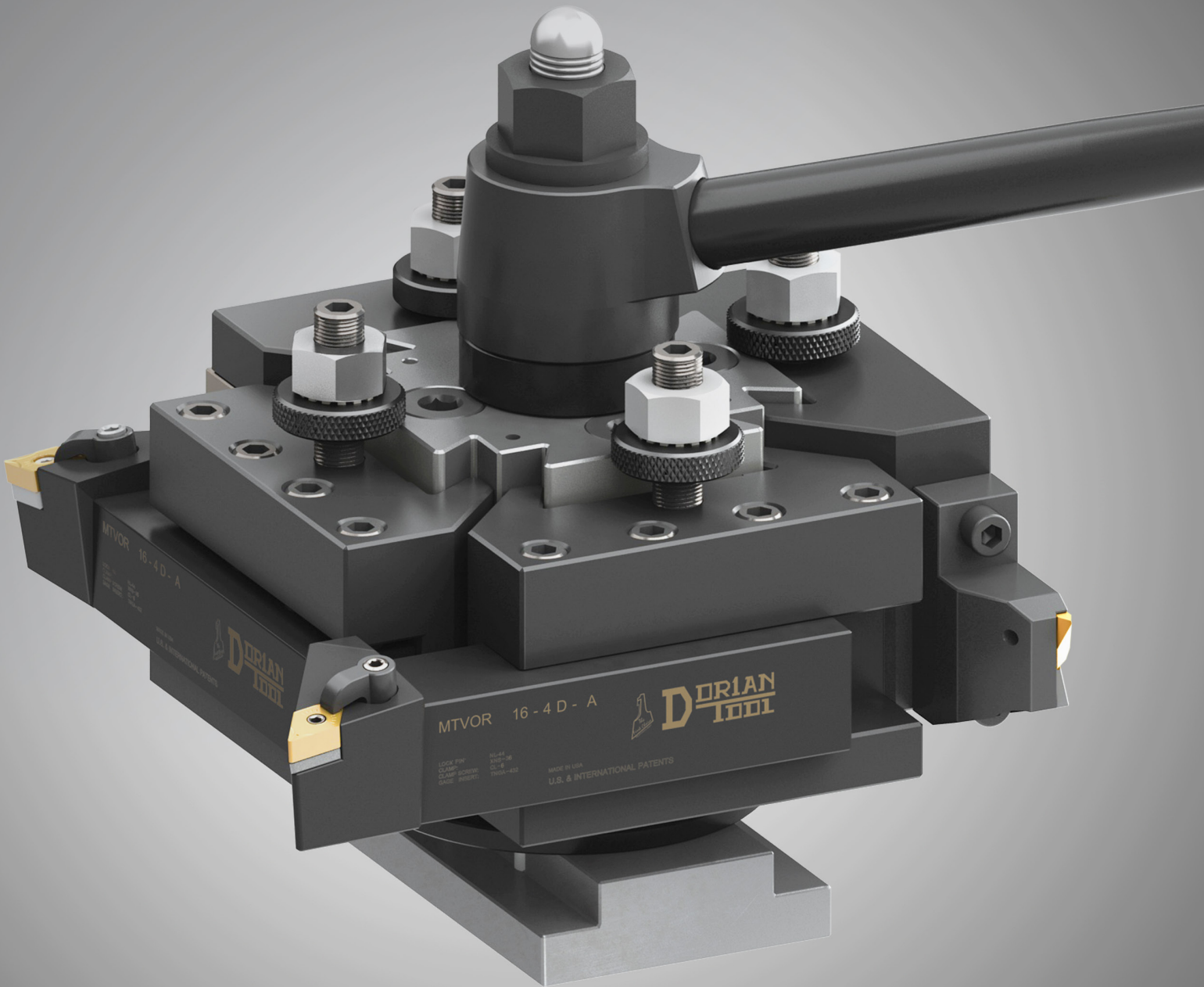


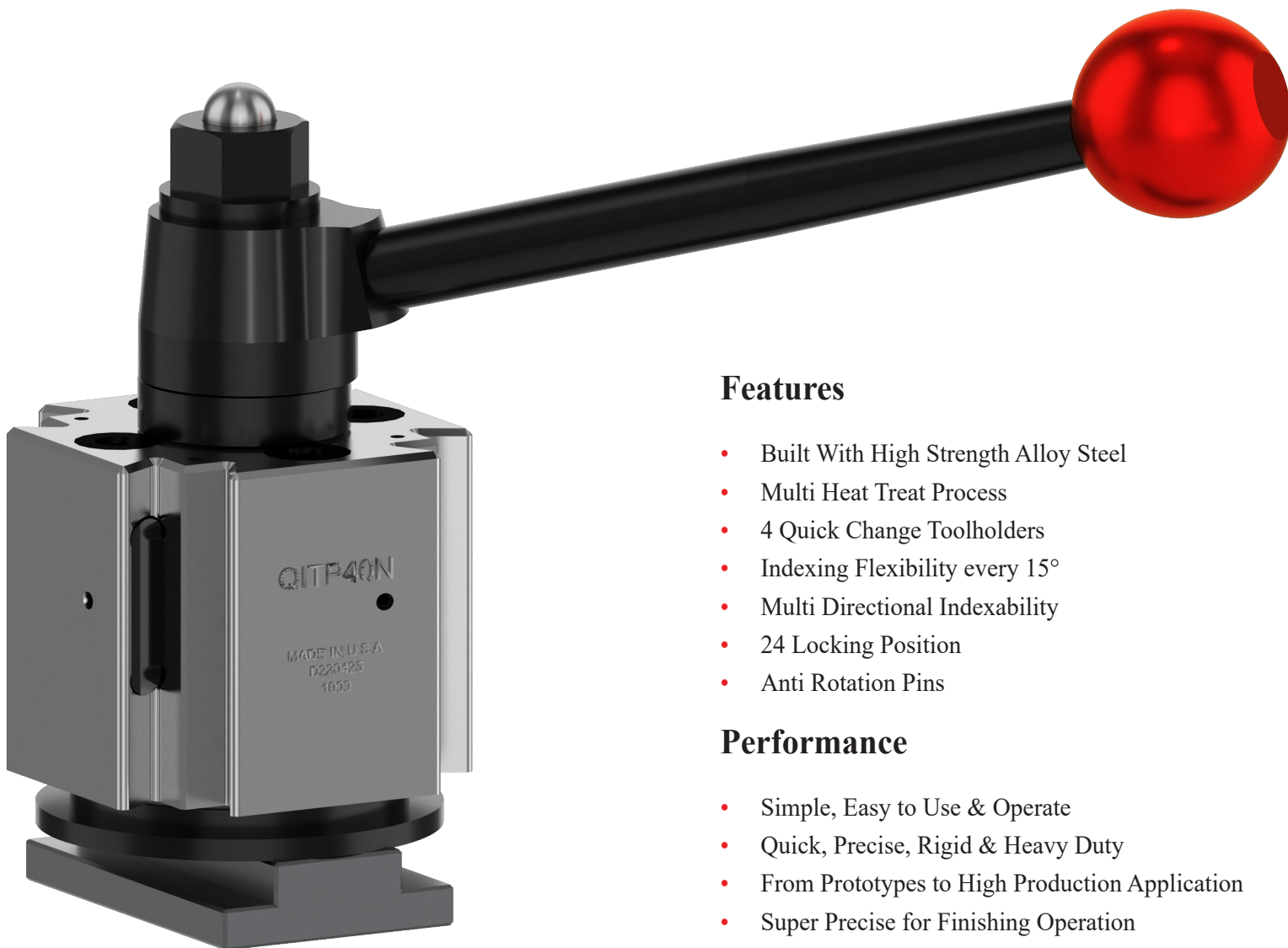


# Tool Post & Tool Holders



**TECHNOLOGY,  
QUALITY &  
PERFORMANCE**

# Quadra<sup>®</sup> 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  $\pm .0001'' / .00254\text{mm}$

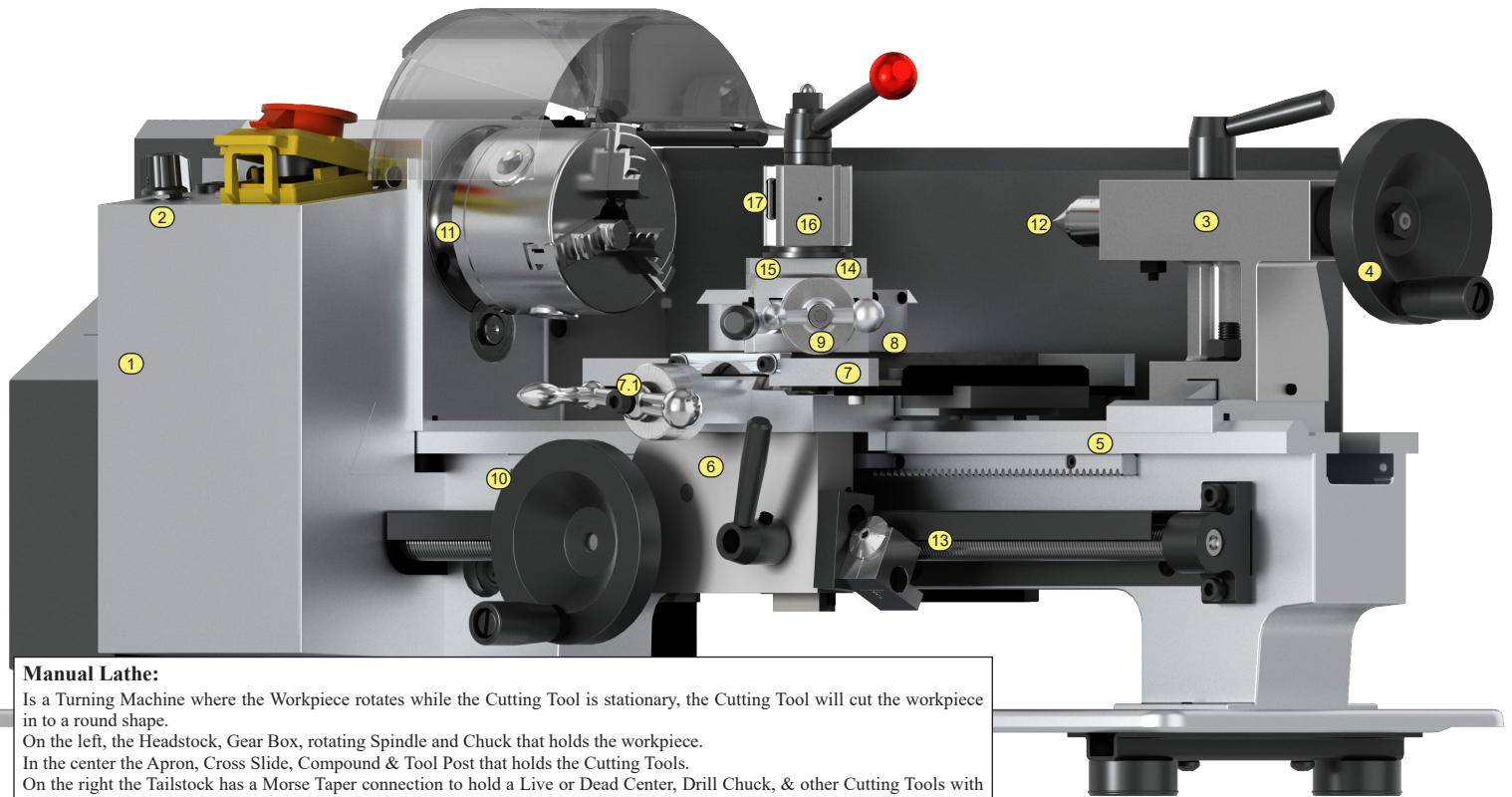
### SDN Tool Post and Toolholders Reference

Technical Support see pages:

4 to 5 & 33 to 44

Tool Post & Holders Ordering Information see pages:

45 to 59



## 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 operate 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.

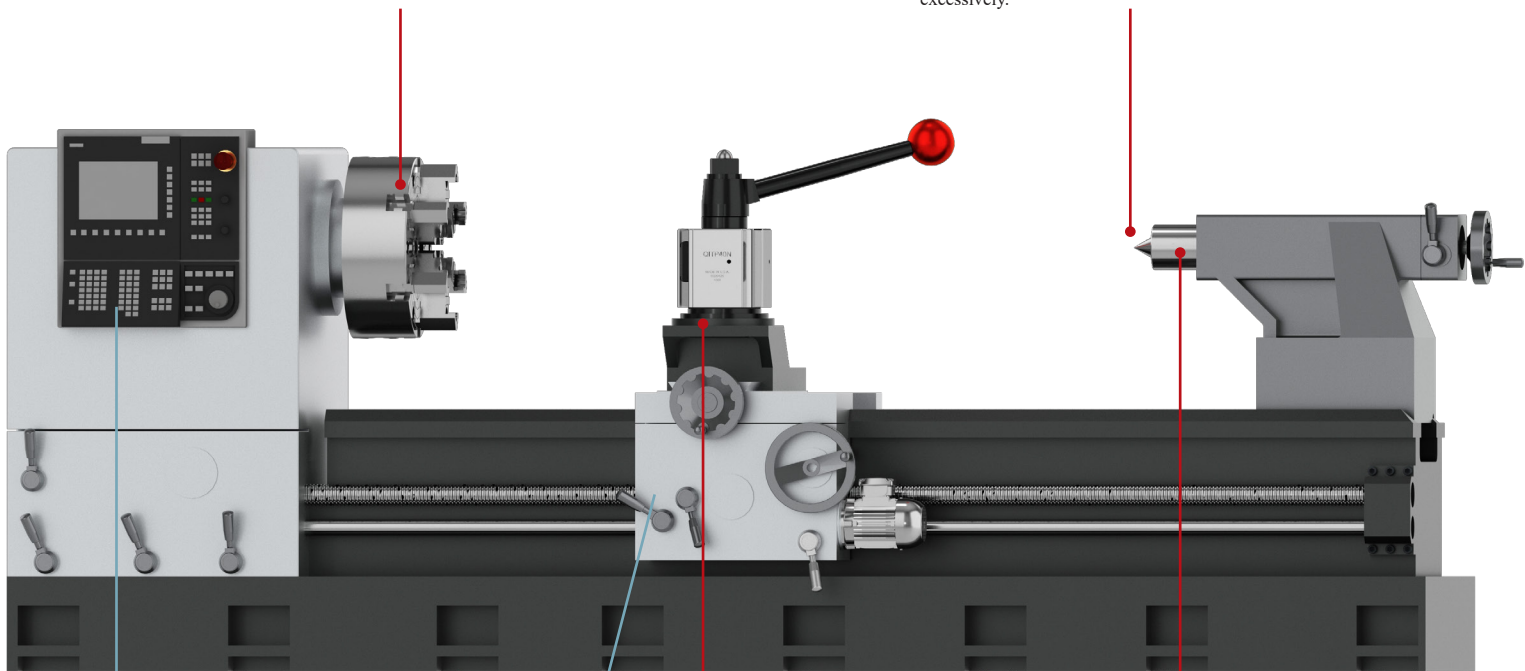
In the center the Apron and Tool Post that holds the Cutting Tools.

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.**

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

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



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

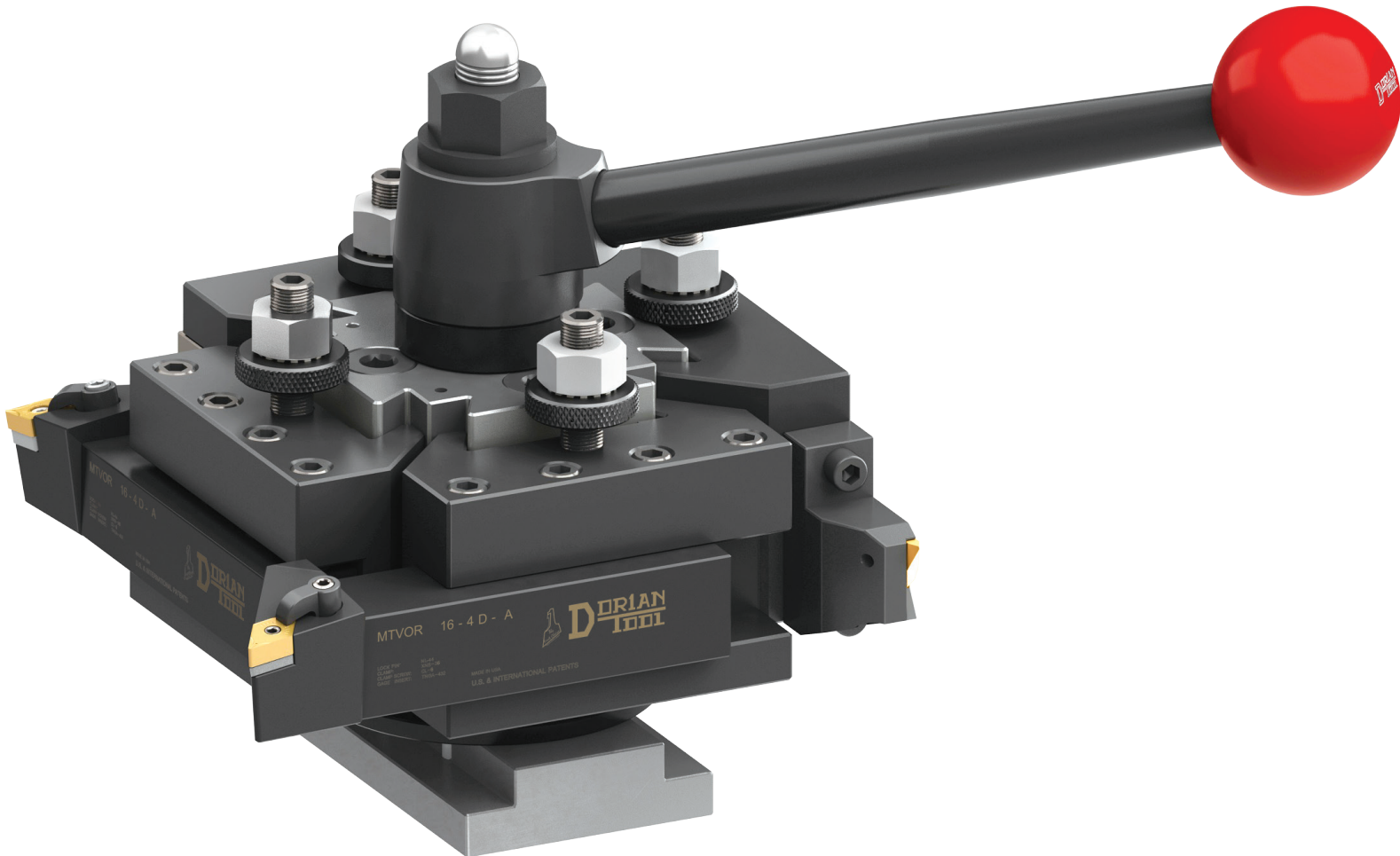
**Manual Handle:** To operates the machine manually.

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

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

# Quadra<sup>®</sup> Indexing Quick Change Tool Post & Toolholders

*QITP with 4 Toolholders  
&  
24 Positions Indexability*



*Performance is not an Option!*

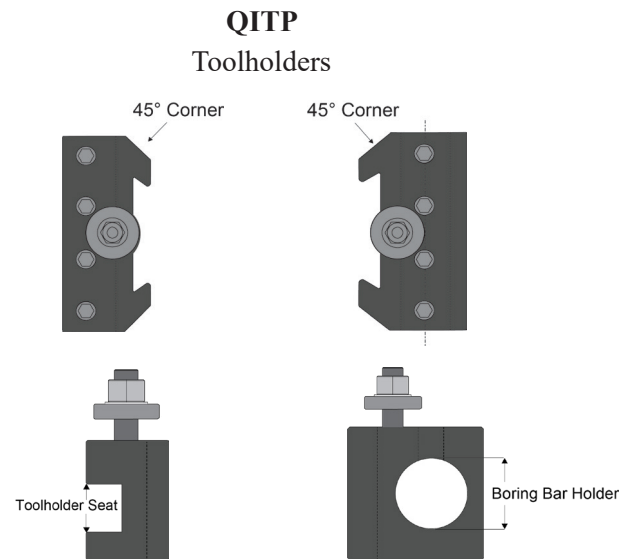
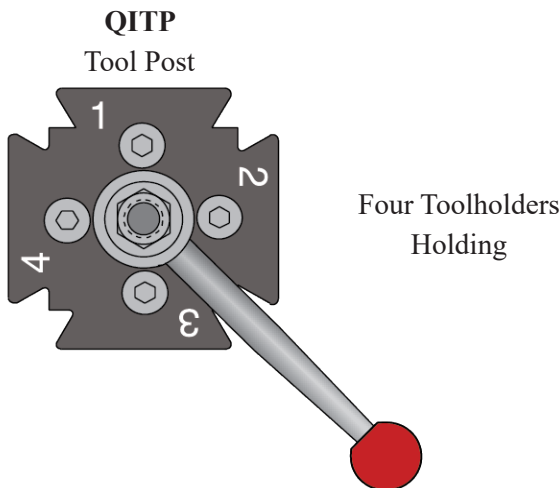
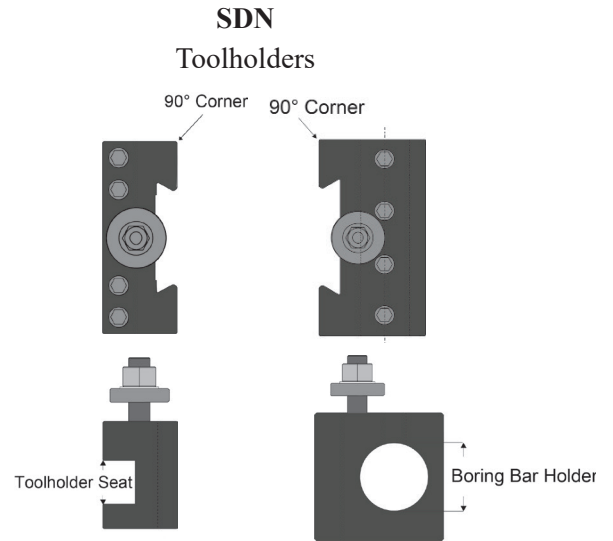
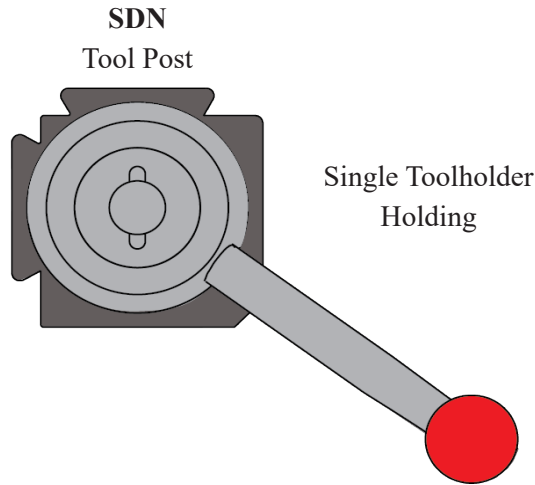
# Quadra<sup>®</sup> Tool Post and Toolholders Sizes & Crossover

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 Treating 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



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 <sup>™</sup>	Quadra <sup>®</sup>	Inch	mm	Inch	mm	
SDN25AXA	QITP25N	2.500	63.5	1/2 - 3/4	12 - 20	See Boring Bar Holders
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	

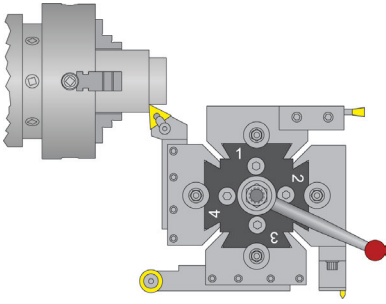
## The Multi-Patented Tool Post with The Most Advanced Indexing and Locking Technology

2 Pre-Loaded Positioning Index Pins

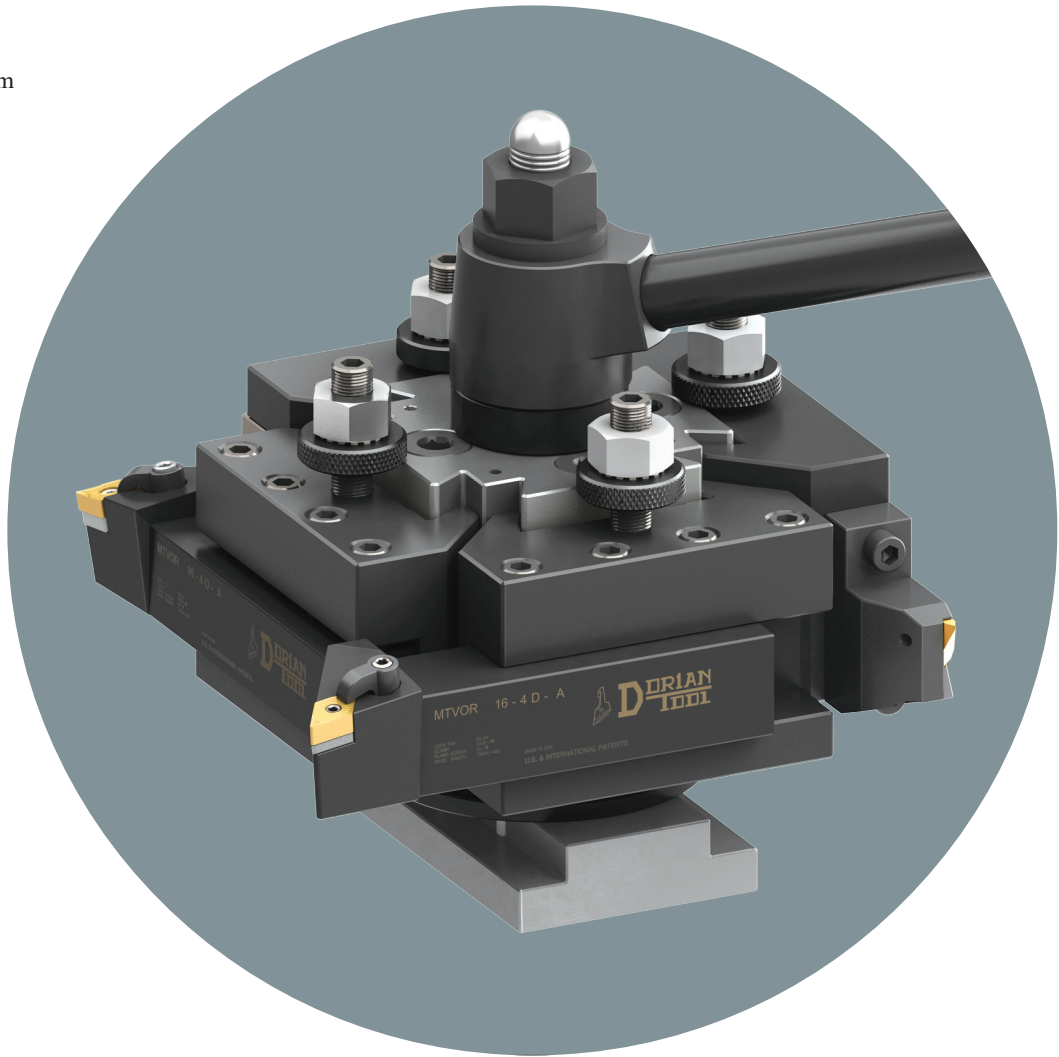
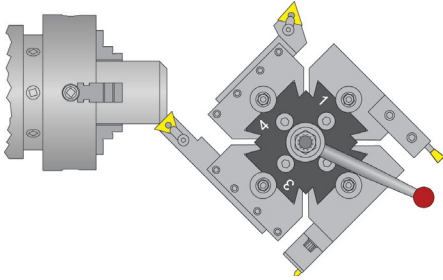
24 Super Precise Ball Bearing Locking System

**Strong - Rigid - Precise!**

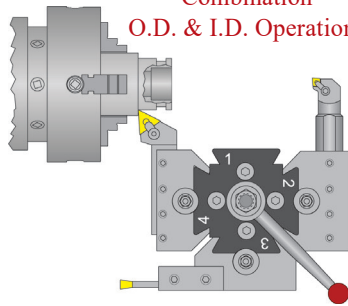
### O.D. Turning Operations



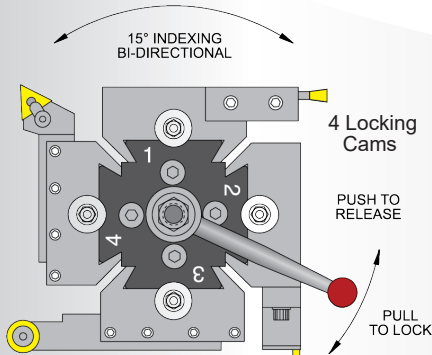
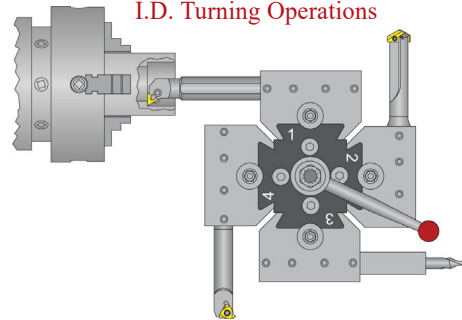
### O.D. Chamfering Operations 15° Increments



### 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.



## Features

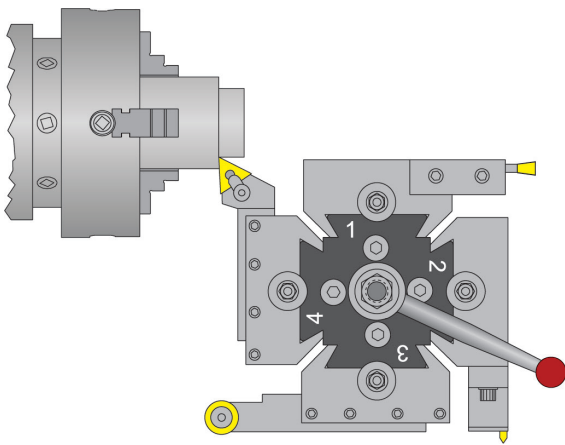
Heavy Duty Construction  
 Heat Treated High Strength Alloy Steel  
 Precision Ground Toolholder Locking Stations  
 "T Nut" Mounting System with Anti Rotatin Pin  
 Custom "T Nut" Available  
 Ready to Install and Use  
 Highest Locking Forces for Regidity & Accuracy

Positive Locking Systemes, with Obsolete Zero Backlash  
 24 Super Pricise Ball Bearing Locking System  
 4 Quick Change Toolholders locked Indipendebility  
 Wide range of Toolholders available  
 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

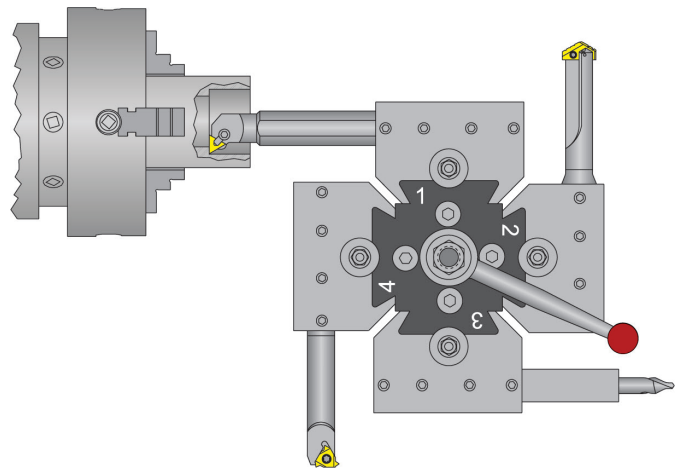
Finishing to Roughing or Threading



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

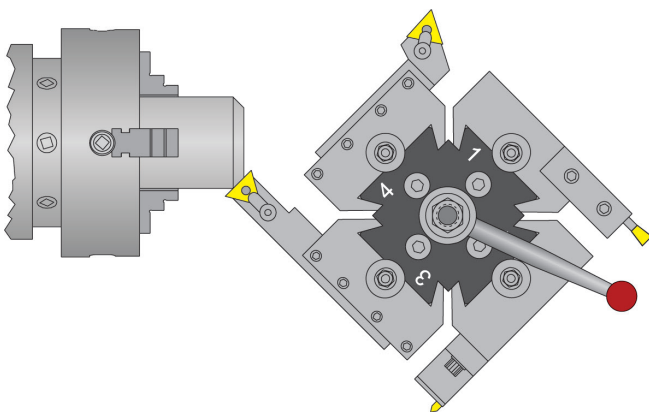
Finishing to Roughing or Threading



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

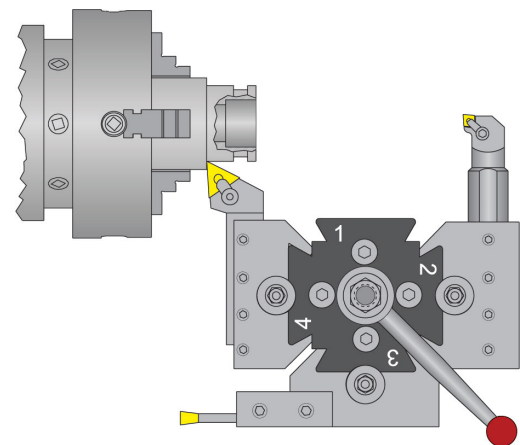
15° Increments



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<sup>®</sup> 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 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;**

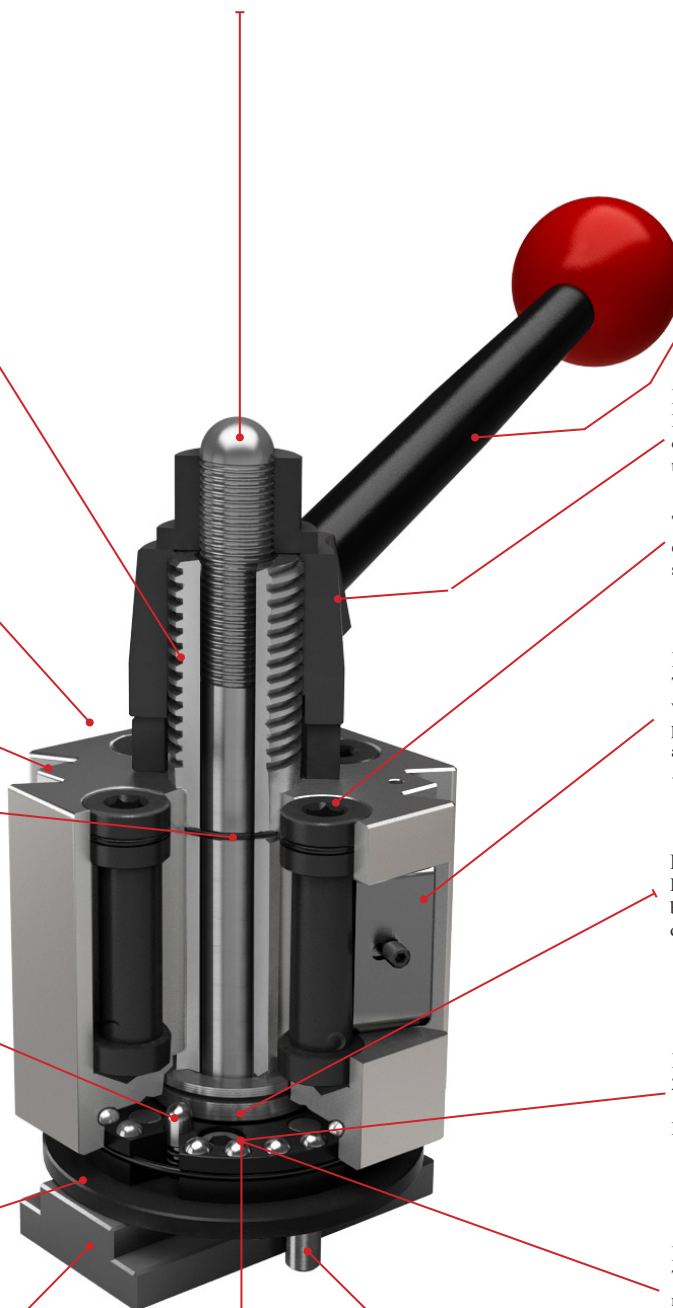
The accuracy and repeatability of this system will not be deteriorated by wear; however, will only get better with usage.

**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.

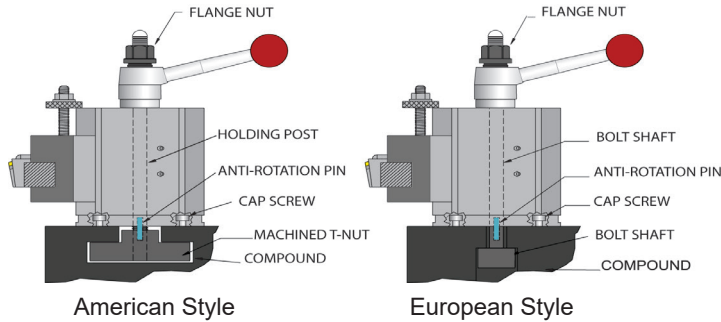
**24 Super Precise Ball Bearings;**

Indexing and Locking System, assures accuracy and precise repeatability when Tool Post is indexed and locked.



## Tool Post Mounting

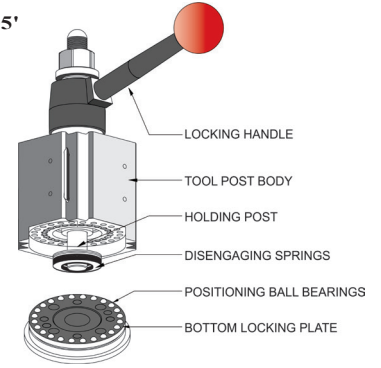
**Quick, Simple, & Rigid**



Tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flanged Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using the Bolt Shaft is the common mounting method on European lathes. Optional cap screws and dowel pins may be used to secure the toolpost directly to the compound or the T-nut. This is advantageous if there is tool post shifting during heavy or interrupted cuts.

## Indexing System

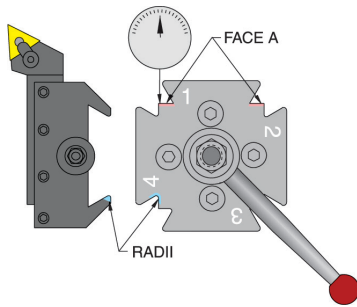
**Repeatability within .00005'**



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

## Indicating Position

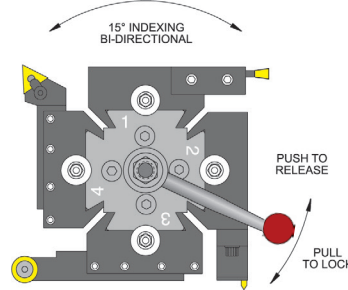
**Squareness within .0005"**



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.

## Operation

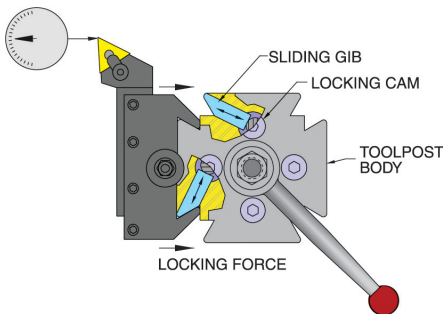
**Index from Tool to Tool in Seconds**



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

## Holder Locking System

**20,000 lbs Locking Force**

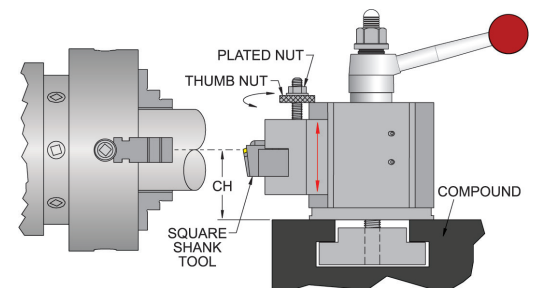


The holder locking system of the Quadra Indexing Tool Post is based on the four Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam style Locking Pin, locking it positively. The cam rotates from 0° (Release Position) to approximately 45° (Locking Position).

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

## Holder Center Height Adjustment

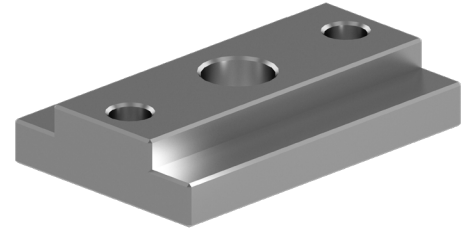
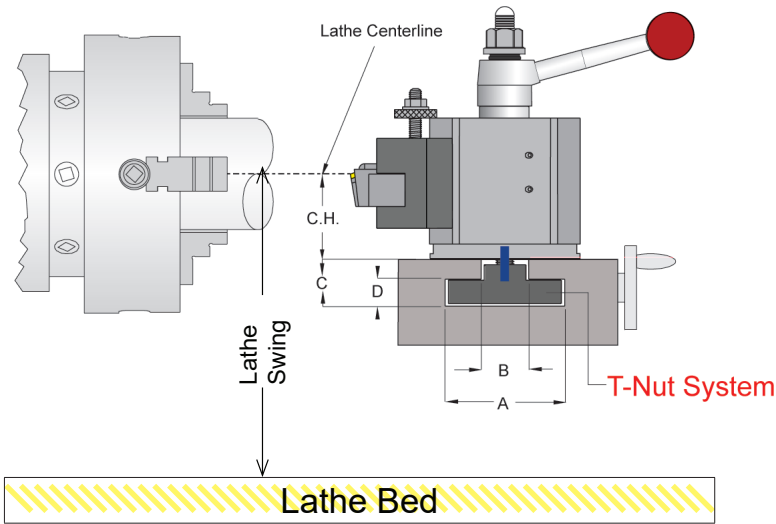
**Positive Center Height Adjustment**



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

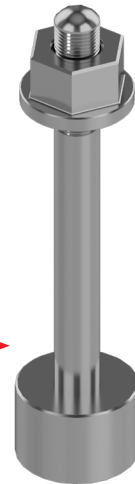
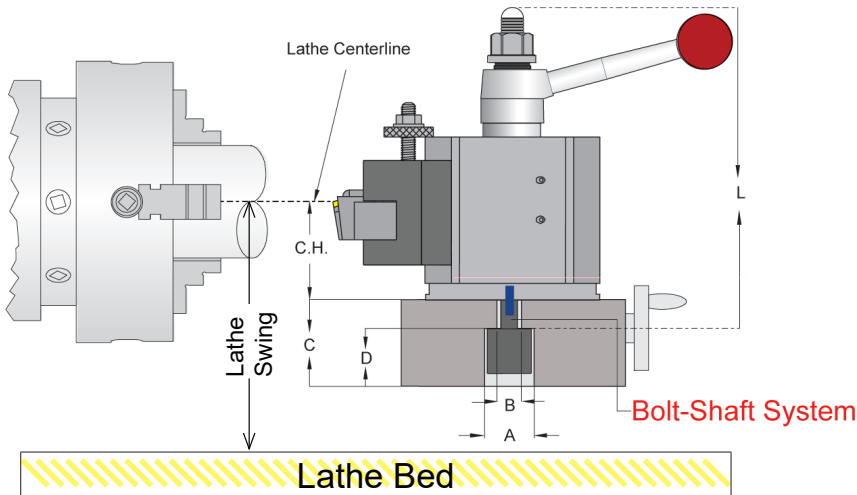
## American Mounting System

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



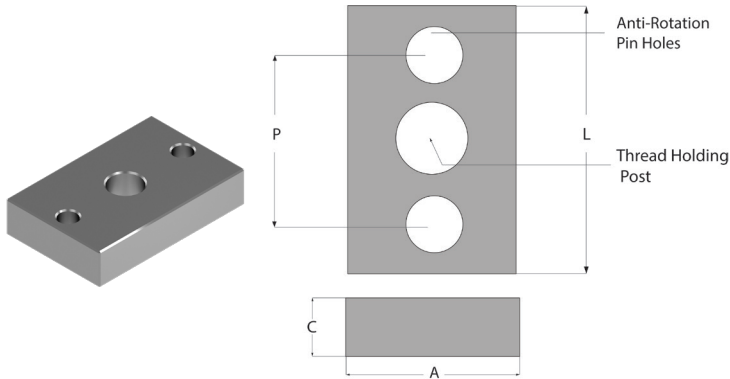
Bolt Shaft non standar item, supplied only on request

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.

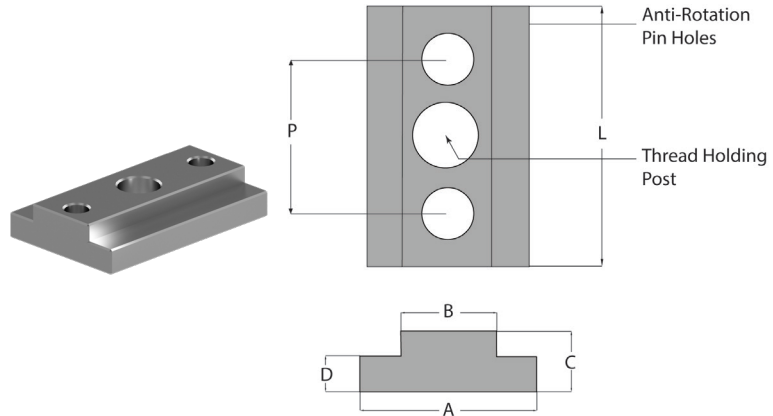
\* Please place an X for American or European mounting Style in the boxes above.



**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<sup>®</sup> Tool Post Cutting Tool Center Height Set-Up

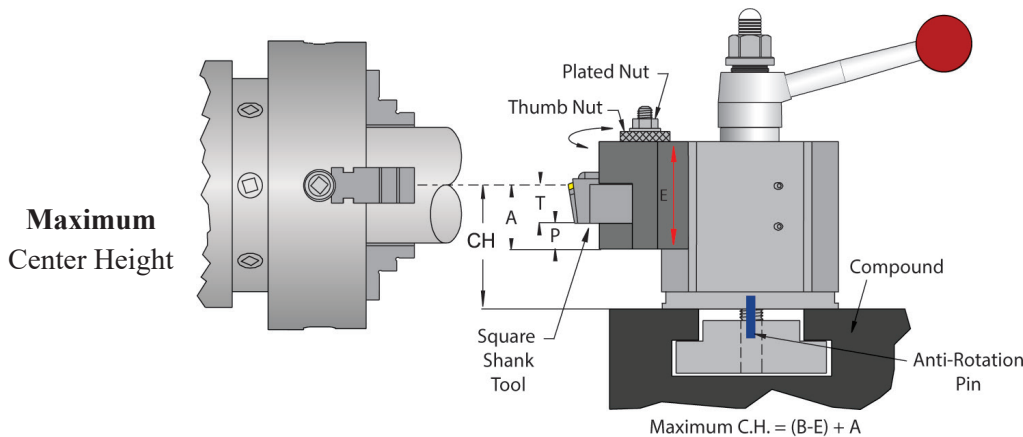
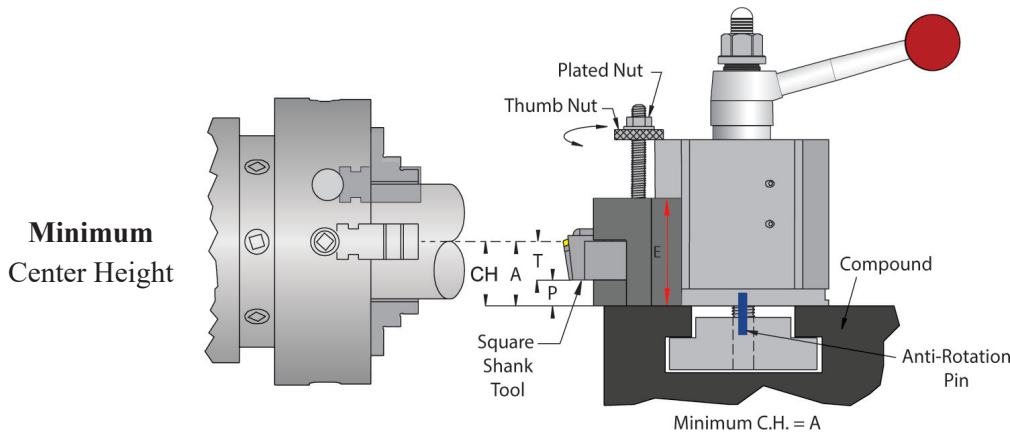
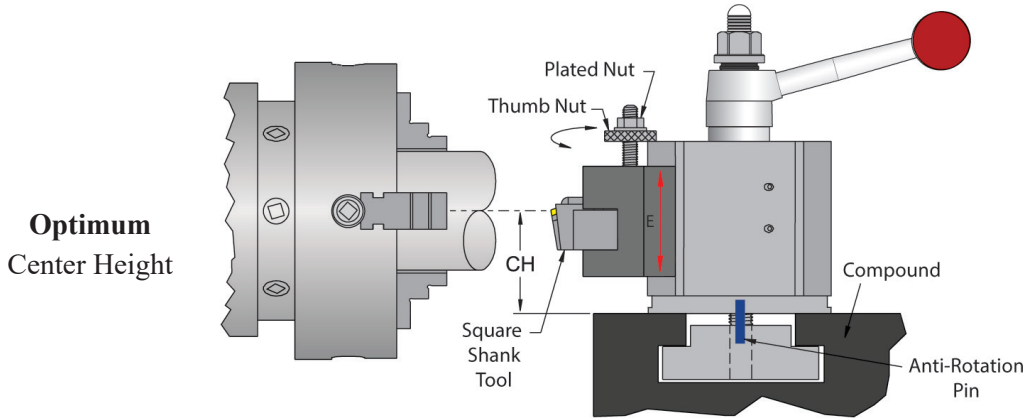
## Factors that determine the proper Tool Post for a specific lathe:

- |                            |                      |                            |
|----------------------------|----------------------|----------------------------|
| 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



## 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

## 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.

## 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<sup>®</sup> Tool Post & Toolholders Structure Specification

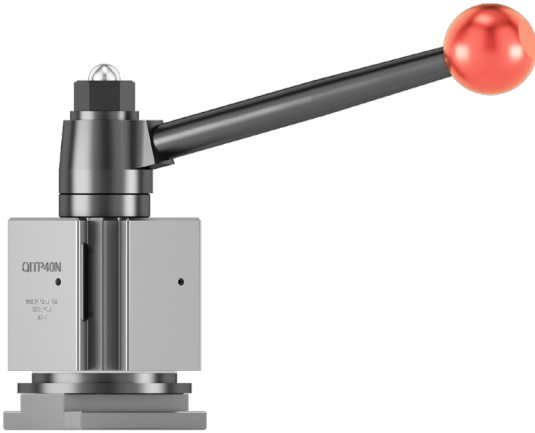
## Structure Specifications

## 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, 3.5"/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



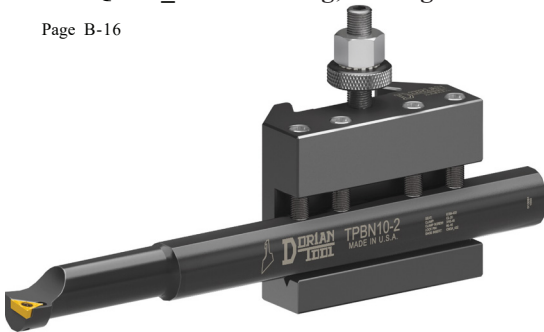
Holders are Built with 4140 Chromium-  
 Molybdenum Alloy Steel  
 Special Heat Treat Process to protect  
 Surface, & minimize Cutting Vibration  
 Quick Change Mounting

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



Holders 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.

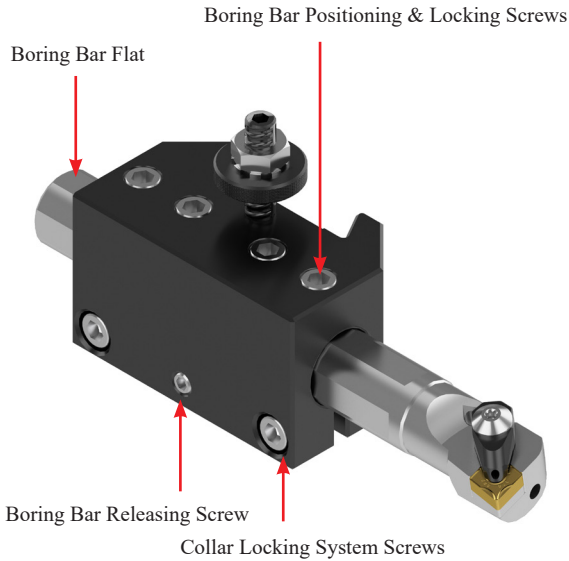
#### Features:

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

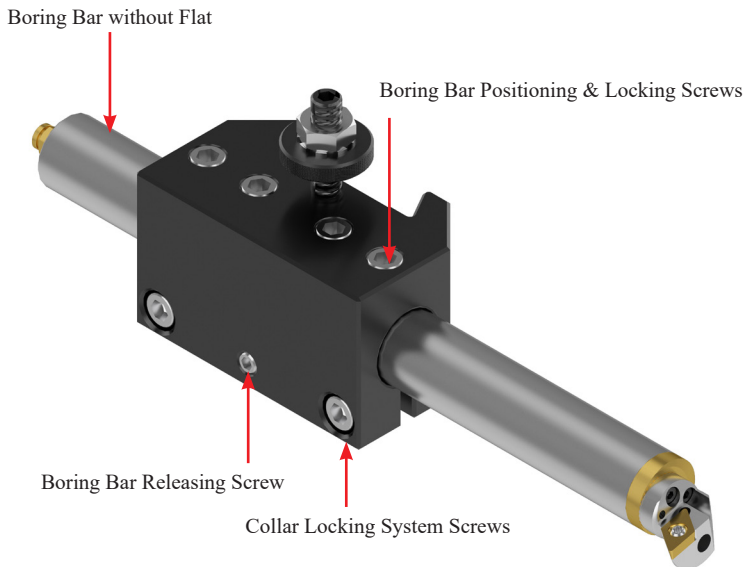
Longer Inserts Life  
Maximum Locking Force  
Maximum Rigidity & Stability

Higher Productivity  
Best Roughing Performance  
Best Surface Finish & Tolerance

#### Mounting of a Boring Bar with Flats

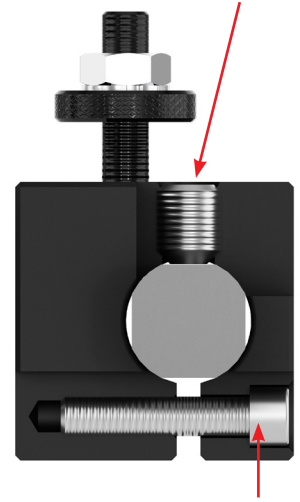


#### Mounting of a Boring Bar without Flats



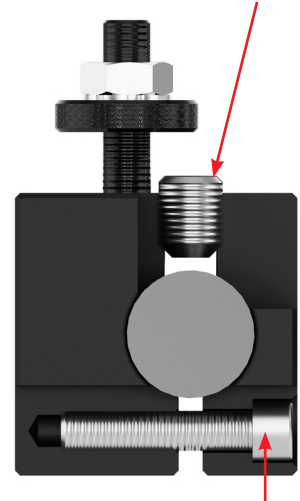
#### Locking Instruction

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



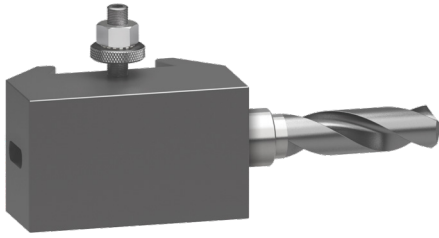
## Structure Specifications

## Features

## Application

### No. QITPN-5 Morse Taper Holder

Page B-19



Holders 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

All the Drilling, Reaming, Tapping, Operation using Drill Chuck or Morse Taper  
Heavy Duty Drilling Operation

### No. QITPN-36 5C Collet Holder

Page B-19



Holders 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

Holds 5 C Collets Series

Accept, Round, Square & Hexagonal Collets

Versatile for Multi Operation  
Drilling, Boring, Reaming, Threading, Turning  
Using Standard or Special Tools

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

Page B-19



Holders 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

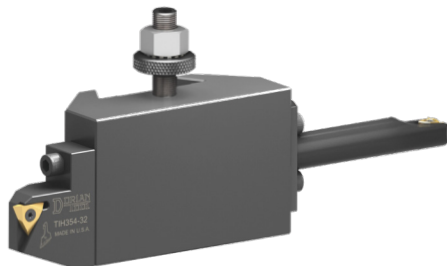
Toolholder Squareness and Parallel .0005" x inch/.00127 mm

Holds Industry Standard Sizes Cut-Off Blades

Cut-Off Operation  
Grooving Operation

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

Page B-21



Holders 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

Holds OD Threading Cartridge

Holds ID Threading Bar

Easy to Set-Up, Simple to Use

Uses Industry Style Threading Inserts

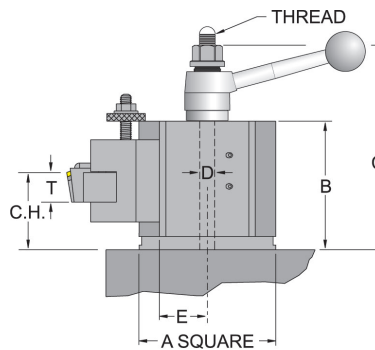
O.D. and I.D. Threading

# Quadra® Indexing Quick Change Tool Post

by  
Dorian Tool



The TRUE Solution for every turning application



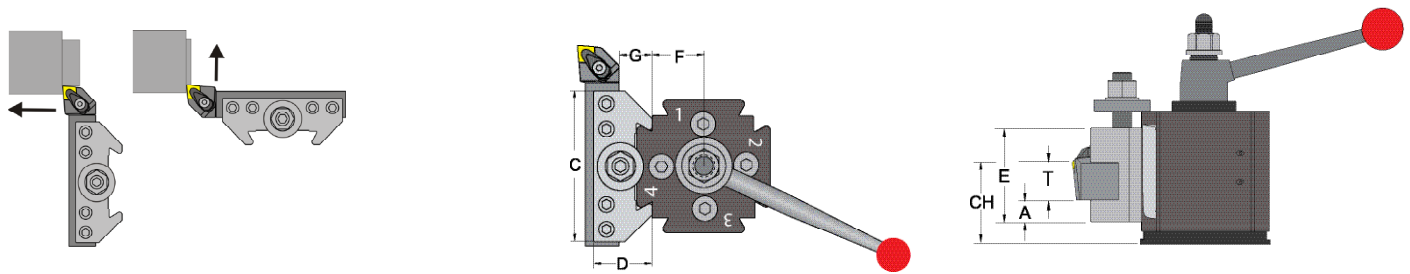
Description	QITP25N 00000		QITP30N 00002		QITP35N 00004		QITP40N 00006		QITP50N 00008		QITP60N 00010	
UPC No. 733101-	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
System												
Lathe Swing Over Bed	≤12"	≤300,0	13-15"	320,0	14-17"	400,0	16-20"	450,0	17-32"	500,0	≥25-XHD	XHD
A	2.500	63	3.000	76	3.500	88	4.000	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	1.0-1¼	25-32	1¼ - 1½	32-40	1 ½	40.0
Optimum C.H.*	1.422	36.1	1.747	44.4	1.835	46.6	2.202	55.9	2.995	76.1	3.440	87.4
C.H. MIN.	0.995	25.3	1.213	30.8	1.445	36.7	1.757	44.6	2.245	57.0	2.750	69.9
C.H. MAX.	1.849	50.0	2.282	58.0	2.225	56.5	2.646	67.2	3.744	95.1	4.129	104.9
Thread	1/2-20	M12x1,75	1/2-20	M12x1,75	5/8-18	M16x2,0	3/4-16	M18x2,5	1.0-14	M24x3,0	1½-12	M27x3,0

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

# Quadra<sup>®</sup> Quick Change-Toolholder Ordering Specification

## No. QITPN-1 Turning & Facing Toolholder

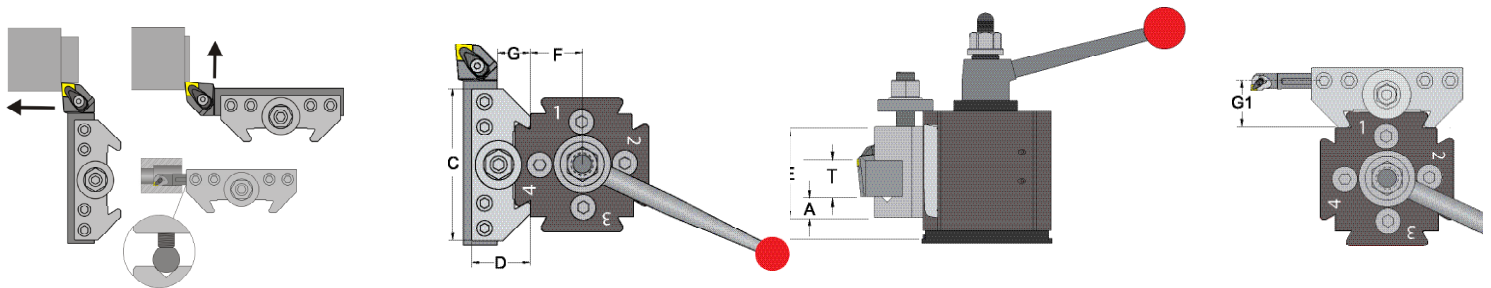
This Toolholder is best used for holding square shank Cutting Tools close to the Tool Post to maximize Rigidity, Stability & Performance, in turning, facing, and threading Operation.



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.

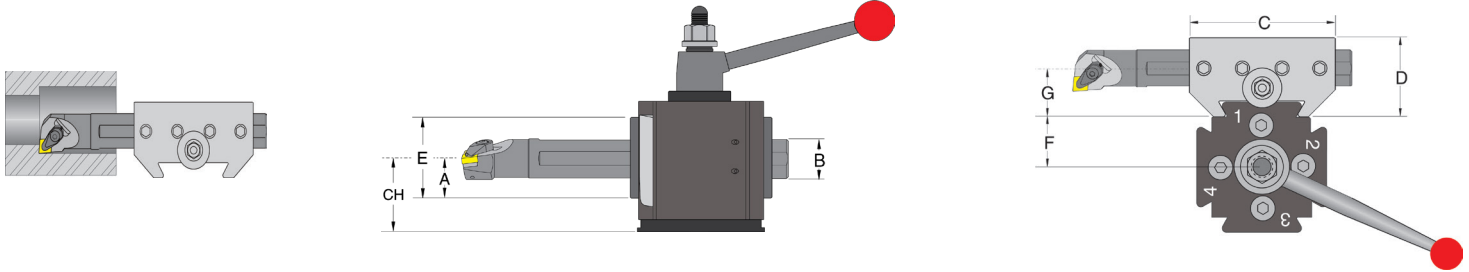


Description	UPC No.733101-	System	A	T	C	D	E	F	G	G1
QITP25N-2	00104	in	0.375	.750	2.750	1.240	1.740	0.880	0.770	1.030
		mm	9.53	20.00	69.85	31.50	44.20	22.35	19.56	26.16
QITP30N-2	00254	in	0.437	1.000	3.250	1.490	2.240	1.115	0.890	1.210
		mm	11.10	25.00	82.55	37.85	56.90	28.32	22.61	30.73
QITP35N-2	00404	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<sup>®</sup> Quick Change-Toolholder Ordering Specification

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

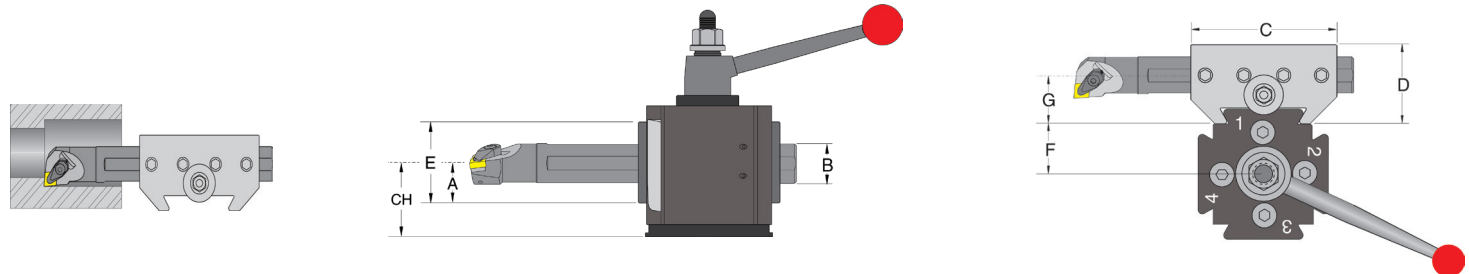
This Toolholder with DUAL Locking System, is best used for holding Round Tools and Boring Bars with or without flats. The Boring Bar, is locked 360° around the Diameter in to the Toolholder, The DUAL locking System, will fuse the Boring Bar with the Toolholder in One Unit, achieving the best possible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



Description	UPC No.733101-	A	B Boring Bar Capacity	C	D	E	F	G
<b>Inches Toolholders</b>								
QITP25N-4-750-DUAL	00111	0.745	0.750	2.750	1.490	1.490	0.880	0.937
QITP30N-4-1000-DUAL	00261	0.995	1.000	3.250	1.990	1.990	1.115	1.250
QITP35N-4-1000-DUAL	00411	1.120	1.000	3.750	2.240	2.240	1.245	1.375
QITP40N-4-1250-DUAL	00561	1.245	1.250	4.500	2.490	2.490	1.530	1.500
QITP50N-4-1500-DUAL	00711	1.495	1.500	5.500	2.990	2.990	1.900	2.000
QITP60N-4-2000-DUAL	00861	1.995	2.000	6.500	3.990	3.990	2.207	2.500
<b>Metric Toolholders</b>								
QITP25N-4M-20-DUAL	01113	19	19	70	38	38	22	24
QITP30N-4M-25-DUAL	01263	25	25	83	51	51	28	32
QITP35N-4M-25-DUAL	01419	28	25	95	57	57	31	35
QITP40N-4M-32-DUAL	01567	32	32	114	63	63	39	38
QITP50N-4M-40-DUAL	01717	38	38	140	76	76	48	51
QITP60N-4M-50-DUAL	01867	51	50	165	101	101	56	63

## 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.



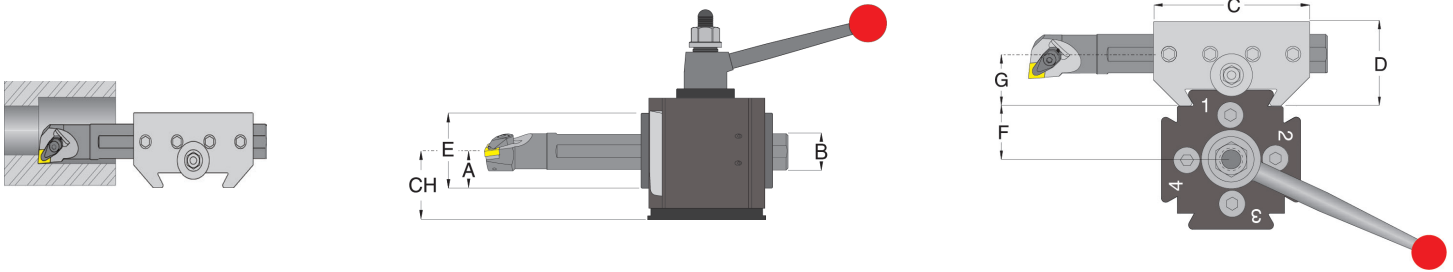
Description	UPC No.733101-	A	B Boring Bar Capacity	C	D	E	F	G
<b>Inches Toolholders</b>								
QITP35N-41-1250-DUAL	00413	1.120	1.250	3.750	2.240	2.240	1.245	1.375
QITP40N-41-1500-DUAL	00563	1.370	1.500	4.500	2.740	2.740	1.530	1.625
QITP50N-41-2000-DUAL	00713	1.745	2.000	5.500	3.490	3.490	1.900	2.250
QITP60N-41-2500-DUAL	00863	2.245	2.500	6.500	4.490	4.490	2.207	2.750
<b>Metric Toolholders</b>								
QITP35N-41M-32-DUAL	00421	28	32	95	57	57	32	35
QITP40N-41M-40-DUAL	00569	35	40	114	70	70	39	41
QITP50N-41M-50-DUAL	00719	44	50	140	89	89	48	57
QITP60N-41M-60-DUAL	00869	57	60	165	114	114	56	70



# Quadra<sup>®</sup> Quick Change-Toolholder Ordering Specification

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

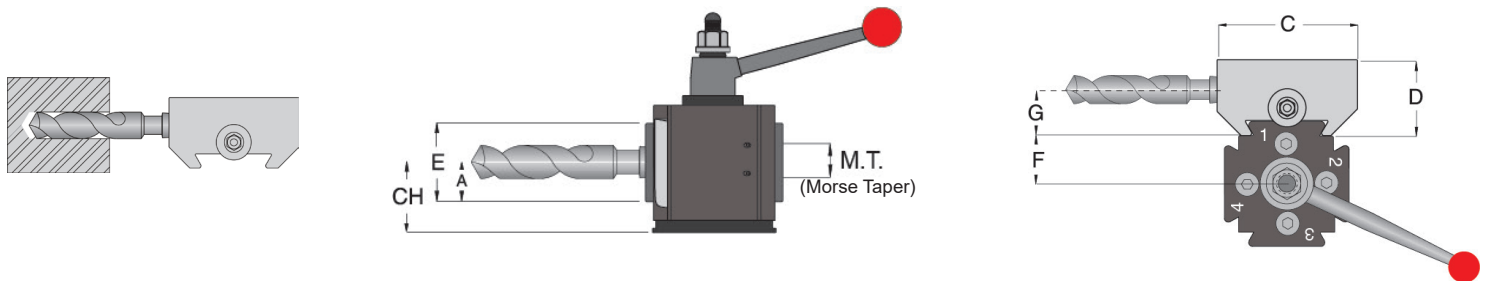
This Toolholder with DUAL Locking System, is best used for holding Round Tools and Boring Bars with or without flats. The Boring Bar, is locked 360° around the Diameter in to the Toolholder, The DUAL locking System, will fuse the Boring Bar with the Toolholder in One Unit, achieving the best possible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



Description	UPC No.733101-	A	B Boring Bar Capacity	C	D	E	F	G
<b>Inches Toolholders</b>								
QITP35N-41-150-CNC	00418	1.245	1.500	4.000	2.490	2.490	1.245	1.500
QITP40N-41-200-CNC	00568	1.495	2.000	4.500	2.990	2.990	1.530	1.750
QITP50N-41-250-CNC	00718	1.995	2.500	6.500	3.990	3.990	1.900	2.250
QITP60N-41-300-CNC	00868	2.245	3.000	7.000	4.490	4.490	2.207	2.625
<b>Metric Toolholders</b>								
DQ35CXA-41SM-40-DUAL	00423	31	40	102	63	63	32	38
DQ40CA-41SM-50-DUAL	00571	38	50	114	76	76	39	45
DQ50DA-41SM-60-DUAL	00721	51	60	165	101	101	48	57
DQ60EA-41SM-80-DUAL	00871	57	80	178	114	114	56	67

## No. QITPN-5 Morse Taper Toolholder

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

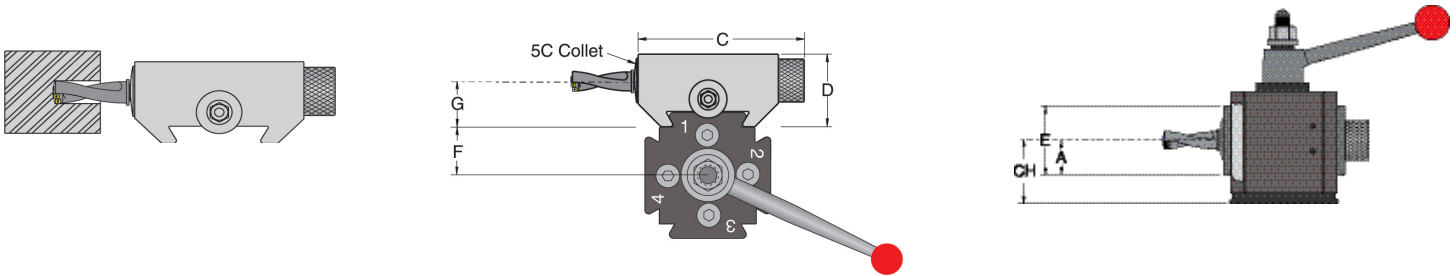


Description	UPC No. 733101-	System	A	Morse Taper	C	D	E	F	G
QITP35N-5-4	00424	in	1.250	MT4	4.150	2.500	2.500	1.245	1.615
		mm	31.80	MT4	105.41	63.50	63.50	31.62	41.02
QITP40N-5-4	00572	in	1.250	MT4	4.500	2.500	2.500	1.530	1.615
		mm	31.80	MT4	114.30	63.50	63.50	38.90	41.02
QITP50N-5-5	00722	in	1.750	MT5	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<sup>®</sup> Quick Change-Toolholder Ordering Specification

## No. QITPN-36 5C Collet Toolholder

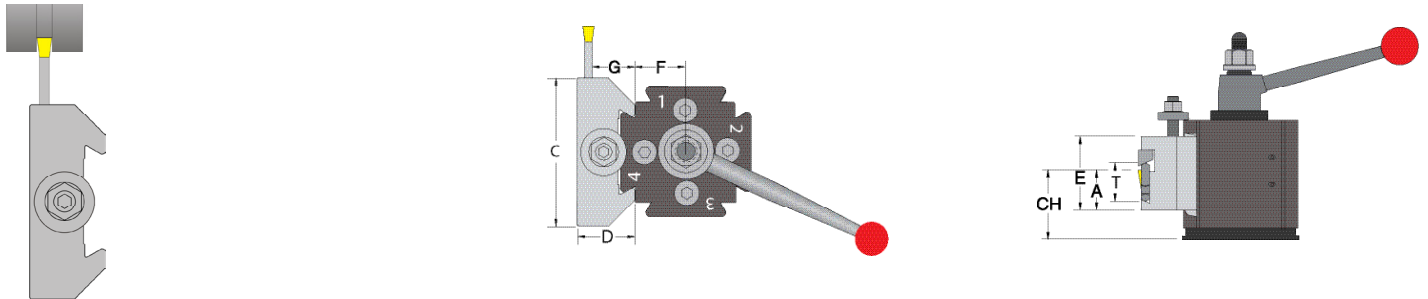
This holder's wide range of collet adaptability makes this tool ideal for holding drills, taps, chucks, & boring bars. It holds the tools with extreme rigidity without scarring them. Fits industry standard tool posts.



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

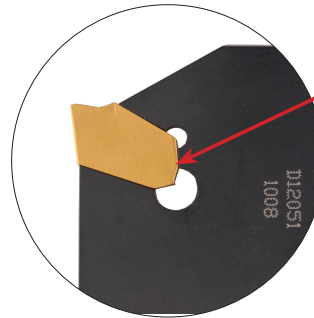


Description	UPC No.733101-	System	A	Dual Blade Capacity		C	D	E	F	G
				Slot Grip Blade	Twin Edge Blade					
QITP25N-7-71C	00126	in	0.933	SGIH-19-2	TWECOB-19-2	2.750	1.250	2.000	0.880	1.127
		mm	23.70			69.85	31.75	50.80	22.35	28.63
QITP30N-7-71C	00276	in	0.933	SGIH-26-2 to 26-6	TWECOB-26-2 to 26-6	3.250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

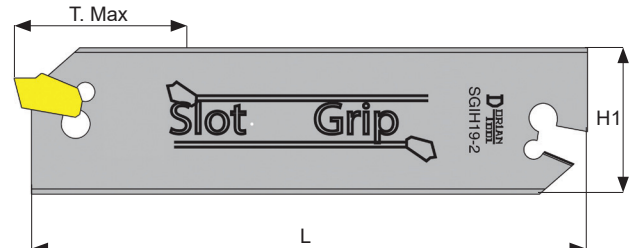
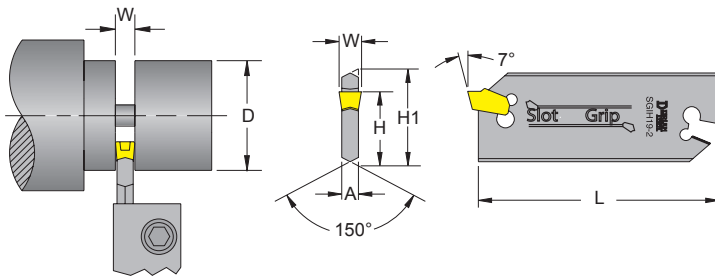


## Positive Stop Blades



### 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"

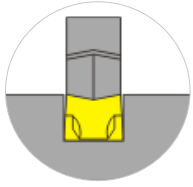
### 32mm (1 1/4") Slot Grip Blades

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/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

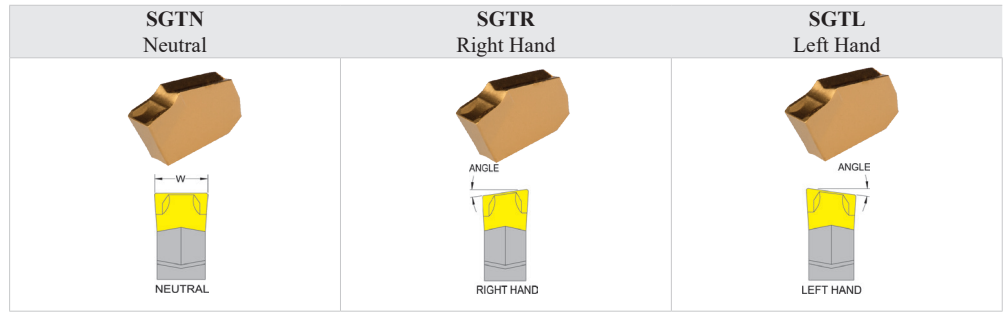


### Chip breaker Geometry

- 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.



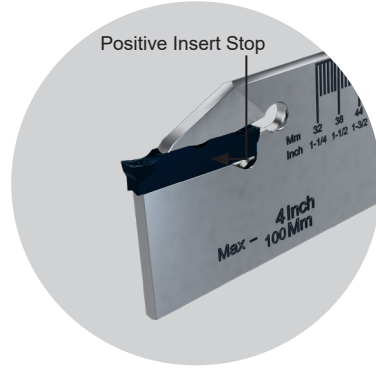
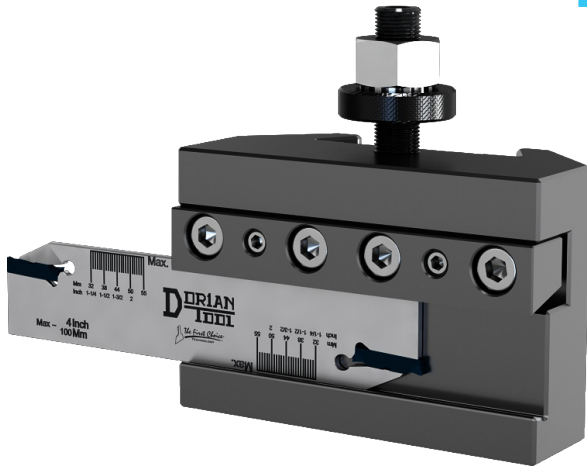
### Application

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

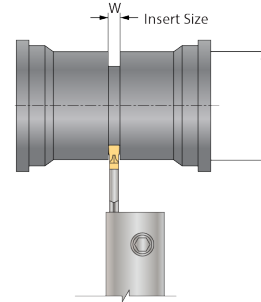
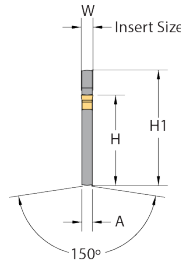
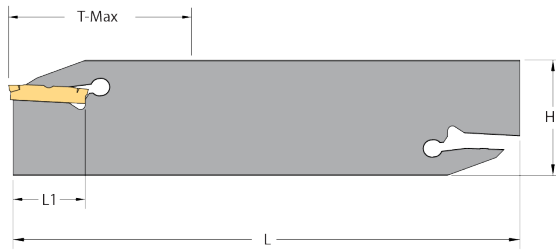
Insert Grade	Material		Insert Grade		Insert Coating		
	Carbon & Alloy Steel	Aluminum & Non-Ferrous Metals & Materials	P35	K25 N25	CVD TiN Coated	Uncoated	PVD TiAlN Coated
ANSI	Insert Size mm	Lead Angle	Width + 0,05	DC656	DK25	DASK25B	
			inch	UPC #	UPC #	UPC #	
SGTN-2	2	0°	.087	2	82222	82220	82223
SGTN-2.4	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	-	-

## Twin Edge Blades

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



Double "V" Locking System



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	0.079	KCIK-DN	61204
									DNPG-22 2002-1SR-N			

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


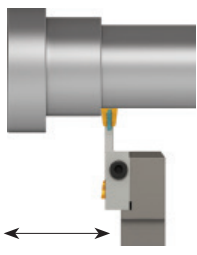
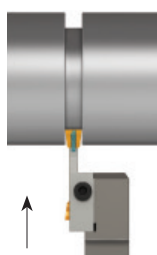
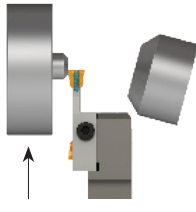
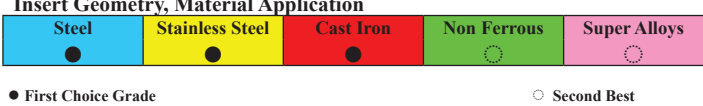
Blades Description	UPC #	T. Max	A	D	L	L1	H	H1	Insert Description	Insert Width	Insert Extraction Key Description	UPC #
TWECOB-DNTF-26-20	61965	1.000	0.063	2.000	4.331	0.866	0.842	1.024	DNTQ-22 2002-3EU-N	0.079	KCIK-DN	61204
TWECOB-DNTF-26-30	61966	1.550	0.094	3.100	4.331	0.866	0.842	1.024	DNPG-22 2002-1SR-N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

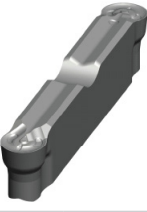
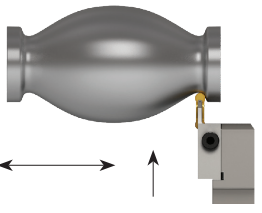
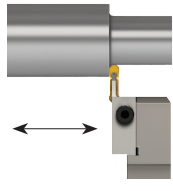
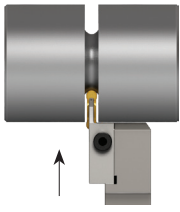

### 32mm (1 1/4") Twin Edge Blades


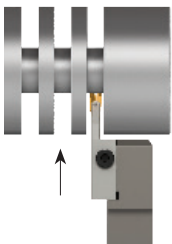
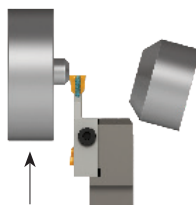
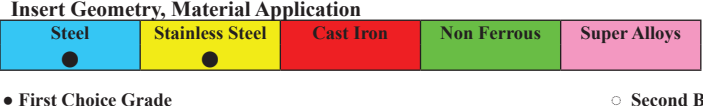
Blades Description	UPC #	T. Max	A	D	L	L1	H	H1	Insert Description	Insert Width	Insert Extraction Key Description	UPC #
TWECOB-DNTF-32-20	61968	1.150	0.063	2.300	5.906	0.866	0.984	1.260	DNTQ-22 2002-3EU-N	0.079	KCIK-DN	61204
									DNPG-22 2002-1SR-N			
TWECOB-DNTF-32-30	61969	1.750	0.094	3.500	5.906	0.866	0.984	1.260	DNTQ-22 3003-3EU-N	0.118		
									DNTR-22 3015-3EU-N			
									DNPG-22 3002-1SR-N			
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		
									DNTR-25 4020-3EU-N			
									DNPG-25 4003-1SR-N			
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		
									DNTR-25 5025-3EU-N			
									DNPG-25 5004-1SR-N			
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		
									DNPG-25 6004-1SR-N			



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

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

Insert Specification					Insert Application				
<b>Double-End Cutting Edge</b> <b>DNPG-N- DPP40SG</b>									
<b>Neutral Straight Nose</b> Uni-Direction Parting Off & Grooving					 				
Cutting Data					<b>Insert Geometry, Material Application</b>				
Insert Dimension			Maximum $f_n$ Feed Rate for Parting-off						
Width	Length	Corner Radius	inch	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						

# 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

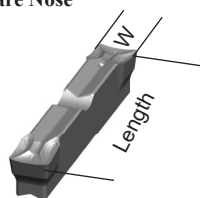
DPP40SG					
Material		V <sub>c</sub> (SFM)			
Steel		F/min.		m/min.	
P	Carbon Steel	264	495	80	150
	Low Alloy Steel	231	396	70	120
	High Temp Alloys	198	330	60	100
M	Ferritic	330	594	100	180
	Austenitic	264	495	80	150
	Duplex	231	363	70	110
	Martensitic	198	297	60	90
K	Gray Cast Iron	264	561	80	170
	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				

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

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

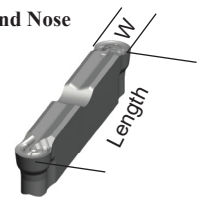
## Insert Specifications

### “T” Square Nose



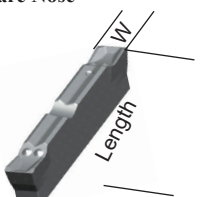
UPC #	Application	Part Number	Insert Size		Corner Radius	Grade
			Width	Length		DUP35UG
82440	Turning Grooving Parting-Off	DNTQ-22 2002-3EU-N DUP35UG	.079" (2mm)	.866"	.008"	•
82442		DNTQ-22 3003-3EU-N DUP35UG	.118" (3mm)	.866"	.012"	•
82443		DNTQ-25 4004-3EU-N DUP35UG	.157" (4mm)	.984"	.016"	•
82444		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		Radius	Grade
			Width	Length		DUP35UG
82459	Profiling Turning Grooving	DNTR-22 3015-3EU-N DUP35UG	.118" (3mm)	.866"	.059" (1.5mm)	•
82460		DNTR-25 4020-3EU-N DUP35UG	.157" (4mm)	.984"	.079" (2.0mm)	•
82461		DNTR-25 5025-3EU-N DUP35UG	.197" (5mm)	.984"	.098" (2.5mm)	•

### “G” Square Nose



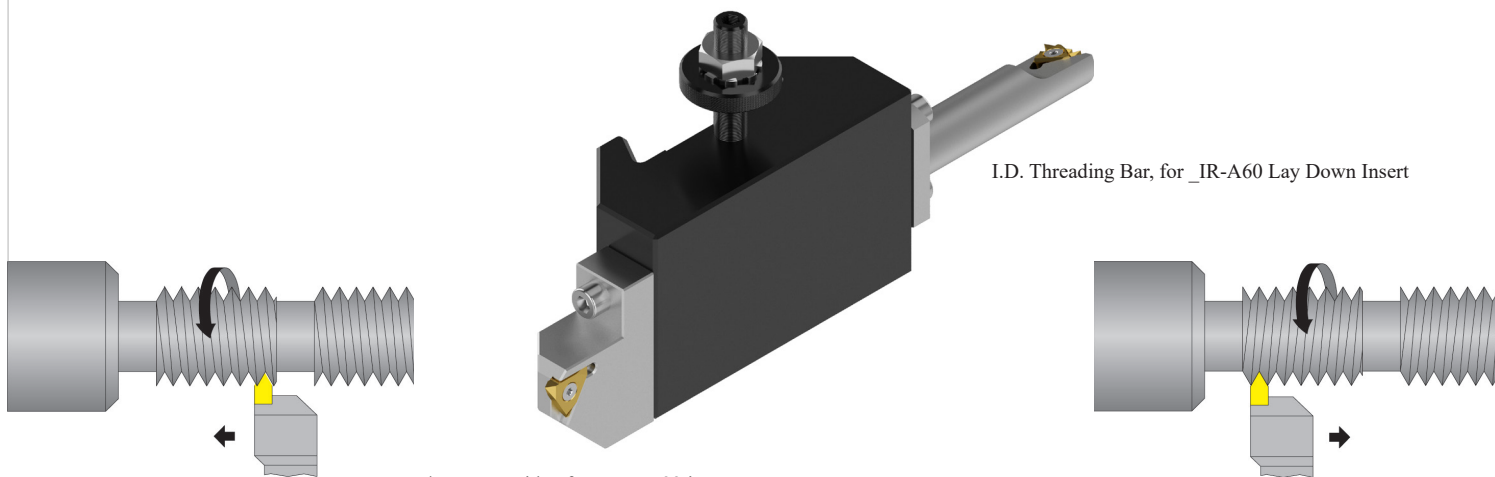
UPC #	Application	Part Number	Insert Size		Corner Radius	Grade
			Width	Length		DPP40SG
82475	Grooving Parting-Off	DNPG-22 2002-1SR-N DPP40SG	.079" (2mm)	.866"	.008"	•
82476		DNPG-22 3002-1SR-N DPP40SG	.118" (3mm)	.866"	.008"	•
82477		DNPG-25 4003-1SR-N DPP40SG	.157" (4mm)	.984"	.012"	•
82478		DNPG-25 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

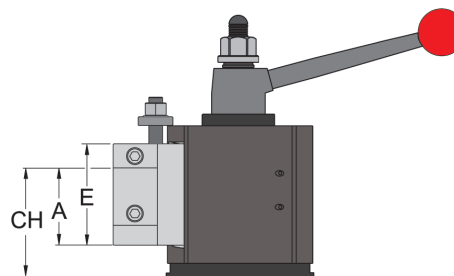
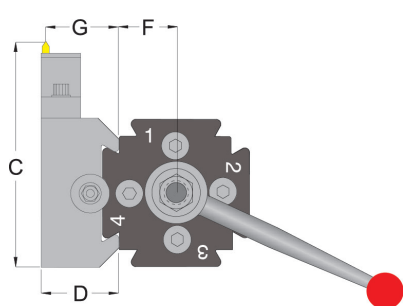
## No. QITPN-881 O.D. and I.D. Threading Toolholder

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



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



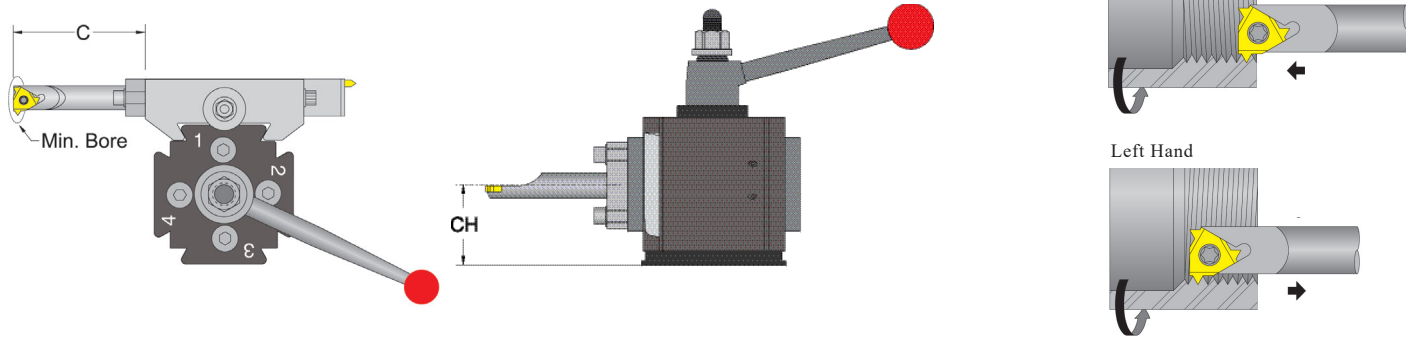
Description	UPC No.	System	A	C	D	E	F	G	*O.D. Cartridge for TNMC-32 insert				
									Desc.	UPC No. 733101-	TNMC Insert	Torx Screw	Torx Key
QITP25N-881-OE	00132	in	0.875	4.130	1.250	1.750	0.880	1.000	TIH253-32	03621	32	GTS-1M	T-10
		mm	22.20		31.80	44.50	22.40	25.40					
QITP30N-881-OE	00282	in	1.000	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

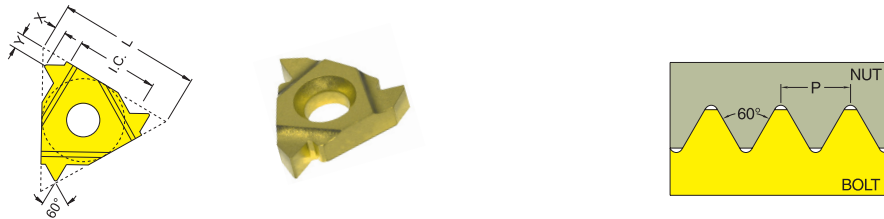
## Internal Threading Bar For QITPN-881 Toolholder

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.



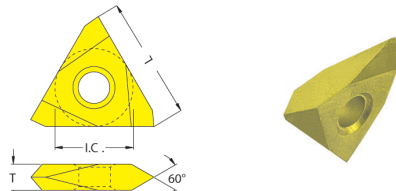
Series	Right Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	in	mm	in	mm	TPI	mm			
25,30,35,40	NL50R	03661	111R-A60	0.500	12,7	2.375	60,3	16-48	0,5-1,5	.250	TS-25.45-6M1	T-8
25,30,35,40	NL75R	03663	161R-AG60	0.750	19,1	2.875	73,0	8-48	0,5-3,0	.375	TS-16	T-10

## 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
111R-A60	DVP656	74056	DVK10	74057	111L-A60	DVP656	74060	DVK10	74061	11 mm	0.250	16-48	0,5-1,5	0,8	0,9
161R-A60		74064		74065	161L-A60		74068		74069	16 mm	0.375	16-48	0,5-1,5		
161R-G60		74072		74073	161L-G60		74076		74077	16 mm	0.375	8-14	1,75-3,0	1,2	1,7
161R-AG60		74080		74081	161L-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											

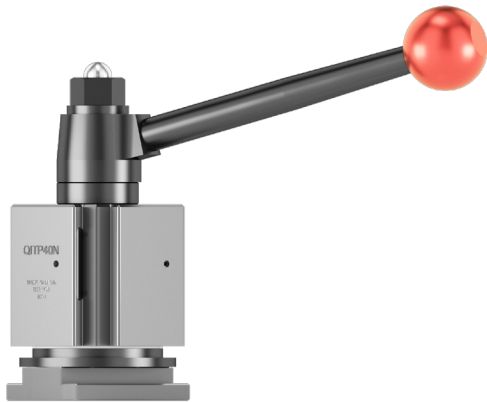
# Quadra® Indexing Quick Change Tool Post & Toolholders Sets

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

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

Set Includes:

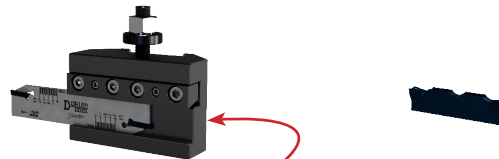
- (1) Tool Post
- (4) Holders
- (4) Toolholders **FREE**
- (5) Inserts **FREE**



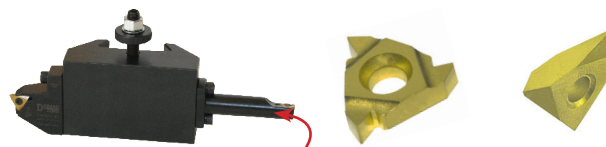
1ea. QITPN-1 + Free Square Shank Toolholder & 1 Free Turning Insert



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 No. QITPN-1 Turning & Facing Toolholder No. QITPN-2 Turning, Facing & Boring Toolholder No. QITPN-7-71C Reversible Cut-Off Blade Toolholder No. QITPN-881 O.D. or I.D. Threading Toolholder	QITP25N-1 QITP25N-2 QITP25N-7-71C QITP25N-881-OE	QITP30N-1 QITP30N-2 QITP30N-7-71C QITP30N-881-OE	QITP35N-1 QITP35N-2 QITP35N-7-71C QITP35N-881-OE	QITP40N-1 QITP40N-2 QITP40N-7-71C QITP40N-881-OE
<b>Free Tooling</b>				
(4) Toolholders Turning Square Shank Boring Bar Cut-Off Blade Threading Bar	STNCR08-2J STCMB06-2 TWECOB-DNTF-19-20 NL50R	STNCR10-2A STCMB08-2 TWECOB-DNTF-19-20 NL50R	STNCR12-3B STCMB10-2 TWECOB-DNTF-26-30 NL75R	STNCR64-3D STCMB12-3 TWECOB-DNTF-26-30 NL75R
(5) Inserts Turning Insert Turning & Boring Insert Turning & Grooving Insert O.D. Threading Insert I.D. Threading Insert	TCMT-21.51-PEM-DPC25UT TCMT-21.52-PEM-DPC25UT DNTQ-222002-3EU-DPP35UG TNMC-32NV-DVP656 11IR-A60-DVP656	TCMT-21.51-PEM-DPC25UT TCMT-21.52-PEM-DPC25UT DNTQ-222002-3EU-DPP35UG TNMC-32NV-DVP656 11IR-A60-DVP656	TCMT-21.51-PEM-DPC25UT TCMT-32.52-PEM-DPC25UT DNTQ-223003-3EU-DPP35UG TNMC-32NV-DVP656 16IR-A60-DVP656	TCMT-32.51-PEM-DPC25UT TCMT-32.52-PEM-DPC25UT DNTQ-223003-3EU-DPP35UG TNMC-32NV-DVP656 16IR-A60-DVP656

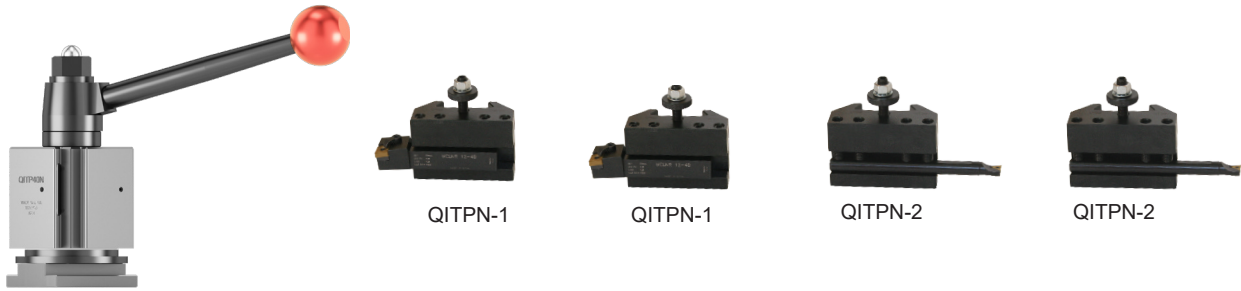


## Quadra® Indexing Quick Change Tool Post Turning Set

### Turning Set Includes

- (1) Tool Post
- (4) Holders

Tooling Not Included



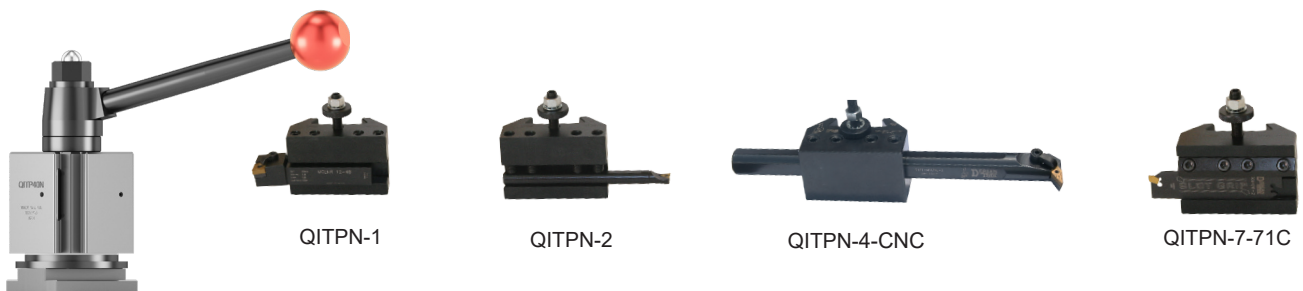
UPC No. 733101-	00014	00015	00016	00017	00018	00019
Description	QITP25N-TS	QITP30N-TS	QITP35N-TS	QITP40N-TS	QITP50N-TS	QITP60N-TS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
<b>Set Includes</b>						
(1) Tool Post	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
(4) Holders	(2) QITP2N5-1 (2) QITP25N-2	(2) QITP30N-1 (2) QITP30N-2	(2) QITP35N-1 (2) QITP35N-2	(2) QITP40N-1 (2) QITP40N-2	(2) QITP50N-1 (2) QITP50N-2	(2) QITP60N-1 (2) QITP60N-2

## Quadra® Indexing Quick Change Tool Post Standard Set

### Standard Set Includes

- (1) Tool Post
- (4) Holders

Tooling Not Included



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



# Super Quick Change Tool Post

Quality  
Performance  
Rigidity  
Repeatability



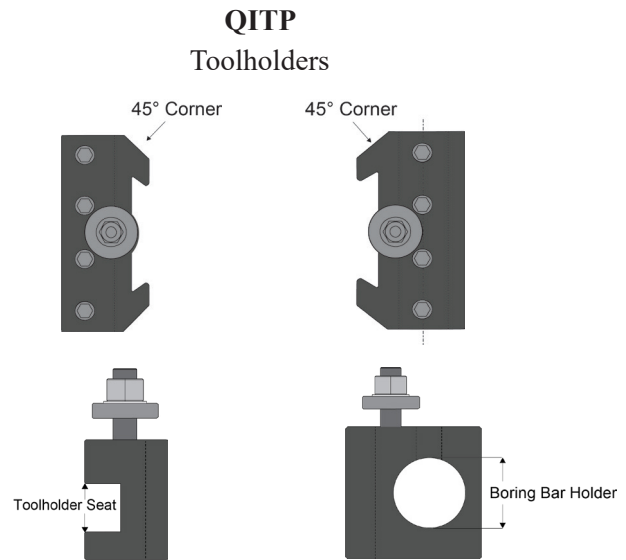
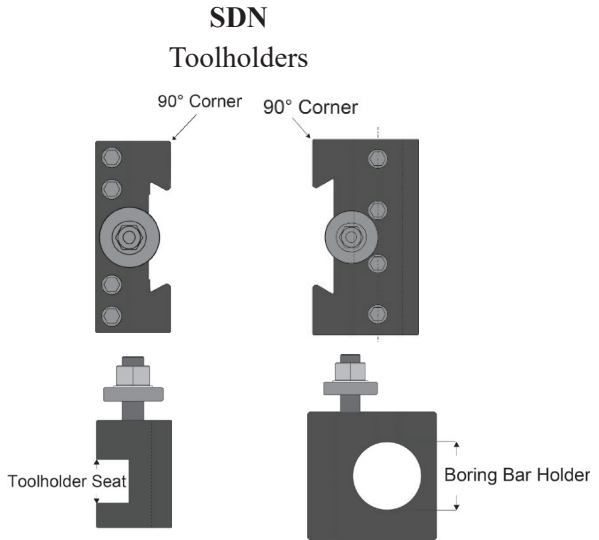
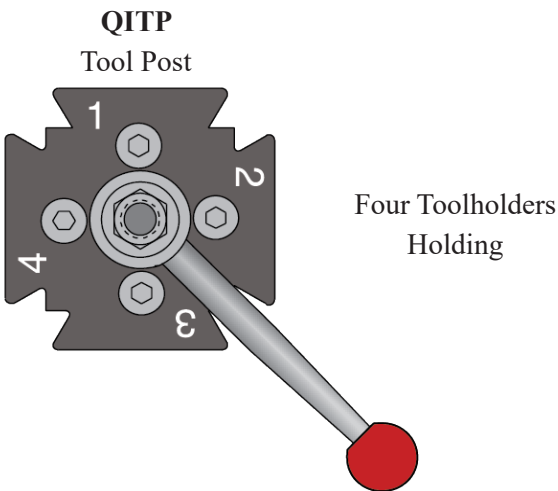
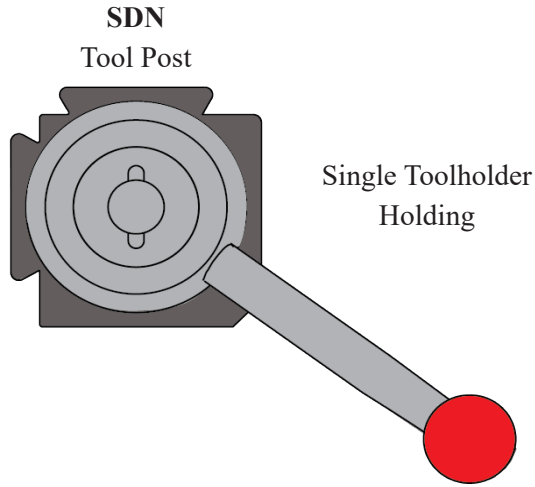
# SDN Tool Post and Toolholders Sizes & Crossover

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

The Toolholders, are treated with a Special Low Temperature Heat Treating 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

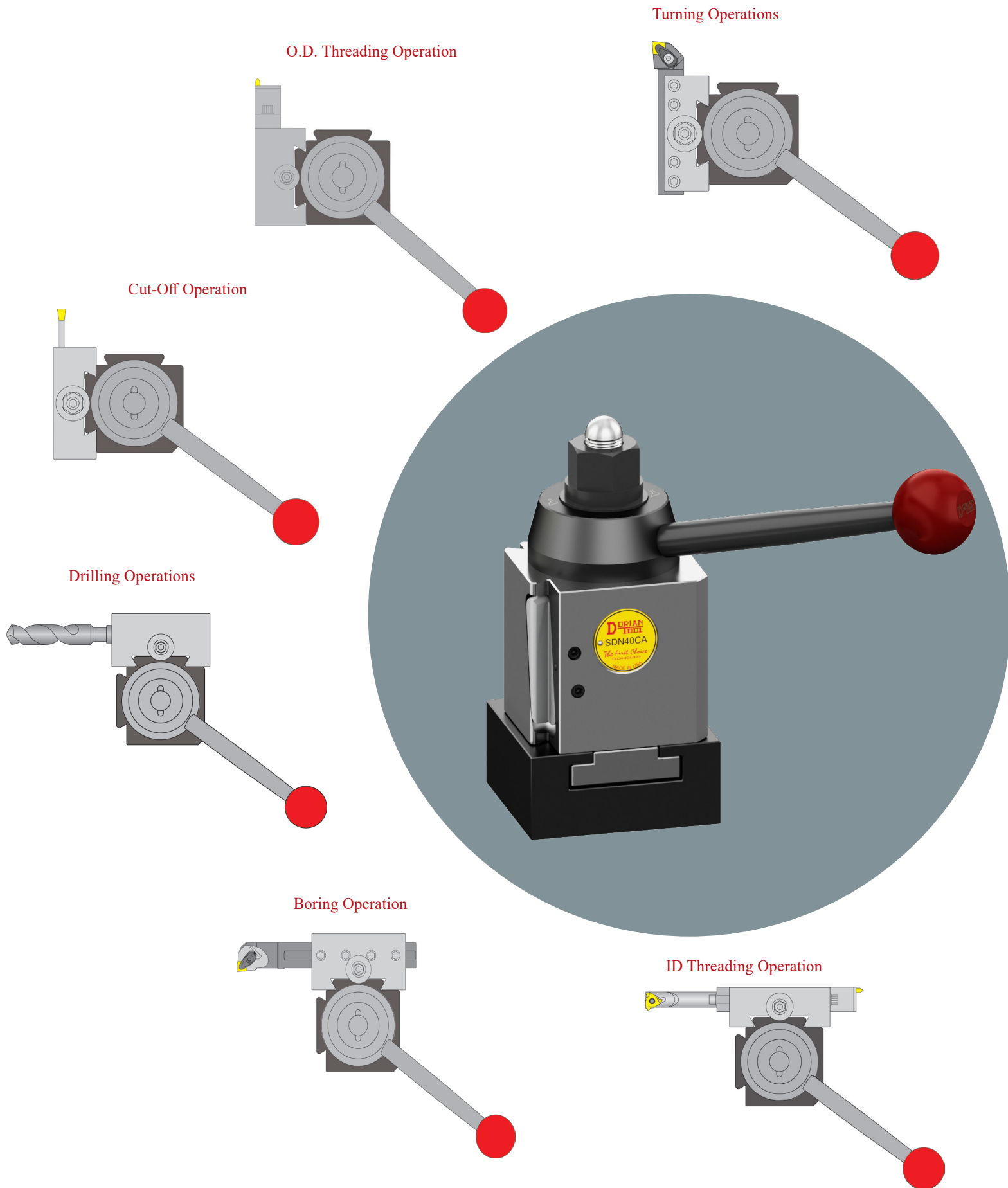
All the Quadra & SDN Boring Bar Holders, Features a DUAL Locking System for Maximum Rigidity, Stability & Performance in the Roughing Operation, and High Surface Finishing & Close Tolerances for finishing Operation



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





# 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 through-out 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 gibs, 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 gibs 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;

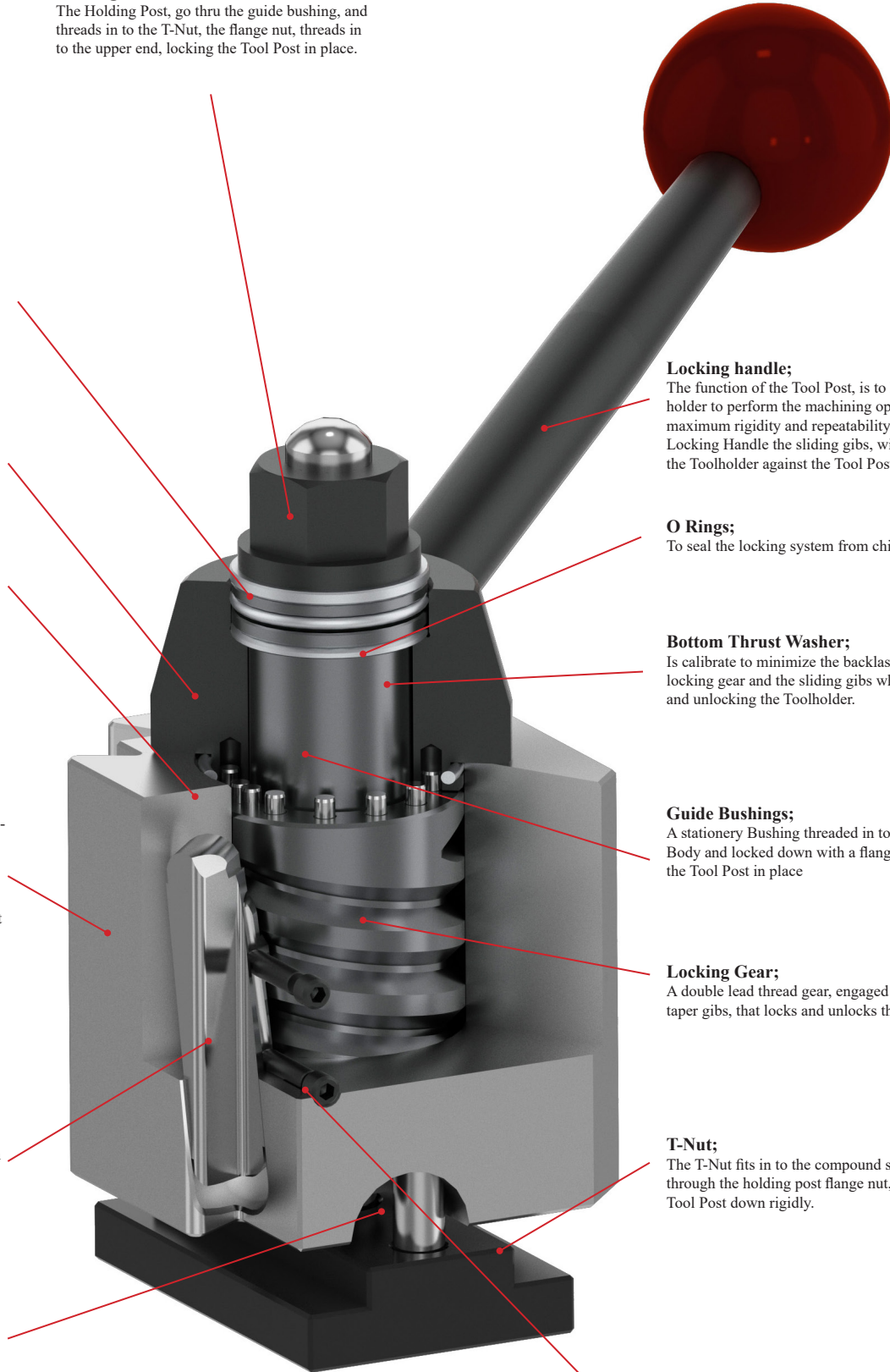
A double lead thread gear, engaged to the sliding taper gibs, that locks and unlocks the Toolholder

## T-Nut;

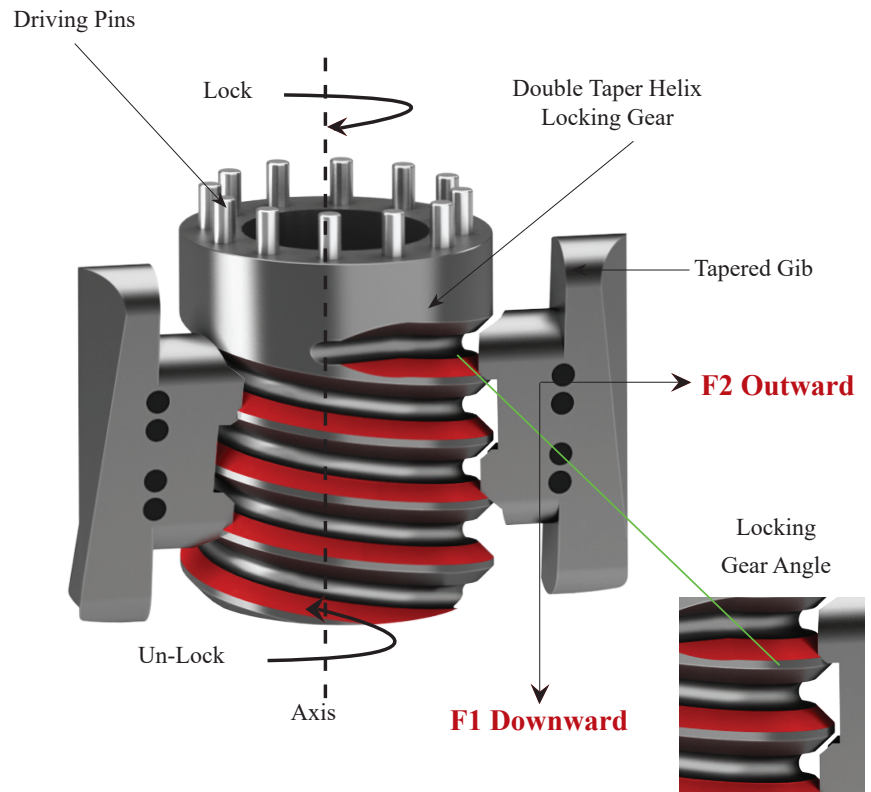
The T-Nut fits in to the compound slot, and through the holding post flange nut, will lock the Tool Post down rigidly.

## Guiding Pins & Set Screws;

To hold sliding gibs in place



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



### 1. F1 Downward Force:

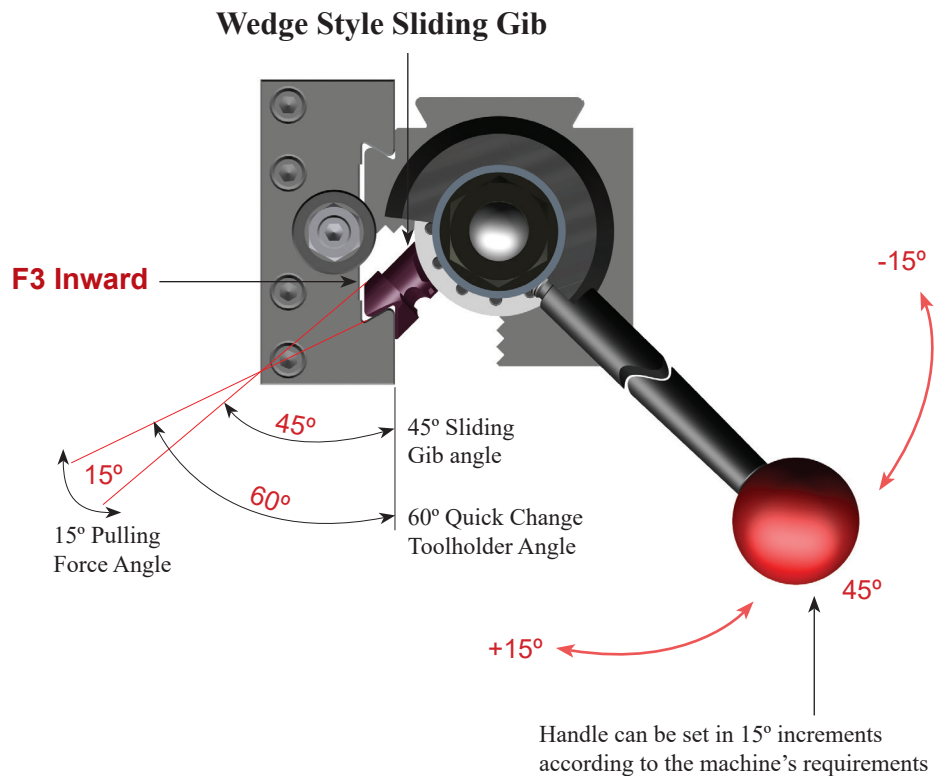
(shown right) Rotating the locking gear moves the gib down, expanding the tool post dovetail to lock the toolholder.

### 2. F2 Outward Force:

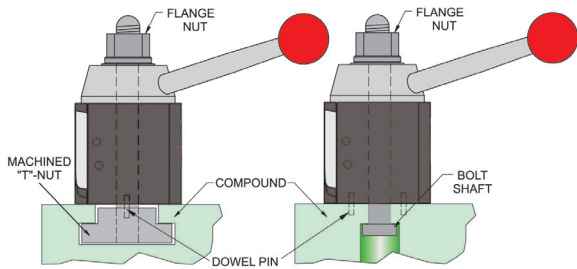
(shown right) When the gibs make full contact with the toolholder dovetail, the double-angle helix of the locking gear forces the gib outward, neutralizing any backlash to zero.

### 3. F3 Inward Force:

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

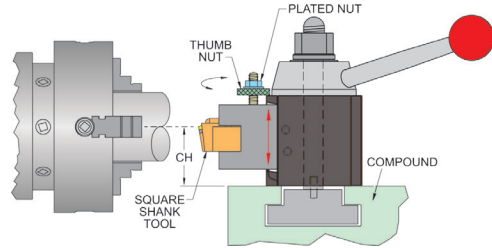


## Tool Post Mounting



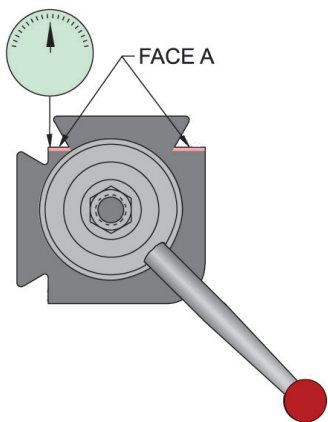
The tool post mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flange Nut will provide a rigid and reliable mounting of the tool post. The "T" Nut is provided blank or machined according to customer specification. Using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

## Center Height Adjustment



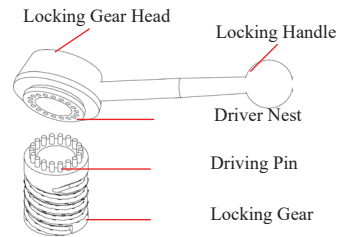
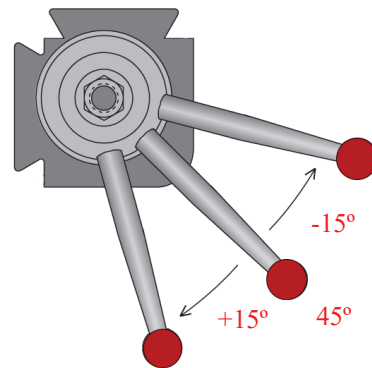
The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool by rotating the Thumb Nut until the desired height is reached and locking the Plated Nut to preserve it. Maximum center height has been reached when the top of the holder is flush with the top of the tool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

## Indicating Position



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

## Locking Handle Positioning

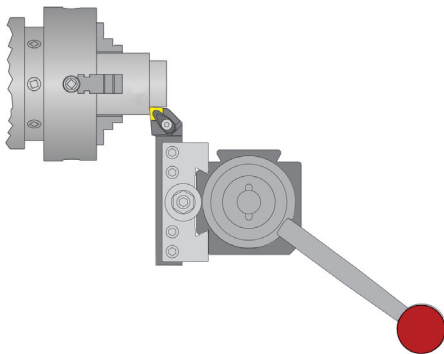


To change the position of the handle: remove the \*flange nut; remove the \*guide bushing; pull the locking gear head and place to the desired position.

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

## O.D. Turning Operations

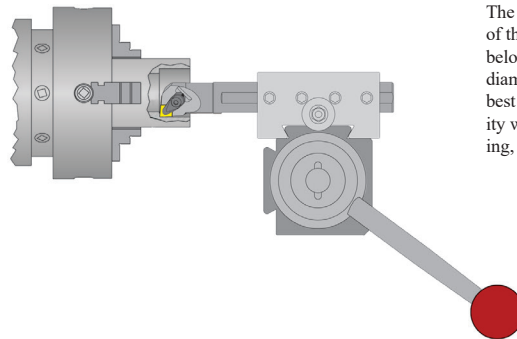
Turning, Threading, Cut-Off, Grooving, & Chamfering



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

## I.D. Turning Operations

Boring, Threading, Grooving, Drilling, & Center Drilling



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

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

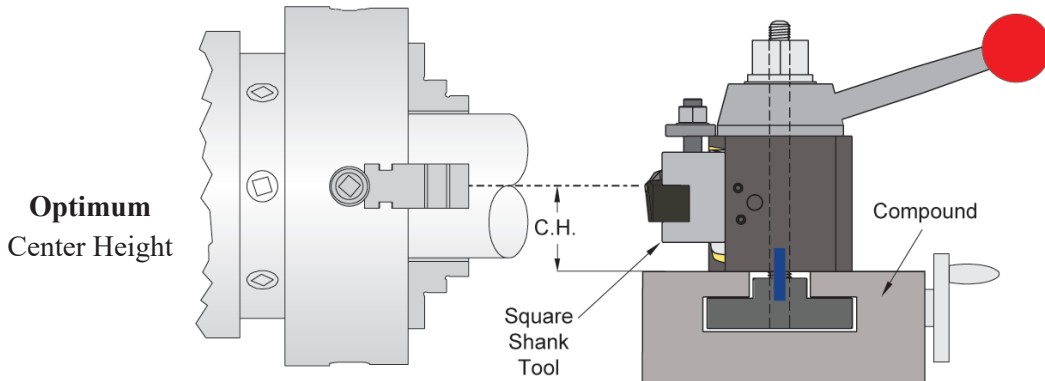
## Factors that determine the proper Tool Post for a specific lathe:

- |                            |                      |                            |
|----------------------------|----------------------|----------------------------|
| 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."

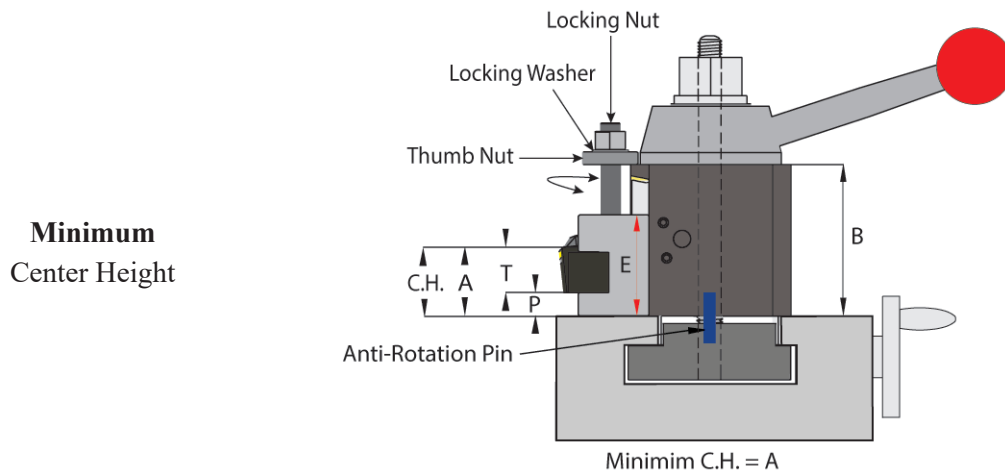
"CH" = Center Height is measured from top of compound to lathe center line  
 "P" = Toolholder bottom lip  
 "B" = Tool Post Height (See page 17)

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



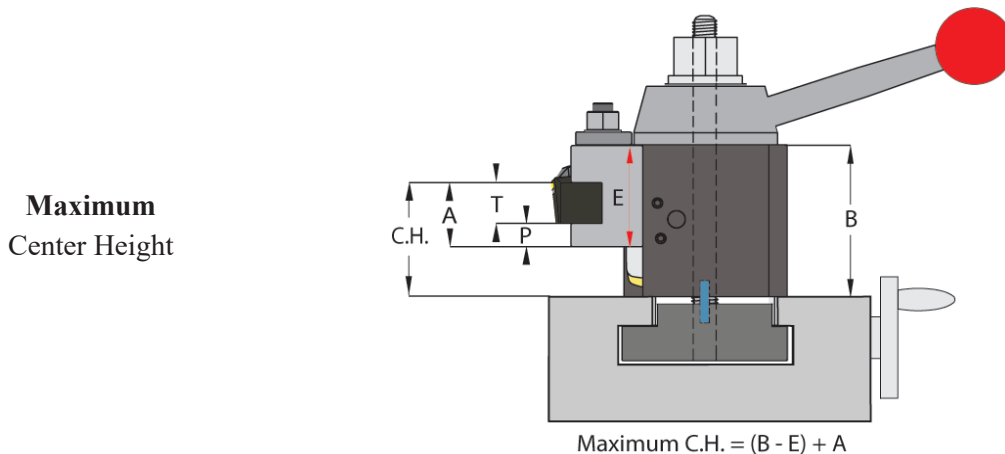
## Tool Post Mounting Technical Notes

- 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



## 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.



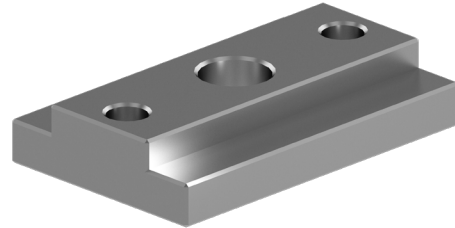
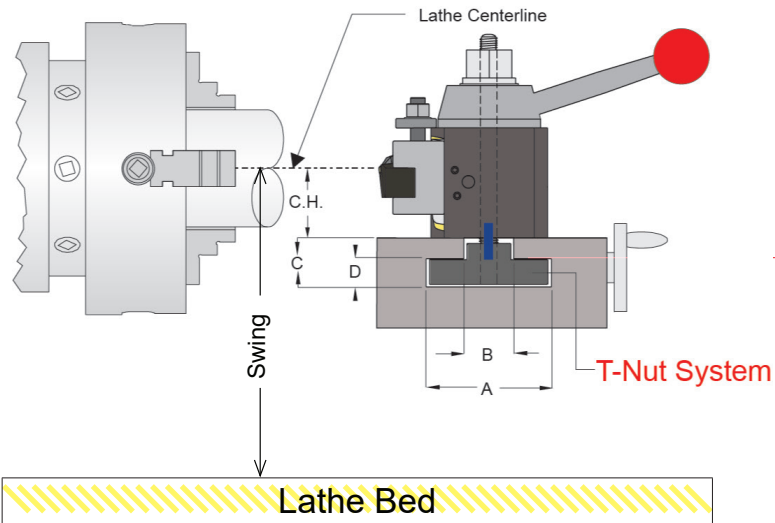
## Center and Cutting Tool Capacity Technical Notes

- 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

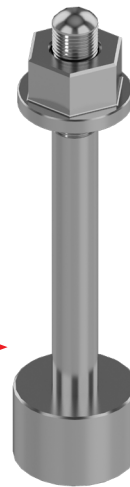
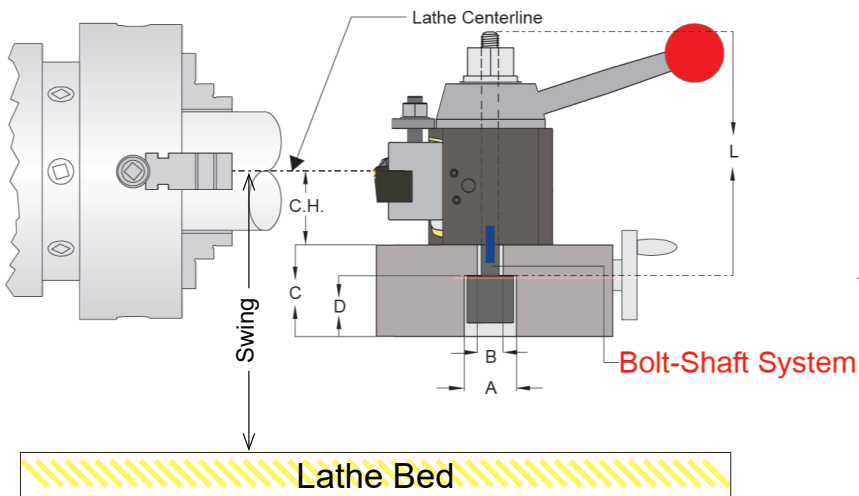
## American Mounting System

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



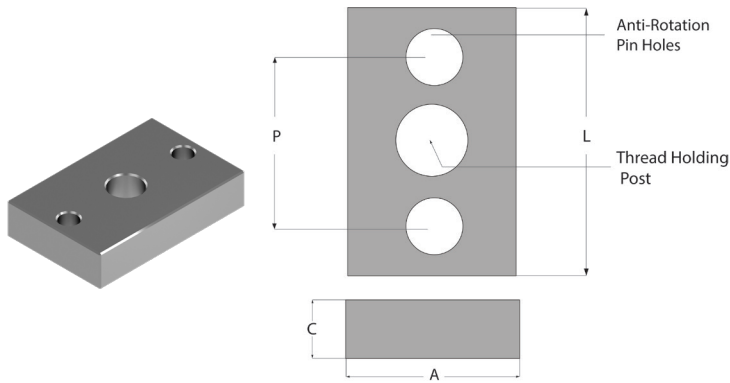
Bolt Shaft non standar item, supplied only on request

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  $\pm 0.003$ in.

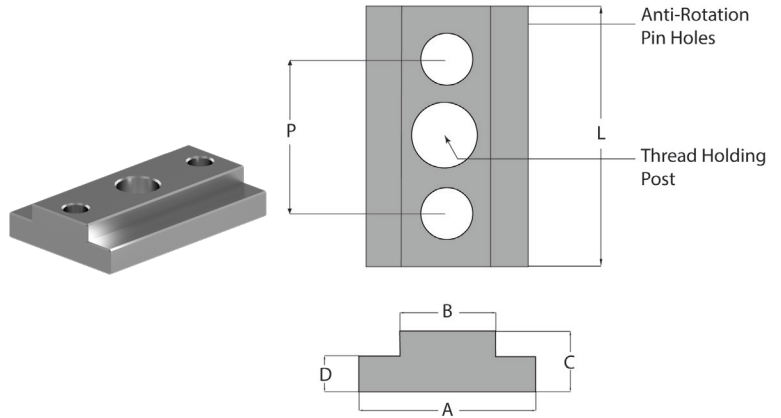
\* Please place an X for American or European mounting Style in the boxes above.



## 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

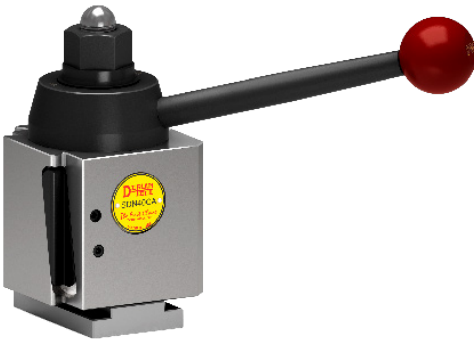
## Structure Specifications

## Features

## Application

### SUPER Quick Change Tool Post

Page B-30



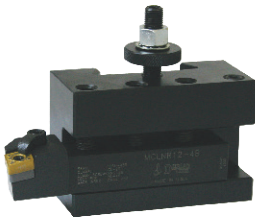
6 sizes of the Tool Post are available  
 2.5"/63mm, 3.0"/76mm, 3.5"/88mm,  
 4.0"/101mm, 5.0"/126mm, 6.0"/152mm  
 Toolholders Capacity, from 3/8"/10mm  
 to 1-1/2"/40mm

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 Cromium-  
 Molybdenum Alloy Steel  
 Special Heat Treat Process to protect  
 Surface, & minimize Cutting Vibration  
 Quick Change Mounting

Toolholder Interchangeability within  
 .0001"/.00127mm

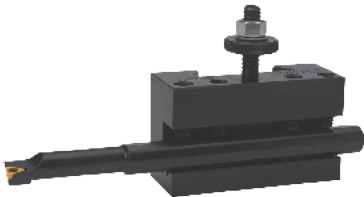
Toolholder Squireness and Parallel .0005" x  
 inch/.00127 mm

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 Cromium-  
 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 Squireness and Parallel .0005" x  
 inch/.00127 mm

Over size Capacity for large Indexable Square  
 Shank

Capeble 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 Cromium-  
 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 Squireness 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

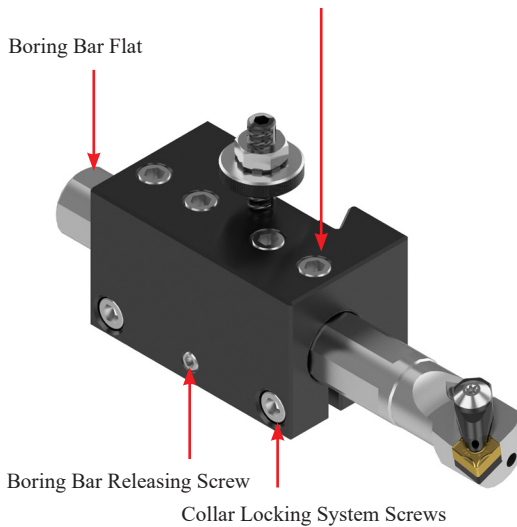
Longer Inserts Life  
Maximum Locking Force  
Maximum Rigidity & Stability

Higher Productivity  
Best Roughing Performance  
Best Surface Finish & Tolerance

### Mounting of a Boring Bar with Flats

Boring Bar Positioning & Locking Screws

Boring Bar Flat

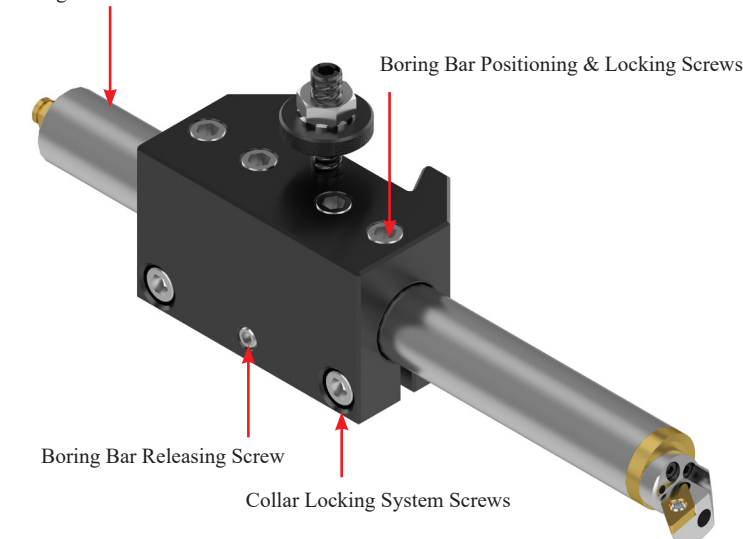


Boring Bar Releasing Screw

Collar Locking System Screws

### Mounting of a Boring Bar without Flats

Boring Bar without Flat

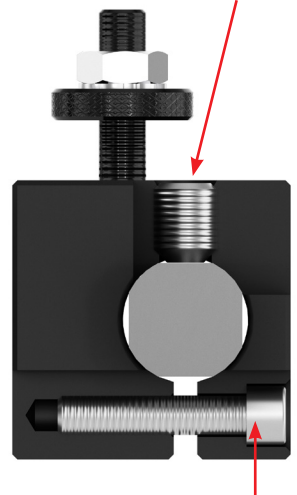


Boring Bar Releasing Screw

Collar Locking System Screws

### Locking Instruction

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

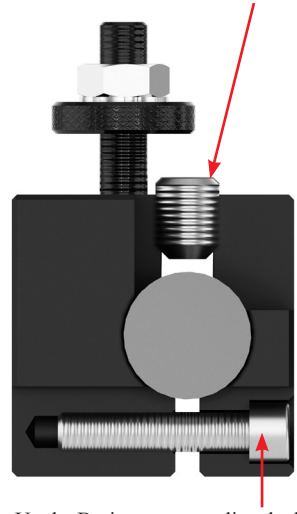


Once The Boring is on center line, lock the holder side screws.

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.

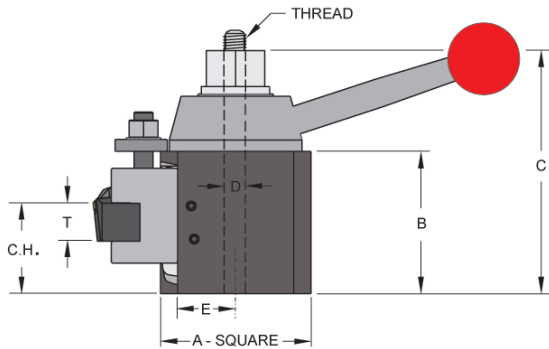


Set-Up the Boring on center line, lock the holder side screws, The Boring Bar, is locked 360° around the Diameter in to the Holder, fusing in One the Boring Bar with the Holder, achieving the best possible Boring Rigidity & Stability

# SDN Quick Change Tool Post & Toolholders Structure Specification

	Structure Specifications	Features	Applicati
<p><b>No. D5 Morse Taper Holder</b></p> <p>Page B-33</p> 	<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</p> <p>using Drill Chuck or Morse Taper</p> <p>Heavy Duty Drilling Operation</p>
<p><b>No. D7-71C Reversible Twin Cut-Off Blade Holder</b></p> <p>Page B-34</p> 	<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>
<p><b>No. D881 O.D. or I.D. Threading Holder</b></p> <p>Page B-36</p> 	<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 ID 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>
<p><b>No. D35 Dovetail Drill Chuck Holder</b></p> <p>Page B-38</p> 	<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>2 Pieces Construction, for Precise Parallelism Calibration</p> <p>Supplied with Rohm Drill Chuck</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 a 1/2"/12.7mm capacity, precise, Strong &amp; Rigid Drill Chuck</p>	<p>Versatile for Multi Operation</p> <p>Drilling, Boring, Reaming, Threading</p> <p>Using Standard Tools or Special Tool</p>
<p><b>No. D36 5C Collet Holder</b></p> <p>Page B-38</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, Turning</p> <p>Using Standard Tools or Special Tool</p>

# Super Quick Change Tool Post



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

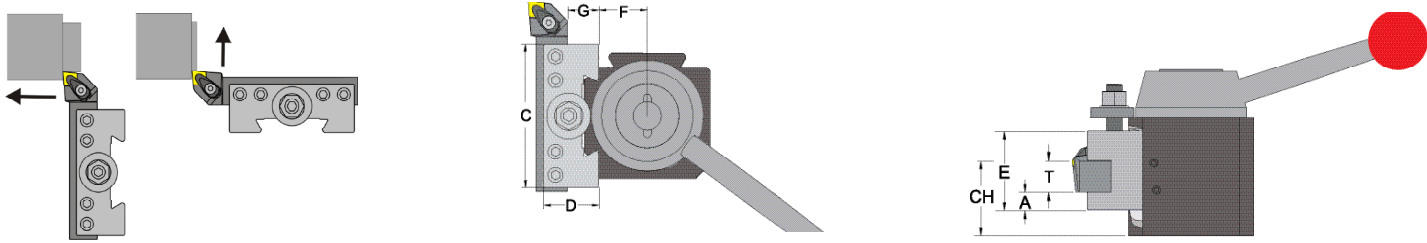
Description	SDN25AXA		SDN30BXA		SDN35CX A		SDN40CA		SDN50DA		SDN60EA	
UPC No. 733101-	01000		01002		01004		01006		01008		01010	
System	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
Lathe Swing Over Bed	≤12	≤300	13-15	330-380	14-17	350-430	16-20	400-500	17-32	430-810	≥25	≥635
A	2.500	63	3.000	76	3.500	88	4.000	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	1.0-1¼	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	1¼-12	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

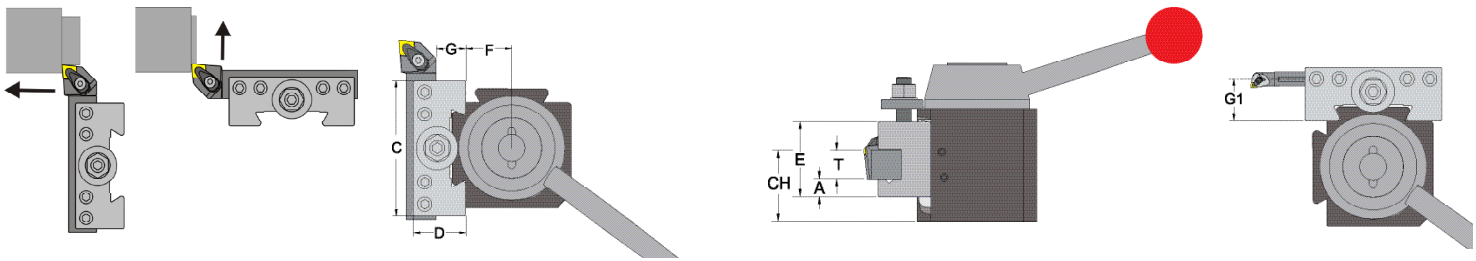
This toolholder is best used for holding square shank toolholders close to the tool post to maximize rigidity when turning, facing, and threading. Fits industry standard tool posts.



Description	UPC No.733101-	A	T	C	D	E	F	G
<b>Inches Toolholders</b>								
D25AXA-1	01100	0.375	0.750	2.750	1.250	1.750	0.880	.790
D30BXA-1	01250	0.437	1.000	3.250	1.500	2.250	1.115	.915
D35CXA-1	01400	0.500	1.000	3.750	1.750	2.500	1.199	1.040
D40CA-1	01550	0.562	1.250	4.500	2.000	3.000	1.530	1.040
D50DA-1	01700	0.750	1.500	6.000	2.500	3.500	1.900	1.290
D60EA-1	01850	1.000	1.500	7.000	3.000	4.000	2.207	1.540
<b>Metric Toolholders</b>								
D35CXA-1	01401	13	25	95	44	64	30	26
D40CA-1	01551	14	32	114	51	76	39	26

## 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.



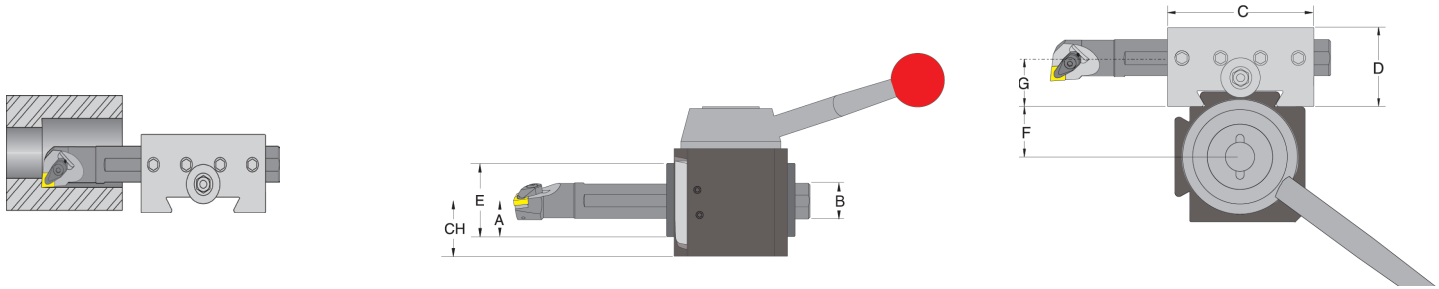
Description	UPC No.733101-	A	T	C	D	E	F	G	G1
<b>Inches Toolholders</b>									
D25AXA-2	01104	0.375	0.750	2.750	1.250	1.750	0.880	0.790	1.015
D30BXA-2	01254	0.437	1.000	3.250	1.500	2.250	1.115	0.915	1.205
D35CXA-2	01404	0.500	1.000	3.750	1.750	2.500	1.199	1.040	1.390
D40CA-2	01554	0.562	1.250	4.500	2.000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



# SDN-Toolholder Ordering Specification

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

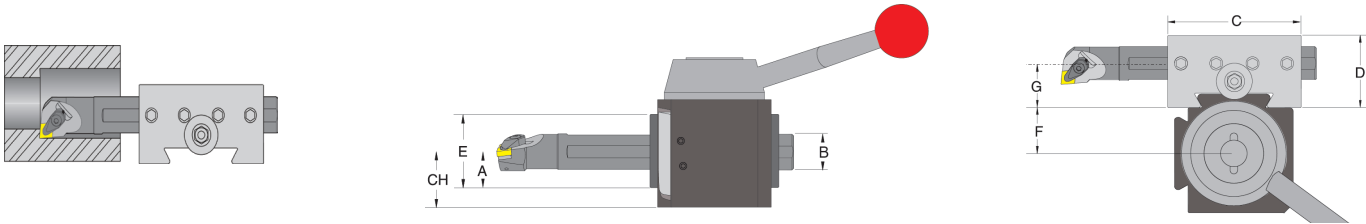
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter-free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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



Description	UPC No.733101-	A	B Boring Bar Capacity	C	D	E	F	G
<b>Inches Toolholders</b>								
D25AXA-4-750-DUAL	01111	.745	.750	2.750	1.490	1.490	.880	.937
D30BXA-4-1000-DUAL	01261	.995	1.000	3.250	1.990	1.990	1.115	1.250
D35CXA-4-1000-DUAL	01411	1.120	1.000	3.750	2.240	2.240	1.199	1.375
D40CA-4-1250-DUAL	01559	1.245	1.250	4.500	2.490	2.490	1.530	1.500
D50DA-4-1500-DUAL	01709	1.495	1.500	5.500	2.990	2.990	1.900	2.000
D60EA-4-2000-DUAL	01859	1.995	2.000	6.500	3.990	3.990	2.207	2.500
<b>Metric Toolholders</b>								
D25AXA-4M-20-DUAL	00117	19	19	70	38	38	22	24
D30BXA-4M-25-DUAL	00267	25	25	83	51	51	28	32
D35CXA-4M-25-DUAL	00417	28	25	95	57	57	32	35
D40CA-4M-32-DUAL	00567	32	32	114	63	63	39	38
D50DA-4M-40-DUAL	00717	38	38	140	76	76	48	51
D60EA-4M-50-DUAL	00867	51	51	165	101	101	56	64

## 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.

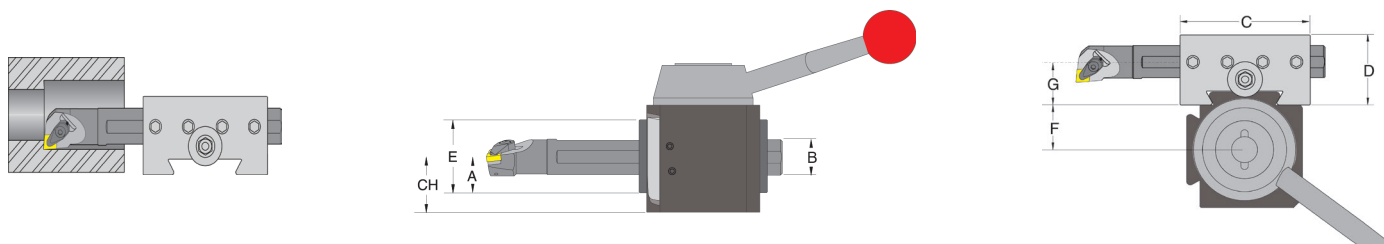


Description	UPC No.733101-	A	B Boring Bar Capacity	C	D	E	F	G
<b>Inches Toolholders</b>								
D25AXA-41-1000-DUAL	01113	.870	1.000	2.750	1.740	1.740	.880	1.062
D30BXA-41-1250-DUAL	01263	1.120	1.250	3.250	2.240	2.240	1.115	1.375
D35CXA-41-1250-DUAL	01413	1.120	1.250	3.750	2.240	2.240	1.199	1.375
D40CA-41-1500-DUAL	01563	1.245	1.500	4.500	2.490	2.490	1.530	1.500
D50DA-41-2000-DUAL	01713	1.745	2.000	5.500	3.490	3.490	1.900	2.250
D60EA-41-2500-DUAL	01863	1.995	2.500	6.500	3.990	3.990	2.207	2.375
<b>Metric Toolholders</b>								
D25AXA-41M-25-DUAL	01119	22	25	70	44	44	22	27
D30BXA-41M-32-DUAL	01269	28	32	83	57	57	28	35
D35CXA-41M-32-DUAL	01419	28	32	95	57	57	31	35
D40CA-41M-40-DUAL	01569	32	40	114	63	63	39	38
D50DA-41M-50-DUAL	01719	44	50	140	89	89	48	57
D60EA-41M-60-DUAL	01869	51	60	165	101	101	56	60

# SDN-Toolholder Ordering Specification

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

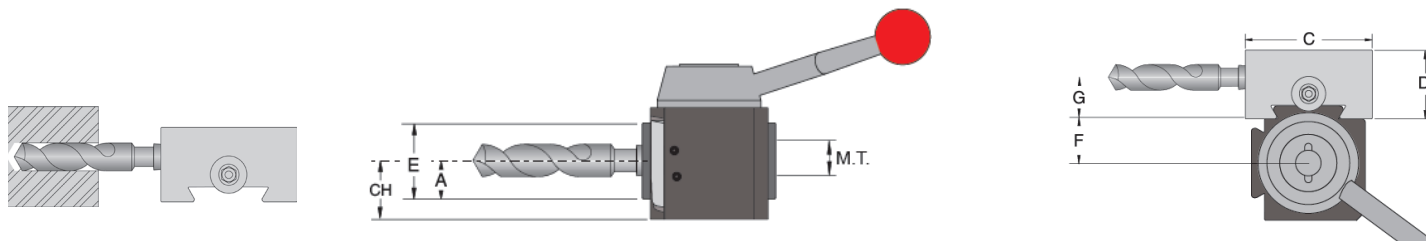
This holder is best used for holding boring bars. It has four flat-face locking-screws that automatically align the center height and rake angle of the boring bar while locking it rigidly for chatter free machining. Flat-face locking-screws do not scar the boring bar. This holder reduces setup time by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



Description	UPC No.733101-	A	B Boring Bar Capacity	C	D	E	F	G
<b>Inches Toolholders</b>								
D35CXA-41S-1500-DUAL	01415	1.245	1.500	4.000	2.490	2.490	1.199	1.500
D40CA-41S-2000-DUAL	01565	1.495	2.000	4.500	2.990	2.990	1.530	1.750
D50DA-41S-2500-DUAL	01715	1.995	2.500	6.500	3.990	3.990	1.900	2.250
D60EA-41S-3000-DUAL	01865	2.245	3.000	7.000	4.490	4.490	2.207	2.625
<b>Metric Toolholders</b>								
DQ35CXA-41SM-40-DUAL	00423	32	40	102	63	63	31	38
DQ40CA-41SM-50-DUAL	00571	38	50	114	76	76	39	45
DQ50DA-41SM-60-DUAL	00721	51	60	165	101	101	18	57
DQ60EA-41SM-80-DUAL	00871	57	80	178	114	114	56	67

## No. D5 Morse Taper Toolholder

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

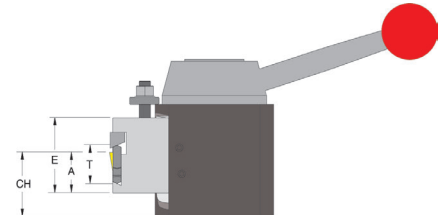
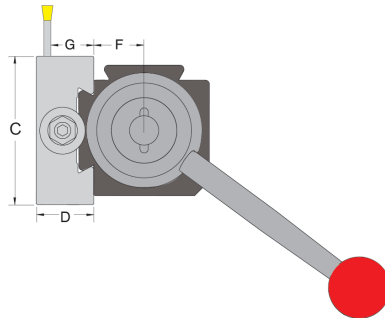
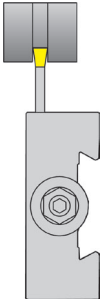


Description	UPC No. 733101-	System	A	Morse Taper	C	D	E	F	G
D35CXA-5-4	01424	in	1.125	MT4	4.150	2.500	2.250	1.199	1.615
		mm	28.58	MT4	105.41	63.50	57.15	30.45	41.02
D40CA-5-4	01572	in	1.250	MT4	4.500	2.500	2.500	1.530	1.615
		mm	31.75	MT4	114.30	63.50	63.50	38.86	41.02
D50DA-5-5	01722	in	1.750	MT5	5.625	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.

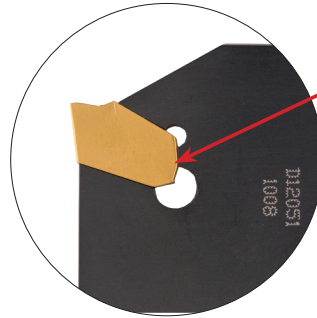


Description	UPC No.733101-	System	Slot Grip Blade		C	D	E	F	G
			A	T					
D25AXA-7-71C	01126	in	0.933	SGIH-19-2	2.750	1.250	2.000	0.880	1.127
		mm	23.70		69.85	31.75	50.80	22.35	28.63
D30BXA-7-71C	01276	in	0.933	SGIH-19-2	3.250	1.250	2.000	1.115	1.127
		mm	23.70		82.60	31.80	50.80	28.30	28.60
D35CXA-7-71C	01428	in	1.255	SGIH-26-2 to 26-6	3.750	1.750	2.500	1.245	1.520
		mm	31.88		95.25	44.45	63.50	31.62	38.61
D40CA-7-71C	01576	in	1.255	SGIH-26-2 to 26-6	4.500	1.750	3.000	1.530	1.520
		mm	31.88		114.30	44.45	76.20	38.86	38.61
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

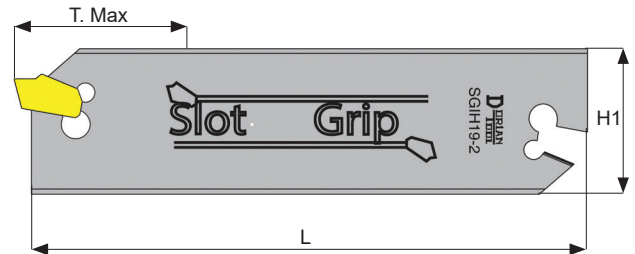
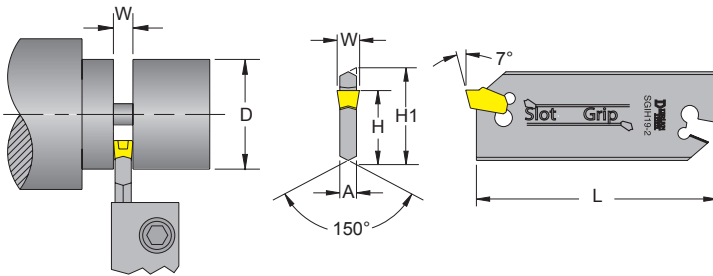


## Positive Stop Blades



### 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"

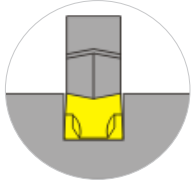
### 32mm (1 1/4") Slot Grip Blades

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/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 Blades Ordering Specification



## SG Inserts for Cut-Off & Grooving Operations

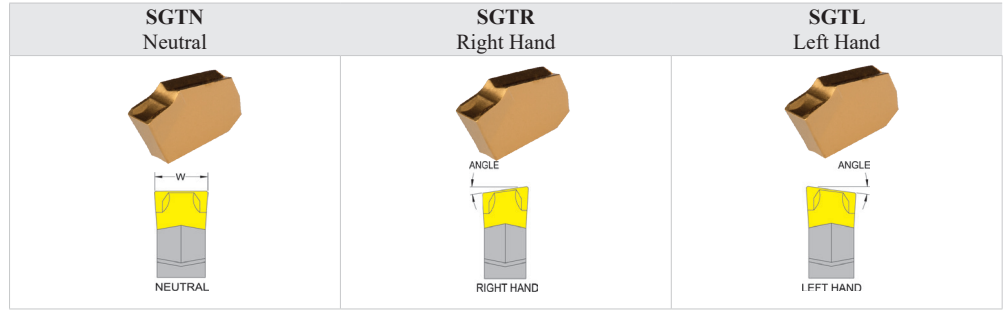


### Chip breaker Geometry

- 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

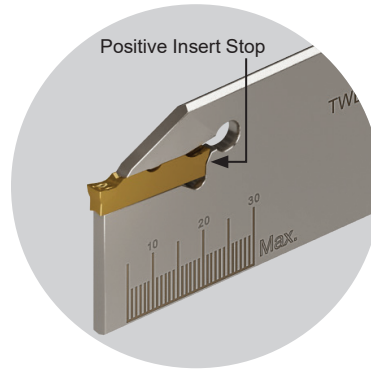
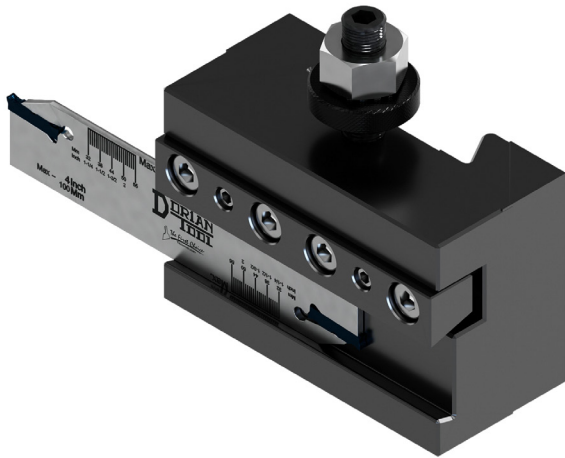
Material	Carbon & Alloy Steel	Aluminum & Non-Ferrous Metals & Materials	Carbon & Alloy Steel	300 & 400 Series Stainless Steel	Cast Iron, Copper/Brass	Aluminum & Non-Ferrous Materials	High Temp Alloys	Hard Steel to 58 HRC
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Insert Grade	Insert Coating		CVD TiN Coated		Uncoated		PVD TiAlN Coated	
	DC656		DK25		DASK25B			
	ANSI	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	-	-	

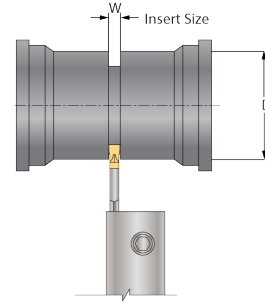
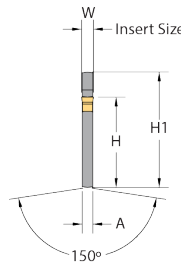
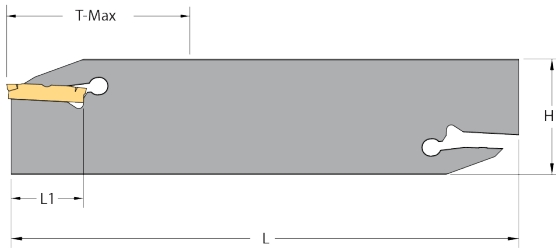
# Kool-Cut™ Twin Edge Blade Ordering Specification

## Twin Edge Blades

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



Double "V"  
Locking System



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	0.079	KCIK-DN	61204
									DNPG-22 2002-1SR-N			

### 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
									DNPG-22 2002-1SR-N			
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		
									DNTR-22 3015-3EU-N			
TWECOB-DNTF-26-40	61967	1.650	0.125	3.300	4.331	0.866	0.842	1.024	DNPG-22 3002-1SR-N	0.157		
									DNTQ-25 4004-3EU-N			
									DNTR-25 4020-3EU-N			
									DNPG-25 4003-1SR-N			

### 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
									DNPG-22 2002-1SR-N			
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		
									DNTR-22 3015-3EU-N			
									DNPG-22 3002-1SR-N			
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		
									DNTR-25 4020-3EU-N			
									DNPG-25 4003-1SR-N			
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		
									DNTR-25 5025-3EU-N			
									DNPG-25 5004-1SR-N			
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		
									DNPG-25 6004-1SR-N			




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

**Insert Specification**

**Double-End Cutting Edge**  
**DNTQ-N- DUP35UG**

**Neutral Straight Nose**  
Multi-Cutting Direction  
Right Hand and Left Hand

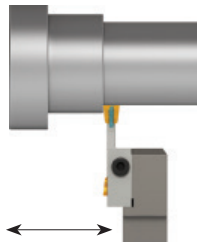


**Cutting Data**

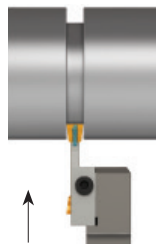
Insert Dimension			Maximum $a_p$ Depth of Cut for Turning	Maximum $f_n$ Feed Rate for Turning, Grooving and Parting-off
Width	Length	Corner Radius	inch	in/rev.
.079" (2mm)	.866"	.008"	.039"	.006 in/rev
.118" (3mm)	.866"	.012"	.059"	.008 in/rev
.157" (4mm)	.984"	.016"	.079"	.009 in/rev
.197" (5mm)	.984"	.016"	.098"	.010 in/rev
.236" (6mm)	.984"	.016"	.118"	.012 in/rev

**Insert Application**

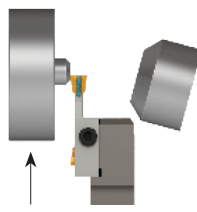
Turning



Grooving



Parting-Off



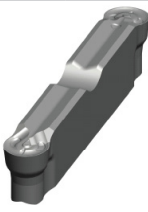
**Insert Geometry, Material Application**

Steel	Stainless Steel	Cast Iron	Non Ferrous	Super Alloys
●	●	●	○	○

● First Choice Grade      ○ Second Best

**Double-End Cutting Edge**  
**DNTR-N- DUP35UG**

**Neutral Round Nose**  
Multi-Cutting Direction  
Right Hand and Left Hand

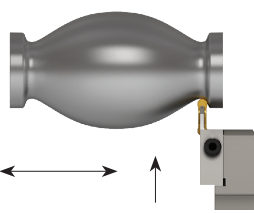


**Cutting Data**

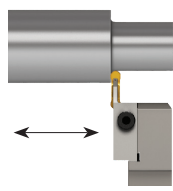
Insert Dimension			Maximum $a_p$ Depth of Cut for Turning	Maximum $f_n$ Feed Rate for Turning, Grooving and Parting-off
Width	Length	Radius	inch	in/rev.
.118" (3mm)	.866"	.059" (1.5mm)	.059"	.012 in/rev
.157" (4mm)	.984"	.079" (2.0mm)	.079"	.014 in/rev
.197" (5mm)	.984"	.098" (2.5mm)	.098"	.016 in/rev

**Insert Application**

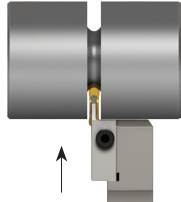
Profiling



Turning



Grooving




**Insert Geometry, Material Application**

Steel	Stainless Steel	Cast Iron	Non Ferrous	Super Alloys
●	●	●	○	○

● First Choice Grade      ○ Second Best

**Double-End Cutting Edge**  
**DNPG-N- DPP40SG**

**Neutral Straight Nose**  
Uni-Direction Parting Off & Grooving

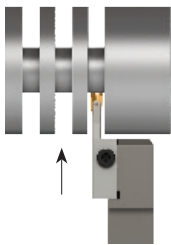


**Cutting Data**

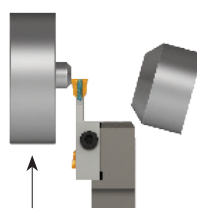
Insert Dimension			Maximum $f_n$ Feed Rate for Parting-off
Width	Length	Corner Radius	in/rev.
.079" (2mm)	.866"	.008"	.006 in/rev
.118" (3mm)	.866"	.008"	.008 in/rev
.157" (4mm)	.984"	.012"	.009 in/rev
.197" (5mm)	.984"	.016"	.010 in/rev
.236" (6mm)	.984"	.016"	.012 in/rev

**Insert Application**

Grooving



Parting-Off



**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 <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

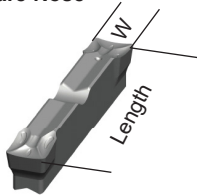
DPP40SG					
Material		V <sub>c</sub> (SFM)			
Steel		F/min.		m/min.	
P	Carbon Steel	264	495	80	150
	Low Alloy Steel	231	396	70	120
	High Temp Alloys	198	330	60	100
M	Ferritic	330	594	100	180
	Austenitic	264	495	80	150
	Duplex	231	363	70	110
	Martensitic	198	297	60	90
K	Gray Cast Iron	264	561	80	170
	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				

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

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

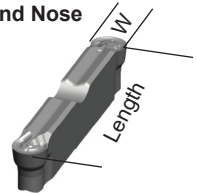
## Insert Specifications

### "T" Square Nose



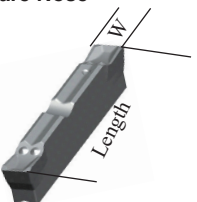
UPC #	Application	Part Number	Insert Size		Corner Radius	Grade
			Width	Length		DUP35UG
82440	Turning Grooving Parting-Off	DNTQ-22 2002-3EU-N DUP35UG	.079" (2mm)	.866"	.008"	•
82442		DNTQ-22 3003-3EU-N DUP35UG	.118" (3mm)	.866"	.012"	•
82443		DNTQ-25 4004-3EU-N DUP35UG	.157" (4mm)	.984"	.016"	•
82444		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		Radius	Grade
			Width	Length		DUP35UG
82459	Profiling Turning Grooving	DNTR-22 3015-3EU-N DUP35UG	.118" (3mm)	.866"	.059" (1.5mm)	•
82460		DNTR-25 4020-3EU-N DUP35UG	.157" (4mm)	.984"	.079" (2.0mm)	•
82461		DNTR-25 5025-3EU-N DUP35UG	.197" (5mm)	.984"	.098" (2.5mm)	•

### "G" Square Nose

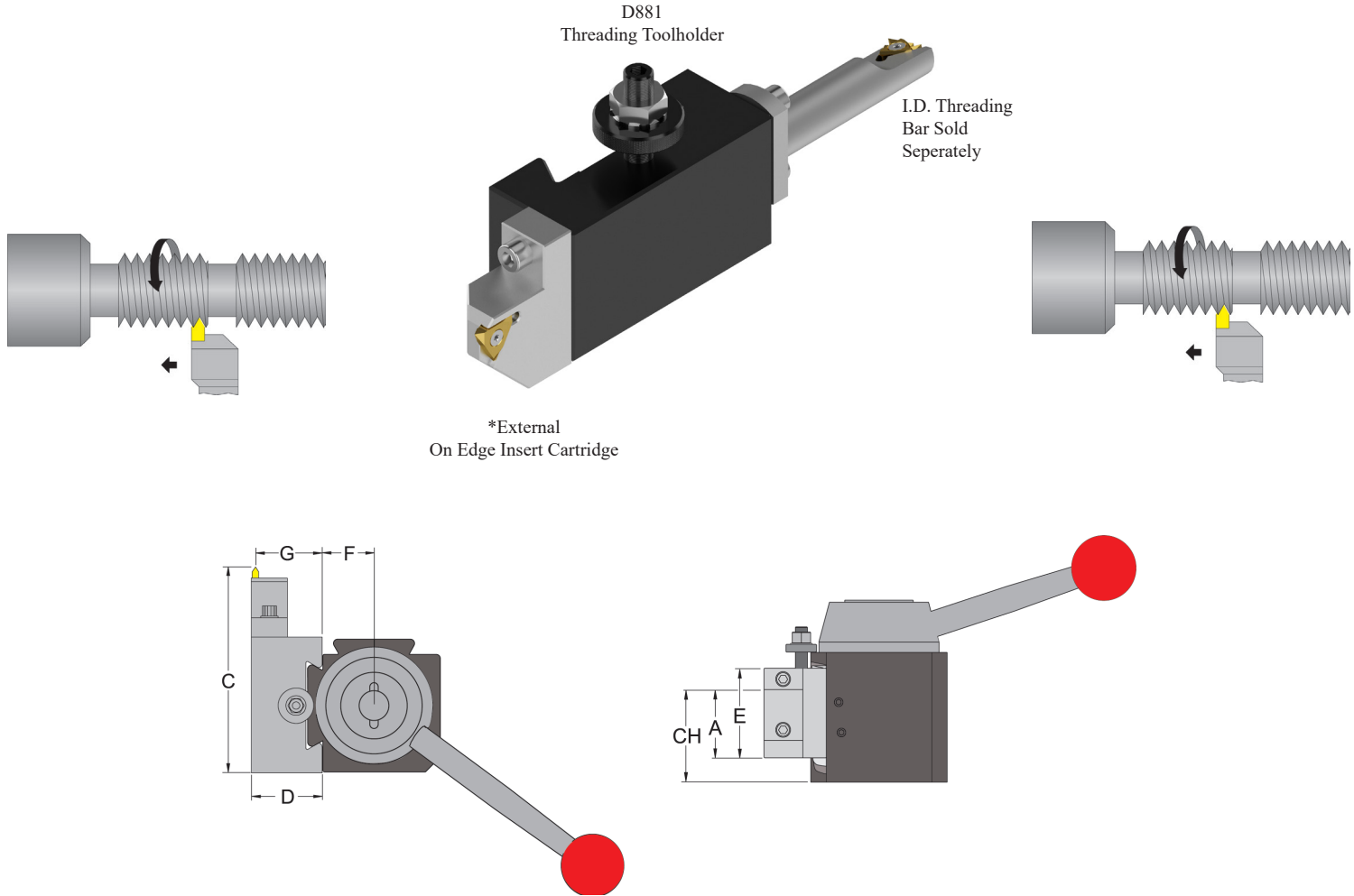


UPC #	Application	Part Number	Insert Size		Corner Radius	Grade
			Width	Length		DPP40SG
82475	Grooving Parting-Off	DNPG-22 2002-1SR-N DPP40SG	.079" (2mm)	.866"	.008"	•
82476		DNPG-22 3002-1SR-N DPP40SG	.118" (3mm)	.866"	.008"	•
82477		DNPG-25 4003-1SR-N DPP40SG	.157" (4mm)	.984"	.012"	•
82478		DNPG-25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

# 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.



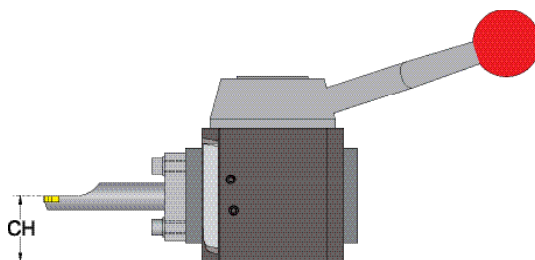
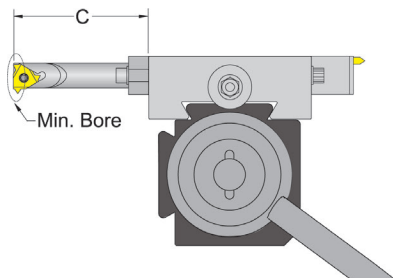
Description	UPC No. 733101-	System	A	C	D	E	F	G	*External On Edge Insert Cartridge				
									Desc.	UPC No. 733101-	TNMC Insert	Torx Screw	Torx Key
D25AXA-881-OE	01132	in	0.875	3.869	1.000	1.500	0.880	1.000	TIH253-32	03621	32	GTS-1M	T-10
		mm	22.23	98.27	25.40	38.10	22.35	25.40					
D30BXA-881-OE	01282	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	TIH354-32	03623	32	GTS-1M	T-10
		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.

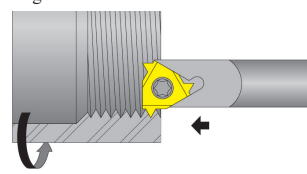
# SDN-Lay-Down Threading Bar Ordering Specification

## Internal Threading Bar For D881 Toolholder

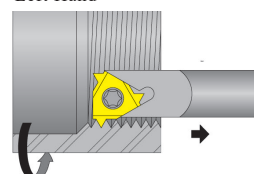
This cartridge is to be used on the #881 holder. It is used for internal threading with a laydown insert. It can be mounted on either end of the base holder.



Right Hand

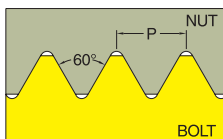
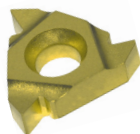
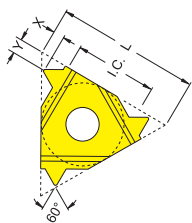


Left Hand



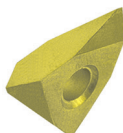
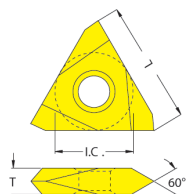
Series	Right Hand			Min. Bore		C		Pitch		Insert I.C.	Torx Screw	Torx Key
	Desc.	No. 733101-	Insert	in	mm	in	mm	TPI	mm			
25,30,35,40	NL50R	03661	11IR-A60	0.500	12,7	2.375	60,3	16-48	0,5-1,5	.250	TS-25.45-6M1	T-8
25,30,35,40	NL75R	03663	16IR-AG60	0.750	19,1	2.875	73,0	8-48	0,5-3,0	.375	TS-16	T-10

## 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

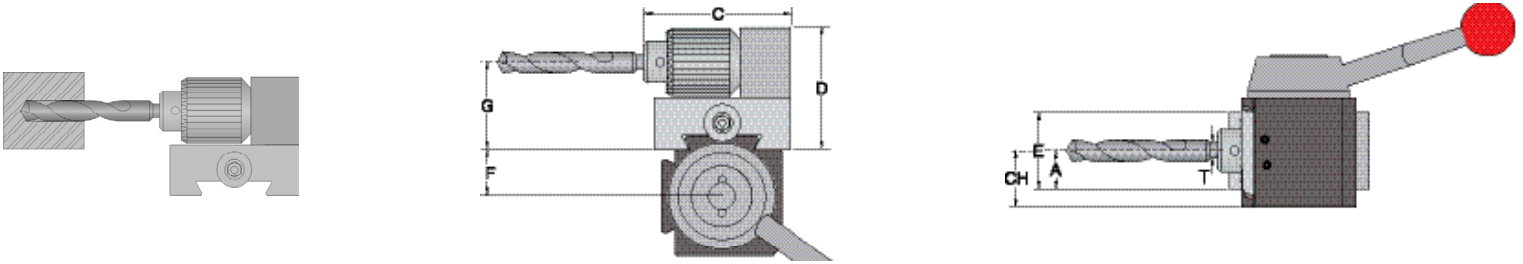


On Edge TNMC 60° Negative Rake Threading Insert					Insert Specification										
Part No.	Grade	UPC	Grade	UPC	I.C.		TPI		T		Hole Dia.		Depth.		
					I.C.	L									
TNMC-32NV-	DVP656	72003	DVK10	72004	0.375	16mm	8-48	0,5-3,0	0.125	3,18	0.150	3,81mm	0.150	3,81mm	
Carbon Steel, Alloy Steel & Stainless Steel				Non Ferouse Metal, Stainless Steel, Aluminium & Cast Iron											

# SDN-Toolholder Ordering Specification

## No. D35 Drill Chuck Toolholder

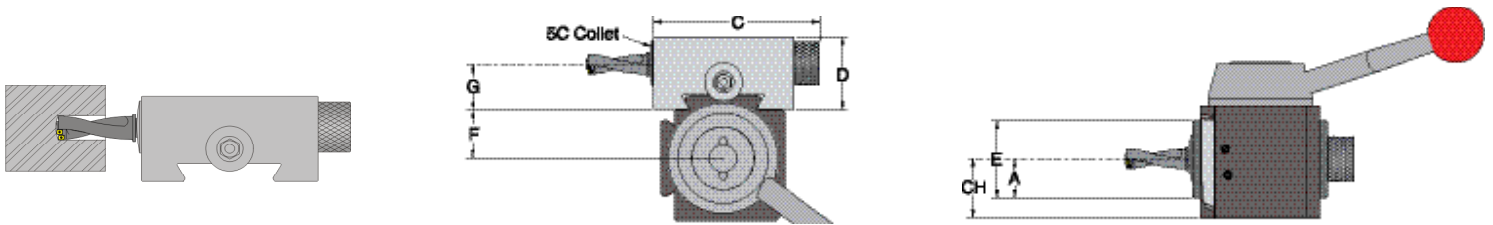
This holder is best used for holding drills, reamers, taps, etc., without tailstock mounting. It uses a drill chuck mounted directly to a quick change holder. This holder is supplied with a drill-chuck. Fits industry standard tool posts.



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

## SUPER Quick Change Tool Post First Time Buyer Set

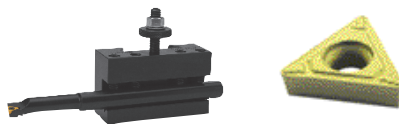
### SUPER Quick Change First Time Buyer SET Includes FREE TOOLING

Set Includes:

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



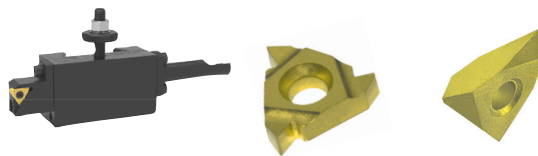
1ea. D1 + 1 Free Turning Toolholder, 1 Free TCMT Turning Inserts



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. 733101-	01056	01058	01060	01062
Description	SDN25AXA-FTB	SDN30BXA-FTB	SDN35CXA-FTB	SDN40CA-FTB
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"
<b>Set Includes</b>				
(1) Super Quick Change Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA
4) Holders	D25AXA-1	D30BXA-1	D35CXA-1	D40CA-1
No. D1 Turning & Facing Toolholder	D25AXA-2	D30BXA-2	D35CXA-2	D40CA-2
No. D2 Turning, Facing & Boring Toolholder	D25AXA-7-71C	D30BXA-7-71C	D35CXA-7-71C	D40CA-7-71C
No. D7-71C Reversible Twin Cut-Off Blade Toolholder	D25AXA-881-OE	D30BXA-881-OE	D35CXA-881-OE	D40CA-881-OE
No. D881 O.D. or I.D. Threading Toolholder				
<b>Free Tooling</b>				
(4) Toolholders	STNCR08-2J	STNCR10-2A	STNCR12-3B	STNCR64-3D
Turning Square Shank	STCMB06-2	STCMB08-2	STCMB10-2	STCMB12-3
Boring Bar	TWECOB-DNTF-19-20	TWECOB-DNTF-19-20	TWECOB-DNTF-26-30	TWECOB-DNTF-26-30
Cut-Off Blade	NL50R	NL50R	NL75R	NL75R
Threading Ba				
(5) Inserts	TCMT-21.51-PEM-DPC25UT	TCMT-21.51-PEM-DPC25UT	TCMT-21.51-PEM-DPC25UT	TCMT-32.51-PEM-DPC25UT
Turning Insert	TCMT-21.52-PEM-DPC25UT	TCMT-21.52-PEM-DPC25UT	TCMT-32.52-PEM-DPC25UT	TCMT-32.52-PEM-DPC25UT
Turning & Boring Insert	DNTQ-222002-3EU-DPP35UG	DNTQ-222002-3EU-DPP35UG	DNTQ-223003-3EU-DPP35UG	DNTQ-223003-3EU-DPP35UG
Turning & Grooving Insert	TNMC-32NV-DVP656	TNMC-32NV-DVP656	TNMC-32NV-DVP656	TNMC-32NV-DVP656
O.D. Threading Insert	11IR-A60-DVP656	11IR-A60-DVP656	16IR-A60-DVP656	16IR-A60-DVP656
I.D. Threading Insert				



# SDN Quick Change Tool Post & Toolholders Sets

## SUPER Quick Change Turning Sets

### Turning Set Includes

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

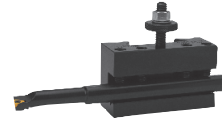
Tooling Not Included



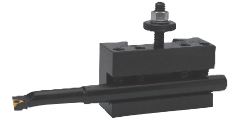
D1



D1



D2



D2

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"
<b>Set Includes</b>						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXa	SDN40CA	SDN50DA	SDN60EA
(4) Holders	(2) D25AXA-1 (2) D25AXA-2	(2) D30BXA-1 (2) D30BXA-2	(2) D35CXa-1 (2) D35CXa-2	(2) D40CA-1 (2) D40CA-2	(2) D50DA-1 (2) D50DA-2	(2) D60EA-1 (2) D60EA-2

## SUPER Quick Change Standard Sets

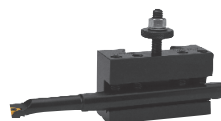
### Standard Set Includes

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

Tooling Not Included



D1



D2



D4-CNC



D7-71C

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"
<b>Set Includes</b>						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXa	SDN40CA	SDN50DA	SDN60EA
(4) Holders	(1) D25AXA-1 (1) D25AXA-2 (1) D25AXA-4-CNC (1) D25AXA-7-71C	(1) D30BXA-1 (1) D30BXA-2 (1) D30BXA-4-CNC (1) D30BXA-7-71C	(1) D35CXa-1 (1) D35CXa-2 (1) D35CXa-4-CNC (1) D35CXa-7-71C	(1) D40CA-1 (1) D40CA-2 (1) D40CA-4-CNC (1) D40CA-7-71C	(1) D50DA-1 (1) D50DA-2 (1) D50DA-4-CNC (1) D50DA-7-71C	(1) D60EA-1 (1) D60EA-2 (1) D60EA-4-CNC (1) D60EA-7-71C

# How to Order the Correct Tool Post for your Lathe

## Contact Information

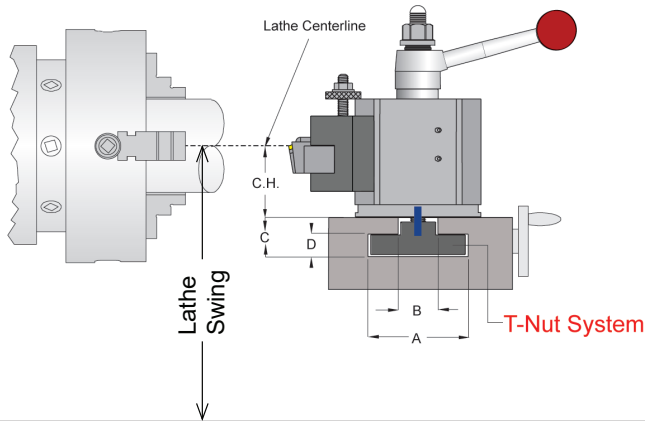
Company:			Name:		
Address:			Phone ( )		
City:	State:	Zip:	Fax ( )		
Email:					

## Technical Information Required

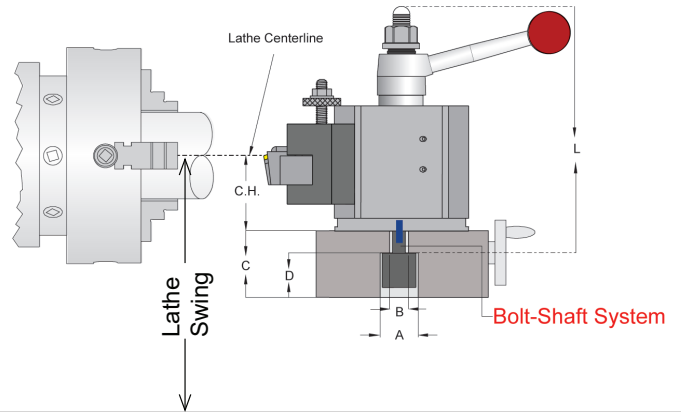
	Inch	Metric		
1 Lathe Swing			7 Type of the Lathe	
2 Tool Center Height			8 Maximum Chuck RPM	
3 Square Shank Tool Size			Type of Work	
4 Square Shank Tool Size			9 Short Run	
5 Holding System	T-Nut	Bolt-Shaft	10 Production	
6 Lathe Horse Power			11 Light Duty Work	
			12 Heavy Duty Work	

## Holding System & Center Height Information

### T-Nut Mounting Style



### Bolt Shaft Mounting Style



Lathe Bedway

	A	B	C	D	L	Thread Size	l	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.

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





## Tool Post Catalog

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sales@doriantool.com  
www.doriantool.com



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