-------|-------|-------|-------|-------|--------------------|--------------|
| SGIH19-2           | 62950 | 0.785  | 0.063 | 1.570 | 3.380 | 0.618 | 0.750 | SGT(N/R/L)-2       | .079"        |

### 26mm (1") Slot Grip Blades

|          |       |       |       |       |       |       |       |              |       |
|----------|-------|-------|-------|-------|-------|-------|-------|--------------|-------|
| SGIH26-2 | 62951 | 1.000 | 0.063 | 2.000 | 4.330 | 0.842 | 1.020 | SGT(N/R/L)-2 | .079" |
| SGIH26-3 | 62952 | 1.500 | 0.094 | 3.000 |       |       |       | SGT(N/R/L)-3 | .118" |
| SGIH26-4 | 62953 | 1.575 | 0.125 | 3.150 |       |       |       | SGT(N/R/L)-4 | .157" |

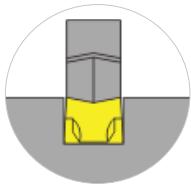
### 32mm (1 1/4") Slot Grip Blades

|          |       |       |       |       |       |       |       |              |       |
|----------|-------|-------|-------|-------|-------|-------|-------|--------------|-------|
| SGIH32-3 | 62956 | 1.970 | 0.094 | 3.940 | 5.900 | 0.984 | 1.250 | SGT(N/R/L)-3 | .118" |
| SGIH32-4 | 62957 | 1.970 | 0.125 | 3.940 |       |       |       | SGT(N/RL)-4  | .157" |
| SGIH32-5 | 62958 | 2.355 | 0.156 | 4.710 |       |       |       | SGT(N/R/L)-5 | .197" |
| SGIH32-6 | 62959 | 2.355 | 0.203 | 4.710 |       |       |       | SGT(N/R/L)-6 | .236" |
| SGIH32-8 | 62960 | 2.755 | 0.268 | 5.510 |       |       |       | SGT(N/R/L)-8 | .315" |
| SGIH32-9 | 62961 | 2.755 | 0.312 | 5.510 |       |       |       | SGT(N/R/L)-9 | .354" |

# Slot Grip Cut-Off Blades Ordering Specification

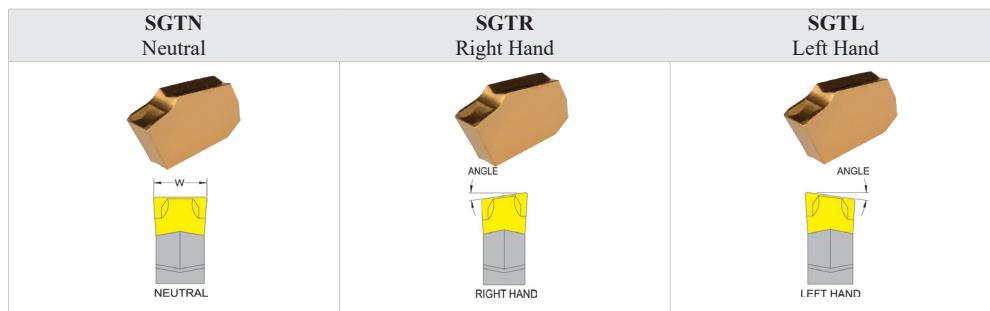


## SG\_ Inserts for Cut-Off & Grooving Operations



### Chip breaker Geometry

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



### Cut-Off & Grooving

Inserts are 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.

### Application

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

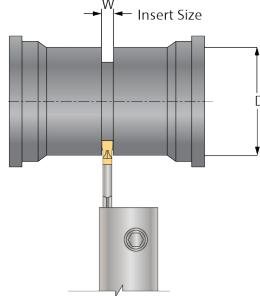
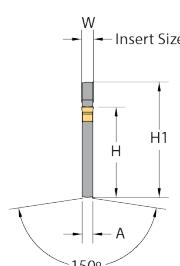
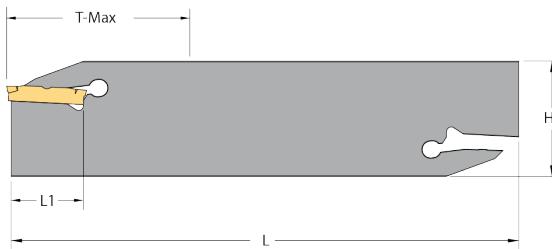
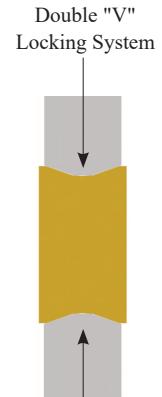
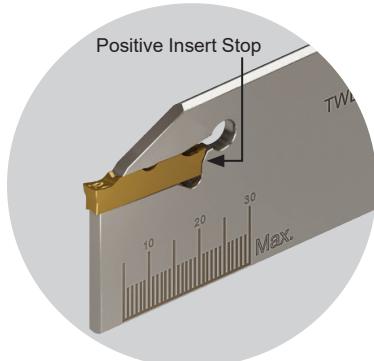
| Material | Carbon & Alloy Steel | Aluminum & Non-Ferrous Metals & Materials | Carbon & Alloy Steel | 300 & 400 Series Stainless Steel | Cast Iron, Copper/Brass | Aluminum & Non-Ferrous Materials | High Temp Alloys | Hard Steel to 58 HRC |
|----------|----------------------|---|----------------------|----------------------------------|-------------------------|----------------------------------|------------------|----------------------|
|          | P35                  | K25 N25                                   |                      |                                  | K25 P25 M25             |                                  |                  |                      |

| Insert Grade | Insert Coating |            |                              | CVD TiN Coated | Uncoated |       | PVD TiAlN Coated |      |       |
|--------------|----------------|------------|------------------------------|----------------|----------|-------|------------------|------|-------|
|              | Insert Size mm | Lead Angle | Width + 0,05<br>inch      mm |                | UPC #    | UPC # | DASK25B          |      |       |
| ANSI         |                |            |                              |                |          |       | DC656            | DK25 | UPC # |
| SGTN-2       | 2              | 0°         | .087                         | 2              | 82222    | 82220 |                  |      | 82223 |
| SGTN-2.4     | 2,4            | 0          | .094                         | 2,4            | 82306    | 82304 |                  |      | 82307 |
| SGTN-3       | 3              | 0°         | .122                         | 3              | 82226    | 82224 |                  |      | 82227 |
| SGTN-4       | 4              | 0°         | .161                         | 4              | 82230    | 82228 |                  |      | 82231 |
| SGTN-4.8     | 4,8            | 0          | .189                         | 4,8            | 82318    | 82316 |                  |      | 82319 |
| SGTN-5       | 5              | 0°         | .201                         | 5              | 82234    | 82232 |                  |      | 82235 |
| SGTN-6       | 6              | 0°         | .252                         | 6              | 82238    | 82236 |                  |      | 82239 |
| SGTN-8       | 8              | 0°         | .315                         | 8              | 82242    | -     |                  |      | -     |
| SGTN-9       | 9              | 0°         | .378                         | 9              | 82246    | 82244 |                  |      | 82247 |
| SGTR-2-8     | 2              | 8°         | .087                         | 2              | 82250    | 82248 |                  |      | 82251 |
| SGTR-2.4-8   | 2,4            | 8          | .094                         | 2,4            | 82310    | 82308 |                  |      | 82311 |
| SGTR-3-8     | 3              | 8°         | .122                         | 3              | 82254    | 82252 |                  |      | 82255 |
| SGTR-4-8     | 4              | 8°         | .161                         | 4              | 82258    | 82256 |                  |      | 82259 |
| SGTR-4.8-8   | 4,8            | 8          | .189                         | 4,8            | 82322    | 82320 |                  |      | 82323 |
| SGTR-5-8     | 5              | 8°         | .201                         | 5              | 82262    | 82260 |                  |      | 82263 |
| SGTR-6-8     | 6              | 8°         | .252                         | 6              | 82266    | -     |                  |      | -     |
| SGTR-9-8     | 9              | 8°         | .378                         | 9              | 82274    | -     |                  |      | -     |
| SGTL-2-8     | 2              | 8°         | .087                         | 2              | 82278    | 82276 |                  |      | 82279 |
| SGTL-4-8     | 4              | 8°         | .161                         | 4              | -        | 82284 |                  |      | 82287 |
| SGTL-5-8     | 5              | 8°         | .201                         | 5              | 82290    | -     |                  |      | -     |

# Kool-Cut™ Twin Edge Blade Ordering Specification

## Twin Edge Blades

- Double Cutting Edge
- High Rigidity
- Better Finish
- Straight Cut



Insert Extraction Key  
Sold Separately

### 19mm (3/4") Twin Edge Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | L1    | H     | H1    | Insert Description                       | Insert Width | Insert Extraction Key Description | UPC # |  |  |  |  |  |
|--------------------|-------|--------|-------|-------|-------|-------|-------|-------|--|--------------|-----------------------------------|-------|--|--|--|--|--|
| TWECOB-DNTF-19-20  | 61973 | .785   | 0.063 | 1.570 | 3.380 | 0.866 | 0.618 | 0.750 | DNTQ-22 2002-3EU-N<br>DNPG-22 2002-1SR-N |              |                                   |       |  |  |  |  |  |
|                    |       |        |       |       |       |       |       |       | DNTQ-22 2002-3EU-N<br>DNPG-22 2002-1SR-N | 0.079        | KCIK-DN                           | 61204 |  |  |  |  |  |

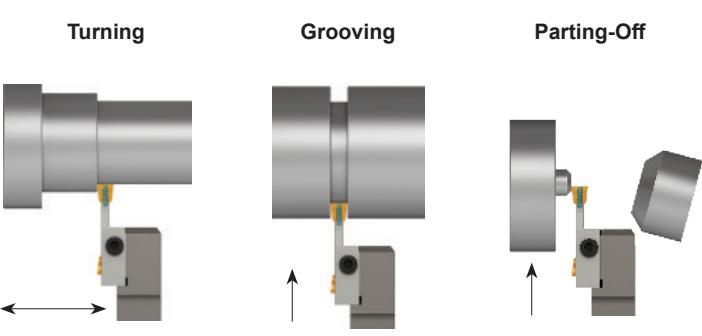
### 26mm (1") Twin Edge Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | L1    | H     | H1    | Insert Description   | Insert Width | Insert Extraction Key Description | UPC # |
|--------------------|-------|--------|-------|-------|-------|-------|-------|-------|--|--------------|-----------------------------------|-------|
| TWECOB-DNTF-26-20  | 61965 | 1.000  | 0.063 | 2.000 | 4.331 | 0.866 | 0.842 | 1.024 | DNTQ-22 2002-3EU-N<br>DNPG-22 2002-1SR-N                       | 0.079        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       | DNTQ-22 3003-3EU-N<br>DNTR-22 3015-3EU-N<br>DNPG-22 3002-1SR-N | 0.118        |                                   |       |
| TWECOB-DNTF-26-30  | 61966 | 1.550  | 0.094 | 3.100 | 4.331 | 0.866 | 0.842 | 1.024 | DNTQ-25 4004-3EU-N<br>DNTR-25 4020-3EU-N<br>DNPG-25 4003-1SR-N | 0.157        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       | DNTQ-25 5004-3EU-N<br>DNTR-25 5025-3EU-N<br>DNPG-25 5004-1SR-N | 0.197        |                                   |       |
| TWECOB-DNTF-26-40  | 61967 | 1.650  | 0.125 | 3.300 | 4.331 | 0.866 | 0.842 | 1.024 | DNTQ-25 6004-3EU-N<br>DNTR-25 6004-1SR-N                       | 0.236        |                                   |       |

### 32mm (1 1/4") Twin Edge Blades

| Blades Description | UPC # | T. Max | A     | D     | L     | L1    | H     | H1    | Insert Description   | Insert Width | Insert Extraction Key Description | UPC # |
|--------------------|-------|--------|-------|-------|-------|-------|-------|-------|--|--------------|-----------------------------------|-------|
| TWECOB-DNTF-32-20  | 61968 | 1.150  | 0.063 | 2.300 | 5.906 | 0.866 | 0.984 | 1.260 | DNTQ-22 2002-3EU-N<br>DNPG-22 2002-1SR-N                       | 0.079        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       | DNTQ-22 3003-3EU-N<br>DNTR-22 3015-3EU-N<br>DNPG-22 3002-1SR-N | 0.118        |                                   |       |
| TWECOB-DNTF-32-30  | 61969 | 1.750  | 0.094 | 3.500 | 5.906 | 0.866 | 0.984 | 1.260 | DNTQ-25 4004-3EU-N<br>DNTR-25 4020-3EU-N<br>DNPG-25 4003-1SR-N | 0.157        | KCIK-DN                           | 61204 |
|                    |       |        |       |       |       |       |       |       | DNTQ-25 5004-3EU-N<br>DNTR-25 5025-3EU-N<br>DNPG-25 5004-1SR-N | 0.197        |                                   |       |
| TWECOB-DNTF-32-40  | 61970 | 1.950  | 0.125 | 3.900 | 5.906 | 0.984 | 0.984 | 1.260 | DNTQ-25 6004-3EU-N<br>DNTR-25 6004-1SR-N                       | 0.236        |                                   |       |
| TWECOB-DNTF-32-50  | 61971 | 2.350  | 0.157 | 4.700 | 5.906 | 0.984 | 0.984 | 1.260 | DNTQ-25 6004-3EU-N<br>DNTR-25 6004-1SR-N                       | 0.236        |                                   |       |
| TWECOB-DNTF-32-60  | 61972 | 2.750  | 0.203 | 5.500 | 5.906 | 0.984 | 0.984 | 1.260 | DNTQ-25 6004-3EU-N<br>DNTR-25 6004-1SR-N                       | 0.236        |                                   |       |

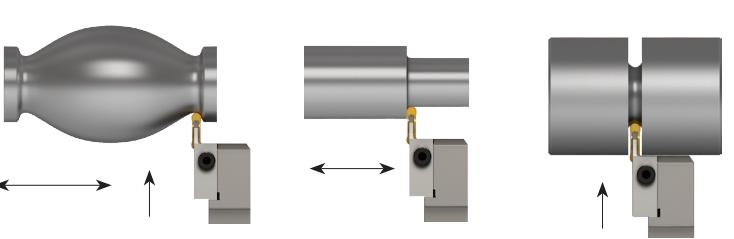
# Kool-Cut™ Twin Edge Insert Turning & Grooving Application

| Insert Specification  |        |               |  |  | Insert Application   |  |  |
|---|--------|---------------|--|--|--|--|--|
| <b>Double-End Cutting Edge</b><br><b>DNTQ-N- DUP35UG</b><br><br><b>Neutral Straight Nose</b><br>Multi-Cutting Direction<br>Right Hand and Left Hand |        |               |  |  |   |  |  |
| Cutting Data  |        |               |  |  |  |  |  |
| Insert Dimension  |        |               | Maximum $a_p$<br>Depth of Cut<br>for Turning | Maximum $f_n$<br>Feed Rate for<br>Turning, Grooving<br>and Parting-off |  |  |  |
| Width   | Length | Corner Radius | inch   | in/rev.  |  |  |  |
| .079" (2mm)   | .866"  | .008"         | .039"  | .006 in/rev  |  |  |  |
| .118" (3mm)   | .866"  | .012"         | .059"  | .008 in/rev  |  |  |  |
| .157" (4mm)   | .984"  | .016"         | .079"  | .009 in/rev  |  |  |  |
| .197" (5mm)   | .984"  | .016"         | .098"  | .010 in/rev  |  |  |  |
| .236" (6mm)   | .984"  | .016"         | .118"  | .012 in/rev  |  |  |  |

**Insert Geometry, Material Application**

|       |                 |           |             |              |
|-------|-----------------|-----------|-------------|--------------|
| Steel | Stainless Steel | Cast Iron | Non Ferrous | Super Alloys |
|-------|-----------------|-----------|-------------|--------------|

● First Choice Grade      ○ Second Best

| Insert Specification   |        |                  |  |  | Insert Application  |  |  |
|--|--------|------------------|--|--|---|--|--|
| <b>Double-End Cutting Edge</b><br><b>DNTR-N- DUP35UG</b><br><br><b>Neutral Round Nose</b><br>Multi-Cutting Direction<br>Right Hand and Left Hand |        |                  |  |  |   |  |  |
| Cutting Data   |        |                  |  |  |  |  |  |
| Insert Dimension   |        |                  | Maximum $a_p$<br>Depth of Cut<br>for Turning | Maximum $f_n$<br>Feed Rate for<br>Turning, Grooving<br>and Parting-off |   |  |  |
| Width  | Length | Radius           | inch   | in/rev.  |   |  |  |
| .118" (3mm)  | .866"  | .059"<br>(1.5mm) | .059"  | .012 in/rev  |   |  |  |
| .157" (4mm)  | .984"  | .079"<br>(2.0mm) | .079"  | .014 in/rev  |   |  |  |
| .197" (5mm)  | .984"  | .098"<br>(2.5mm) | .098"  | .016 in/rev  |   |  |  |

**Insert Geometry, Material Application**

|       |                 |           |             |              |
|-------|-----------------|-----------|-------------|--------------|
| Steel | Stainless Steel | Cast Iron | Non Ferrous | Super Alloys |
|-------|-----------------|-----------|-------------|--------------|

● First Choice Grade      ○ Second Best

| Insert Specification   |        |               |  |             | Insert Application   |  |  |  |
|--|--------|---------------|--|-------------|--|--|--|--|
| <b>Double-End Cutting Edge</b><br><b>DNPG-N- DPP40SG</b><br><br><b>Neutral Straight Nose</b><br>Uni-Direction Parting Off & Grooving |        |               |  |             |   |  |  |  |
| Cutting Data   |        |               |  |             |  |  |  |  |
| Insert Dimension   |        |               |  |             | Maximum $f_n$<br>Feed Rate for<br>Parting-off  |  |  |  |
| Width  | Length | Corner Radius |  | in/rev.     |  |  |  |  |
| .079" (2mm)  | .866"  | .008"         |  | .006 in/rev |  |  |  |  |
| .118" (3mm)  | .866"  | .008"         |  | .008 in/rev |  |  |  |  |
| .157" (4mm)  | .984"  | .012"         |  | .009 in/rev |  |  |  |  |
| .197" (5mm)  | .984"  | .016"         |  | .010 in/rev |  |  |  |  |
| .236" (6mm)  | .984"  | .016"         |  | .012 in/rev |  |  |  |  |

**Insert Geometry, Material Application**

|       |                 |           |             |              |
|-------|-----------------|-----------|-------------|--------------|
| Steel | Stainless Steel | Cast Iron | Non Ferrous | Super Alloys |
|-------|-----------------|-----------|-------------|--------------|

● First Choice Grade      ○ Second Best

# Kool-Cut™ Twin Edge Blade Ordering Specification

| DUP35UG  |                     |             |      |        |     |  |
|----------|---------------------|-------------|------|--------|-----|--|
| Material |                     | $V_c$ (SFM) |      |        |     |  |
| Steel    |                     | F/min.      |      | m/min. |     |  |
| P        | Carbon Steel        | 363         | 627  | 110    | 190 |  |
|          | Low Alloy Steel     | 363         | 594  | 110    | 180 |  |
|          | High Temp Alloys    | 231         | 528  | 70     | 160 |  |
| M        | Ferritic            | 396         | 660  | 120    | 200 |  |
|          | Austenitic          | 330         | 561  | 100    | 170 |  |
|          | Duplex              | 231         | 363  | 70     | 110 |  |
|          | Martensitic         | 198         | 297  | 60     | 90  |  |
| K        | Gray Cast Iron      | 330         | 660  | 100    | 200 |  |
|          | Modular Cast Iron   | 330         | 594  | 100    | 180 |  |
|          | Malleable Cast Iron | 264         | 528  | 80     | 160 |  |
| N        | Unleaded Copper     | 373         | 825  | 113    | 250 |  |
|          | Brass               | 663         | 1472 | 201    | 446 |  |
|          | Unleaded Bronze     | 287         | 495  | 87     | 150 |  |
| S        | Iron Base           | 86          | 172  | 26     | 52  |  |
|          | Nickel Base         | 53          | 116  | 16     | 35  |  |
|          | Titanium            | 198         | 429  | 60     | 130 |  |

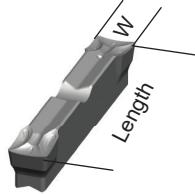
| DPP40SG  |                     |             |     |        |     |  |
|----------|---------------------|-------------|-----|--------|-----|--|
| Material |                     | $V_c$ (SFM) |     |        |     |  |
| Steel    |                     | F/min.      |     | m/min. |     |  |
| P        | Carbon Steel        | 264         | 495 | 80     | 150 |  |
|          | Low Alloy Steel     | 231         | 396 | 70     | 120 |  |
|          | High Temp Alloys    | 198         | 330 | 60     | 100 |  |
| M        | Ferritic            | 330         | 594 | 100    | 180 |  |
|          | Austenitic          | 264         | 495 | 80     | 150 |  |
|          | Duplex              | 231         | 363 | 70     | 110 |  |
|          | Martensitic         | 198         | 297 | 60     | 90  |  |
| K        | Gray Cast Iron      | 264         | 561 | 80     | 170 |  |
|          | Modular Cast Iron   | 297         | 495 | 90     | 150 |  |
|          | Malleable Cast Iron | 231         | 462 | 70     | 140 |  |
| N        | Unleaded Copper     |             |     |        |     |  |
|          | Brass               |             |     |        |     |  |
|          | Unleaded Bronze     |             |     |        |     |  |
| S        | Iron Base           |             |     |        |     |  |
|          | Nickel Base         |             |     |        |     |  |
|          | Titanium            |             |     |        |     |  |

| DUP35UG                     | HC-P25/M25 K30 N30 S30  | Coated | PVD-TiAlN 4μm |
|-----------------------------|---|--------|---------------|
| Insert Characteristics      | Hard, Wear, Abrasive and Impact Resistant   |        |               |
| First Choice Application    | Universal Multi Purpose Turning and Grooving Application; for carbon steel, alloy steel, stainless steel, cast iron, high-temp alloys & non-ferrous materials |        |               |
| Cutting Speed SFM ( $V_c$ ) | High Cutting Speed in stable turning and grooving conditions, light interrupted cut   |        |               |
| Cutting Condition           | Wet   |        |               |

| DPP40SG                     | HC-P45/M45   | Multi Coated | PVD-TiAlN 7μm |
|-----------------------------|--|--------------|---------------|
| Insert Characteristics      | Extremely Tough and Impact Resistant Substrate   |              |               |
| First Choice Application    | For Heavy or Interrupted Part Off and Grooving Applications; for Forgings and Castings of Carbon Steel, Alloy Steel, Stainless Steel and Cast Iron |              |               |
| Cutting Speed SFM ( $V_c$ ) | Low to Medium Cutting Speed in unstable conditions and heavy interrupted cut   |              |               |
| Cutting Condition           | Wet  |              |               |

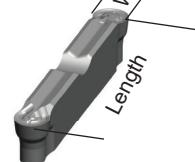
## Insert Specifications

### "T" Square Nose



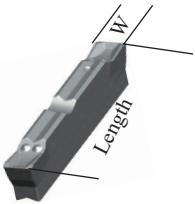
| UPC # | Application                        | Part Number                | Insert Size Width | Length | Corner Radius | Grade |
|-------|------------------------------------|----------------------------|-------------------|--------|---------------|-------|
| 82440 | Turning<br>Grooving<br>Parting-Off | DNTQ-22 2002-3EU-N DUP35UG | .079" (2mm)       | .866"  | .008"         | •     |
|       |                                    | DNTQ-22 3003-3EU-N DUP35UG | .118" (3mm)       | .866"  | .012"         | •     |
|       |                                    | DNTQ-25 4004-3EU-N DUP35UG | .157" (4mm)       | .984"  | .016"         | •     |
|       |                                    | DNTQ-25 5004-3EU-N DUP35UG | .197" (5mm)       | .984"  | .016"         | •     |
|       |                                    | DNTQ-25 6004-3EU-N DUP35UG | .236" (6mm)       | .984"  | .016"         | •     |

### "R" Round Nose



| UPC # | Application                      | Part Number                | Insert Size Width | Length | Radius           | Grade |
|-------|----------------------------------|----------------------------|-------------------|--------|------------------|-------|
| 82459 | Profiling<br>Turning<br>Grooving | DNTR-22 3015-3EU-N DUP35UG | .118" (3mm)       | .866"  | .059"<br>(1.5mm) | •     |
|       |                                  | DNTR-25 4020-3EU-N DUP35UG | .157" (4mm)       | .984"  | .079"<br>(2.0mm) | •     |
|       |                                  | DNTR-25 5025-3EU-N DUP35UG | .197" (5mm)       | .984"  | .098"<br>(2.5mm) | •     |

### "G" Square Nose

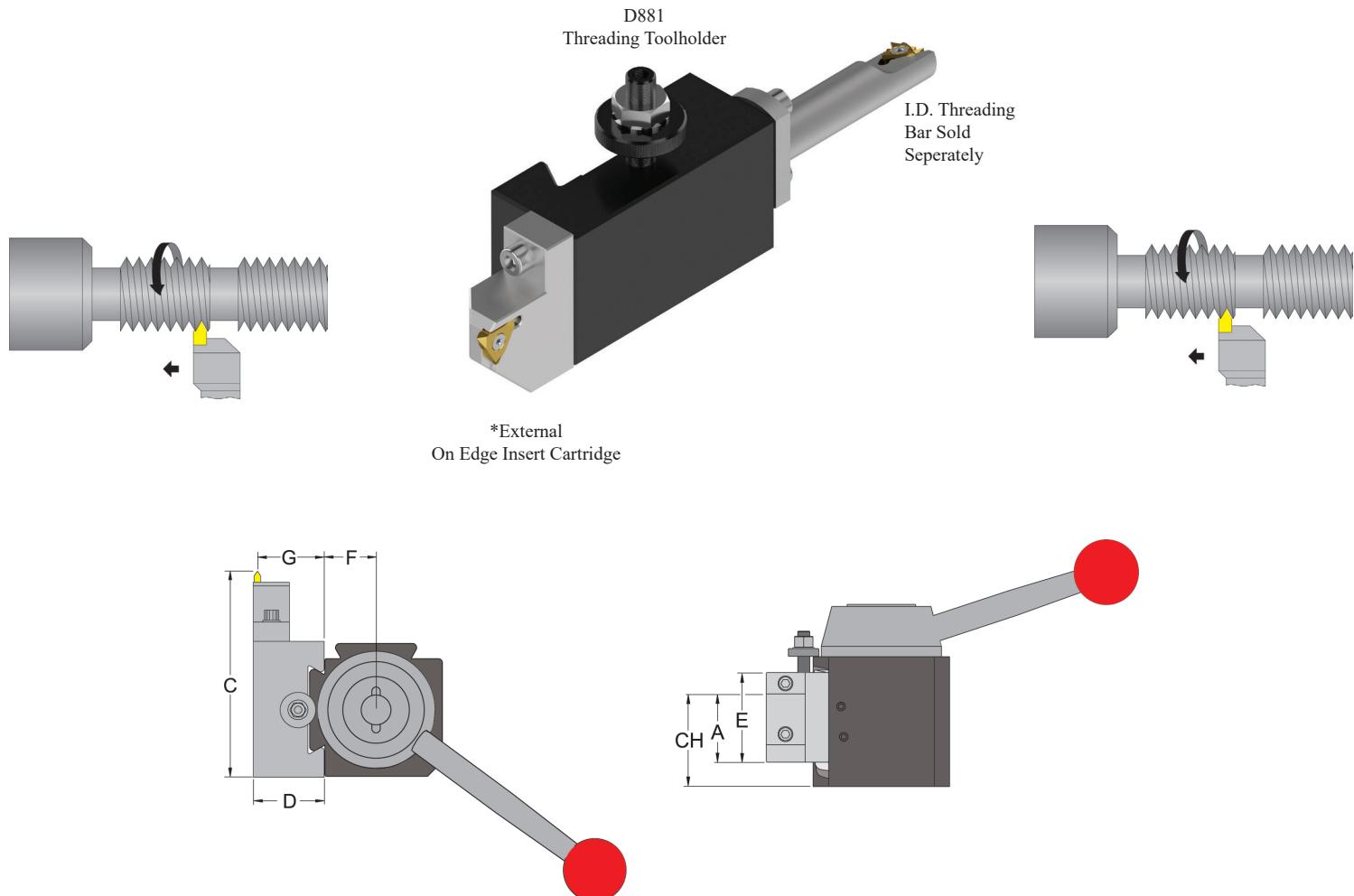


| UPC # | Application             | Part Number                | Insert Size Width | Length | Corner Radius | Grade |
|-------|-------------------------|----------------------------|-------------------|--------|---------------|-------|
| 82475 | Grooving<br>Parting-Off | DNPG-22 2002-1SR-N DPP40SG | .079" (2mm)       | .866"  | .008"         | •     |
|       |                         | DNPG-22 3002-1SR-N DPP40SG | .118" (3mm)       | .866"  | .008"         | •     |
|       |                         | DNPG-25 4003-1SR-N DPP40SG | .157" (4mm)       | .984"  | .012"         | •     |
|       |                         | DNPG-25 5004-1SR-N DPP40SG | .197" (5mm)       | .984"  | .016"         | •     |
|       |                         | DNPG-25 6004-1SR-N DPP40SG | .236" (6mm)       | .984"  | .016"         | •     |

# SDN-Toolholder Ordering Specification

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

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



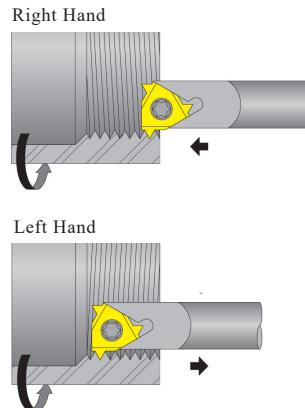
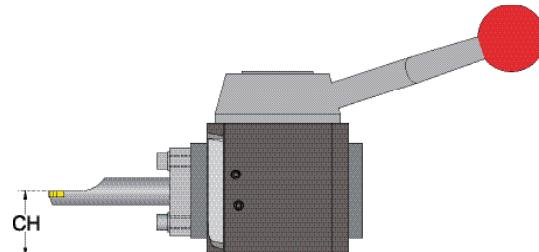
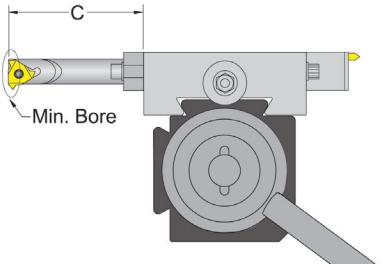
| Description   | UPC No.<br>733101- | System | A     | C      | D     | E     | F     | G     | *External On Edge Insert Cartridge |                    |                |               |             |
|---------------|--------------------|--------|-------|--------|-------|-------|-------|-------|------------------------------------|--------------------|----------------|---------------|-------------|
|               |                    |        |       |        |       |       |       |       | Desc.                              | UPC No.<br>733101- | TNMC<br>Insert | Torx<br>Screw | Torx<br>Key |
| D25AXA-881-OE | 01132              | in     | 0.875 | 3.869  | 1.000 | 1.500 | 0.880 | 1.000 | TIH253-32                          | 03621              | 32             | GTS-1M        | T-10        |
|               |                    | mm     | 22.23 | 98.27  | 25.40 | 38.10 | 22.35 | 25.40 |                                    |                    |                |               |             |
| D30BXA-881-OE | 01282              | in     | 1.000 | 4.369  | 1.250 | 1.750 | 1.115 | 1.250 | TIH354-32                          | 03623              | 32             | GTS-1M        | T-10        |
|               |                    | mm     | 25.40 | 110.97 | 31.75 | 44.45 | 28.32 | 31.75 |                                    |                    |                |               |             |
| D35CXA-881-OE | 01434              | in     | 1.250 | 5.119  | 1.500 | 2.000 | 1.199 | 1.435 | TIH354-32                          | 03623              | 32             | GTS-1M        | T-10        |
|               |                    | mm     | 31.75 | 130.02 | 38.10 | 50.80 | 30.45 | 36.45 |                                    |                    |                |               |             |
| D40CA-881-OE  | 01582              | in     | 1.500 | 5.619  | 1.500 | 2.250 | 1.530 | 1.435 |                                    |                    |                |               |             |
|               |                    | mm     | 38.10 | 142.72 | 38.10 | 57.15 | 38.86 | 36.45 |                                    |                    |                |               |             |

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

# SDN-Lay-Down Threading Bar Ordering Specification

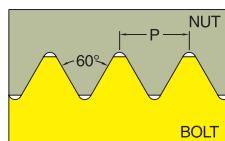
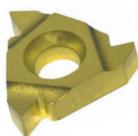
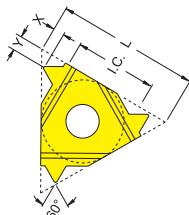
## Internal Threading Bar For D881 Toolholder

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.



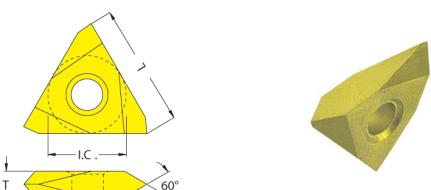
| Series      | Right Hand |             |           | Min. Bore |      | C     |      | Pitch |         | Insert I.C. | Torx Screw   | Torx Key |
|-------------|------------|-------------|-----------|-----------|------|-------|------|-------|---------|-------------|--------------|----------|
|     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

## Laydown Threading Insert 60° Partial Profile



| Lay-Down Internal Right Hand                |        |   |       |   | Lay-Down Internal Left Hand |   |       |       |       | Insert Specification |       |       |          |         |
|---|--------|---|-------|---|-----------------------------|---|-------|-------|-------|----------------------|-------|-------|----------|---------|
| Part No.                                    | Grade  | UPC   | Grade | UPC   | Part No.                    | Grade   | UPC   | Grade | UPC   | L                    | I.C.  | TPI   | x        | y       |
| 11IR-A60                                    | DVP656 | 74056   | DVK10 | 74057                                       | 11IL-A60                    | DVP656  | 74060 | DVK10 | 74061 | 11 mm                | 0.250 | 16-48 | 0,5-1,5  | 0,8 0,9 |
| 16IR-A60                                    |        | 74064   |       | 74065                                       | 16IL-A60                    |   | 74068 |       | 74069 | 16 mm                | 0.375 | 16-48 | 0,5-1,5  |         |
| 16IR-G60                                    |        | 74072   |       | 74073                                       | 16IL-G60                    |   | 74076 |       | 74077 | 16 mm                | 0.375 | 8-14  | 1,75-3,0 | 1,2 1,7 |
| 16IR-AG60                                   |        | 74080   |       | 74081                                       | 16IL-AG60                   |   | 74084 |       | 74085 | 16 mm                | 0.375 | 8-48  | 0,5-3,0  |         |
| Carbon Steel, Alloy Steel & Stainless Steel |        | Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron |       | Carbon Steel, Alloy Steel & Stainless Steel |                             | Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron |       |       |       |                      |       |       |          |         |

## On Edge TNMC 60° Negative Rake Threading Insert

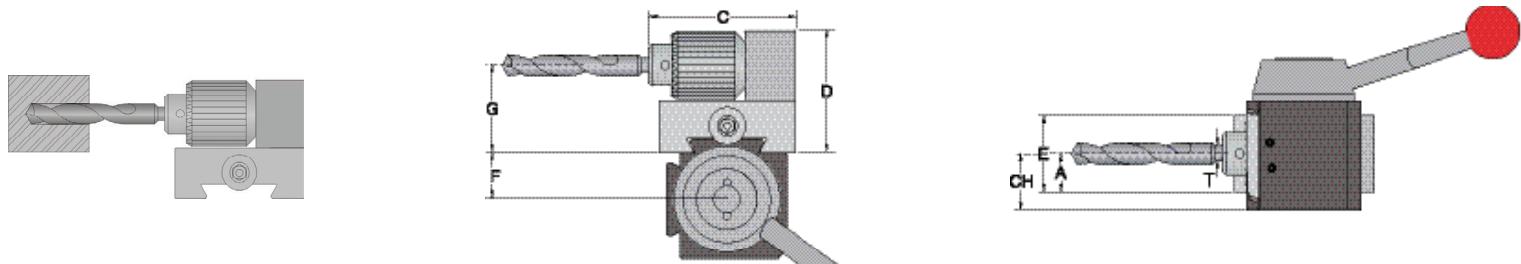


| On Edge TNMC 60° Negative Rake Threading Insert |        |   |       |       | Insert Specification |      |      |         |       |           |       |        |              |
|---|--------|---|-------|-------|----------------------|------|------|---------|-------|-----------|-------|--------|--------------|
| Part No.  | Grade  | UPC   | Grade | UPC   | I.C.                 |      | TPI  |         | T     | Hole Dia. |       | Depth. |              |
|   |        |   |       |       | I.C.                 | L    |      |         |       |           |       |        |              |
| TNMC-32NV-                                      | DVP656 | 72003   | DVK10 | 72004 | 0.375                | 16mm | 8-48 | 0.5-3.0 | 0.125 | 3,18      | 0.150 | 3,81mm | 0.150 3,81mm |
| Carbon Steel, Alloy Steel & Stainless Steel     |        | Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron |       |       |                      |      |      |         |       |           |       |        |              |

# SDN-Toolholder Ordering Specification

## No. D35 Drill Chuck Toolholder

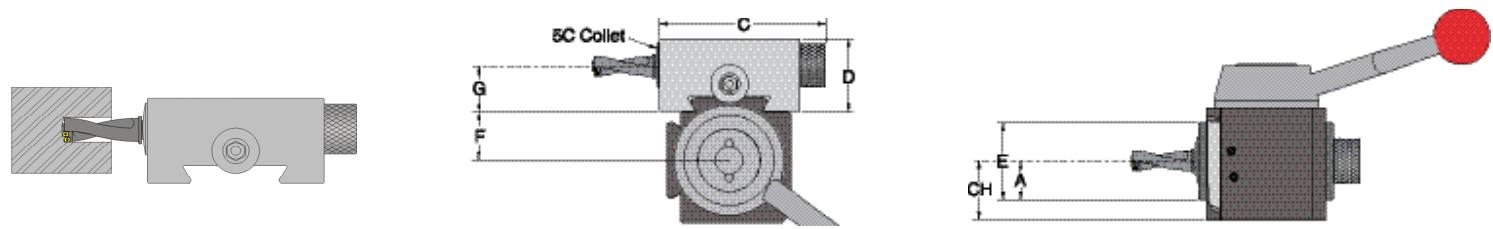
This holder is best used for holding drills, reamers, taps, etc., without tailstock mounting. It uses a drill chuck mounted directly to a quick change holder. This holder is supplied with a drill-chuck. Fits industry standard tool posts.



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

## No. D36 5C Collet Toolholder

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



| Description | UPC No. 733101- | System | A     | C      | D     | E     | F     | G     |
|-------------|-----------------|--------|-------|--------|-------|-------|-------|-------|
| D25AXA-36   | 01142           | in     | 1.125 | 4.250  | 2.500 | 2.250 | 0.880 | 1.500 |
|             |                 | mm     | 28.58 | 107.95 | 63.50 | 57.15 | 22.35 | 38.10 |
| D30BXA-36   | 01292           | in     | 1.125 | 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 |

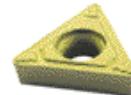
# SDN Quick Change Tool Post & Toolholders Sets

## SUPER Quick Change Tool Post First Time Buyer Set

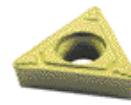
### SUPER Quick Change First Time Buyer SET Includes FREE TOOLING

Set Includes:

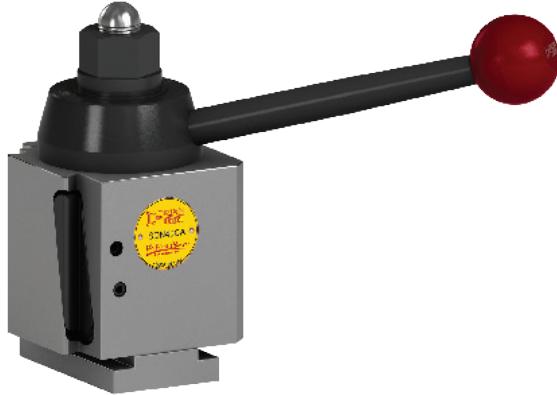
- (1) Tool Post
- (4) Holders
- (4) Toolholders **FREE**
- (5) Inserts **FREE**



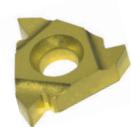
1ea. D1 + 1 **Free** Turning Toolholder, 1 **Free** TCMT Turning Inserts



1ea. D2 +1 **Free** Boring Bar, 1 **Free** TCMT Turning Insert



1ea. D7-71C + 1 **Free** Cut-Off Blade, 1 **Free** Cut-Off Insert



1ea. D881 + 1 **Free** ID Threading Bar, 1 **Free** TNMC OnEdge Insert,  
1 **Free** ID Threading Insert

| UPC No.<br><b>733101-</b> | <b>01056</b>   | <b>01058</b>   | <b>01060</b>   | <b>01062</b>   |
|---------------------------|--|--|--|--|
| Description               | SDN25AXA-FTB   | SDN30BXA-FTB   | SDN35CXA-FTB   | SDN40CA-FTB  |
| Lathe Swing               | Up to 12"  | 13" to 15"   | 14" to 17"   | 16" to 20"   |
| <b>Set Includes</b>       |  |  |  |  |
| (1) Tool Post             | SDN25AXA   | SDN30BXA   | SDN35CXA   | SDN40CA  |
| (4) Holders               | D25AXA-1   | D30BXA-1   | D35CXA-1   | D40CA-1  |
|                           | D25AXA-2   | D30BXA-2   | D35CXA-2   | D40CA-2  |
|                           | D25AXA-7-71C   | D30BXA-7-71C   | D35CXA-7-71C   | D40CA-7-71C  |
|                           | D25AXA-881-OE  | D30BXA-881-OE  | D35CXA-881-OE  | D40CA-881-OE   |
| <b>Free Tooling</b>       |  |  |  |  |
| (4) Toolholders           | STNCR08-2J<br>STCMB06-2<br>TWECOB-DNTF-19-20<br>NL50R  | STNCR10-2A<br>STCMB08-2<br>TWECOB-DNTF-19-20<br>NL50R  | STNCR12-3B<br>STCMB10-2<br>TWECOB-DNTF-26-30<br>NL75R  | STNCR64-3D<br>STCMB12-3<br>TWECOB-DNTF-26-30<br>NL75R  |
|                           |  |  |  |  |
|                           |  |  |  |  |
|                           |  |  |  |  |
| (5) Inserts               | TCMT-21.51-PEM-DPC25UT<br>TCMT-21.52-PEM-DPC25UT<br>DNTQ-222002-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>11IR-A60-DVP656 | TCMT-21.51-PEM-DPC25UT<br>TCMT-21.52-PEM-DPC25UT<br>DNTQ-222002-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>11IR-A60-DVP656 | TCMT-21.51-PEM-DPC25UT<br>TCMT-32.52-PEM-DPC25UT<br>DNTQ-223003-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>16IR-A60-DVP656 | TCMT-32.51-PEM-DPC25UT<br>TCMT-32.52-PEM-DPC25UT<br>DNTQ-223003-3EU-DPP35UG<br>TNMC-32NV-DVP656<br>16IR-A60-DVP656 |
|                           |  |  |  |  |
|                           |  |  |  |  |
|                           |  |  |  |  |
|                           |  |  |  |  |

# SDN Quick Change Tool Post & Toolholders Sets

## SUPER Quick Change Turning Sets

### Turning Set Includes

- (1) Tool Post
- (4) Indexable Cutting Toolholders

Tooling Not Included



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

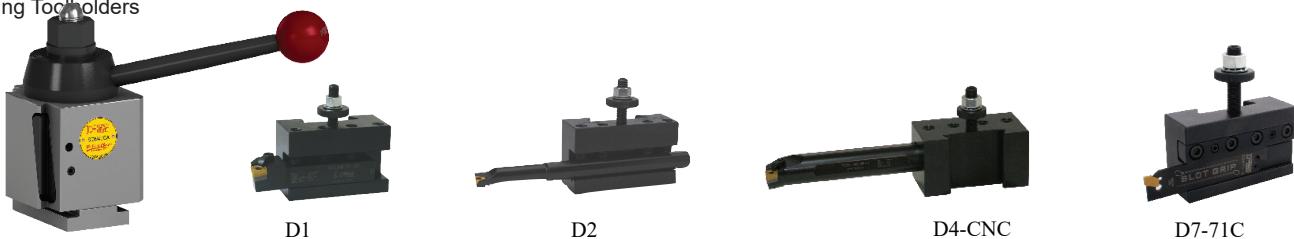
| Set Includes  |                              |                              |                              |                            |                            |                            |
|---------------|------------------------------|------------------------------|------------------------------|----------------------------|---------------------------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

## SUPER Quick Change Standard Sets

### Standard Set Includes

- (1) Tool Post
- (4) Indexable Cutting Toolholders

Tooling Not Included



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

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

# How to Order the Correct Tool Post for your Lathe

## Contact Information

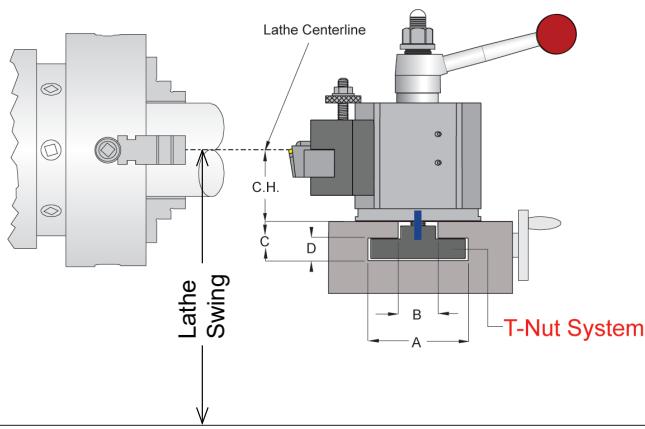
|          |           |      |         |
|----------|-----------|------|---------|
| Company: | Name:     |      |         |
| Address: | Phone ( ) |      |         |
| City:    | State:    | Zip: | Fax ( ) |
| Email:   |           |      |         |

## Technical Information Required

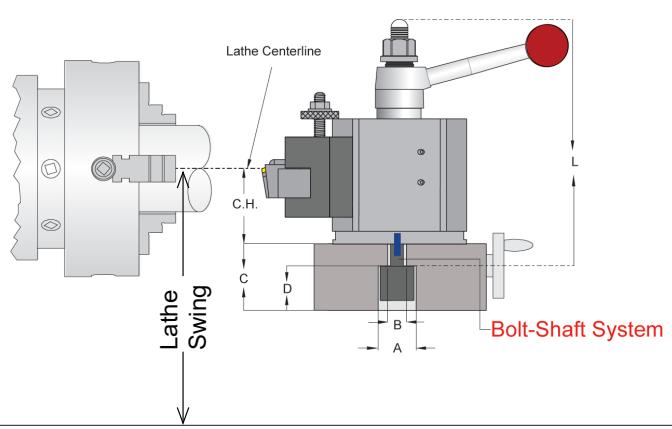
|                          | Inch  | Metric     | 7 Type of the Lathe |
|--------------------------|-------|------------|---------------------|
| 1 Lathe Swing            |       |            | 8 Maximum Chuck RPM |
| 2 Tool Center Height     |       |            | Type of Work        |
| 3 Square Shank Tool Size |       |            | 9 Short Run         |
| 4 Square Shank Tool Size |       |            | 10 Production       |
| 5 Holding System         | T-Nut | Bolt-Shaft | 11 Light Duty Work  |
| 6 Lathe Horse Power      |       |            | 12 Heavy Duty Work  |

## Holding System & Center Height Information

### T-Nut Mounting Style



### Bolt Shaft Mounting Style



Lathe Bedway

|                           | A | B | C | D | L | Thread Size | I | Anti-Rotation Pin Size | P |
|---------------------------|---|---|---|---|---|-------------|---|------------------------|---|
| T-Nut Mounting Size       |   |   |   |   |   |             |   |                        |   |
| Bolt-Shaft Mounting Sizes |   |   |   |   |   |             |   |                        |   |

Please refer to Pgs. 12, 13, 40 & 41

## Dorian Recommendation

| QTY | Description | Part Number | UPC | Price | Discount | Total | Stock | No Stock | Customer Acceptance | P.O. |
|-----|-------------|-------------|-----|-------|----------|-------|-------|----------|---------------------|------|
|     |             |             |     |       |          |       |       |          |                     |      |
|     |             |             |     |       |          |       |       |          |                     |      |
|     |             |             |     |       |          |       |       |          |                     |      |
|     |             |             |     |       |          |       |       |          |                     |      |

# Index

|  |           |  |    |
|--|-----------|--|----|
| <b>Introduction of Quadra Tool Post</b>                                      | <b>2</b>  | SDN Quick Change Tool Post & Toolholders Structure Specification | 42 |
|  |           | SDN Quick Change Tool Post & Toolholders Structure Specification | 43 |
| <b>Introduction of SDN Quick Change Tool Post</b>                            | <b>3</b>  | SDN Quick Change Tool Post & Toolholders Structure Specification | 44 |
|  |           | SDN Quick Change Tool Post Ordering Specification                | 45 |
| <b>Terminology of a Manual Lathe</b>   | <b>4</b>  | SDN 1-Toolholder Ordering Specification                          | 46 |
|  |           | SDN 2-Toolholder Ordering Specification                          | 46 |
| <b>Terminology of a CNC Tool Room Lathe</b>                                  | <b>5</b>  | SDN 4 DUAL-Toolholder Ordering Specification                     | 47 |
|  |           | SDN 41 DUAL-Toolholder Ordering Specification                    | 47 |
| <b>Quadra® Tool Post and Toolholders</b>                                     | <b>6</b>  | SDN 41S DUAL-Toolholder Ordering Specification                   | 48 |
| Quadra® Tool Post and Toolholders Sizes & Crossover                          | 7         | SDN 5 Morse Taper-Toolholder Ordering Specification              | 48 |
| Quadra® Tool Post Indexing System & Multi Operation Set-Up                   | 8         | SDN 7-71C-Toolholder Ordering Specification                      | 49 |
| Quadra® Tool Post Anatomy  | 9         | Slot Grip Cut-Off Blades Ordering Specification                  | 50 |
| Quadra® Tool Post Technical Information                                      | 10        | Slot Grip Cut-Off Blades Ordering Specification                  | 51 |
| Quadra® Tool Post Mounting System  | 11        | Kool-Cut™ Twin Edge Blade Ordering Specification                 | 52 |
| Quadra® T-Nut Data   | 12        | Kool-Cut™ Twin Edge Insert Turning & Grooving Application        | 53 |
| Quadra® T-Nut Data   | 13        | Kool-Cut™ Twin Edge Blade Ordering Specification                 | 54 |
| Quadra® Tool Post Cutting Tool Center Height Set-Up                          | 14        | SDN 881-Threading Toolholder Ordering Specification              | 55 |
| Quadra® Tool Post & Toolholders Structure Specification                      | 15        | Threading Inserts Ordering Specification                         | 56 |
| Quadra® Tool Post & Toolholders Structure Specification                      | 16        | SDN 35 -Drill Chuck Toolholder Ordering Specification            | 57 |
| Quadra® Tool Post & Toolholders Structure Specification                      | 17        | SDN 36 5C -Collet Toolholder Ordering Specification              | 57 |
| Quadra® Quick Change Tool Post Ordering Specification                        | 18        | SDN-First Tool Post Turning Set Ordering Specification           | 58 |
| Quadra-1 Turning & Facing Toolholder Ordering Specification                  | 19        | SDN-First Tool Post Standard Set Ordering Specification          | 59 |
| Quadra-2 Turning & Facing Toolholder Ordering Specification                  | 19        |  |    |
| Quadra-4 Dual Boring Toolholder Ordering Specification                       | 20        |  |    |
| Quadra-41 Dual Boring Toolholder Ordering Specification                      | 20        |  |    |
| Quadra-41S Dual Boring Toolholder Ordering Specification                     | 21        |  |    |
| Quadra-5 Morse Taper Toolholder Ordering Specification                       | 21        |  |    |
| Quadra-36 5C Collet Toolholder Ordering Specification                        | 22        |  |    |
| Quadra-7-71 Extra Heavy Duty Cut-Off Blade Toolholder Ordering Specification | 22        |  |    |
| Slot Grip Cut-Off Blades Ordering Specification                              | 23        |  |    |
| Slot Grip Cut-Off Inserts Ordering Specification                             | 24        |  |    |
| Kool-Cut™ Twin Edge Blade Ordering Specification                             | 25        |  |    |
| Kool-Cut™ Twin Edge Insert Turning & Grooving Application                    | 26        |  |    |
| Kool-Cut™ Twin Edge Inserts Ordering Specification                           | 27        |  |    |
| Quadra-881 Threading Toolholder Ordering Specification                       | 28        |  |    |
| Threading Inserts Ordering Specification                                     | 29        |  |    |
| Quadra-First Tool Post Turning Set Ordering Specification                    | 30        |  |    |
| Quadra-First Tool Post Standard Set Ordering Specification                   | 31        |  |    |
| <b>SDN Super Quick Change Tool Post</b>                                      | <b>33</b> |  |    |
| SDN Tool Post and Toolholders Sizes & Crossover                              | 34        |  |    |
| SDN Tool Post and Toolholders Turning Application                            | 35        |  |    |
| SDN Quick Change Tool Post Anatomy   | 36        |  |    |
| SDN Quick Change Tool Post Cross Section                                     | 37        |  |    |
| SDN Quick Change Tool Post Technical Information                             | 38        |  |    |
| SDN Quick Change Tool Post Cutting Tool Center Height Set-Up                 | 39        |  |    |
| SDN T-Nut Data   | 40        |  |    |
| SDN T-Nut Data   | 41        |  |    |

## Notes

## Notes



**DORIAN**  
INTERNATIONAL  
**TOOLS**

## Tool Post Catalog

**LIVETOOLS.**<sup>®</sup>

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