

**Dorian 2013**

# **Tool Guide**<sup>®</sup>

**No. 4**

## **For Every Day Machining**

**Carbide Inserts**

**Jet-Stream™ Thru Coolant Tools**

**Deep Hole Boring Tools**

**Swiss Machine Tools**

**ISO Turning & Boring Tools**

**API Threading Tools**

**Cut-off Toolholders & Inserts**

**Specialty Milling Tools & Inserts**

**Tool Post & Toolholders**

**CNC Quick Change GangTool**

**Precision Live Centers**

**Knurling Tools & Wheels**

**Automated CNC Turret**

**CNC Adjustable Angle Heads**

**Milling Machine Accessories**

**4th Axis CNC Rotary Table**

**Extra Heavy Duty Modular Bull Nose System**

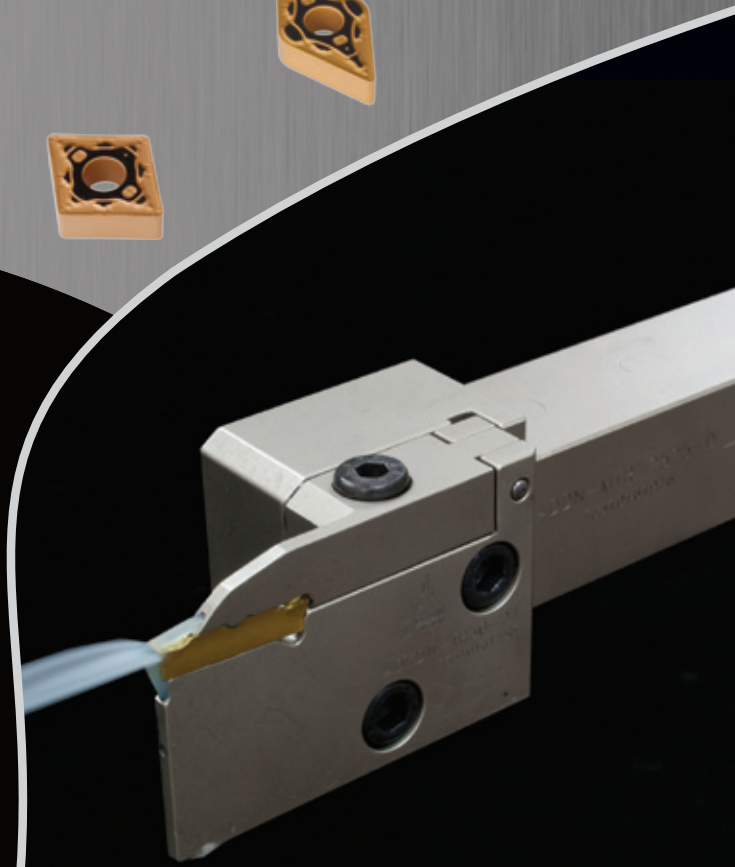
**Kool Cut™ Modular Turning , Facing & Grooving**

**High Performance Tool Presetters & Tightening Fixture**

**Precision V-Flange Tooling**

**Bushings**

**Soft Jaw Machining Adapter**

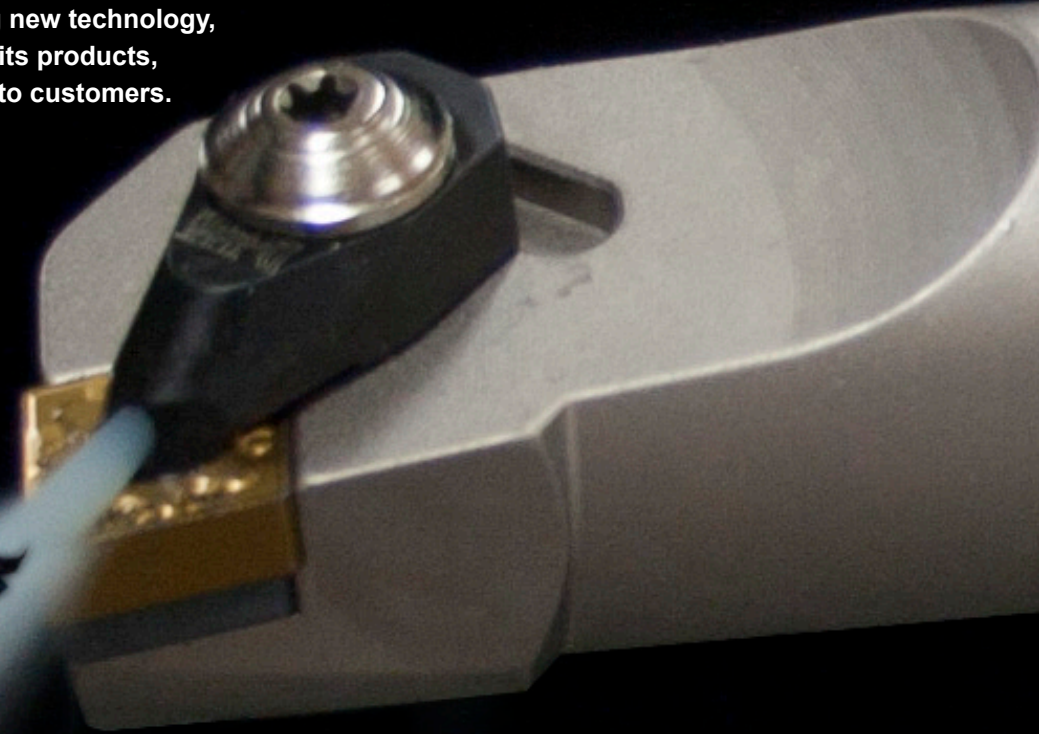


## **Dorian Tool's Vision and Guiding Principle**

"Tomorrow's Technology in Today's Machine Tools",  
is Dorian Tool's vision and guiding principle.

This is reflected by our total commitment to help today's customers achieve their goals by supplying the most advanced tooling with the highest standard of quality and innovative technology in the marketplace. Our highly trained and skilled engineers have developed technologies that set new standards in the industry and changed the machining process forever.

By developing new ideas and promoting new technology,  
Dorian Tool has continuously improved its products,  
service, technical support, and delivery to customers.



## **Inside This Tool Guide**

You will find High Performance Cutting Tools,  
Inserts and Machine Tool Accessories  
for every day machining.

Additionally this Tool Guide will  
give you an excellent overview of our  
complete line of tooling.

See back cover for individual, product specific catalogs  
for each product line.

## **To Place Your Order Today**

Contact Your Local Authorized  
Dorian Tool Distributor

# **THE POWER** OF THE **DORIAN** **JET-STREAM™ THRU COOLANT SYSTEM** **CHANGES THE WAY METAL IS CUT!**



At a close range of 1/4 (6mm), the Jet-Stream™ coolant system aims the coolant precisely onto the cutting edge of the insert at a very high velocity.

See pages 12-14

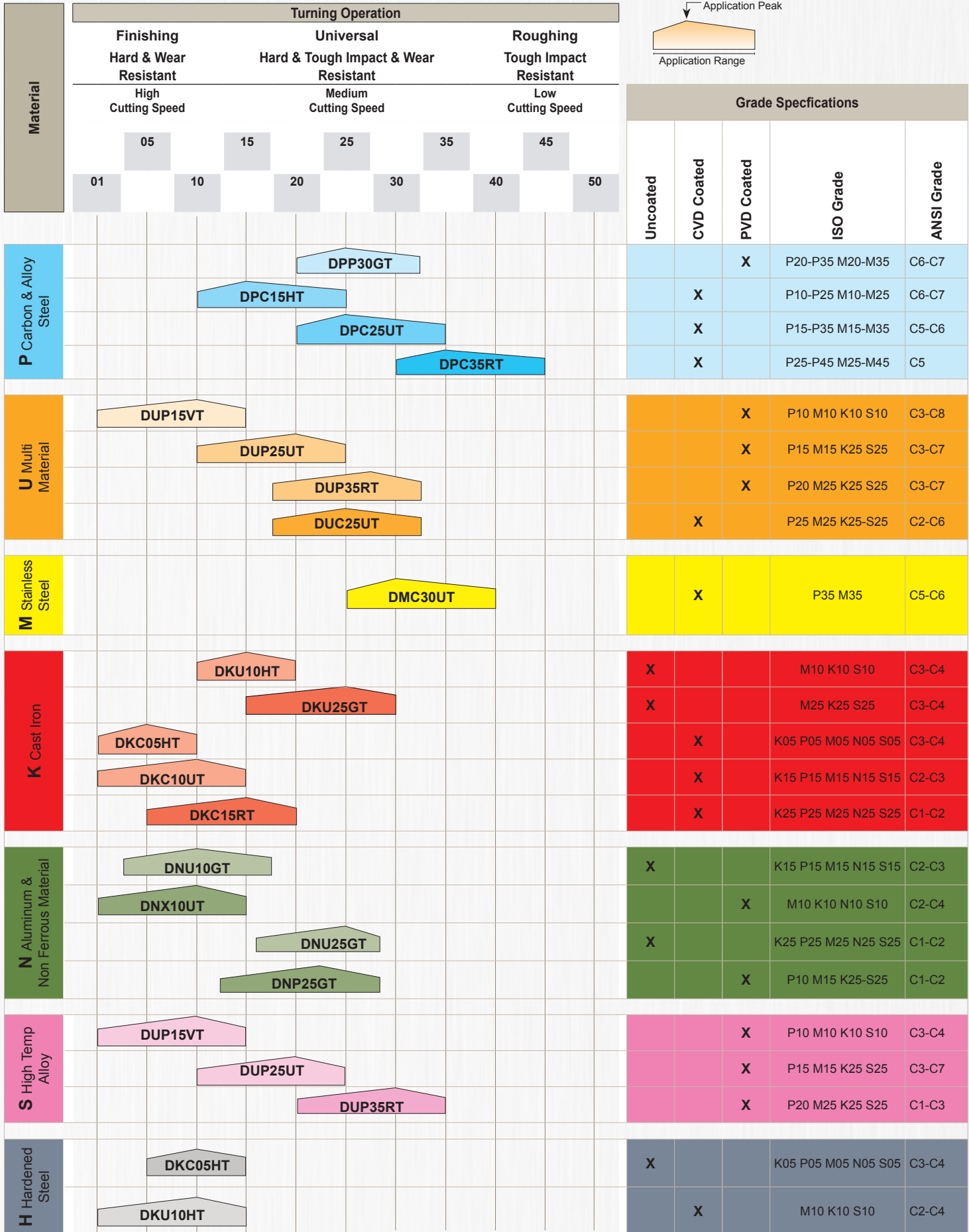
Hot chips are forced away from the insert cutting edge. As a result, the insert will operate at a constant low temperature, with a clean and undamaged cutting edge, changing the way metal is cut!

Dorian's Jet-Stream™ System will Improve:  
Quality, Productivity, and  
**Increase Insert Life Up to 200%**



# Dorian Insert Grade Chart

**NEW**





**NEW**

# Dorian Insert Grade Chart

How to Choose the Best Insert for the Turning Application		Cutting Condition	Extended Turning Grade Material's Use & Application													
<b>1 For Finishing:</b>	Use a hard and wear resistant coated insert grade with a small nose radius, a sharp to light honed cutting edge and a small chipbreaker. Cut at a high SFM with a small Depth of Cut ( $a_p$ ) and Feed Rate per Rev. (fn).		F Finish-Application M Medium-Application R Roughing and Unstable-Application													
<b>2 For Universal:</b>	Use a hard, tough and wear resistant coated insert grade with a medium nose radius, honed cutting edge and medium chipbreaker. Cut at a medium SFM with a medium Depth of Cut ( $a_p$ ) and medium Feed Rate per Rev. (fn)		Materials													
<b>3 For Roughing:</b>	Use a tough coated insert grade with a large nose radius, a heavy honed cutting edge and a large chipbreaker. Cut at a low SFM with a large Depth of Cut ( $a_p$ ) and high Feed Rate per Rev. (fn).		Steel & Alloy Steel	Stainless Steel	Cast Iron	Aluminum & Non Ferrous	High Temp Alloy	Hardened Steel								
<b>4 Cutting Edge:</b>	If insert wears, reduce Spindle Speed RPM (n), increase Feed (fn) or change to a harder insert grade. If insert chips, increase Spindle Speed (n), decrease Feed (fn) and/or to a heavier honed edge, or change to a tougher insert grade. For smooth surface and hard material use hard insert, for interrupt cut and large depth of cut use a tough insert.		P	M	K	N	S	H	Application							
Grade	Description	F	M	R	F	M	R	F	M	R	F	M	R	F	M	R
DPP30GT	<b>First Choice:</b> For general turning applications at a medium SFM. Use inserts to cut Alloy Steel and Stainless Steel. Inserts have a thermal deformative and abrasive resistant substrate with a single layer PVD TiN coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DPC15HT	<b>First Choice:</b> For finishing turning applications at a high SFM. Use inserts to cut Steel and Stainless Steel. Inserts have a hard, wear and abrasive resistant substrate with a CVD $Al_2O_3/TiCN/Al_2O_3/TiCN$ coating (not for interrupted cuts).	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DPC25UT	<b>First Choice:</b> For universal turning applications at a medium SFM. Use inserts to cut Alloy Steel and Stainless Steel. Inserts have a hard, tough, impact, wear and abrasive resistant substrate with a CVD $Al_2O_3/TiCN/Al_2O_3/TiCN$ coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DPC35RT	<b>First Choice:</b> For roughing turning applications at a low SFM. Use inserts to cut Alloy Steel and Stainless Steel. Inserts have a tough and impact resistant substrate with a CVD $Al_2O_3/TiCN/Al_2O_3/TiCN$ coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUP15VT	<b>First Choice:</b> For finishing turning applications at a very high SFM. Use inserts to cut Multi Materials; Ferrous and non Ferrous including all High Temp Super Alloys. Inserts have a very hard, high, wear and abrasive resistant substrate with a PVD AlCrN Coating.	Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUP25UT	<b>First Choice:</b> For universal turning applications at a high SFM. Use inserts to cut Multi Materials; Ferrous and non Ferrous including all High Temp Super Alloys. Inserts have a hard and wear resistant substrate with a PVD Ti/TiAlN/TiN Coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUP35RT	<b>First Choice:</b> For unstable turning applications at a medium SFM. Use inserts to cut Multi Materials; Ferrous and non Ferrous including all High Temp Super Alloys. Inserts have a wear, tough and impact resistant substrate with a PVD TiAlN/WC/C coating.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUC25UT	<b>First Choice:</b> For general turning applications at a medium SFM. Use inserts to cut Multi Materials; Ferrous and non Ferrous. Inserts have a hard, tough, wear, abrasive and shock resistant substrate with a CVD TiN/TiCN/ $Al_2O_3$ /TiN coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DMC30UT	<b>First Choice:</b> For general turning applications at a medium SFM. Use inserts to cut 300, 400 and PH series Austenitic Stainless Steel. Inserts have a hard, tough, impact, abrasive and thermal shock resistant substrate with a CVD TiCN/TiN coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKU10HT	<b>First Choice:</b> For general turning applications at a medium SFM. Use inserts to cut all non Ferrous materials including Gray Iron and Ductile Iron. Also, use inserts to cut Aluminum, Stainless Steel and Hardened Steel. Inserts have an uncoated, wear and abrasive resistant substrate.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKU25GT	<b>First Choice:</b> For general turning applications at a low SFM. Use inserts to cut all non Ferrous Materials including Gray Iron and Ductile Iron. Also, use inserts to cut Aluminum, Stainless Steel and Hardened Steel. Insert have an uncoated, tough, impact and abrasive resistant substrate.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKC05HT	<b>First Choice:</b> For finishing to roughing applications at a high SFM. Use inserts to cut Gray Iron, Nodular Cast Iron and Ductile Iron. Inserts have a high wear resistant substrate and cutting edge with a CVD TiN/TiCN/ $Al_2O_3$ /TiO <sub>2</sub> coating.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKC10UT	<b>First Choice:</b> For general turning applications at a medium to high SFM. Use inserts to cut Gray Iron, Nodular Cast Iron and Ductile Iron. Inserts have a high thermal deformative wear resistant substrate and cutting edge with a CVD TiN/TiCN/ $Al_2O_3$ /TiO <sub>2</sub> /3 $Al_2O_3$ coating.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKC15RT	<b>First Choice:</b> For roughing applications at a medium SFM. Use inserts to cut Gray Iron, Nodular Cast Iron and Ductile Iron. Inserts have a wear, tough and impact resistant substrate with a CVD TiN/TiCN/ $Al_2O_3$ /TiO <sub>2</sub> /3 $Al_2O_3$ coating to withstand interrupted cutting conditions.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DNU10GT	<b>First Choice:</b> For general turning applications at a high SFM. Use inserts to cut all non Ferrous metals including Aluminum and Plastic. Inserts have an uncoated, hard, high, abrasive resistant micro-grained substrate with a hard cutting edge.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DNX10UT	<b>First Choice:</b> For universal turning at a very high SFM. Use inserts to cut all non Ferrous materials including Aluminum, Stainless Steel, Plastic, High Temp Super Alloys and low Silicone Aerospace Aluminum. Inserts have a hard, abrasive resistant substrate and a microplus® plasma TiAlN coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DNU25GT	<b>First Choice:</b> For general turning applications at a medium SFM. Use inserts to cut all non Ferrous materials including Aluminum and Plastic. Inserts have an uncoated, hard micro-grained substrate with a hard cutting edge and toughness for interrupted cuts.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DNP25GT	<b>First Choice:</b> For general turning applications at a high SFM. Use inserts to cut all non Ferrous metals including Aluminum and Plastic. Inserts have a PVD TiN coating and a hard, tough, shock resistant, micro grained substrate with a hard cutting edge for interrupted cuts.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUP15VT	<b>First Choice:</b> For finishing turning applications at a very high SFM. Use inserts to cut all non Ferrous materials including High Temp Super Alloys. Also, use inserts to cut all Ferrous materials. Inserts have a very hard, wear and high abrasive resistant substrate with a PVD AlCrN coating.	Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUP25UT	<b>First Choice:</b> For general turning applications at a high SFM. Use inserts to cut all non Ferrous materials including High Temp Super Alloys. Also, use inserts to cut all Ferrous materials. Inserts have a hard, tough and wear resistant substrate with a PVD Ti/TiAlN/TiN Coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DUP35RT	<b>First Choice:</b> For unstable and roughing turning applications at a medium SFM. Use inserts to cut all non Ferrous materials including High Temp Super Alloys. Also, use inserts to cut all Ferrous materials. Inserts have a tough and impact resistant substrate with a PVD TiAlN/WC/C coating.	Wet/Dry	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKC05HT	<b>First Choice:</b> For turning applications at a medium SFM on up to 65 HRC hardened steel. Inserts have a high wear resistant substrate and cutting edge with a CVD TiN/TiCN/ $Al_2O_3$ /TiO <sub>2</sub> coating.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○
DKU10HT	<b>First Choice:</b> For turning applications at a low SFM on up to 65 HRC hardened steel. Inserts have an uncoated wear resistant substrate and cutting edge.	Wet	○	○	○	○	○	○	○	○	○	○	○	○	○	○

For more information and for grades not listed in this Tool guide refer to our 2013 Turning & Boring catalog.



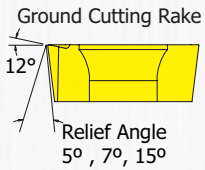
## The GX Style Super Precision Ground Positive Inserts For Precise Turning and Boring Applications

The **GX Style Super Precision Ground Positive Inserts** are ground with a very close tolerance of less than .0003" TIR. This close tolerance assures inserts have accurate indexing and repeatability every time the insert is changed, making the turning operation simple and precise. No off-setting is required when changing the insert.



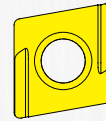
The **GX Style Super Precision Ground Positive Inserts** have a 12° positive, sharp, precise and ground cutting rake angle and nose radius. A minimized contact of the cutting edge with the machined surface reduces friction, heat, cutting force and vibration while maximizing surface finish and machining tolerances.

### Relief Angle








The **GX Style** Positive Turning Inserts are available in 5°, 7° and 15° relief cutting angles.

### Geometry



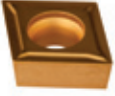


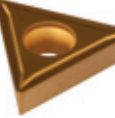



The **GX Style** Positive Turning Inserts are available in 80°, 55°, and 35° Diamond and 60° Triangle. These geometries cover all possible precision turning and boring applications.

SUPER Precision Positive Ground Turning Inserts		Application					
		Universal			Roughing		
		Insert Grade					
		DUP25UT			DUP35RT		
Description	ANSI	UPC 733101-				UPC 733101-	
		R.H.	L.H.	R.H.	L.H.		
<b>CDGX-UEF</b> 80° Diamond Universal 	CDGX-1.20.60.2-UEFR/L	68543	68548	68544	68549		
	CDGX-1.20.60.5-UEFR/L	68553	68558	68554	68559		
	CDGX-1.510.5-UEFR/L	68563	68568	68564	68569		
	CDGX-1.511-UEFR/L	68573	68578	68574	68579		
<b>CPGX-UEF</b> 80° Diamond Universal 	CPGX-1.81.20.5-UEFR/L	68633	68638	68634	68639		
	CPGX-1.81.21-UEFR/L	68643	68648	68644	68649		
<b>DCGX-UEF</b> 55° Diamond Universal 	DCGX-21.51-UEFR/L	68713	68718	68714	68719		
<b>VBGX-UEF</b> 35° Diamond Universal 	VBGX-221-UEFR/L	68903	68908	68904	68909		
	VBGX-331-UEFR/L	68923	68928	68924	68929		
	VBGX-332-UEFR/L	68933	68938	68934	68939		
<b>VCGX-UEF</b> 35° Diamond Universal 	VCGX-221-UEFR/L	68963	68968	68964	68969		
	VCGX-331-UEFR/L	68983	68988	68984	68989		
	VCGX-332-UEFR/L	68993	68998	68994	68999		


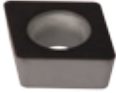
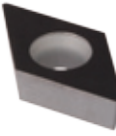
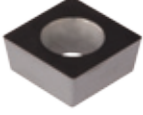
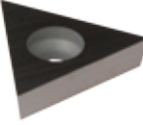
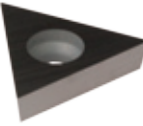
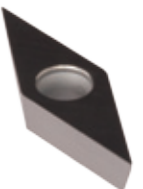
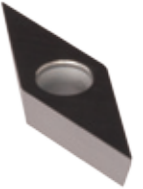


**NEW**

# Positive Turning Inserts

Precision Positive Ground Turning Inserts		Application			
		General	Finishing	Universal	Roughing
		Insert Grade			
		DNU10GT	DUP15VT	DUP25UT	DUP35RT
Description	ANSI	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-
<b>CCGT-UEU</b> 80° Diamond Universal 	CCGT-21.51-UEU	79455	79456	79458	79459
	CCGT-32.51-UEU	79465	79466	79468	79469
	CCGT-431-UEU	79475	79476	79478	79479
	CCGT-432-UEU	79480	79481	79483	79484
<b>CPGT-UEU</b> 80° Diamond Universal 	CPGT-1.81.20.5-UEU	79485	79486	79488	79489
	CPGT-1.81.21-UEU	79490	79491	79493	79494
	CPGT-21.51-UEU	79500	79501	79503	79504
	CPGT-32.51-UEU	79510	79511	79513	79514
<b>DCGT-UEU</b> 55° Diamond Universal 	DCGT-21.51-UEU	79535	79536	79538	79539
	DCGT-32.51-UEU	79545	79546	79548	79549
	DCGT-32.52-UEU	79550	79551	79553	79554
	DCGT-431-UEU	79555	79556	79558	79559
	DCGT-432-UEU	79560	79561	79563	79564
<b>TCGT-UEU</b> 60° Triangle Universal 	TCGT-21.50.2-UEU	79585	79586	79588	79589
	TCGT-21.51-UEU	79595	79596	79598	79599
	TCGT-32.51-UEU	79610	79611	79613	79614
	TCGT-32.52-UEU	79615	79616	79618	79619
<b>TPGT-UEU</b> 60° Triangle Universal 	TPGT-21.51-UEU	79630	79631	79633	79634
	TPGT-32.51-UEU	79645	79646	79648	79649
<b>VBGT-UEU</b> 35° Diamond Universal 	VBGT-221-UEU	79660	79661	79663	79664
	VBGT-331-UEU	79670	79671	79673	79674
	VBGT-332-UEU	79675	79676	79678	79679
<b>VBGT-UEU</b> 35° Diamond Universal 	VCGT-221-UEU	79685	79686	79688	79689
	VCGT-331-UEU	79700	79701	79703	79704
	VCGT-332-UEU	79705	79706	79708	79709
<b>WCGT-UEU</b> 80° Trigon Universal 	WCGT-1.51.50.2-UEU	79710	79711	79713	79714
	WCGT-1.51.50.5-UEU	79715	79716	79718	79719
	WCGT-21.51-UEU	79725	79726	79728	79729
	WCGT-32.51-UEU	79735	79736	79738	79739
	WCGT-32.52-UEU	79740	79741	79743	79744







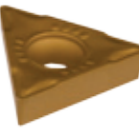
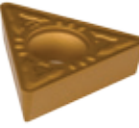




Precision Positive Ground Turning Inserts		Application		
		General	Finishing	Roughing
		Insert Grade		
		DKU10HT	DUP15VT	DUP35RT
Description	ANSI	UPC 733101-	UPC 733101-	UPC 733101-
<b>CDGW-KEU</b> 80° Diamond Universal 	CDGW-1.20.60.2-KEU	79340	79341	79343
	CDGW-1.20.60.5-KEU	79344	79345	79347
	CDGW-1.510.5-KEU	79348	79349	79351
	CDGW-1.511-KEU	79352	79353	79355
<b>CCGW-KEU</b> <b>CCMW-KEU</b> 80° Diamond Universal 	CCGW-21.51-KEU	79356	79357	79359
	CCGW-32.52-KEU	79364	79365	79367
	CCMW-32.51-KEU	70757	79360	
	CCMW-431-KEU	70758	79361	
	CCMW-432-KEU	70759	79362	
<b>CPGW-KEU</b> 80° Diamond Universal 	CPGW-1.81.20.5-KEU	79368	79369	79371
	CPGW-1.81.21-KEU	79372	79373	79375
	CPGW-21.51-KEU	79376	79377	79379
	CPGW-32.51-KEU	79380	79381	79383
	CPGW-32.52-KEU	79384	79385	79387
<b>DCGW-KEU</b> <b>DCMW-KEU</b> 55° Diamond Universal 	DCGW-21.51-KEU	79388	79389	79391
	DCMW-32.51-KEU	70770	79392	
	DCMW-32.52-KEU	70771	79393	
<b>SCMW-KEU</b> Square Universal 	SCMW-32.51-KEU	70774	79394	
	SCMW-431-KEU	70775	79395	
<b>TCGW-KEU</b> <b>TCMW-KEU</b> 60° Triangle Universal 	TCGW-21.51-KEU	79400	79401	79403
	TCGW-32.52-KEU	79408	79409	79411
	TCMW-21.51-KEU	70780	79396	
	TCMW-32.51-KEU	70781	79397	
<b>TPGW-KEU</b> 60° Triangle Universal 	TPGW-21.51-KEU	79412	79413	79415
	TPGW-32.51-KEU	79416	79417	79419
	TPGW-32.52-KEU	79420	79421	79423
<b>VBGW-KEU</b> 35° Diamond Universal 	VBGW-221-KEU	79424	79425	79427
	VBGW-331-KEU	79428	79429	79431
	VBGW-332-KEU	79432	79433	79435
<b>VCGW-KEU</b> 35° Diamond Universal 	VCGW-221-KEU	79436	79437	79439
	VCGW-331-KEU	79440	79441	79443
	VCGW-332-KEU	79444	79445	79447










**NEW**

# Positive & Negative Turning Inserts

Molded Positive Turning Inserts For Steel		Application	
		Finishing	Medium
		Insert Grade	
		DPC15HT	DPC25UT
Description	ANSI	UPC 733101-	UPC 733101-
<b>CCMT-PEF</b> 80° Diamond Finishing 	CCMT-21.51-PEF	71877	71878
	CCMT-32.51-PEF	71883	71884
<b>CCMT-PEM</b> 80° Diamond Medium 	CCMT-21.50.5-PEM	71875	71876
	CCMT-21.52-PEM		71882
	CCMT-32.51-PEM		71936
<b>DCMT-PEF</b> 55° Diamond Finishing 	DCMT-21.51-PEF	71893	
	DCMT-32.51-PEF	71897	
<b>DCMT-PEM</b> 55° Diamond Medium 	DCMT-21.51-PEM		71896
	DCMT-32.52-PEM		71902
<b>TCMT-PEF</b> 60° Triangle Finishing 	TCMT-1.21.20.2-PEF		80249
	TCMT-21.50.5-PEF	71909	71910
	TCMT-21.51-PEF	71911	71912
<b>TCMT-PEM</b> 60° Triangle Medium 	TCMT-21.51-PEM	71941	71942
	TCMT-21.52-PEM	71913	71914
	TCMT-32.51-PEM	71915	71916
	TCMT-32.52-PEM	71917	71918
<b>VBMT-PEF</b> 35° Diamond Finishing 	VBMT-331-PEF	71919	71920
<b>VCMT-PEF</b> 35° Diamond Finishing 	VCMT-331-PEF	71927	71928
<b>VCMT-PEM</b> 35° Diamond Medium 	VCMT 331-PEM		71944
	VCMT 332-PEM		71930
<b>WCMT-PEF</b> 80° Trigon Finishing 	WCMT-1.210.2-PEF		80251













Precision Positive Ground Turning Inserts For Aluminum		Application	
		General	Universal
		Insert Grade	
		DNU10GT	DNX10UT
Description	ANSI	UPC 733101-	UPC 733101-
<b>CCGT-NFU</b> 80° Diamond Universal 	CCGT-21.51-NFU	80024	80025
	CCGT-32.51-NFU	80032	80033
	CCGT-32.52-NFU	80036	80037
<b>DCGT-NFU</b> 55° Diamond Universal 	DCGT-21.51-NFU	80052	80053
	DCGT-32.51-NFU	80060	80061
	DCGT-32.52-NFU	80064	80065
<b>VCGT-NFU</b> 35° Triangle Universal 	VCGT-221-NFU	80103	80104
	VCGT-331-NFU	80111	80112
	VCGT-332-NFU	80115	80116










Molded Negative Turning Inserts For Steel		Application		
		Heavy Roughing	Extra Heavy Roughing with Interrupted Cut	Extra Extra Heavy Roughing in Difficult & Unstable Working Conditions
		Insert Grade		
		DPC15HT	DPC25UT	DPC35RT
Description	ANSI	UPC 733101-	UPC 733101-	UPC 733101-
<b>CNMM-PSH</b> 80° Diamond Heavy Duty Roughing 	CNMM-432-PSH	70160	70161	70162
	CNMM-433-PSH	70163	70164	70165
	CNMM-543-PSH	70166	70167	70168
	CNMM-544-PSH	70169	70170	70171
	CNMM-643-PSH	70172	70173	70174
	CNMM-644-PSH	70175	70176	70177
<b>SNMM-PSH</b> Square Heavy Duty Roughing 	CNMM-646-PSH	70178	70179	70180
	SNMM-432-PSH	70181	70182	70183
	SNMM-433-PSH	70184	70185	70186
	SNMM-543-PSH	70187	70188	70189
	SNMM-544-PSH	70190	70191	70192
	SNMM-643-PSH	70193	70194	70195
	SNMM-644-PSH	70196	70197	70198
	SNMM-646-PSH	70199	70200	70201
SNMM-648-PSH	70202	70203	70204	



# Negative Turning Inserts

**NEW**

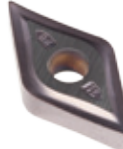
Molded Negative Turning Inserts For Steel		Application		
		Finishing	Universal	Roughing
		Insert Grade		
		DPC15HT	DPC25UT	DPC35RT
Description	ANSI	UPC 733101-	UPC 733101-	UPC 733101-
<b>CNMG-PEF</b> 80° Diamond Finishing 	CNMG-431-PEF	69250		
<b>CNMG-PEM</b> 80° Diamond Medium 	CNMG-432-PEM		69278	
<b>CNMG-PER</b> 80° Diamond Roughing 	CNMG-432-PER		69352	
	CNMG-433-PER			69356
<b>DNMG-PEF</b> 55° Diamond Finishing 	DNMG-331-PEF	69254		
	DNMG-431-PEF	69258		
<b>DNMG-PEM</b> 55° Diamond Medium 	DNMG-332-PEM		69296	
	DNMG-432-PEM		69299	
<b>DNMG-PER</b> 55° Diamond Roughing 	DNMG-432-PER		69376	
<b>TNMG-PEF</b> 60° Triangle Finishing 	TNMG-331-PEF	69268		
<b>TNMG-PEM</b> 60° Triangle Medium 	TNMG-332-PEM		69326	
<b>VNMG-PEF</b> 35° Diamond Finishing 	VNMG-332-PEF		69275	
<b>VNMG-PEM</b> 35° Diamond Medium 	VNMG-332-PEM		69337	
<b>WNMG-PEM</b> 80° Trigon Medium 	WNMG-332-PEM	69342		
	WNMG-432-PEM		69346	
<b>WNMG-PER</b> 80° Trigon Roughing 	WNMG-432-PER		69403	




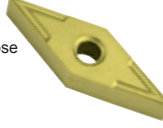
Molded Negative Turning Inserts For Stainless Steel		Application		
		Finishing	Medium	Roughing
		Insert Grade		
		DMC30UT	DMC30UT	DMC30UT
Description	ANSI	UPC 733101-	UPC 733101-	UPC 733101-
<b>CNMG-MEF</b> 80° Diamond Finishing 	CNMG-431-MEF	69965		
<b>CNMG-MEM</b> 80° Diamond Medium 	CNMG-432-MEM		69968	
<b>CNMG-MER</b> 80° Diamond Roughing 	CNMG-433-MER			69970
<b>DNMG-MEF</b> 55° Diamond Finishing 	DNMG-331-MEF	69973		
<b>DNMG-MEM</b> 55° Diamond Medium 	DNMG-332-MEM		69976	
	DNMG-432-MEM		69977	
<b>DNMG-MER</b> 55° Diamond Roughing 	DNMG-443-MER			69981
<b>WNMG-MEF</b> 80° Trigon Finishing 	WNMG-331-MEF	69989		
	WNMG-431-MEF	69990		
<b>WNMG-MEM</b> 80° Trigon Medium 	WNMG-432-MEM		69993	
<b>WNMG-MER</b> 80° Trigon Roughing 	WNMG-432-MER			69996



**NEW**

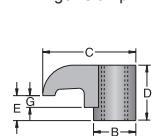
# Negative Turning Inserts & Spare Parts

Negative Ground Turning Inserts For Multi-Materials		Application			
		General	Finishing	Universal	Medium Roughing
		Insert Grade			
		DNU10GT	DUP15VT	DUP25UT	DUP35RT
Description	ANSI	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-
<b>CNGG-SEF</b> 80° Diamond Finishing 	CNGG-431-SEF		70845		
	CNGG-432-SEF				69933
<b>CNMG-SEM</b> 80° Diamond Medium 	CNMG-431-SEM	70805	70851	70887	69938
	CNMG-432-SEM	70806	70852	70890	69939
<b>DNMG-SEM</b> 55° Diamond Medium 	DNMG-431-SEM	70818	70868	70891	69948
	DNMG-432-SEM	70819	70869	70892	69949
<b>VNMG-SEF</b> 35° Diamond Finishing 	VNMG-331-SEF	70830	70874		69954
	VNMG-332-SEF	70831	70875		69955

Negative General Purpose Economy Inserts For Multi-Materials		Application	
		General Purpose	Insert Grade
		DUC25UT	
		Description	ANSI
<b>CNMG-EG</b> 80° Diamond General Purpose 	CNMG-432-EG	70006	
<b>DNMG-EG</b> 55° Diamond General Purpose 	DNMG-432-EG	70034	
<b>TNMG-EG</b> 60° Triangle General Purpose 	TNMG-321-EG	70094	
	TNMG-331-EG	70102	
	TNMG-332-EG	70106	
<b>VNMG-EG</b> 35° Diamond General Purpose 	TNMG-432-EG	70114	
	VNMG-331-EG	70138	
	VNMG-332-EG	70142	
	VNMG-432-EG	70146	
	VNMG-433-EG	70150	

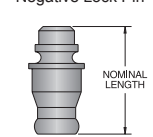
## Standard Spare Parts

Finger Clamp

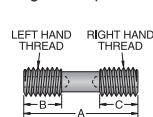


Description	UPC No. 733101-	PKG.	
CL-6	90681	10	
CL-7	90682		
CL-9	90683		
CL-12	90684		
CL-19	90685		
CL-20	90686		
CL-30	90688	10	
NL-23	90472		
NL-33	90473		
NL-33L	90474		
NL-34	90475		
NL-34L	90476		
NL-44	90478	10	
NL-46	90479		
NL-58	90483		
NL-68	90487		
XNS-35	90901		10
XNS-36	90902		
XNS-47	90906		
XNS-48	90907		
XNS-510	90908		
XNS-58	90910		
XNS-59	90911		

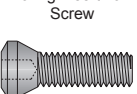
Negative Lock Pin



Finger Clamp Screw

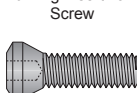


Boring Insert Torx Screw

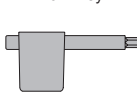


Description	UPC No. 733101-	PKG.
TS-06	91306	10
TS-4.7-8M1	90976	
TS-4.7-10M1	90982	
TS-4.7-10M1	90982	
TS-4.7-10M1	90982	
TS-4.7-10M1	90982	
TS-25.-45-6M2	90972	10
TS-4.7-10M1	90982	
T-6	92001	10
T-7	92002	
T-15	92006	
T-20	92007	

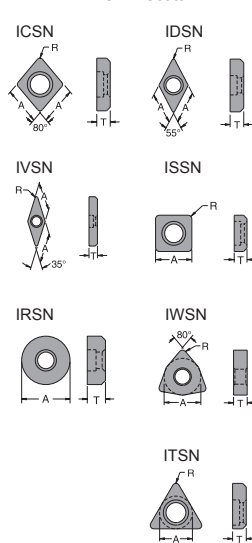
Turning Insert Torx Screw



Torx Key



Shim Seats



Description	UPC No. 733101-	PKG.
ICSN-332	90007	10
ICSN-433	90008	
ICSN-533	90010	
ICSN-633	90012	
IDSN-322	90016	10
IDSN-433	90021	
IDSN-533	90024	10
IVSN-322	90065	
IVSN-324	90068	10
ISSN-322	90050	
ISSN-433	90059	
ISSN-533	90060	
ISSN-633	90062	10
IRSN-43	90031	
IRSN-63	90033	10
IWSN-322	90070	
IWSN-433	90072	
ITSN-333	90088	
ITSN-433	90093	10
ITSN-533	90098	

## Jet-Stream Thru Coolant Spare Parts

Seat Screw



Clamp Screw



Upper 'O' Ring Seal



Lower 'O' Ring Seal

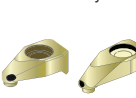


Description	Part No. 733101-
SM-M3	53318
SM-M4	53319
SM-M6	53320
M-M66	53317
SM-S4	53316
JSCS-03	53323
JSCS-04	53324
JSCS-06	53326
JSCS-04-HPV	53321
JSOR-03	53328
JSOR-01	53315
JSOR-07	53327
JSOR-06	53330
JSOR-04	53314

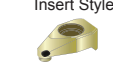
### Turning Dor-Lock Clamp Sets\*

Insert Style	Description	Part No. 733101-
CNMG Insert Style	JSLC-HPC3-B	53250
	JSLC-HPCTW-4N	53289
	JSLC-HPC5	53252
	JSLC-HPC6	53248
DNMG Insert Style	JSLC-HPD3	53253
	JSLC-HPD4	53254
DNMG & TNMG Insert Style	JSLC-HPDT3-BR	53268
	JSLC-HPDT3-BL	53269

TNMG & WNMG Insert Style



WNMG Insert Style



VNMG Insert Style



Description	Part No. 733101-
JSLC-HPTW3N	53261
JSLC-HPTW3R	53262
JSLC-HPTW3L	53263
JSLC-HPCTW-4N	53289
JSLC-HPTW4R	53265
JSLC-HPTW4L	53266
JSLC-HPW3-B	53270
JSLC-HPV3	53267

### NEW High Volume Turning Dor-Lock Clamp

Insert Style	Description	733101-
CNMG / TNMG / WNMG	JSLC-HPC-TW-4N-HPV	53290

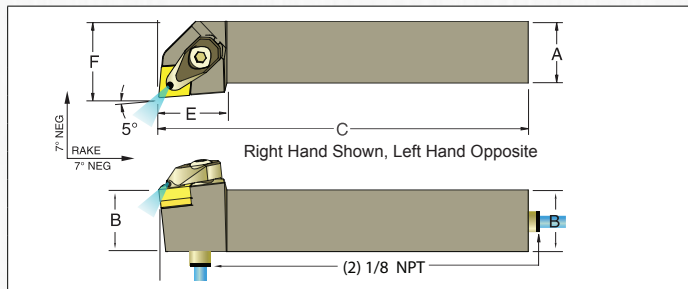
### Threading (DorNotch) Dor-Lock Clamp Sets\*

NT & NTP 60° Insert Style	Description	733101-
	JSLC-HP72	53350
	JSLC-HP73	53351
	JSLC-HP76	53352
	JSLC-HP77	53353

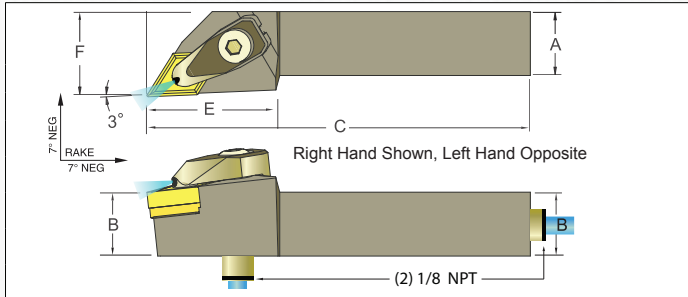
\*Dor-Lock turning and threading **clamp sets** include **upper and lower o-rings**.



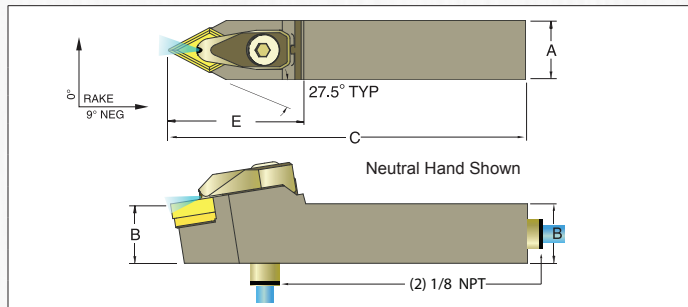
# Jet-Stream™ Thru Coolant Toolholders



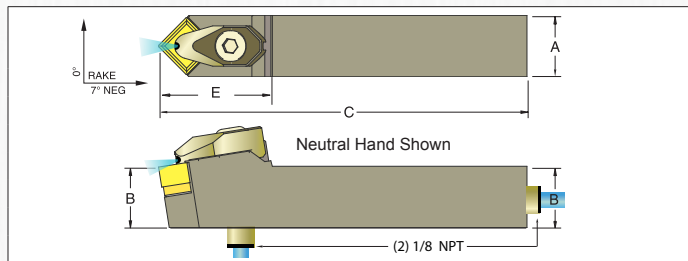
ADCLN R/L Toolholder Style L - Negative 5° end or side cutting edge angle for negative 80° diamond CNM_inserts							
Description	Part No. 733101-		A/B	C	E	F	CNM_ Gage Insert
	R.H.	L.H.					
ADCLNR/L-12-4B	53000	53001	0.75	4.50	1.250	1.000	432
ADCLNR/L-16-4D	53002	53003	1.00	6.00	1.250	1.250	432
ADCLNR/L-20-4D	53004	53005	1.25	6.00	1.250	1.500	432
ADCLNR/L-20-5D	53006	53007	1.25	6.00	1.375	2.000	543
ADCLNR/L-24-4E	53008	53009	1.50	7.00	1.250	2.000	432
ADCLNR/L-24-5E	53010	53011	1.50	7.00	1.375	2.000	543



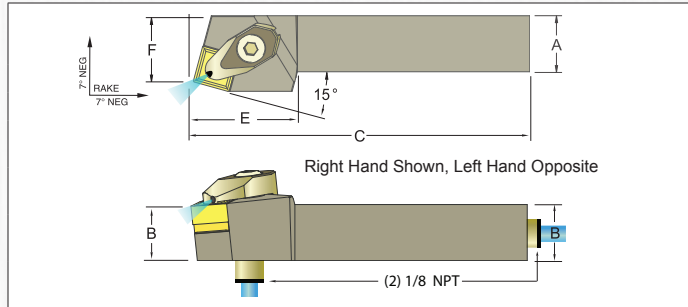
ADDJN R/L Toolholder Style J - 3° side cutting edge angle for negative 55° diamond DNM_inserts							
Description	Part No. 733101-		A/B	C	E	F	DNM_ Gage Insert
	R.H.	L.H.					
ADDJNR/L-12-3B	53016	53017	0.75	4.50	1.500	1.000	332
ADDJNR/L-12-4B	53018	53019	0.75	4.50	1.500	1.000	432
ADDJNR/L-16-4D	53020	53021	1.00	6.00	1.500	1.250	432
ADDJNR/L-20-4D	53022	53023	1.25	6.00	1.500	1.500	432
ADDJNR/L-24-4E	53024	53025	1.50	7.00	1.500	2.000	432



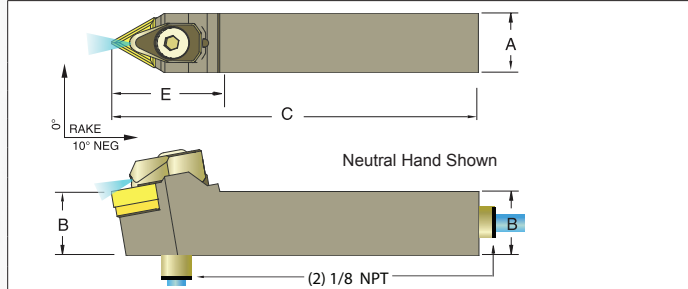
ADDPN Neutral Toolholder Style P - 27.5° side cutting edge angle for negative 55° diamond DNM_inserts						
Description	Part No. 733101-		A/B	C	E	DNM_ Gage Insert
	Neutral					
ADDPNN-12-3B	53030		0.75	4.50	1.750	332
ADDPNN-12-4B	53031		0.75	4.50	1.750	432
ADDPNN-16-3D	53032		1.00	6.00	1.750	332
ADDPNN-16-4D	53033		1.00	6.00	1.750	432
ADDPNN-20-4D	53034		1.25	6.00	1.750	432
ADDPNN-24-4E	53035		1.50	7.00	1.750	432



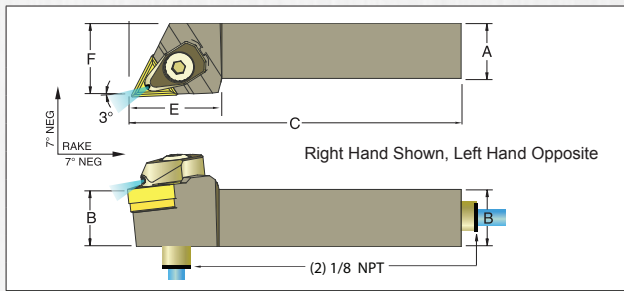
ADSDN Neutral Toolholder Style D - 45° side cutting edge angle for negative square SNM_inserts						
Description	Part No. 733101-		A/B	C	E	SNM_ Gage Insert
	Neutral					
ADSDNN-12-4B	53053		0.75	4.50	1.375	432
ADSDNN-16-4D	53054		1.00	6.00	1.375	432
ADSDNN-20-4D	53055		1.25	6.00	1.375	432
ADSDNN-20-5D	53056		1.25	6.00	1.375	543
ADSDNN-24-5E	53058		1.50	7.00	1.625	543



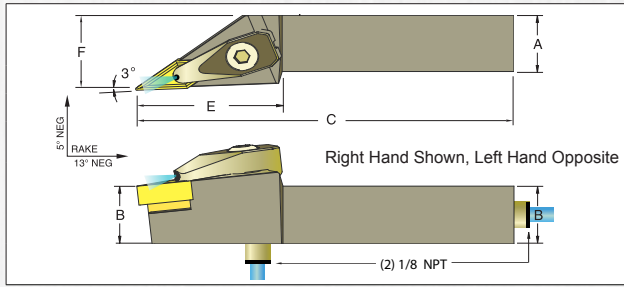
ADSRN R/L Toolholder Style R - 15° side cutting edge angle for negative square SNM_inserts							
Description	Part No. 733101-		A/B	C	E	F	SNM_ Gage Insert
	R.H.	L.H.					
ADSRNR/L-12-4B	53040	53041	0.75	4.50	1.375	0.880	432
ADSRNR/L-16-4D	53043	53044	1.00	6.00	1.375	1.000	432
ADSRNR/L-20-5D	53045	53046	1.25	6.00	1.375	1.000	543
ADSRNR/L-24-5E	53047	53048	1.50	7.00	1.375	1.000	543



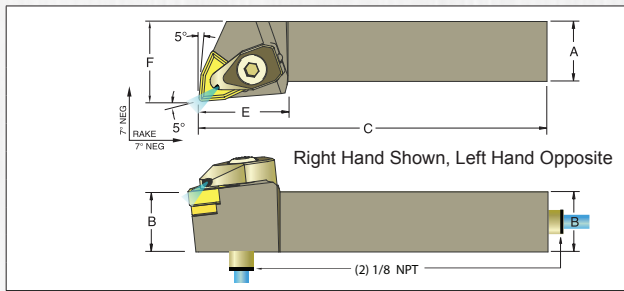
ADTEN Neutral Toolholder Style E - 30° side cutting edge angle for negative triangle TNM_inserts						
Description	Part No. 733101-		A/B	C	E	TNM_ Gage Insert
	Neutral					
ADTENN-12-3B	53075		0.75	4.50	1.375	332
ADTENN-12-4B	53076		0.75	4.50	1.375	432
ADTENN-16-3D	53077		1.00	6.00	1.375	332
ADTENN-16-4D	53078		1.00	6.00	1.375	432
ADTENN-20-4D	53079		1.25	6.00	1.50	432
ADTENN-24-4E	53080		1.50	7.00	1.625	432



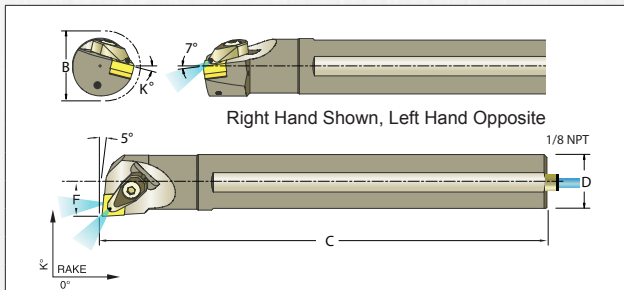
ADTJN R/L Toolholder Style J - 3° side cutting edge angle for negative triangle TNM_ inserts							
Description	Part No. 733101-		A/B	C	E	F	TNM_ Gage Insert
	R.H.	L.H.					
ADTJNR/L-12-3B	53063	53064	0.75	4.50	1.250	1.000	332
ADTJNR/L-12-4B	53065	53066	0.75	4.50	1.250	1.250	432
ADTJNR/L-16-3D	53067	53068	1.00	6.00	1.250	1.500	332
ADTJNR/L-16-4D	53069	53070	1.00	6.00	1.250	2.000	432
ADTJNR/L-20-4D	53071	53072	1.25	6.00	1.375	2.000	432
ADTJNR/L-24-4E	53073	53074	1.50	7.00	1.50	2.000	432



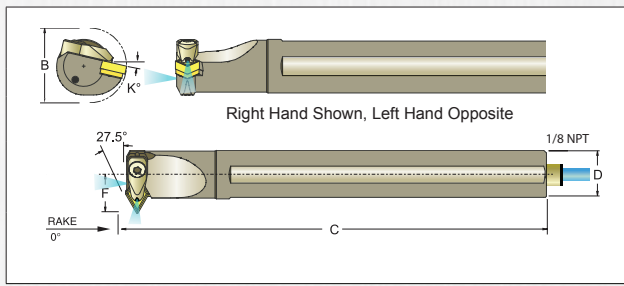
ADVJN R/L Toolholder Style J - Negative 3° side cutting edge angle for negative 35° diamond VNM_ inserts							
Description	Part No. 733101-		A/B	C	E	F	VNM_ Gage Insert
	R.H.	L.H.					
ADVJNR/L-12-3B	53081	53082	0.75	4.50	1.750	1.000	332
ADVJNR/L-16-3D	53083	53084	1.00	6.00	1.750	1.250	332
ADVJNR/L-20-3D	53085	53086	1.25	6.00	1.750	1.500	332
ADVJNR/L-24-3E	53087	53088	1.50	7.00	1.750	2.000	332



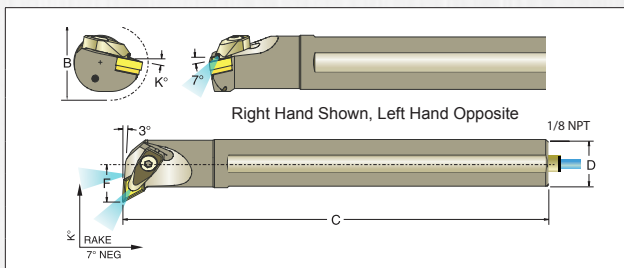
ADWLN R/L Toolholder Style L - Negative 5° end or side cutting edge angle for negative 80° trigon WNM_ inserts							
Description	Part No. 733101-		A/B	C	E	F	WNM_ Gage Insert
	R.H.	L.H.					
ADWLN/R-12-3B	53093	53094	0.75	4.50	1.000	1.000	332
ADWLN/R-12-4B	53095	53096	0.75	4.50	1.250	1.000	432
ADWLN/R-16-3D	53097	53098	1.00	6.00	1.000	1.250	332
ADWLN/R-16-4D	53099	53100	1.00	6.00	1.250	1.250	432
ADWLN/R-20-4D	53101	53102	1.25	6.00	1.250	1.500	432
ADWLN/R-24-4E	53103	53104	1.50	7.00	1.250	2.000	432



AS-ADCLN R/L Boring Bar Style L - Negative 5° side & end cutting edge angle for negative 80° diamond CNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	CNM_ Gage Insert
	R.H.	L.H.						
AS-12R-ADCLNR/L-3	53120	53121	1.000	8.00	0.75	0.500	10°	322
AS-16R-ADCLNR/L-4	53122	53123	1.280	8.00	1.00	0.640	14°	432
AS-20S-ADCLNR/L-4	53124	53125	1.530	10.00	1.25	0.765	14°	432
AS-24S-ADCLNR/L-4	53126	53127	1.780	10.00	1.50	0.890	11°	432
AS-32T-ADCLNR/L-4	53128	53129	2.562	12.00	2.00	1.281	11°	432
AS-32T-ADCLNR/L-5	53130	53131	2.562	12.00	2.00	1.281	11°	543



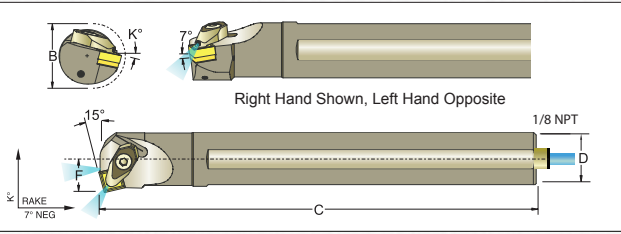
AS-ADDPN R/L Boring Bar Style P - Negative 27.5° end cutting edge angle for negative 55° diamond DNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	DNM_ Gage Insert
	R.H.	L.H.						
AS-20S-ADDPNR/L-4	53150	53151	1.705	10.00	1.25	1.000	13°	432
AS-24S-ADDPNR/L-4	53152	53153	2.000	10.00	1.50	1.125	10°	432



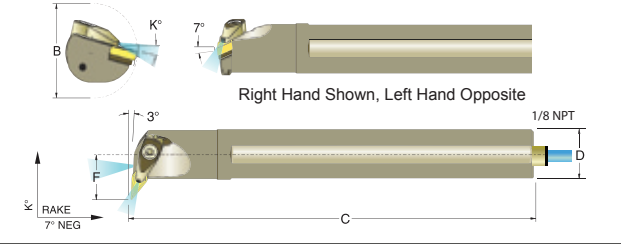
AS-ADDUN R/L Boring Bar Style U - Negative 3° end cutting edge angle for negative 55° diamond DNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	DNM_ Gage Insert
	R.H.	L.H.						
AS-16R-ADDUNR/L-3	53137	53138	1.300	8.00	1.00	0.750	11°	332
AS-20S-ADDUNR/L-4	53139	53140	2.000	10.00	1.25	1.000	11°	432
AS-24S-ADDUNR/L-4	53141	53142	2.250	10.00	1.50	1.125	11°	432
AS-32T-ADDUNR/L-4	53143	53144	3.000	12.00	2.00	1.375	11°	432



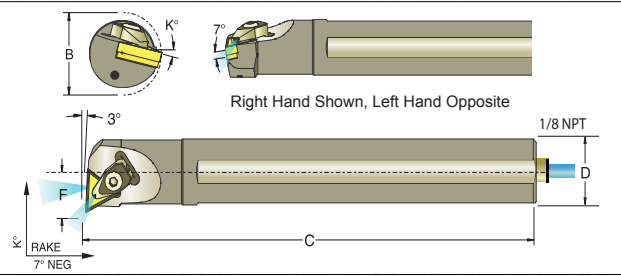
# Jet-Stream™ Thru Coolant Toolholders



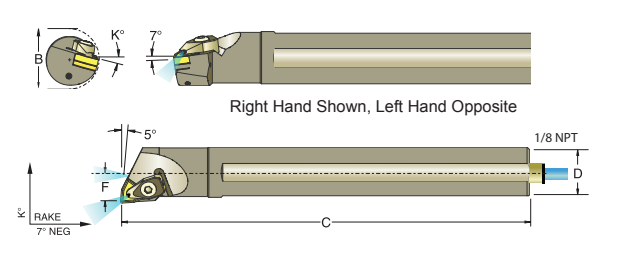
AS-ADSKN R/L Boring Bar Style K - 15° End cutting edge angle for negative square SNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	SNM_ Gage Insert
	R.H.	L.H.						
AS-20S-ADSKNR/L-4	53159	53160	1.53	10.00	1.25	0.765	10°	432
AS-24S-ADSKNR/L-4	53161	53162	1.76	10.00	1.50	0.890	11°	432
AS-32T-ADSKNR/L-4	53163	53164	2.40	12.00	2.00	1.281	12°	432
AS-32T-ADSKNR/L-5	53165	53166	2.40	12.00	2.00	1.281	12°	543



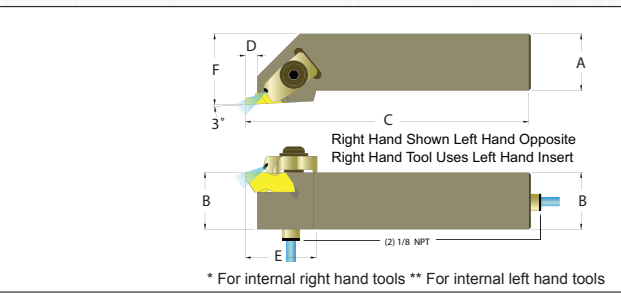
AS-ADVUN R/L Boring Bar Style U - Negative 3° side cutting edge angle for negative 35° diamond VNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	VNM_ Gage Insert
	R.H.	L.H.						
AS-20S-ADVUNR/L-3	53189	53190	2.250	10.00	1.25	1.125	14°	332
AS-24S-ADVUNR/L-3	53191	53192	2.500	10.00	1.50	1.250	11°	332



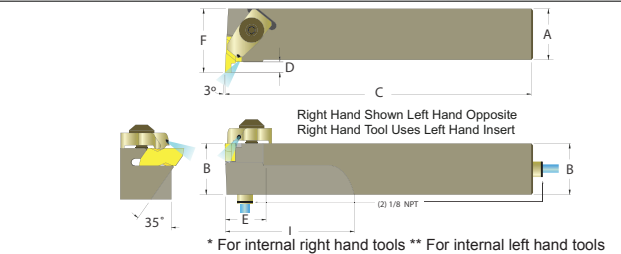
AS-ADTUN R/L Boring Bar Style U - Negative 3° end cutting edge angle for negative triangle TNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	TNM_ Gage Insert
	R.H.	L.H.						
AS-12R-ADTUNR/L-3	53172	53173	1.000	8.00	0.75	0.500	14°	322
AS-16R-ADTUNR/L-3	53174	53175	1.280	8.00	1.00	0.640	14°	332
AS-20S-ADTUNR/L-4	53176	53177	1.530	10.0	1.25	0.765	14°	432
AS-24S-ADTUNR/L-4	53178	53179	2.060	10.0	1.50	0.890	11°	432
AS-32T-ADTUNR/L-4	53180	53181	2.562	12.0	2.00	1.281	11°	432



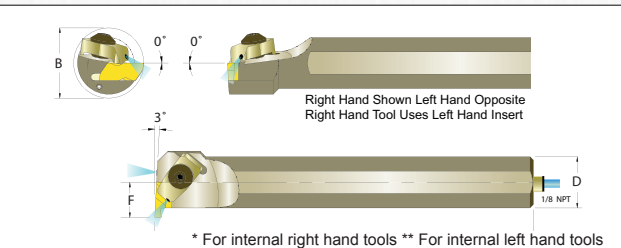
AS-ADWLN R/L Boring Bar Style L - Negative 5° end & side cutting edge angle for negative 80° trigon WNM_ inserts								
Description	Part No. 733101-		B	C	D	F	K°	WNM_ Gage Insert
	R.H.	L.H.						
AS-12R-ADWLN R/L-3	53198	53199	1.000	8.00	0.75	0.500	14°	332
AS-16R-ADWLN R/L-4	53200	53201	1.280	8.00	1.00	0.640	14°	432
AS-20S-ADWLN R/L-4	53202	53203	1.530	10.00	1.25	0.765	14°	432
AS-24S-ADWLN R/L-4	53204	53205	1.780	10.00	1.50	0.890	11°	432
AS-32T-ADWLN R/L-4	53206	53207	2.000	12.00	2.00	1.281	12°	432



ADNSR R Threading Toolholder Style S - External DorNotch toolholder for threading and grooving DorNotch inserts									
Description	Part No. 733101-		A	B	C	D	E	F	Gage Insert
	R.H.	L.H.							
ADNSR/L12-3B	53450	53451	0.75	0.75	4.50	0.21	1.25	1.00	
ADNSR/L16-3D	53452	53453	1.00	1.00	6.00	0.21	1.25	1.25	* NG-3R ** NG-3L
ADNSR/L20-3D	53454	53455	1.25	1.25	6.00	0.21	1.25	1.50	
ADNSR/L16-4D	53456	53457	1.00	1.00	6.00	0.29	1.38	1.25	
ADNSR/L20-4D	53458	53459	1.25	1.25	6.00	0.29	1.38	1.50	* NG-4R ** NG-4L
ADNSR/L24-4E	53460	53461	1.50	1.50	7.00	0.29	1.38	1.75	



ADNER R/L Threading Toolholder Style E - Gang external DorNotch toolholder for threading and grooving DorNotch inserts									
Description	Part No. 733101-		A/B	C	D	E	F	I	Gage Insert
	R.H.	L.H.							
ADNER/L12-3B	53465	53466	0.75	4.50	0.21	0.75	1.13	2.00	
ADNER/L16-3D	53467	53468	1.00	6.00	0.21	0.75	1.25	2.00	* NG-3L ** NG-3R
ADNER/L20-3D	53469	53470	1.25	6.00	0.21	0.75	1.50	2.00	
ADNER/L16-4D	53471	53472	1.00	6.00	0.29	0.75	1.38	2.00	* NG-4L ** NG-4R
ADNER/L20-4D	53473	53474	1.25	6.00	0.29	0.75	1.63	2.00	



AS-ADNE R/L Threading Bar Style E - Internal DorNotch Boring Bar for threading and grooving DorNotch inserts								
Description	Part No. 733101-		B	C	D	F		Gage Insert
	R.H.	L.H.						
AS-16R-ADNER/L-3	53490	53491	1.38	8.00	1.00	0.69		
AS-20S-ADNER/L-3	53492	53493	1.75	10.00	1.25	0.88		* NG-3L ** NG-3R
AS-24S-ADNER/L-3	53494	53495	2.00	10.00	1.50	1.00		
AS-32T-ADNER/L-4	53496	53497	2.75	12.00	2.00	1.38		** NG-4R * NG-4L

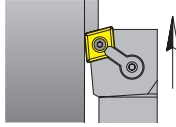
# **ISO TURNING TOOLHOLDERS & BORING BARS**



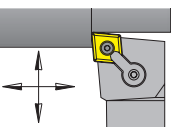


# Turning Toolholders

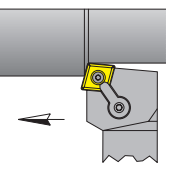
## MCKN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	CNM_ Gage Insert
		R.H.	L.H.		
	MCKNR/L12-4B	50066	50067	0.750	432
	MCKNR/L16-4C	50070	50071	1.000	
	MCKNR/L16-4D	50074	50075	1.000	
	MCKNR/L20-4D	50078	50079	1.250	
	MCKNR/L20-5D	50086	50087	1.250	543
	MCKNR/L24-6E	50102	50103	1.500	643

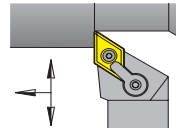
## MCLN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	CNM_ Gage Insert
		R.H.	L.H.		
	MCLNR/L10-4B	50116	50117	0.625	432
	MCLNR/L12-4B	50120	50121	0.750	
	MCLNR/L16-4C	50124	50125	1.000	
	MCLNR/L16-4D	50128	50129	1.000	
	MCLNR/L20-4D	50132	50133	1.250	
	MCLNR/L24-4D	50136	50137	1.500	
	MCLNR/L24-4E	50140	50141	1.500	
	MCLNR/L16-5D	50152	50153	1.000	543
	MCLNR/L20-5D	50156	50157	1.250	
	MCLNR/L16-6D	50168	50169	1.000	643
	MCLNR/L20-6D	50172	50173	1.250	
	MCLNR/L20-6E	50174	50175	1.250	
	MCLNR/L24-6D	50176	50177	1.500	
	MCLNR/L24-6E	50180	50181	1.500	

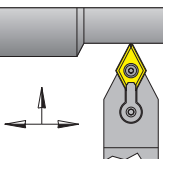
## MCRN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	CNM_ Gage Insert
		R.H.	L.H.		
	MCRNR/L12-4B	50220	50221	0.750	432
	MCRNR/L16-4D	50228	50229	1.000	
	MCRNR/L20-4D	50232	50233	1.250	
	MCRNR/L20-5D	50244	50245	1.250	543
	MCRNR/L20-6D	50256	50257	1.250	643
	MCRNR/L24-6E	50260	50261	1.500	

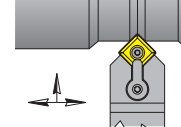
## MDJN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	DNM_ Gage Insert
		R.H.	L.H.		
	MDJNR/L16-3C	50314	50315	1.000	332
	MDJNR/L12-4B	50324	50325	0.750	
	MDJNR/L16-4C	50328	50329	1.000	
	MDJNR/L16-4D	50332	50333	1.000	
	MDJNR/L20-4D	50336	50337	1.250	
	MDJNR/L24-4D	50340	50341	1.500	
	MDJNR/L24-4E	50344	50345	1.500	543
	MDJNR/L16-5D	50352	50353	1.000	
	MDJNR/L20-5D	50356	50357	1.250	
	MDJNR/L24-5E	50364	50365	1.500	

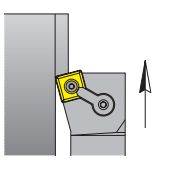
## MDPN - Negative Toolholder

	Description	UPC No. 733101-	Shank Size	DNM_ Gage Insert
		NEUTRAL		
	MDPNN12-4B	50370	0.750	432
	MDPNN16-4D	50372	1.000	
	MDPNN20-4D	50374	1.250	
	MDPNN16-5D	50376	1.000	

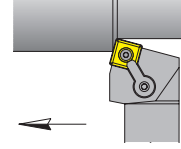
## MSDN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	SNM_ Gage Insert
		NEUTRAL			
	MSDNN08-3A	50392		0.500	322
	MSDNN08-3B	50394		0.500	
	MSDNN10-3B	50396		0.625	
	MSDNN12-3B	50398		0.750	
	MSDNN12-4B	50400		0.750	432
	MSDNN16-4D	50402		1.000	
	MSDNN16-5D	50406		1.000	543
	MSDNN20-5D	50408		1.250	
	MSDNN16-6D	50414		1.000	643
	MSDNN20-6D	50416		1.250	
	MSDNN24-6E	50418		1.500	

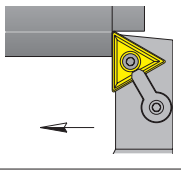
## MSKN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	SNM_ Gage Insert
		R.H.	L.H.		
	MSKNR/L12-4B	50448	50449	0.750	432
	MSKNR/L16-4D	50456	50457	1.000	
	MSKNR/L16-5D	50460	50461	1.000	543
	MSKNR/L20-6D	50472	50473	1.250	643

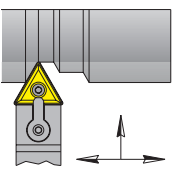
## MSRN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	SNM_ Gage Insert
		R.H.	L.H.		
	MSRNR/L12-4B	50506	50507	0.750	432
	MSRNR/L16-4D	50514	50515	1.000	
	MSRNR/L20-4D	50518	50519	1.250	
	MSRNR/L16-5D	50530	50531	1.000	543
	MSRNR/L20-5D	50534	50535	1.250	
	MSRNR/L16-6D	50542	50543	1.000	643
	MSRNR/L20-6D	50546	50547	1.250	
	MSRNR/L24-6E	50550	50551	1.500	

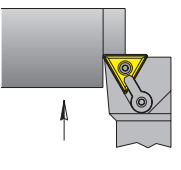
## MTAN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	TNM_ Gage Insert
		R.H.	L.H.		
	MTANR/L08-2A	50606	50607	0.500	221
	MTANR/L10-3B	50614	50615	0.625	322
	MTANR/L12-3B	50618	50619	0.750	

## MTEN - Negative Toolholder

	Description	UPC No. 733101-		Shank Size	TNM_ Gage Insert
		NEUTRAL			
	MTENN08-2A	50690		0.500	221
	MTENN10-3B	50692		0.625	322
	MTENN12-3B	50694		0.750	332
	MTENN12-4B	50698		0.750	432
	MTENN16-4D	50700		1.000	
	MTENN85-4D	50702		1.000	543
	MTENN20-5D	50706		1.250	

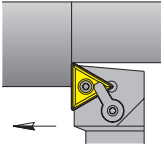
## MTFN - Negative Toolholder

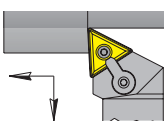
	Description	UPC No. 733101-		Shank Size	TNM_ Gage Insert
		R.H.	L.H.		
	MTFNR/L12-3B	50738	50739	0.750	322
	MTFNR/L16-4D	50754	50755	1.000	432
	MTFNR/L16-5D	50774	50775	1.000	543
	MTFNR/L20-5D	50778	50779	1.250	663
	MTFNR/L24-6E	50792	50793	1.500	

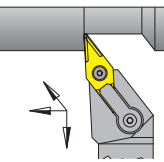


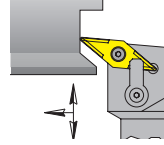


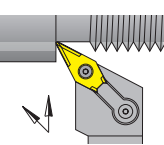
# Turning Toolholders

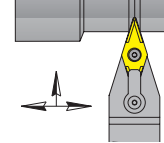
MTGN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	TNM_ Gage Insert
		R.H.	L.H.		
	MTGNR/L08-2A	50802	50803	0.500	221
	MTGNR/L10-3B	50810	50811	0.625	322
	MTGNR/L12-3B	50814	50815	0.750	
	MTGNR/L16-4D	50830	50831	1.000	432
	MTGNR/L20-4D	50834	50835	1.250	543
	MTGNR/L20-5D	50858	50859	1.250	
	MTGNR/L24-6E	50872	50873	1.500	663

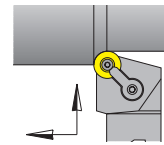
MTJN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	TNM_ Gage Insert
		R.H.	L.H.		
	MTJNR/L08-2A	50882	50883	0.500	221
	MTJNR/L10-3B	50890	50891	0.625	322 332
	MTJNR/L12-3B	50894	50895	0.750	
	MTJNR/L16-3D	50898	50899	1.000	432
	MTJNR/L16-4D	50902	50903	1.000	
	MTJNR/L20-4D	50906	50907	1.250	543
	MTJNR/L20-5D	50918	50919	1.250	
	MTJNR/L24-5E	50922	50923	1.500	663
	MTJNR/L24-6E	50934	50935	1.500	

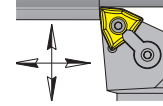
MVJN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	VNM_ Gage Insert
		R.H.	L.H.		
	MVJNR/L12-3B	51062	51063	0.750	332
	MVJNR/L16-3C	51066	51067	1.000	
	MVJNR/L16-3D	51070	51071	1.000	
	MVJNR/L20-3D	51074	51075	1.250	
	MVJNR/L16-4D	51090	51091	1.000	432
	MVJNR/L20-4D	51094	51095	1.250	
	MVJNR/L24-4E	51098	51099	1.500	

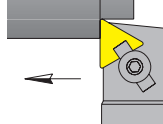
MVLN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	VNM_ Gage Insert
		R.H.	L.H.		
	MVLNR/L16-4C	51108	51109	1.000	432
	MVLNR/L16-4D	51112	51113	1.000	
	MVLNR/L20-4D	51116	51117	1.250	

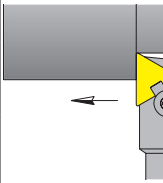
MVTN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	VNM_ Gage Insert
		R.H.	L.H.		
	MVTNR/L16-3D	51142	51143	1.000	332
	MVTNR/L20-3D	51146	51147	1.250	

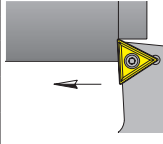
MVVN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	VNM_ Gage Insert
		NEUTRAL			
	MVVNN12-3B	51160		0.750	332
	MVVNN16-3D	51164		1.000	
	MVVNN16-4D	51168		1.000	432

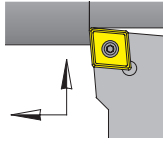
MRGN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	RNM_ Gage Insert
		R.H.	L.H.		
	MRGNR/L12-4B	51198	51199	0.750	43
	MRGNR/L16-4C	51202	51203	1.000	
	MRGNR/L16-4D	51206	51207	1.000	
	MRGNR/L20-4D	51210	51211	1.250	
	MRGNR/L20-6D	51230	51231	1.250	64
	MRGNR/L24-6E	51234	51235	1.500	

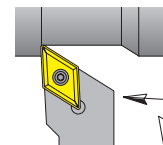
MWLN - Negative Toolholder					
	Description	UPC No. 733101-		Shank Size	WNM_ Gage Insert
		R.H.	L.H.		
	MWLNLR/L12-3B	51262	51263	0.750	332
	MWLNLR/L16-3C	51264	51265	1.000	
	MWLNLR/L12-4B	51266	51267	0.750	432
	MWLNLR/L16-4D	51270	51271	1.000	
	MWLNLR/L20-4D	51274	51275	1.250	

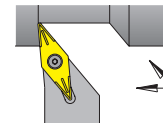
CTAP - Positive Toolholder					
	Description	UPC No. 733101-		Shank Size	TPG_ Gage Insert
		R.H.	L.H.		
	CTAPR/L08-2J	51386	51387	0.500	221
	CTAPR/L12-3B	51398	51399	0.750	322
	CTAPR/L16-3D	51402	51403	1.000	
	CTAPR/L16-4D	51410	51411	1.000	432

CTGP - Positive Toolholder					
	Description	UPC No. 733101-		Shank Size	TPG_ Gage Insert
		R.H.	L.H.		
	CTGPR/L10-3B	51492	51493	0.625	322
	CTGPR/L12-3B	51496	51497	0.750	

STNC - Positive Toolholder					
	Description	UPC No. 733101-		Shank Size	TCMT Gage Insert
		R.H.	L.H.		
	STNCR/L08-2J	51736	-	0.500	21.51
	STNCR/L10-2A	51738	51747	0.625	
	STNCR/L12-3B	51740	-	0.750	32.52
	STNCR/L64-3D	51742	51759	0.750	

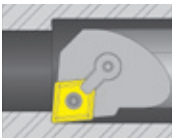
SCLC - Positive Toolholder					
	Description	UPC No. 733101-		Shank Size	CC_T Gage Insert
		R.H.	L.H.		
	SCLCR/L06-2J	51800	51801	0.375	21.51
	SCLCR/L08-3A	51804	51805	0.500	32.52
	SCLCR/L10-3B	51808	51809	0.625	
	SCLCR/L12-3B	51812	51813	0.750	

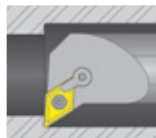
SDJC - Positive Toolholder					
	Description	UPC No. 733101-		Shank Size	DC_T Gage Insert
		R.H.	L.H.		
	SDJCR/L06-2J	51872	51873	0.375	21.51
	SDJCR/L08-3A	51880	51881	0.500	32.52
	SDJCR/L12-3B	51888	51889	0.750	


SVJB - Positive Toolholder					
	Description	UPC No. 733101-		Shank Size	VBMT Gage Insert
		R.H.	L.H.		
	SVJBR/L12-3B	52006	52007	0.750	332
	SVJBR/L16-3D	52014	52015	1.000	




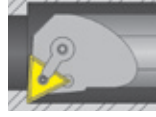
# Boring Bars


S-MCLN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	CNM_ Gage Insert	
	R.H.	L.H.				
	S12S-MCLNR/L-4	55006	55007	0.750	1.000	432
	S16T-MCLNR/L-4	55010	55011	1.000	1.280	
	S20U-MCLNR/L-4	55014	55015	1.250	1.530	
	S24U-MCLNR/L-4	55018	55019	1.500	1.780	
	S28U-MCLNR/L-4	55022	55023	1.750	2.030	
S32V-MCLNR/L-4	55024	55025	2.000	2.562	543	
S24U-MCLNR/L-5	55026	-	1.500	2.374		
S32V-MCLNR/L-5	55030	55031	2.000	2.562		
S40V-MCLNR/L-5	55034	-	2.500	3.062		
S32V-MCLNR/L-6	55042	55043	2.000	2.562		643
S40V-MCLNR/L-6	55050	55051	2.500	3.062		


S-MDUN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	DNM_ Gage Insert	
	R.H.	L.H.				
	S16T-MDUNR/L-3	55066	55067	1.000	1.300	332
	S20U-MDUNR/L-4	55070	55071	1.250	2.000	432
	S24U-MDUNR/L-4	55074	55075	1.500	2.250	
	S28U-MDUNR/L-4	55078	55079	1.750	2.500	
	S32V-MDUNR/L-4	55082	55083	2.000	3.000	
S40V-MDUNR/L-5	55098	55099	2.500	3.500	543	

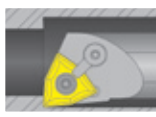
S-MSKN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	SNM_ Gage Insert	
	R.H.	L.H.				
	S20U-MSKNR-4	55100	-	1.250	1.470	432
	S24U-MSKNR-4	55102	-	1.500	1.760	
	S28U-MSKNR-4	55104	-	2.010	1.750	
	S32V-MSKNR-6	55106	-	2.000	2.240	


S-MTFN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	TNM_ Gage Insert	
	R.H.	L.H.				
	S12S-MTFNR-3	55150	-	0.750	1.000	322
	S16T-MTFNR-3	55154	-	1.000	1.280	
	S20U-MTFNR-3	55158	-	1.250	1.530	
	S24U-MTFNR-3	55162	-	1.500	1.780	
	S20U-MTFNR-4	55170	-	1.250	1.530	
S24U-MTFNR-4	55174	-	1.500	2.060		
S32V-MTFNR-4	55182	-	2.000	2.562		
S40V-MTFNR-4	55190	-	2.500	3.062		

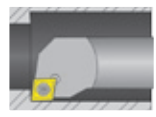
S-MTUN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	TNM_ Gage Insert	
	R.H.	L.H.				
	S12S-MTUNR/L-3	55204	55205	0.750	1.000	322
	S16T-MTUNR/L-3	55208	55209	1.000	1.280	
	S20U-MTUNR/L-3	55212	55213	1.250	1.530	
	S24U-MTUNR/L-3	55216	55217	1.500	2.060	
	S20U-MTUNR/L-4	55220	55221	1.250	1.530	
S24U-MTUNR/L-4	55224	55225	1.500	2.060		
S32V-MTUNR/L-4	55228	-	2.000	2.562		


S-MVUN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	VNM_ Gage Insert	
	R.H.	L.H.				
	S16T-MVUNR/L-3	55266	55267	1.000	2.000	332
	S20U-MVUNR/L-3	55270	55271	1.250	2.250	
	S24U-MVUNR/L-3	55274	55275	1.500	2.500	
	S32V-MVUNR/L-4	55282	55283	2.000	3.250	

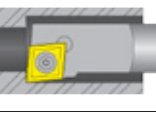
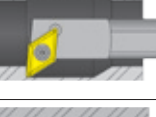


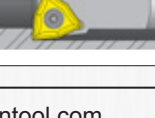
S-MVXN - Negative Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	VNM_ Gage Insert	
	R.H.	L.H.				
	S24U-MVXNR-3	55300	-	1.500	2.250	332
	S32V-MVXNR-4	55308	-	2.000	3.000	432

S-MWLN - Negative Boring Bars							
Description	UPC No. 733101-		Bar Size	Min. Bore	WNM_ Gage Insert		
	R.H.	L.H.					
	S12S-MWLN/L-3	55318	55319	0.750	1.000	332	
	S16T-MWLN/L-3	55320	-	1.000	1.280		
S16T-MWLN/L-4	55322	55323	1.000	1.280	432		
	S20U-MWLN/L-4	55326	55327	1.250			1.530
	S24U-MWLN/L-4	55330	55331	1.500			1.780

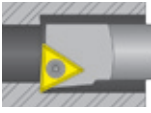
S-CTFP - Positive Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	TPG_ Gage Insert	
	R.H.	L.H.				
	S10S-CTFPR-2	55358	-	0.625	0.770	221
	S12S-CTFPR-3	55360	-	0.750	1.125	322
	S16T-CTFPR-3	55364	-	1.000	1.280	
	S20U-CTFPR-3	55368	-	1.250	1.530	
	S24U-CTFPR-3	55372	-	1.500	1.840	
	S20U-CTFPR-4	55380	-	1.250	1.530	
S24U-CTFPR-4	55384	-	1.500	2.060		


S-SCLC - Positive Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	CC_T Gage Insert	
	R.H.	L.H.				
	S06M-SCLCR/L-2	55470	55471	0.375	0.477	21.51
	S08M-SCLCR/L-2	55474	55475	0.500	0.602	
	S10R-SCLCR/L-2	55478	55479	0.625	0.812	
	S08M-SCLCR/L-3	55482	55483	0.500	0.625	32.52
	S10R-SCLCR/L-3	55486	55487	0.625	0.797	
	S12S-SCLCR/L-3	55490	55491	0.750	0.954	
	S16T-SCLCR/L-3	55494	55495	1.000	1.250	
	S16T-SCLCR/L-4	55498	55499	1.000	1.280	
	S20U-SCLCR/L-4	55502	-	1.250	1.530	
S24U-SCLCR/L-4	55506	55507	1.500	1.780		


S-SDUC - Positive Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	DC_T Gage Insert	
	R.H.	L.H.				
	S06M-SDUCR/L-2	55560	55561	0.375	0.625	21.51
	S08M-SDUCR/L-2	55564	-	0.500	0.780	
	S10R-SDUCR/L-2	55568	55569	0.625	0.840	
	S12S-SDUCR/L-3	55572	55573	0.750	1.125	32.52
	S16T-SDUCR/L-3	55576	-	1.000	1.500	
	S20U-SDUCR/L-3	55580	55581	1.125	1.750	


MINI - Positive Boring Bars						
Description	UPC No. 733101-		Bar Size	Min. Bore	Gage Insert	
	R.H.	L.H.				
	S06H-SCLCR/L-2	55450	55451	0.375	0.394	CC_T
	S08K-SCLCR/L-2	55454	55455	0.500	0.550	
	S10M-SCLCR/L-2	55458	-	0.625	0.708	
	S06H-SDUCR/L-2	55540	-	0.375	0.492	DC_T
	S08K-SDUCR/L-2	55544	-	0.500	0.610	
	S10M-SDUCR/L-2	55548	-	0.625	0.768	
	S08H-STUCR-1.2-2	55724	-	0.500	0.286	TC_T
	S08H-STUCR-1.2-3	55726	-	0.500	0.313	
	S08H-STUCR-1.2-4	55728	-	0.500	0.374	
	S08H-SWUCR-1.2-2	55900	-	0.500	0.228	WC_T
	S08H-SWUCR-1.2-3	55902	-	0.500	0.308	
	S08H-SWUCR-1.2-4	55904	-	0.500	0.374	
	S06H-SWUCR-2	55906	-	0.375	0.394	WC_T
	S08K-SWUCR-2	55907	-	0.500	0.550	
	S10M-SWUCR-2	55908	-	0.625	0.708	




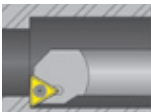
S-STUC - Positive Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	TC_T Gage Insert
	S06M-STUCR-2	55628	0.375	0.477	21.51
S08M-STUCR-2	55629	0.500	0.602		
S10R-STUCR-2	55630	0.625	0.797		
S12S-STUCR-3	55631	0.750	0.954	32.52	
S16T-STUCR-3	55632	1.000	1.280		

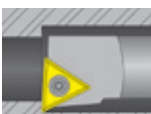
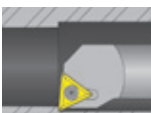
S-SVMC - Positive Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	VC_T Gage Insert
	S10S-SVMCR-2	55731	0.625	.0980	221
S12S-SVMCR-3	55732	0.750	1.000	332	
S16T-SVMCR-3	55733	1.000	1.300		

S-SVUC - Positive Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	VC_T Gage Insert
	S12S-SVUCR-2	55800	0.750	1.125	221
S16T-SVUCR-2	55804	1.000	1.300		
S16T-SVUCR-3	55808	1.000	1.375	332	
S20U-SVUCR-3	55812	1.250	1.750		

S-SVXC - Positive Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	VC_T Gage Insert
	S12S-SVXCR-2	55822	0.750	1.125	221
S16T-SVXCR-2	55826	1.000	1.500		
S20U-SVXCR-3	55834	1.250	2.250	332	

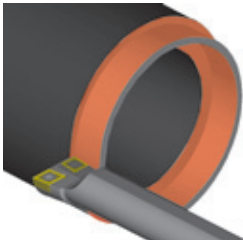
S-SCLP - Positive Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	CP_T Gage Insert
	S06M-SCLPR-2	55761	0.375	0.480	21.51
S08R-SCLPR-2	55763	0.500	0.600		
S10S-SCLPR-3	55767	0.625	0.770		
S12S-SCLPR-3	55769	0.750	0.930	32.52	
S16T-SCLPR-3	55771	1.000	1.200		

S-STFP - Positive Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	TPG_ Gage Insert
	S06M-STFPR-2	55636	0.375	0.470	21.51
S08M-STFPR-2	55640	0.500	0.600		
S10R-STFPR-2	55644	0.625	0.770		
S12S-STFPR-3	55648	0.750	0.930	322	

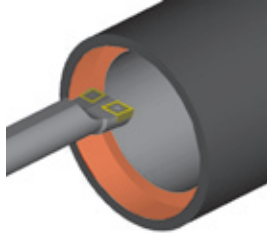
STCMB / TPBN - Positive Utility Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	Gage Insert
	STCMB06-2	55738	0.500	0.500	TC_T, 21.51
STCMB08-2	55740	0.500	0.590		
STCMB10-2	55742	0.625	0.750		
STCMB12-3	55744	0.750	0.845	TC_T, 32.52	
STCMB16-3	55746	1.000	1.115		
STCMB20-4	55748	1.250	1.370	TC_T, 432	
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	Gage Insert
	TPBN06-2	55658	0.500	0.430	TPG_, 21.51
TPBN08-2	55660	0.500	0.590		
TPBN10-2	55662	0.625	0.682		
TPBN12-3	55664	0.750	0.845	TPG_, 322	
TPBN16-3	55666	1.000	1.115		
TPBN20-3	55668	1.250	1.370	TPG_, 432	
TPBN20-4	55670	1.250	1.370		

## Double Insert Boring Bars One Tool For Turning, Boring & Facing

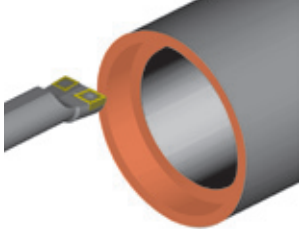
Turning

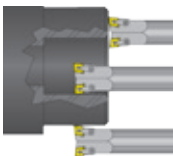


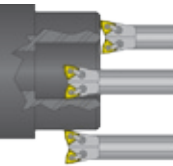
Boring

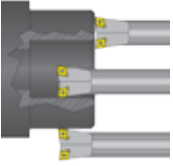


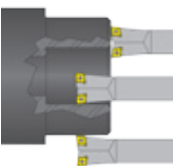
Facing



S-DCLN - Double Insert Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	CNM_ Gage Insert
	S16T-DCLN-4	57510	1.000	1.500	432
S20U-DCLN-4	57514	1.250	1.750		
S24U-DCLN-4	57518	1.500	2.000		
S24U-DCLN-5	57522	1.500	2.000	543	
S32V-DCLN-5	57526	2.000	2.625		

S-DWLN - Double Insert Boring Bars					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	WNM_ Gage Insert
	S12M-DWLN-3	57610	0.750	1.250	332
S16Q-DWLN-3	57614	1.000	1.500		
S16T-DWLN-4	57618	1.000	1.500	432	
S24U-DWLN-4	57626	1.500	2.000		

Mini S-DCLC - Double Insert Boring Bar					
	Description	UPC No. 733101- R.H.	Bar Size	Min. Bore	CC_T Gage Insert
	S08K-DCLC-2	57700	.500	0.688	21.51
S10L-DCLC-2	57704	.625	0.938		
S12M-DCLC-3	57708	.750	1.063	32.52	

Mini DCLC - Double Insert Boring Toolholder (Square Shank)					
	Description	UPC No. 733101- R.H.	Shank Size	Min. Bore	CC_T Gage Insert
	DCLC06-2A	57718	.375	0.813	21.51
DCLC08-2A	57722	.500	1.063		
DCLC10-3C	57726	.625	1.375		



## Deep Hole Boring Made Simple!

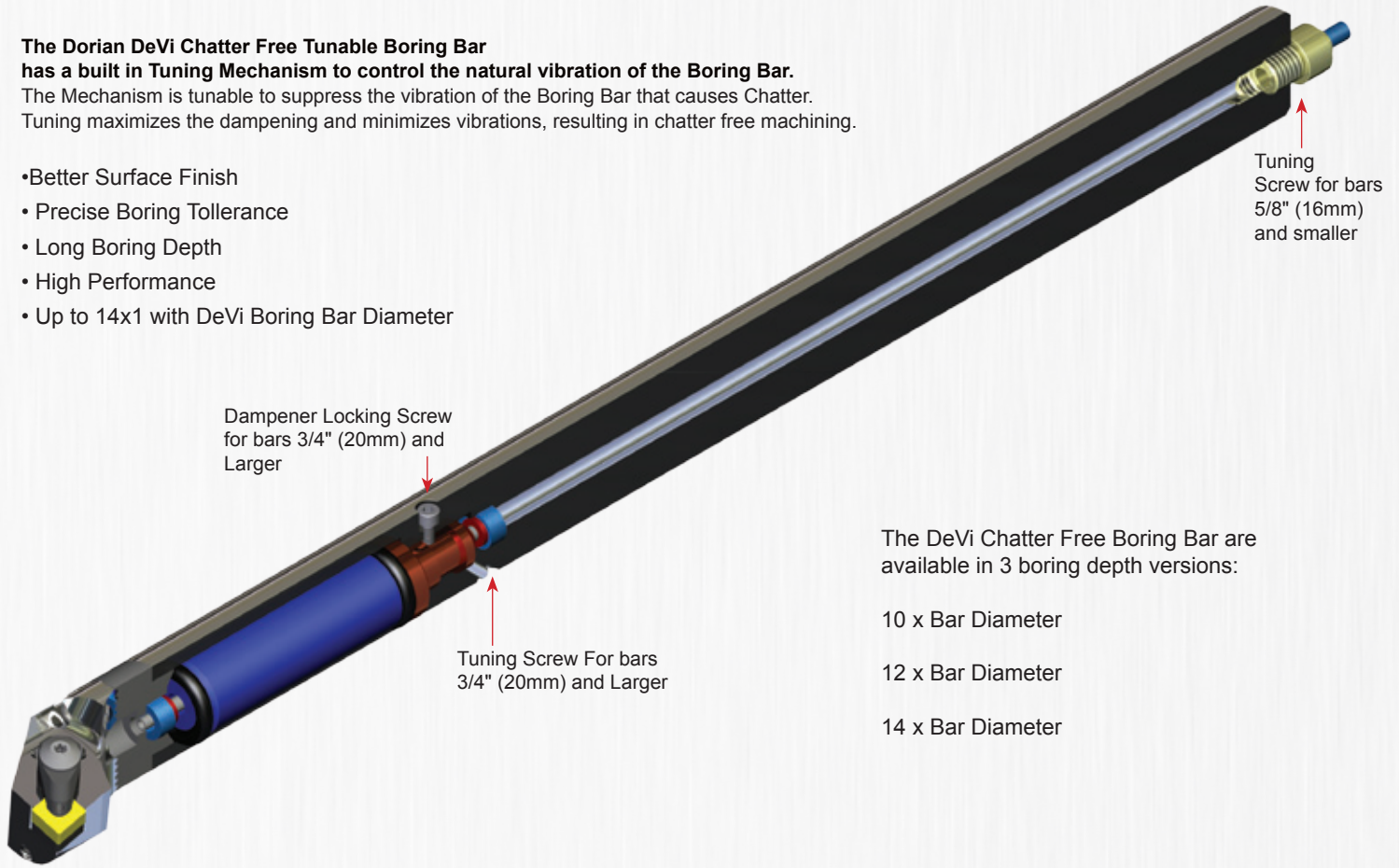
### The Dorian DeVi Chatter Free Tunable Boring Bar

has a built in Tuning Mechanism to control the natural vibration of the Boring Bar.

The Mechanism is tunable to suppress the vibration of the Boring Bar that causes Chatter.

Tuning maximizes the dampening and minimizes vibrations, resulting in chatter free machining.

- Better Surface Finish
- Precise Boring Tolerance
- Long Boring Depth
- High Performance
- Up to 14x1 with DeVi Boring Bar Diameter



The DeVi Chatter Free Boring Bar are available in 3 boring depth versions:

- 10 x Bar Diameter
- 12 x Bar Diameter
- 14 x Bar Diameter

### Re-Tuning the DeVi Chatter Free Boring Bar

The DeVi Chatter Free Boring Bars are 100% dynamically tuned, accelerometer tested and certified, to meet Dorian Tool Quality Control Standard, technical requirement and performance.

The DeVi Chatter Free Boring Bars can be re-tuned on the machine if not performing properly.

### To maximize bar rigidity and minimize vibration the Devi Bar has No Flats.

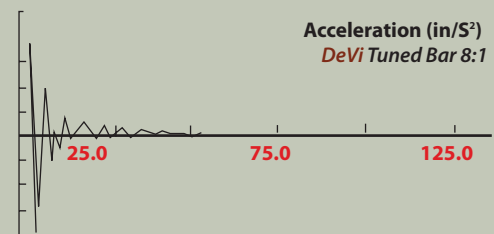
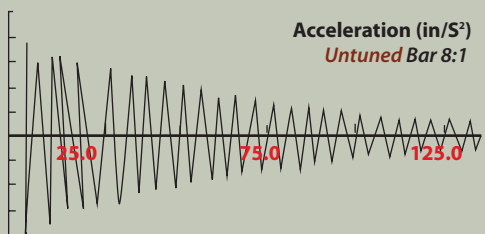
Round holding works best with a **Split Collar Style** boring bar holder.

**Set screw style** boring bar holders diminish the performance.

Best Performance obtained when clamping 4 x Diameter.

As shown below, by accelerometer testing, a standard carbide bar will vibrate at its natural frequency significantly longer than a "Tuned" DeVi bar.

**The increased damping allows for greater depth of cut without chatter and reduced vibration in interrupted cutting!**



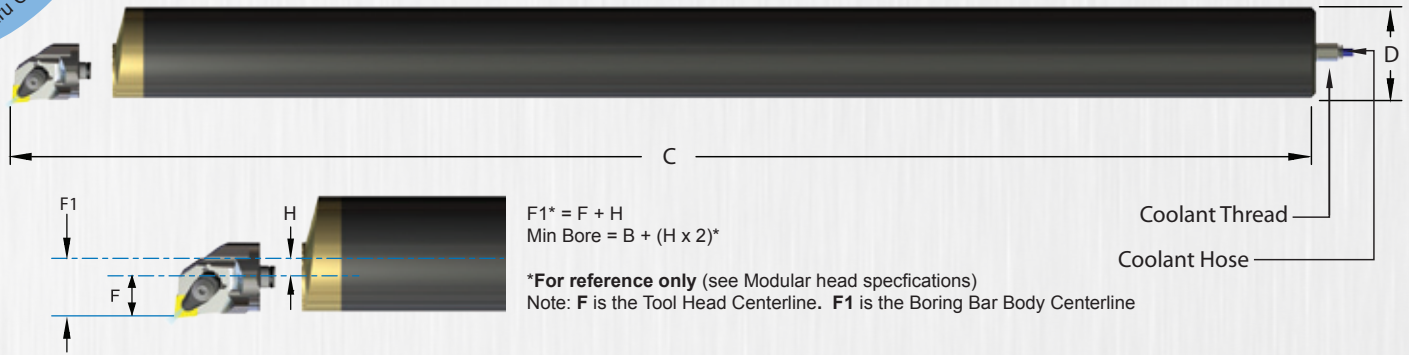


**NEW**

# DeVi Modular Chatter Free Tunable Boring Bar System

- Boring Ratio 10:1
- Modular Positive Insert Boring Heads
- Modular Threading Insert Heads
- Special Bars Built on Request
- Modular Negative Insert Boring Heads

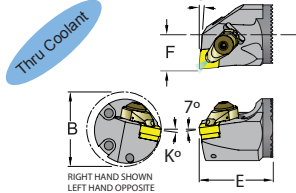
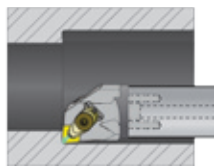
Thru Coolant



Boring Bar Description	Part No. 733101- R.H. & L.H.	Boring Ratio	D	C	Bore Depth	H	F1*	Min. Bore*	Modular Heads*	Coolant Hole	Coolant Thread
AS24X-10-DVI-MBBB-21	59433	10:1	1.500	21.00	15.00	0	F1* = F + H	B + (H x 2)	DBOMH24/40_ASR/L	.25	18-27 NPT
AS28X-10-DVI-MBBB-25	59434	10:1	1.750	24.50	17.50	.125			DBOMH24/40_ASR/L	.25	
AS32X-10-DVI-MBBB-28	59435	10:1	2.000	28.00	20.00	.250			DBOMH24/40_ASR/L	.3125	
AS40X-10-DVI-MBBB-35	59436	10:1	2.500	35.00	25.00	.500			DBOMH24/40_ASR/L	.375	1/4-18 NPT
AS48X-10-DVI-MBBB-42	59437	10:1	3.000	42.00	30.00	.750			DBOMH24/40_ASR/L	.375	
AS64X-10-DVI-MBBB-56	59438	10:1	4.000	56.00	40.00	1.25			DBOMH24/40_ASR/L	.375	

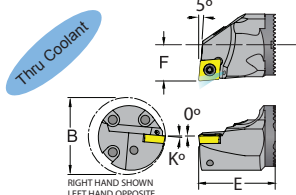
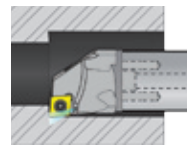
One high pressure coolant connection kit supplied, see Dorian's Deep Hole Boring Catalog for details. \*Modular heads sold separately.

## ADCLN R/L DeVi Modular CHATTER FREE Tunable Boring Bar Head Style L - Negative 5° End & Side Cutting Edge Angle for negative 80° diamond CN\_\_ inserts



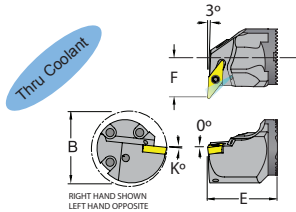
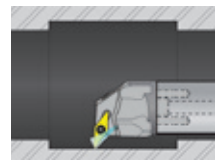
Head	Part No. 733101-		Head Specifications				Bars	Hardware Specifications		
Inch Description	R.H.	L.H.	B	E	F	K°	Dia.	CNMG Gage Insert	Seat	Seat Screw
DBOMH-24/40M-ADCLNR/L-4	59507	59508	1.780	1.875	0.900	11°	1.50 & Up	432	ICSN-433	SM-S4

## ASCLC R/L DeVi Modular CHATTER FREE Tunable Boring Bar Head - Style L - Negative 5° End & Side Cutting Edge Angle for 7° positive 80° diamond CC\_\_ inserts



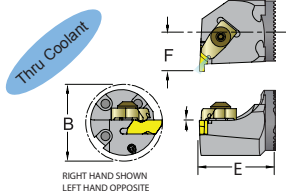
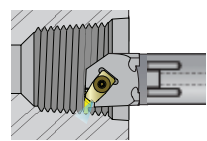
Head	Part No. 733101-		Head Specifications				Bars	Hardware Specifications		
Inch Description	R.H.	L.H.	B	E	F	K°	Dia.	CCGW Gage Insert	Insert Screw	Torx Screw
DBOMH-24/40M-ASCLCR/L-4	59529	59530	1.780	1.875	0.890	5°	1.50 & Up	432	TS-5.8-10M1	T-20

## ASVUC R/L DeVi Modular CHATTER FREE Tunable Boring Bar Head - Style U - Negative 3° End Cutting Edge Angle for 7° positive 35° diamond VC\_\_ inserts



Head	Part No. 733101-		Head Specifications				Bars	Hardware Specifications		
Inch Description	R.H.	L.H.	B	E	F	K°	Dia.	VCGW Gage Insert	Insert Screw	Torx Screw
DBOMH-24/40M-ASVUCR/L-3	59545	59546	2.500	1.875	1.312	6°	1.50 & Up	332 160408	TS-35.6-9M1	T-15

## ADNE R/L DeVi Modular CHATTER FREE Tunable DorNotch Threading Bar Head - Style E - Internal DorNotch Boring Bar for threading and grooving DorNotch inserts



Head	Part No. 733101-		Head Specifications				Bars	Hardware Specifications		
Inch Description	R.H.	L.H.	B	E	F	Dia.	DorNotch Gage Insert	Dor-Lock Clamp	Clamp Screw	
DBOMH-24/40M-ADNER/L-3	59557	59558	2.000	1.875	1.000	1.50 & Up	NG-3L* NG-3R**	JSLC-HP73* JSLC-HP72**	JSCS-04	

\*For right hand tool. \*\*For left hand tool.

Note: Smaller size DeVi Deep Hole Boring Bars are available as either Solid (one-piece) or with Quick Change heads. See our NEW DeVi Deep Hole Boring Catalog for additional Modular Heads.

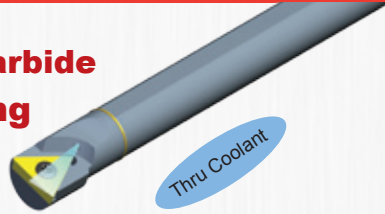
**CALL FOR SPECIALS.**



# Solid Carbide Boring & Threading Bar System



## New Dorian Solid Carbide Deep Hole Boring Technology!



- 5/32" to 5/8" shanks
- 6:1 Boring Ratio
- Made in USA
- 8:1 Boring Ratio can be achieved under favorable conditions.

### Solid Carbide Body

Made of precision ground Carbide. Engineered for deep boring bar applications to maximize rigidity and dampen vibrations.

### Alloy Steel Head-Hardened to 40-44HRC

The insert head is made of heat treated Alloy Steel with a thru coolant system to improve chip evacuation in deep boring.

### Also available with Quick Change Heads

For multi-application versatility.

### Brazing

The insert head and carbide bar are brazed. The right combination of silver braze and thickness makes the brazing strong and unbreakable but flexible to an interrupted cut.

### Threaded End

All the boring bars are supplied with a thru coolant hole. Bars over 1/2" and 12mm are threaded for easy coolant connection.

### E\_SCLD CARBIDE Solid Boring Bars - Style L - Negative 5° End & Side Cutting Edge Angle for 15° positive 80°diamond CD\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	CDGB Insert
E02.5H-SCLDR-1.2	59575	6:1	0.175	4.00	0.156	1.20.60.2
E03.0H-SCLDR-1.2	59579	6:1	0.205	4.00	0.187	
E03.5H-SCLDR-1.2	59583	6:1	0.245	4.00	0.218	
E04H-SCLDR-1.5	59587	6:1	0.270	4.00	0.250	1.510.5
E05K-SCLDR-1.5	59591	6:1	0.335	5.00	0.312	

### E\_SCLC Thru Coolant CARBIDE Solid Boring Bars - Style L - Negative 5° End & Side Cutting Edge Angle for 7° positive 80°diamond CC\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	CDGW Insert
E06M-SCLCR-2	59595	6:1	0.396	6.00	0.375	21.51
E08K-SCLCR-2	59599	6:1	0.550	5.00	0.500	
E08R-SCLCR-2	59603	6:1	0.550	8.00	0.500	
E10M-SCLCR-2	59607	6:1	0.740	6.00	0.625	
E10S-SCLCR-2	59611	6:1	0.740	10.00	0.625	
E08K-SCLCR-3	59615	6:1	0.550	5.00	0.500	32.52
E08R-SCLCR-3	59619	6:1	0.550	8.00	0.500	
E10M-SCLCR-3	59623	6:1	0.740	6.00	0.625	
E10S-SCLCR-3	59627	6:1	0.740	10.00	0.625	

### E\_SCLP Thru Coolant CARBIDE Solid Boring Bars - Style L - Negative 5° End & Side Cutting Edge Angle for 11° positive 80°diamond CP\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	CPGW Insert
E05K-SCLPR-1.8	59631	6:1	0.335	5.00	0.312	1.81.20.5
E06M-SCLPR-2	59635	6:1	0.396	6.00	0.375	21.51
E08K-SCLPR-2	59639	6:1	0.550	5.00	0.500	
E08R-SCLPR-2	59643	6:1	0.550	8.00	0.500	
E10M-SCLPR-2	59647	6:1	0.740	6.00	0.625	
E10S-SCLPR-2	59651	6:1	0.740	10.00	0.625	
E08K-SCLPR-3	59655	6:1	0.550	5.00	0.500	32.52
E08R-SCLPR-3	59659	6:1	0.550	8.00	0.500	
E10M-SCLPR-3	59663	6:1	0.740	6.00	0.625	
E10S-SCLPR-3	59667	6:1	0.740	10.00	0.625	

### E\_SDQC Thru Coolant CARBIDE Solid Boring Bars - Style N - Negative 17.5° End Cutting Edge Angle for 7° positive 55° diamond DC\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	DCMT Insert
E06M-SDQCR-2	59691	6:1	0.487	6.00	0.375	21.51
E08K-SDQCR-2	59695	6:1	0.650	5.00	0.500	
E08R-SDQCR-2	59699	6:1	0.650	8.00	0.500	
E10M-SDQCR-2	59703	6:1	0.781	6.00	0.625	
E10S-SDQCR-2	59707	6:1	0.781	10.00	0.625	

### E\_SDXC Thru Coolant CARBIDE Solid Boring Bars - Style X - Negative 5° Back Boring Cutting Edge Angle for 7° positive 55° diamond DC\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	DCMT Insert
E06M-SDXCR-2	59731	6:1	0.581	5.66	0.375	21.51
E08K-SDXCR-2	59735	6:1	0.712	4.66	0.500	
E08R-SDXCR-2	59739	6:1	0.712	7.66	0.500	
E10M-SDXCR-2	59743	6:1	0.844	5.66	0.625	
E10S-SDXCR-2	59747	6:1	0.844	9.66	0.625	

### E\_NE Thru Coolant CARBIDE Solid Threading & Grooving Bar - Style E - Internal DorNotch Bar for threading and grooving DorNotch inserts

Description	733101-R.H.	Boring Ratio*	Min.Bore	OAL	Dia.	Dor-Notch Insert
E08K-NER-2	59951	6:1	0.830	5.12	0.500	*NG-2L
E08R-NER-2	59955	6:1	0.830	8.12	0.500	**NG-2R
E10M-NER-2	59959	6:1	1.000	6.00	0.625	*NG-2L
E10S-NER-2	59963	6:1	1.000	10.00	0.625	**NG-2R

\*For right hand tool. \*\* For left hand tool

### E\_SN CARBIDE Solid Threading Bar - Internal Small Shank Laydown Bar for Laydown Inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	Laydown Insert
E03.5H-SNR-06	59919	6:1	0.249	4.00	0.218	06-A60
E04H-SNR-06	59923	6:1	0.307	4.00	0.250	
E05K-SNR-08	59927	6:1	0.378	5.00	0.312	
E06M-SNR-H11	59931	6:1	0.500	6.00	0.375	11-A60
E08K-SNR-H11	59935	6:1	0.590	5.00	0.500	
E08R-SNR-H11	59939	6:1	0.590	8.00	0.500	
E10M-SNR-H16	59943	6:1	0.750	6.00	0.625	16-A60
E10S-SNR-H16	59947	6:1	0.750	10.00	0.625	

### E\_STUC CARBIDE Solid Boring Bars - Style U - Negative 3° End Cutting Edge Angle for 7° positive triangle TC\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	TCMT Insert
E04H-STUCR-1.2	59751	6:1	0.281	4.00	0.250	1.21.20.2
E05K-STUCR-1.2	59755	6:1	0.339	5.00	0.312	
E06M-STUCR-1.2	59759	6:1	0.409	6.00	0.375	
E06M-STUCR-2	59763	6:1	0.456	6.00	0.375	21.51
E08K-STUCR-2	59767	6:1	0.587	5.00	0.500	
E08R-STUCR-2	59771	6:1	0.587	8.00	0.500	
E10M-STUCR-2	59775	6:1	0.750	6.00	0.625	
E10S-STUCR-2	59779	6:1	0.750	10.00	0.625	

### E\_STUP CARBIDE Solid Boring Bars - Style U - Negative 3° End Cutting Edge Angle for 11° positive triangle TP\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	TPMT Insert
E06M-STUPR-2	59783	6:1	0.456	6.00	0.375	21.51
E08K-STUPR-2	59787	6:1	0.587	5.00	0.500	
E08R-STUPR-2	59791	6:1	0.587	8.00	0.500	
E10M-STUPR-2	59795	6:1	0.750	6.00	0.625	
E10S-STUPR-2	59799	6:1	0.750	10.00	0.625	

### E\_SVQC CARBIDE Solid Boring Bars - Style Q - Negative 17.5° End Cutting Edge Angle for 7° positive 35° diamond VC\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	VCMT Insert
E10M-SVQCR-2	59819	6:1	0.844	6.00	0.625	221
E10S-SVQCR-2	59823	6:1	0.844	10.00	0.625	

### E\_SVUC CARBIDE Solid Boring Bars - Style U - Negative 3° End Cutting Edge Angle for 7° positive 35° diamond VC\_\_ inserts

Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	VCMT Insert
E10M-SVUCR-2	59827	6:1	0.844	6.00	0.625	221
E10S-SVUCR-2	59831	6:1	0.844	10.00	0.625	

### E\_SVXC CARBIDE Solid Boring Bars - Style X - Negative 5° Back Boring Cutting Edge Angle for 7° positive 35° diamond VC\_\_ inserts

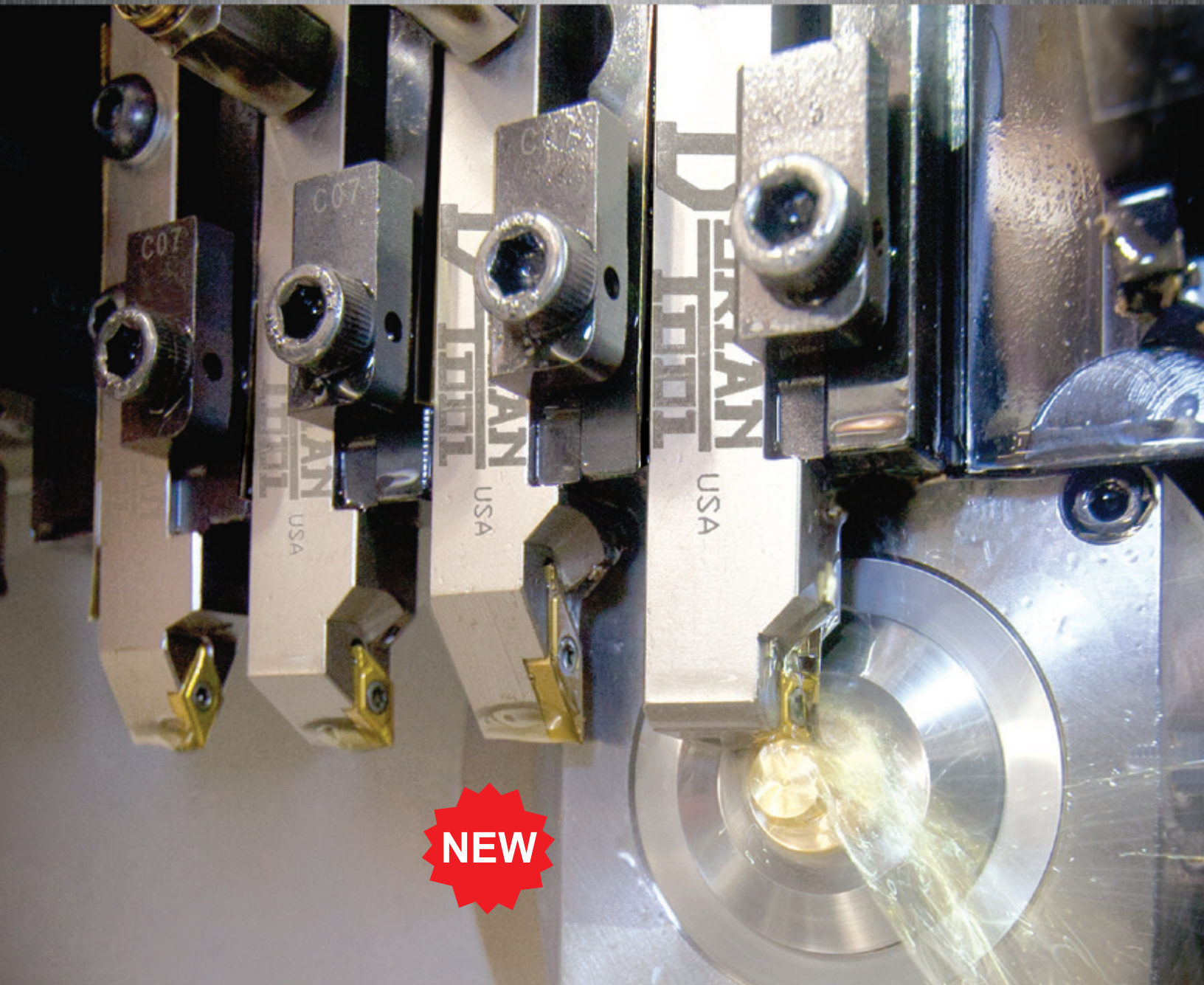
Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	VCMT Insert
E10M-SVXCR-2	59835	6:1	1.0	5.76	0.625	221
E10S-SVXCR-2	59839	6:1	1.0	9.76	0.625	

### E\_SVUP CARBIDE Solid Boring Bars - Style U - Negative 3° End Cutting Edge Angle for 11° positive 35° diamond VP\_\_ inserts

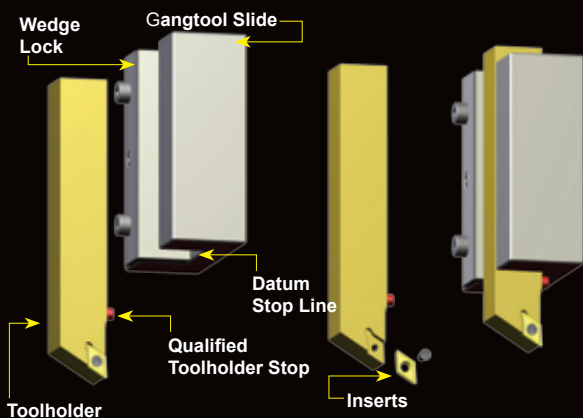
Description	733101-R.H.	Boring Ratio	Min.Bore	OAL	Dia.	VPMT Insert
E10M-SVUPR-2	59851	6:1	0.844	6.00	0.625	221
E10S-SVUPR-2	59855	6:1	0.844	10.00	0.625	



# SWISS SCREW MACHINE TOOLS AND ADVANCED TECHNOLOGY

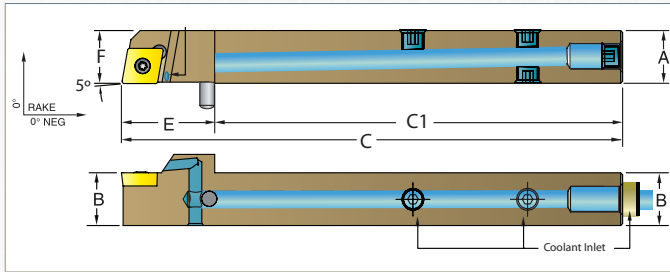


**NEW**



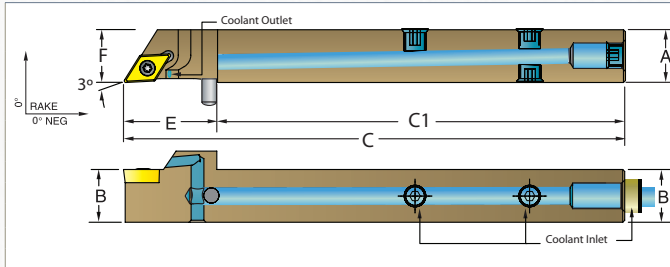
## Featuring

- Zero Tolerance with a Qualified Toolholder Stop
- Simple & Easy Insert Change
- Custom Dorian Gangtool



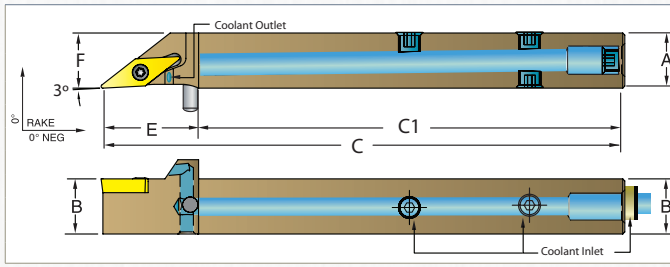
**ASCNC Jet-Stream™ Thru Coolant R/L Toolholder Style N -**  
Negative 5° End or Side Cutting Edge Angle for 7° positive 80° diamond CC\_W inserts

Metric Description	R.H.	L.H.	A	B	C	C1	E (Tool Stop)	F	Insert
ASCNCR/L 1010-H06	60770	60771	10	10	100	75	25	10	CCGW-060204
ASCNCR/L 1212-H06	60772	60773	12	12	100	75	25	12	CCGW-060204
ASCNCR/L 1616-H06	60774	60775	16	16	100	75	25	16	CCGW-060204
ASCNCR/L 1212-H09	60776	60777	12	12	100	75	25	12	CCGW-09T308
ASCNCR/L 1616-H09	60778	60779	16	16	100	75	25	16	CCGW-09T308
ASCNCR/L 2020-K09	60780	60781	20	20	125	100	25	20	CCGW-09T308
<b>Inch Description</b>									
ASCNCR/L 08-2A	60698	60699	0.500	0.500	4.000	3.00	1.000	0.500	CCGW-21.51
ASCNCR/L 08-3A	60701	60702	0.500	0.500	4.000	3.00	1.000	0.500	CCGW-32.52



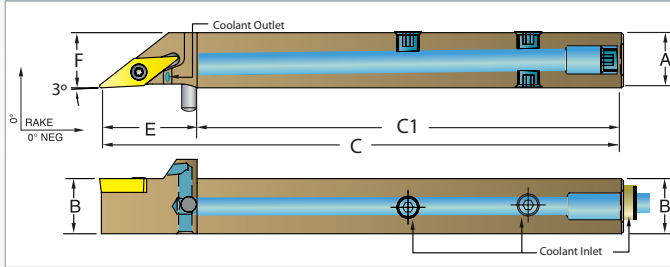
**ASDNC Jet-Stream™ Thru Coolant R/L Toolholder Style N -**  
3° Side Cutting Edge Angle for 7° positive 55° diamond DC\_W inserts

Metric Description	R.H.	L.H.	A	B	C	C1	E (Tool Stop)	F	Insert
ASDNCR/L 1010-H07	60810	60811	10	10	100	75	25	10	DCGW-070204
ASDNCR/L 1212-H07	60812	60813	12	12	100	75	25	12	DCGW-070204
ASDNCR/L 1616-H07	60814	60815	16	16	100	75	25	16	DCGW-070204
ASDNCR/L 1212-H11	60816	60817	12	12	100	75	25	12	DCGW-11T308
ASDNCR/L 1616-H11	60818	60819	16	16	100	75	25	16	DCGW-11T308
ASDNCR/L 2020-K11	60820	60821	20	20	125	100	25	20	DCGW-11T308
<b>Inch Description</b>									
ASDNCR/L 08-2A	60708	60709	0.500	0.500	4.000	3.00	1.000	0.500	DCGW-21.51
ASDNCR/L 08-3A	60711	60712	0.500	0.500	4.000	3.00	1.000	0.500	DCGW-32.52



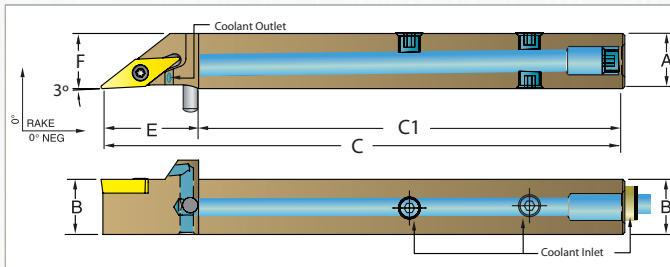
**ASVNB Jet-Stream™ Thru Coolant R/L Toolholder Style N -**  
3° Side Cutting Edge Angle for 5° positive 35° diamond VB\_W inserts

Metric Description	R.H.	L.H.	A	B	C	C1	E (Tool Stop)	F	Insert
ASVNBRL 1010-H11	60882	60883	10	10	100	75	25	10	VBGW-110304
ASVNBRL 1212-H11	60884	60885	12	12	100	75	25	12	VBGW-110304
ASVNBRL 1212-K16	60886	60887	12	12	107	75	32	12	VBGW-160408
ASVNBRL 1616-K16	60888	60889	16	16	107	75	32	16	VBGW-160408
ASVNBRL 2020-K16	60890	60891	20	20	132	100	32	20	VBGW-160408
<b>Inch Description</b>									
ASVNBRL 08-2A	60727	60728	0.500	0.500	4.000	3.00	1.000	0.500	VBGW-221
ASVNBRL 08-3A	60729	60730	0.500	0.500	4.000	3.00	1.000	0.500	VBGW-332



**ASVNC Jet-Stream™ Thru Coolant R/L Toolholder Style N -**  
3° Side Cutting Edge Angle for 7° positive 35° diamond VC\_W inserts

Metric Description	R.H.	L.H.	A	B	C	C1	E (Tool Stop)	F	Insert
ASVNCRL 1010-H11	60914	60915	10	10	100	75	25	10	VCGW-110304
ASVNCRL 1212-H11	60916	60917	12	12	100	75	25	12	VCGW-110304
ASVNCRL 1616-H11	60918	60919	16	16	100	75	25	16	VCGW-110304
ASVNCRL 1212-K16	60920	60921	12	12	107	75	32	12	VCGW-160408
ASVNCRL 1616-K16	60922	60923	16	16	107	75	32	16	VCGW-160408
ASVNCRL 2020-K16	60924	60925	20	20	132	100	32	20	VCGW-160408
<b>Inch Description</b>									
ASVNCRL 08-2A	60738	60739	0.500	0.500	4.000	3.00	1.000	0.500	VCGW-221
ASVNCRL 08-3A	60741	60742	0.500	0.500	4.000	3.00	1.000	0.500	VCGW-332

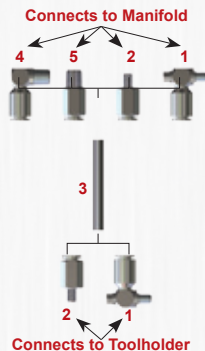


**ASVNP Jet-Stream™ Thru Coolant R/L Toolholder Style N -**  
3° Side Cutting Edge Angle for 11° positive 35° diamond VP\_W inserts

Metric Description	R.H.	L.H.	A	B	C	C1	E (Tool Stop)	F	Insert
ASVNPRL 1010-H11	60948	60649	10	10	100	75	25	10	VPGW-110304
ASVNPRL 1212-H11	60950	60951	12	12	100	75	25	12	VPGW-110304
ASVNPRL 1212-K16	60952	60953	12	12	107	75	32	12	VPGW-160408
ASVNPRL 1616-K16	60954	60955	16	16	107	75	32	16	VPGW-160408
ASVNPRL 2020-K16	60956	60957	20	20	132	100	32	20	VPGW-160408
<b>Inch Description</b>									
ASVNPRL 08-2A	60745	60746	0.500	0.500	4.000	3.00	1.000	0.500	VPGW-221
ASVNPRL 08-3A	60747	60748	0.500	0.500	4.000	3.00	1.000	0.500	VPGW-332

## High Pressure Coolant Connection System

- High pressure Quick Release Connector
- Metric and Inch Thread Connectors
- High Pressure Tubing



**6 mm High Pressure Coolant Connection Kit**

Item	UPC No. 733101-	QTY.	Part Number	Description	Size	Working Pressure	
						Bar	PSI
Kit	60480	1	6MM-HPCK	High Pressure Coolant Quick Release Connector	6mm	200	2800
<b>The High Pressure Coolant Connection Kit Consist of:</b>							
1	60486	2	DT-HP90C-6x6	90° Elbow High Pressure Banjo Quick Release Connector	6mm Thread, 6 mm Tubing	200	2800
2	60487	2	DT-HP0SC-6x6	Straight High Pressure Quick Release Connector	6mm Thread, 6 mm Tubing	200	2800
3	60488	1	DT-HPTU-6x3	6x3mm High Pressure Polyamide Tubing (300mm) 12" Long	6OD x 3ID x 30 mm Long	200	2800
4	60489	1	DT-HP90C-1/8x6	90° Elbow High Pressure Quick Release Connector	18"NPT Thread, 6 mm Tubing	200	2800
5	60490	1	DT-HP0SC-1/8x6	Straight High Pressure Quick Release Connector	18"NPT Thread, 6 mm Tubing	200	2800





**NEW**

# External Turning, Grooving & Cut-off Toolholders for Swiss Screw Machines

## Choose from 3 Depths of Cut

**SHORT** : Grooving Max 0.472 " to 0.709"

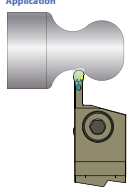
**MEDIUM** : Grooving Max 0.945" to 1.102

**LONG** : Grooving Max 1.417" to 1.575"

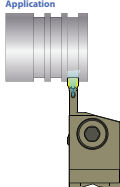
**For Five Different Applications!**  
for Swiss Screw Machines



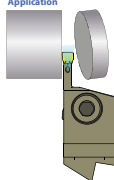
**Profiling**  
Application



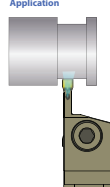
**Grooving**  
Application



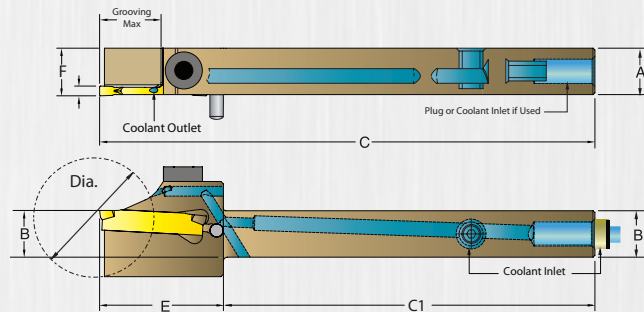
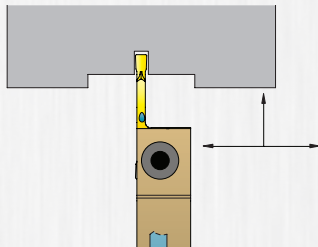
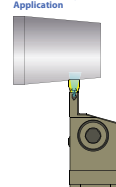
**Part-off**  
Application



**Turning & Grooving**  
Application



**Turning**  
Application



### Jet-Stream™ Thru Coolant External Turning, Grooving & Cut-off Toolholders for Swiss Screw Machines

#### SHORT Depth of Cut : Grooving Max 0.472 " to 0.709"

Metric Description	Part No. 733101-		Insert Size	A	B	E (Tool Stop)	C	C1	F	Grooving Max	Dia. Max.	Insert	Lock Screw	Hex Key
	Right Hand	Left Hand												
ADDN-TFR/L-1010-H20-06	61000	61001	2/2.5 mm	10	10	32	107	75	10	6	12	DN_-22_N-20	CS-M0416	AHK-3M
ADDN-TFR/L-1212-H20-06	61002	61003	2/2.5 mm	12	12	32	107	75	12	6	12	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-1212-H30-09	61008	61009	3 mm	12	12	32	107	75	12	9	18	DN_-22_N-30-	CS-M0520	AHK-4M
ADDN-TFR/L-1616-H20-06	61004	61005	2/2.5 mm	16	16	32	107	75	16	6	12	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-1616-H30-09	61006	61007	3 mm	16	16	32	107	75	16	9	18	DN_-22_N-30-	CS-M0520	AHK-4M

#### Inch Description

ADDN-TFR/L08-20A-06	61040	61041	.079/0.098 inch	0.500	0.500	1.25	4.25	3.00	0.5	0.236	0.472	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-08-30A-09	61042	61043	0.118 inch	0.500	0.500	1.25	4.25	3.00	0.5	0.354	0.709	DN_-22_N-30-	CS-M0520	AHK-4M

#### MEDIUM Depth of Cut : Grooving Max 0.945" to 1.102"

Metric Description	Part No. 733101-		Insert Size	A	B	E (Tool Stop)	C	C1	F	Grooving Max	Dia. Max.	Insert	Lock Screw	Hex Key
	Right Hand	Left Hand												
ADDN-TFR/L-1010-H20-12	61010	61011	2/2.5 mm	10	10	32	107	75	10	12	24	DN_-22_N-20	CS-M0416	AHK-3M
ADDN-TFR/L-1212-H20-12	61012	61013	2/2.5 mm	12	12	32	107	75	12	12	24	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-1212-H30-14	61018	61019	3 mm	12	12	32	107	75	12	14	28	DN_-22_N-30-	CS-M0520	AHK-4M
ADDN-TFR/L-1616-H20-12	61014	61015	2/2.5 mm	16	16	32	107	75	16	12	24	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-1616-H30-14	61016	61017	3 mm	16	16	32	107	75	16	14	28	DN_-22_N-30-	CS-M0520	AHK-4M

#### Inch Description

ADDN-TFR/L-08-20A-12	61044	61045	.079/0.098 inch	0.500	0.500	1.25	4.25	3.00	0.5	0.472	0.945	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-08-30A-14	61046	61047	0.118 inch	0.500	0.500	1.25	4.25	3.00	0.5	0.551	1.102	DN_-22_N-30-	CS-M0520	AHK-4M

#### LONG Depth of Cut : Grooving Max 1.417" to 1.575"

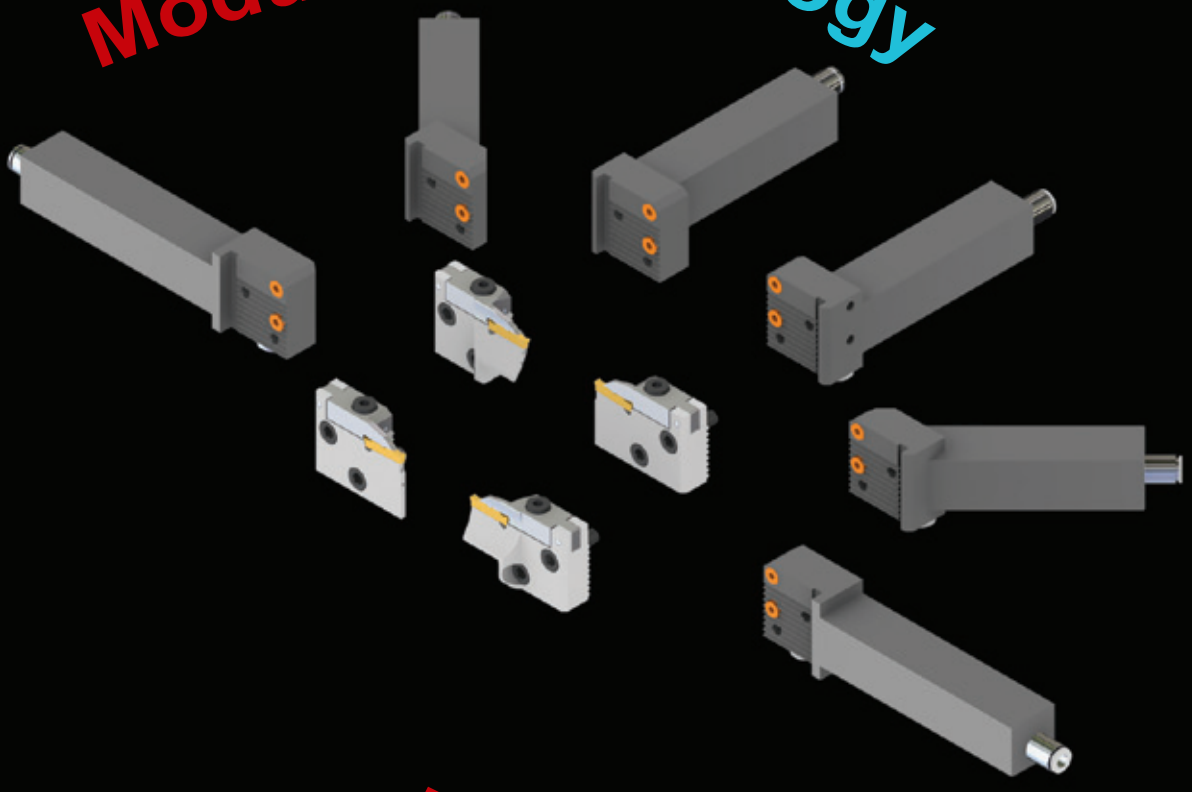
Metric Description	Part No. 733101-		Insert Size	A	B	E (Tool Stop)	C	C1	F	Grooving Max	Dia. Max.	Insert	Lock Screw	Hex Key
	Right Hand	Left Hand												
ADDN-TFR/L-1010-H20-18	61020	61021	2/2.5 mm	10	10	32	107	75	10	18	36	DN_-22_N-20	CS-M0416	AHK-3M
ADDN-TFR/L-1212-H20-18	61022	61023	2/2.5 mm	12	12	32	107	75	12	18	36	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-1616-H20-18	61024	61025	2/2.5 mm	16	16	32	107	75	16	18	36	DN_-22_N-20	CS-M0520	AHK-4M
ADDN-TFR/L-1616-H30-20	61026	61027	3 mm	16	16	32	107	75	16	20	40	DN_-22_N-30-	CS-M0520	AHK-4M

#### Inch Description

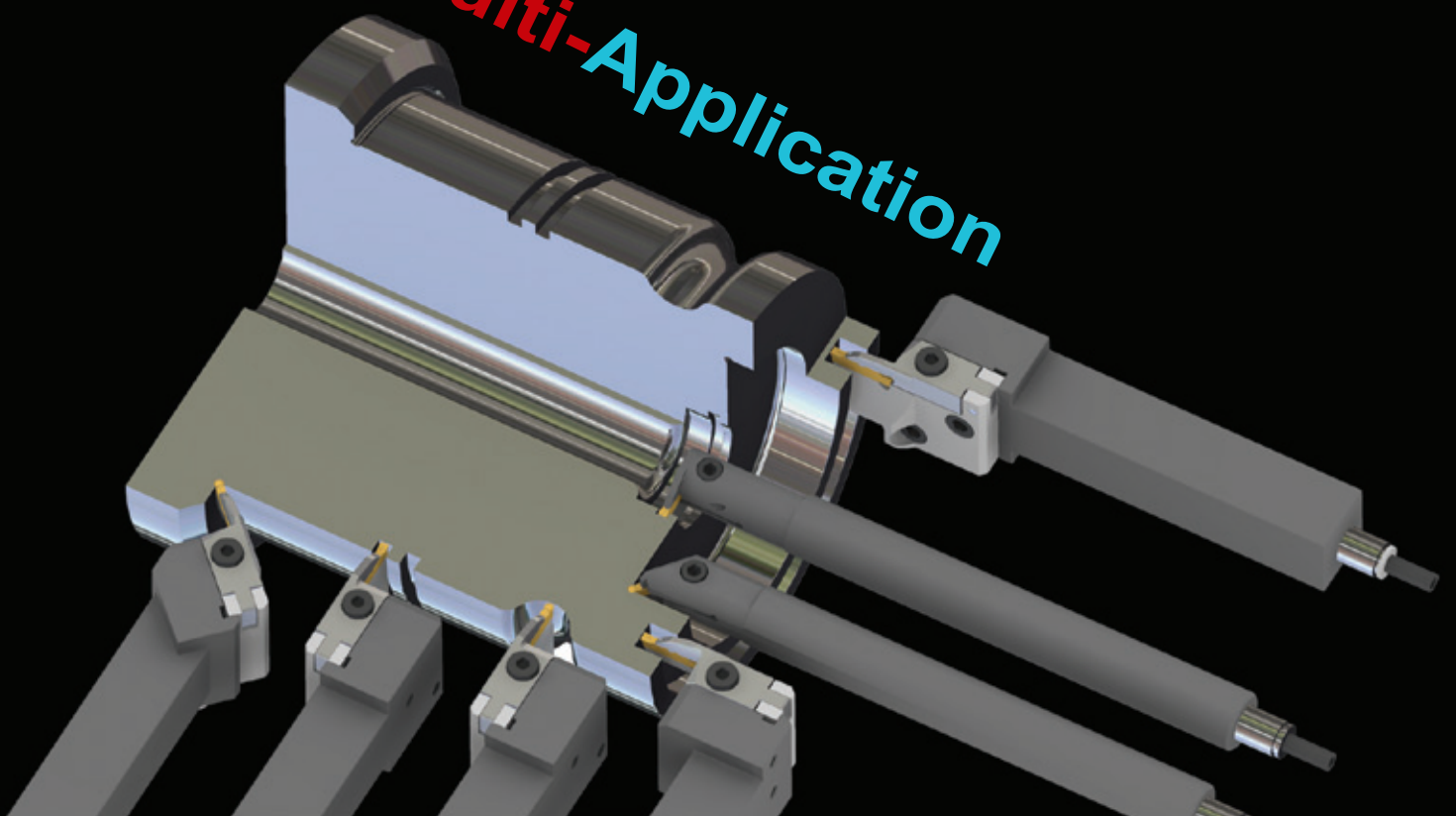
ADDN-TFR/L-08-20A-18	61048	61049	.079/0.098 inch	0.500	0.500	1.25	4.25	3.00	0.5	0.709	1.417	DN_-22_N-20	CS-M0520	AHK-4M
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# DORIAN **INNOVATION** AT ITS **BEST** IMPROVING THE WAY **METAL** IS CUT!

## **Modular** Technology



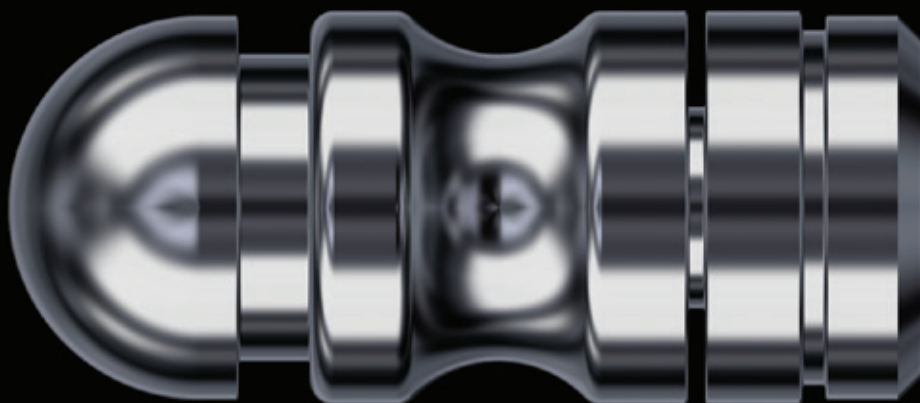
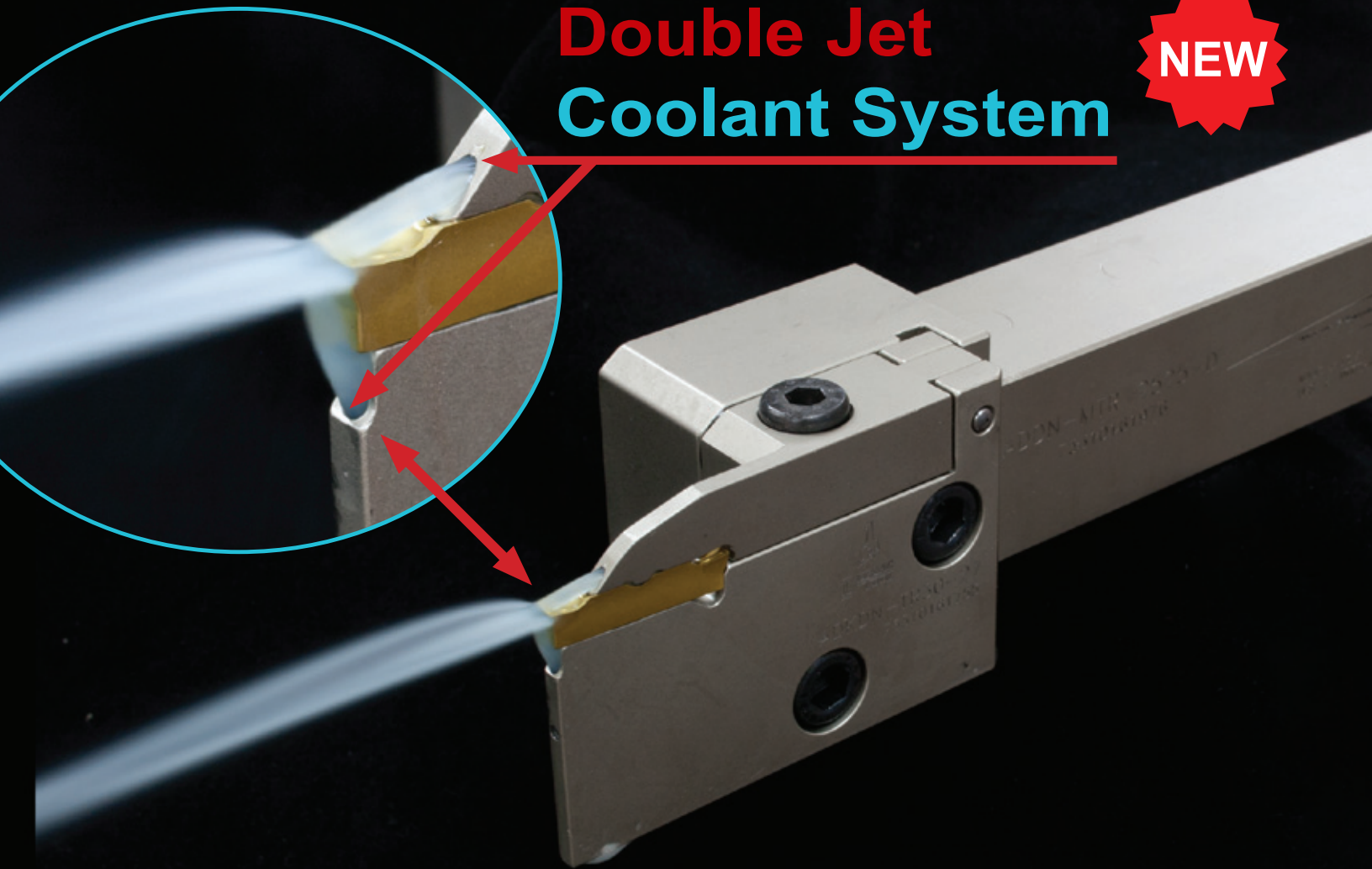
## **Multi-Application**

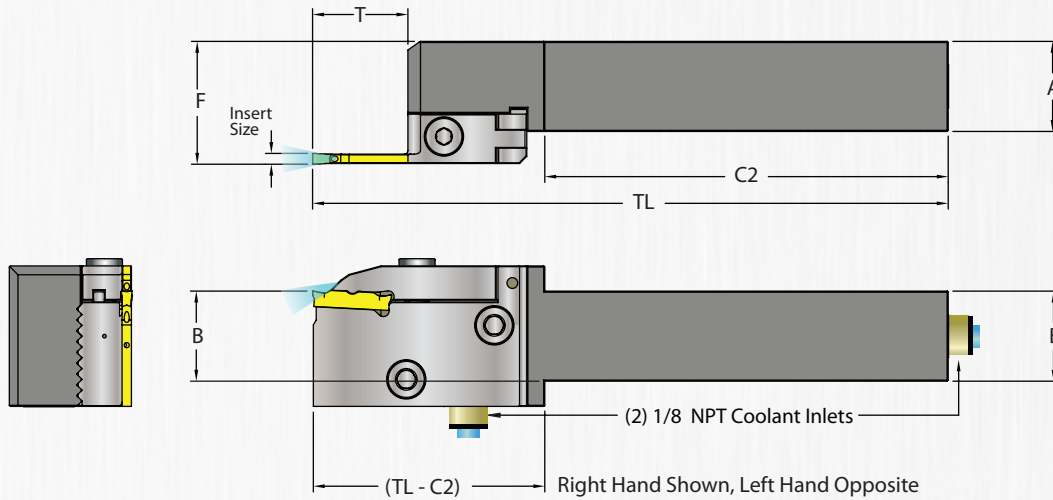


# DORIAN **KOOL CUT** MODULAR TURNING, FACING & GROOVING

**Double Jet  
Coolant System**

**NEW**





.079" (2mm) Insert			Jet-Stream™ Kool Cut Modular Turning and Grooving Toolholder											
Description	UPC No. 733101-		A	B	C2	F	TL	T	Insert		Clamp Screw	Cartridge Screw	Hex Key	Seal
	Right Hand	Left Hand							Size	Style				
ADDN-MTR/L-12-C20-06	61516	61570	0.75	0.75	3.5	1.189	5.232	0.236	0.079	DNTF-222002	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-12-C20-12	61517	61571					5.469	0.472						
ADDN-MTR/L-12-C20-18	61518	61572					5.705	0.709						
ADDN-MTR/L-16-D20-06	61519	61573	1.00	1.00	4.0	1.386	5.732	0.236	0.079	DNTF-222002	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-16-D20-12	61520	61574					5.969	0.472						
ADDN-MTR/L-16-D20-18	61521	61575					6.205	0.709						
ADDN-MTR/L-20-E20-06	61522	61576	1.25	1.25	4.5	1.661	6.232	0.236	0.079	DNTF-222002	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-20-E20-12	61523	61577					6.469	0.472						
ADDN-MTR/L-20-E20-18	61524	61578					6.705	0.709						

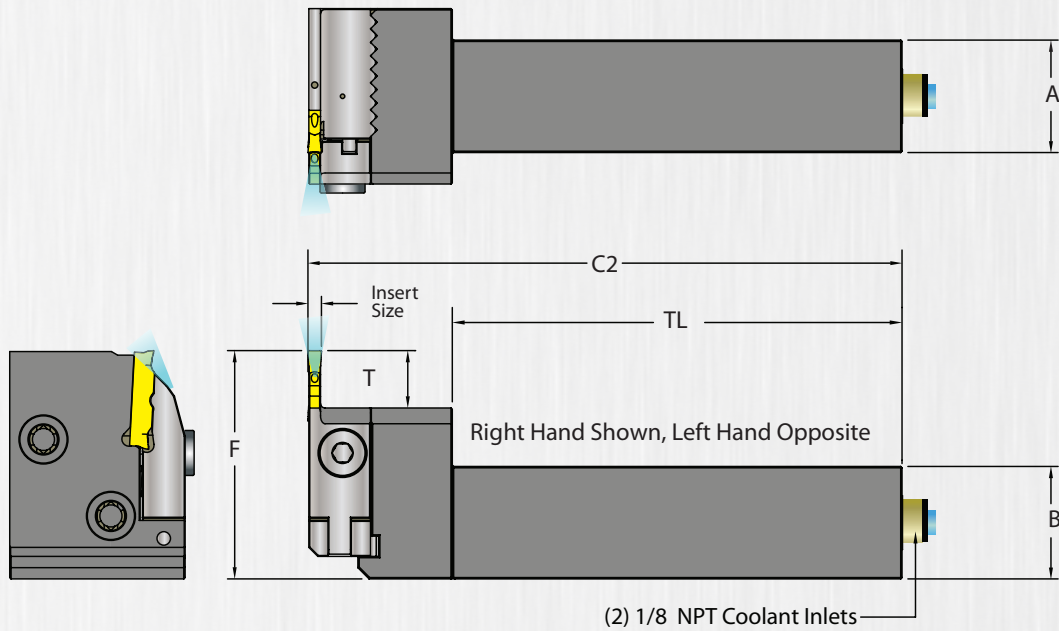
.118" (3mm) Insert			Jet-Stream™ Kool Cut Modular Turning and Grooving Toolholder											
Description	UPC No. 733101-		A	B	C2	F	TL	T	Insert		Clamp Screw	Cartridge Screw	Hex Key	Seal
	Right Hand	Left Hand							Size	Style				
ADDN-MTR/L-12-C30-09	61525	61579	0.75	0.75	3.5	1.193	5.354	0.354	0.118	DNTF-223003	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-12-C30-18	61526	61580					5.709	0.709						
ADDN-MTR/L-12-C30-27	61527	61581					6.063	1.063						
ADDN-MTR/L-16-D30-09	61528	61582	1.00	1.00	4.0	1.390	5.854	0.354	0.118	DNTF-223003	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-16-D30-18	61529	61583					6.209	0.709						
ADDN-MTR/L-16-D30-27	61530	61584					6.563	1.063						
ADDN-MTR/L-20-E30-09	61531	61585	1.25	1.25	4.5	1.665	6.354	0.354	0.118	DNTF-223003	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-20-E30-18	61532	61586					6.709	0.709						
ADDN-MTR/L-20-E30-27	61533	61587					7.063	1.063						

.157" (4mm) Insert			Jet-Stream™ Kool Cut Modular Turning and Grooving Toolholder											
Description	UPC No. 733101-		A	B	C2	F	TL	T	Insert		Clamp Screw	Cartridge Screw	Hex Key	Seal
	Right Hand	Left Hand							Size	Style				
ADDN-MTR/L-12-C40-12	61534	61588	0.75	0.75	3.5	1.197	5.472	0.472	0.157	DNTF-254004	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-12-C40-18	61535	61589					5.709	0.709						
ADDN-MTR/L-12-C40-24	61536	61590					5.945	0.945						
ADDN-MTR/L-12-C40-36	61537	61591					6.417	1.417						
ADDN-MTR/L-16-D40-12	61538	61592	1.00	1.00	4.0	1.394	5.472	0.472	0.157	DNTF-254004	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-16-D40-18	61539	61593					5.709	0.709						
ADDN-MTR/L-16-D40-24	61540	61594					5.945	0.945						
ADDN-MTR/L-16-D40-36	61541	61595					6.417	1.417						
ADDN-MTR/L-20-E40-12	61542	61596	1.25	1.25	4.5	1.669	5.472	0.472	0.157	DNTF-254004	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MTR/L-20-E40-18	61543	61597					5.709	0.709						
ADDN-MTR/L-20-E40-24	61544	61598					5.945	0.945						
ADDN-MTR/L-20-E40-36	61545	61599					6.417	1.417						



**NEW**

# Kool Cut Modular Turning, Facing & Grooving



.079" (2mm) Insert			Jet-Stream™ Kool Cut Modular Turning and Grooving Gang Toolholder												
Description	UPC No. 733101-		A	B	H	C2	F	TL	T	Insert		Clamp Screw	Cartridge Screw	Hex Key	Seal
	Right Hand	Left Hand								Size	Style				
ADDN-MGR/L-12-C20-06	61624	61678	0.75	0.75	0.75	3.50	1.732	4.80	0.236	0.079	DNTF-222002	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-12-C20-12	61625	61679					1.969	4.80	0.472						
ADDN-MGR/L-12-C20-18	61626	61680					2.205	4.80	0.709						
ADDN-MGR/L-16-D20-06	61627	61681	1.00	1.00	1.00	4.00	1.736	5.30	0.236	0.079	DNTF-222002	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-16-D20-12	61628	61682					1.972	5.30	0.472						
ADDN-MGR/L-16-D20-18	61629	61683					2.209	5.30	0.709						
ADDN-MGR/L-20-E20-06	61630	61684	1.25	1.25	1.25	5.00	1.736	6.30	0.236	0.079	DNTF-222002	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-20-E20-12	61631	61685					1.972	6.30	0.472						
ADDN-MGR/L-20-E20-18	61632	61686					2.209	6.30	0.709						

.118" (3mm) Insert			Jet-Stream™ Kool Cut Modular Turning and Grooving Gang Toolholder												
Description	UPC No. 733101-		A	B	H	C2	F	TL	T	Insert		Clamp Screw	Cartridge Screw	Hex Key	Seal
	Right Hand	Left Hand								Size	Style				
ADDN-MGR/L-12-C30-09	61633	61687	0.75	0.75	0.75	3.50	1.850	4.80	0.354	0.118	DNTF-223003	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-12-C30-18	61634	61688					2.205	4.80	0.709						
ADDN-MGR/L-12-C30-27	61635	61689					2.559	4.80	1.063						
ADDN-MGR/L-16-D30-09	61636	61690	1.00	1.00	1.00	4.00	1.854	5.30	0.354	0.118	DNTF-223003	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-16-D30-18	61637	61691					2.209	5.30	0.709						
ADDN-MGR/L-16-D30-27	61638	61692					2.563	5.30	1.063						
ADDN-MGR/L-20-E30-09	61639	61693	1.25	1.25	1.25	5.00	1.854	6.30	0.354	0.118	DNTF-223003	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-20-E30-18	61640	61694					2.209	6.30	0.709						
ADDN-MGR/L-20-E30-27	61641	61695					2.563	6.30	1.063						

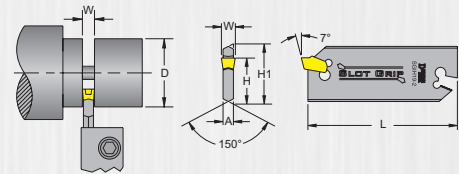
.157" (4mm) Insert			Jet-Stream™ Kool Cut Modular Turning and Grooving Gang Toolholder												
Description	UPC No. 733101-		A	B	H	C2	F	TL	T	Insert		Clamp Screw	Cartridge Screw	Hex Key	Seal
	Right Hand	Left Hand								Size	Style				
ADDN-MGR/L-12-C40-12	61642	61696	0.75	0.75	0.75	3.5	1.969	4.80	0.472	0.157	DNTF-254004	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-12-C40-18	61643	61697					2.205	4.80	0.709						
ADDN-MGR/L-12-C40-24	61644	61698					2.441	4.80	0.945						
ADDN-MGR/L-12-C40-36	61645	61699					2.913	4.80	1.417						
ADDN-MGR/L-16-D40-12	61646	61700	1.00	1.00	1.00	4.0	1.969	5.30	0.472	0.157	DNTF-254004	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-16-D40-18	61647	61701					2.205	5.30	0.709						
ADDN-MGR/L-16-D40-24	61648	61702					2.441	5.30	0.945						
ADDN-MGR/L-16-D40-36	61649	61703					2.913	5.30	1.417						
ADDN-MGR/L-20-E40-12	61650	61704	1.25	1.25	1.25	4.5	1.969	5.80	0.472	0.157	DNTF-254004	CS-M0616	CS-M0620	HAHK-50	CS08-04
ADDN-MGR/L-20-E40-18	61651	61705					2.205	5.80	0.709						
ADDN-MGR/L-20-E40-24	61652	61706					2.441	5.80	0.945						
ADDN-MGR/L-20-E40-36	61653	61707					2.913	5.80	1.417						





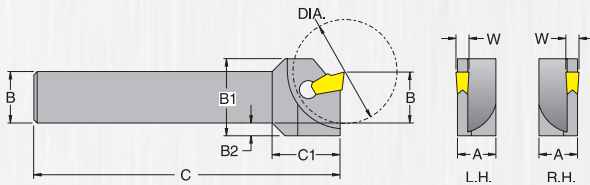
# Slot Grip Cut-Off Toolholder & Insert

**Slot Grip Positive Stop Blades** - Improved blade design featuring a "Positive Stop". Inserts are securely held in Slot Grip 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. The inserts' 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. Clearance angle ranges from 4° to 7°.



Description	UPC No. 733101-	Insert Used	W		D Max		A		L		H		H1	
			in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
SGIH19-2	62950	SGT(N/R/L)-2	.087	2	1.57	39,9	.063	1,57	3.38	85,9	.618	15,7	0.75	19,1
SGIH26-2	62951	SGT(N/R/L)-2	.087	2	2.00	50,8	.063	1,57						
SGIH26-3	62952	SGT(N/R/L)-3	.122	3	3.00	76,2	.094	2,39	4.33	110,0	.842	21,4	1.02	25,9
SGIH26-4	62953	SGT(N/R/L)-4	.161	4	3.15	80,0	.125	3,18						
SGIH32-3	62956	SGT(N/R/L)-3	.122	3	3.94	100,0	.094	2,39						
SGIH32-4	62957	SGT(N/R/L)-4	.161	4	3.94	100,0	.125	3,18	5.90	149,9	.984	25,0	1.25	31,8
SGIH32-5	62958	SGT(N/R/L)-5	.201	5	4.71	119,6	.156	3,96						
SGIH32-6	62959	SGT(N/R/L)-6	.252	6	4.72	119,9	.203	5,16						

**Cut-Off Toolholder** - The square shank design of the Cut-Off toolholder ensures a precise center line of the insert with respect to the center of the work-piece, when the toolholder is mounted directly on the CNC turret. Inserts are securely held in Slot Grip blades by a tapered locking system. No additional clamping devices are required. Slot Grip Cut-Off toolholders come in a broad selection of shank sizes.



Description	UPC No. 733101-		B	Max Dia	W	Insert Used
	R.H.					
SGTHR-9,5-2	63000		0.375	1.109	.087 & 0.93	SGTN/R/L-2,2,4
SGTHR-12,7-2	63002		0.500	1.172	.087 & 0.93	
SGTHR-16-2	63004		0.625	1.172	.087 & 0.93	
SGTHR-19-2	63006		0.750	1.266	.087 & 0.93	SGTN/R/L-3
SGTHR-12,7-3	63010		0.500	1.266	.120	
SGTHR-16-3	63012		0.625	1.406	.120	
SGTHR-19-3	63014		0.750	2.062	.120	
SGTHR-25,4-3	63016		1.000	1.328	.120	
SGTHR-19-5	63024		0.750	1.531	.187 & .200	
SGTHR-25,4-5	63026		1.000	3.000	.187 & .200	SGTN/R/L-4,8-5

**Neutral Cut-Off Toolholder** - The two piece clamp style of this tool provides a precise and rigid blade locking and easy mounting of the tool into CNC turrets. Simple block design accommodates Slot Grip and competitive blade systems. Slot Grip Cut-Off toolholders come in a broad selection of shank sizes.



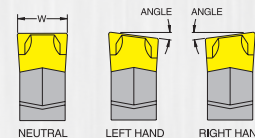
Description	Part No. 733101-		Shank Size	Blade Used
	Neutral			
SGTBN12,7-2	62970		0.500	SGIH19-2
SGTBN19-5	62973		0.750	SGIH26-2 THRU SGIH26-6
SGTBN19-6	62974		0.750	SGIH32-3 THRU SGIH32-9
SGTBN25,4-6	69275		1.000	
SGTBN31,8-6	62976		1.250	

**Cut-Off & Grooving Inserts** - 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.

Description	DASK25B For High Performance Machining	DC656 For General Turning Applications	Insert Size	Lead Angle	Width ± .004	
					in	mm
SGTN-2	82223	82222	2	0°	.087	2mm
SGTR-2-8	82251	82250	2	8°	.087	2mm
SGTN-3	82227	82226	3	0°	.122	3mm
SGTR-3-8	82255	82254	3	8°	.122	3mm
SGTN-4	82231	82230	4	0°	.161	4mm
SGTR-4-8	82259	82258	4	8°	.161	4mm
SGTN-5	82235	82234	5	0°	.201	5mm
SGTN-6	82239	82238	6	0°	.252	6mm
SGTN-8	82243	82242	8	0°	.315	8mm
SGTN-9	82247	82246	9	0°	.378	9mm

### Chipbreaker Geometry

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



### Application

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

### Cutting Data

- Feed Per Revolution (in./rev.) .006-.031
- Surface Feet/Minute (ft./min.) 375-730

Insert Grade	Coating Specifications	ISO	Material to Machine	Insert Grade Specifications
DC656	CVD COATED CVD TiN/ TiC-TiN	P15-P35	Free Cutting Steel, Low Carbon Steel Alloy Carbon Steel, Alloy Steel under 48 HRC 400 Series Stainless Steel	First Choice for general turning applications on ferrous metals and stainless steel, at medium cutting sfm.
		M20-M35		
DASK25B	PVD COATED PVD TiN+TiAlN+TiN	P10-P25	Free Cutting Steel, High Temper Alloys Stainless Steel Austenitic Cast Iron/Copper/Brass	First Choice for general turning applications on ferrous metals and stainless steel, at medium cutting sfm.
		M15-35		
		K05-K20		
		S10-S25		

### Blade & Insert Set

Set Description	Set Part No. 733101-	(1) Blade	(10) Inserts
SGIH26-3S	85360	SGIH26-3	SGTN-3
SGIH32-3S	85364	SGIH32-3	SGTN-3

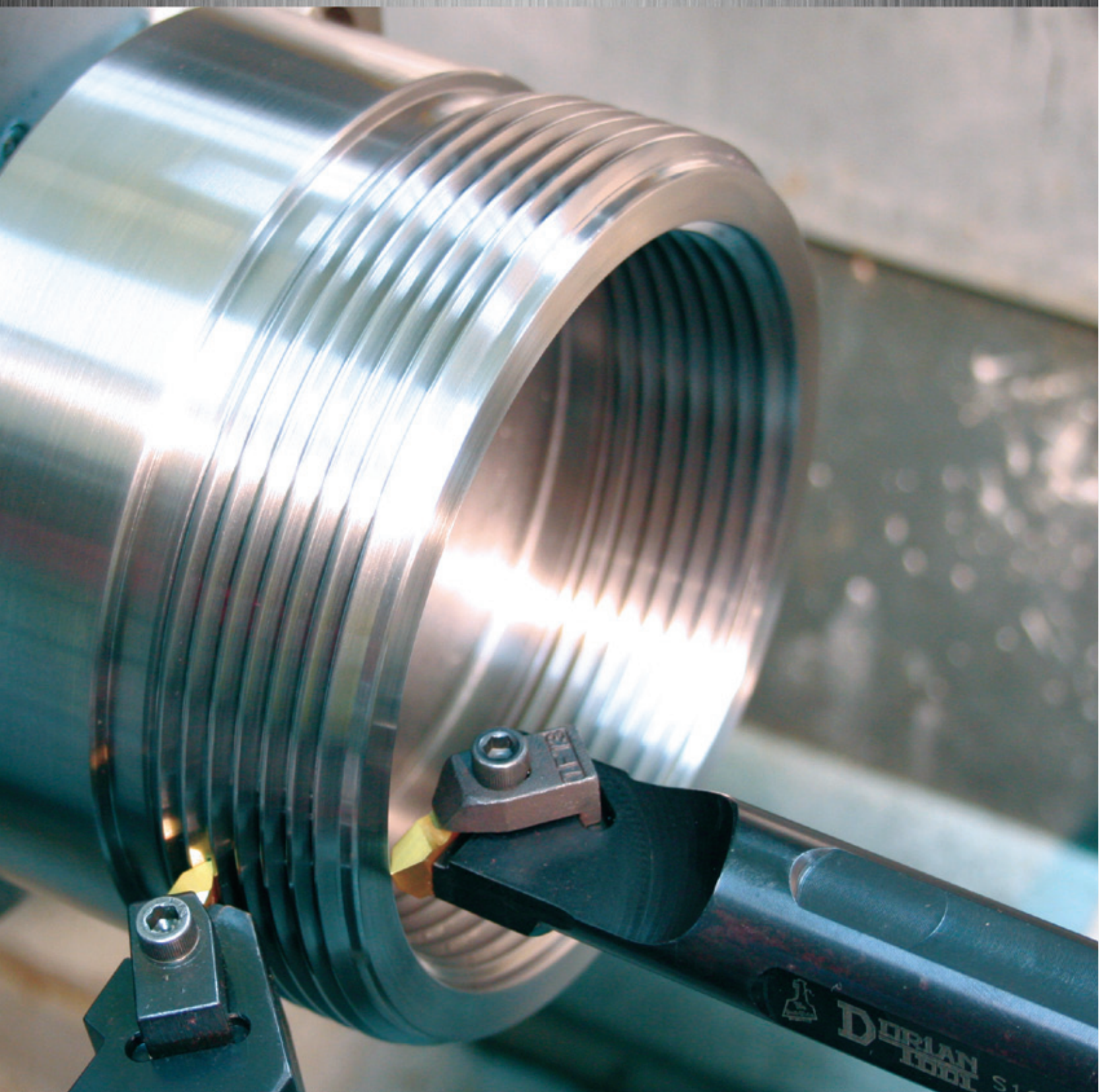


### Blade, Toolholder & Insert Set

Set Description	Set Part No. 733101-	(1) Blade	(10) Inserts	(1) Toolholder
SGTBN19-5S	85326	SGIH26-3	SGTN-3	SGTBN19-5
SGTBN25,4-6S	85330	SGIH32-3	SGTN-3	SGTBN25,4-6



**ONEDGE, LAYDOWN & DORNOTCH**  
**THREADING TOOLHOLDERS & INSERTS**


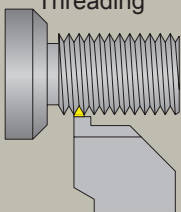
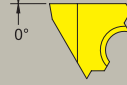
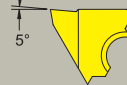

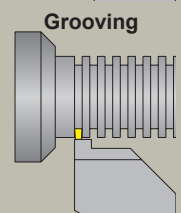





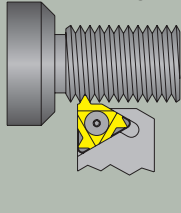
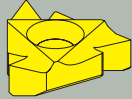
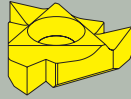




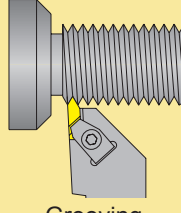


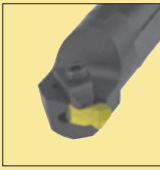
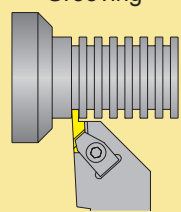


## Choose From Three Threading Styles:


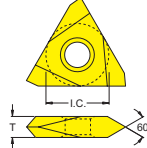
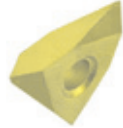
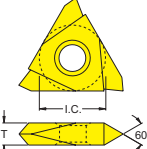
- OnEdge** Threading for Multi-Purpose Applications.
- Laydown** Threading for Small Diameter Holes, Clearance Restrictions and Precision Threading Applications.
- DorNotch** Threading when Maximum Rigidity and precision Threading is Required.


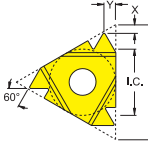
On Edge Style	Machining Applications	Insert Identification
External 	Threading 	N - Negative 0°  P - Positive 5° 
Internal 	Grooving 	A - With hole  C - Countersink on both 


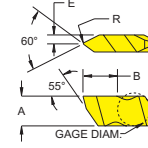

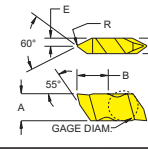
Laydown Style	Machining Applications	Insert Identification
External 	Threading 	E - External  I - Internal 
Internal 		Partial Profile: A = 16-48 N = 5-7 AG = 8-48 Q = 4.5-4 G = 8-14  Full Profile: Metric: Pitch in mm Inches: Thread per inch

DorNotch Style	Machining Applications	Insert Identification
External 	Threading 	LH - Left Hand  RH - Right Hand 
Internal 	Grooving 	Insert No.    T 1            .100 2            .150 3            .195 4            .255 5            .380 6            .383 8            .438

Non-Ferrous Material	Ferrous Material
<b>Dorian Insert Grade</b>	
<b>DVK10</b>	<b>DVP656</b>
For all Non-Ferrous Material; 300 series stainless steel, Ductile Cast Iron, Aluminum and High Temper Alloy.	For all Ferrous Material; Alloy Steels, Carbon Steels and 400 Series Stainless Steel

On Edge Threading Inserts	Dorian Insert Grade-		
	Insert Description	Non-Ferrous DVK10	Ferrous DVP656
<b>NV "V" Thread Negative Rake</b>  	<b>TNMA</b>	UPC No. 733101-	
	TNMA-32NV	72529	72528
	TNMA-43NV	72536	72535
	TNMA-54NV	72557	72556
	<b>TNMC</b>	UPC No. 733101-	
	TNMC-32NV	72004	72003
TNMC-43NV	72008	72010	
TNMC-54NV	72032	72031	
<b>NV "V" Thread Positive Rake</b>  	<b>TPMA</b>	UPC No. 733101-	
	TPMA-32NV	73394	73393
	TPMA-43NV	73401	73400
	TPMA-54NV	73415	73414
	<b>TPMC</b>	UPC No. 733101-	
	TPMC-32NV	73056	73055
TPMC-43NV	73063	73062	
TPMC-54NV	73077	73076	

Laydown Threading Insert	Dorian Insert Grade-		
	Insert Description	Non-Ferrous DVK10	Ferrous DVP656
<b>Ext. 60° Partial Profile Thread</b>   <p>Internal Shown External Opposite</p>	<b>External</b>	UPC No. 733101-	
	11ER-A60	74001	74000
	11EL-A60	74005	74004
	16ER-AG60	74025	74024
	16EL-AG60	74029	74028
	22ER-N60	74033	74032
	22EL-N60	74037	74036
	<b>Internal</b>	UPC No. 733101-	
	11IR-A60	74057	74056
	11IL-A60	74061	74060
	16IR-AG60	74081	74080
	16IL-AG60	74085	74084
	22IR-N60	74089	74088
	22IL-N60	74093	74092

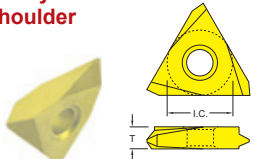
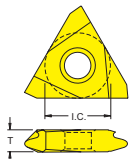
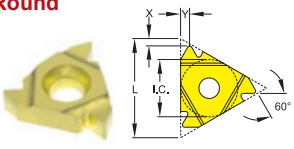
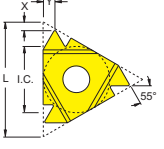
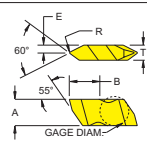
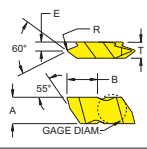
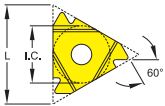
DorNotch Threading Inserts	Dorian Insert Grade-		
	Insert Description	Non-Ferrous DVK10	Ferrous DVP656
<b>NT-60° "V" Thread Neutral Rake Angle</b>  	Neutral	UPC No. 733101-	
	NT-2R-	82901	82900
	NT-2L-	82905	82904
	NT-3R-	82909	82908
	NT-3L-	82913	82912
<b>NTP-60° "V" Thread Positive "V" Thread</b>   <p>5° Pos. Rake Angle</p>	Positive	UPC No. 733101-	
	NTP-2R-	82925	82924
	NTP-2L-	82929	82928
	NTP-3R-	82933	82932
	NTP-3L-	82937	82936

**API & OIL FIELD**  
**THREADING INSERTS**



## API & Oil Field Threading Inserts

For more information reference Dorian's Threading Catalog

API & Oil Field Threading Inserts For more information reference Dorian's Threading Catalog				General Purpose Ferrous		High Performance Ferrous & Non Ferrous		
				Carbon Steel, Alloy Steel & Stainless Steel		Carbon Steel, Alloy Steel & Stainless Steel, Cast Iron, Aluminum & H.T.A.		
				Dorian Insert Grade DVP656		Dorian Insert Grade DASK25B		
<b>API On Edge Threading</b> (Negative Rake) External Shown, Internal Opposite	<b>Rotary Shoulder</b>  	<b>External</b>	TNMA	TNMC	TNMA	TNMC	TNMA	TNMC
			TNMA-54-530-E	TNMC-54-530-E	72949	72423	72951	72424
			TNMA-55-425-E	TNMC-55-425-E	72952	72426	72954	72427
			TNMA-55-428-E	TNMC-55-428-E	72955	72429	72957	72430
			TNMA-55-435-E	TNMC-55-435-E	72961	72435	72963	72436
			TNMA-55-438-E	TNMC-55-438-E	72964	72438	72967	72439
	TNMA-55-530-E	TNMC-55-530-E	72966	72441	72969	72442		
	<b>RD Round</b>  	<b>External</b>	TNMA	TNMC	TNMA	TNMC	TNMA	TNMC
			TNMA-43-8RD-E	TNMC-43-8RD-E	72998	72471	73000	72472
			TNMA-43-10RD-E	TNMC-43-10RD-E	73001	72474	73003	72475
			TNMA-54-8RD-E	TNMC-54-8RD-E	73004	72477	73006	72478
			TNMA-43-8RD-I	TNMC-43-8RD-I	73007	72480	73009	72481
TNMA-43-10RD-I			TNMC-43-10RD-I	73010	72483	73012	72484	
TNMA-54-8RD-I	TNMC-54-8RD-I	73013	72486	73015	72487			
<b>API Laydown Threading</b> External Shown, Internal Opposite	<b>Round</b>  	<b>External</b>	Right	Right	Right	Right	Right	Right
			16ER-8APIRD	16IR-8APIRD	78320	78324	78321	78325
			16ER-10APIRD	16IR-10APIRD	78328	78332	78329	78333
			Right	Right	Right	Right	Right	Right
			22ER-530	22IR-530	78672	78676	78673	78677
			22ER-438	22IR-438	78688	78692	78689	78693
			22ER-435	22IR-435	78696	78700	78697	78701
			22ER-428	22IR-428	78712	78716	78713	78717
			22ER-425	22IR-425	78720	78723	78721	78724
	<b>Round Shoulder</b>  	<b>External</b>	27ER-530	27IR-530	78727	78731	78728	78732
			27ER-438	27IR-438	78743	78747	78744	78748
			27ER-435	27IR-435	78751	78755	78752	78756
			27ER-428	27IR-428	78759	78763	78760	78764
			27ER-425	27IR-425	78767	78771	78768	78772
			Internal	External	Internal	External	Internal	External
			V84-8RD-E	V84-8RD-I	84660	84664	84662	84666
			V84-10RD-E	V84-10RD-I	84668	84672	84670	84674
			V85-425-E	V85-425-I	84740	84744	84742	84746
V85-428-E	V85-428-I	84748	84752	84750	84754			
V85-435-E	V85-435-I	84764	84768	84766	84770			
V85-438-E	V85-438-I	84772	84776	84774	84778			
V85-530-E	V85-530-I	84780	84784	84782	84786			
<b>API Dor Notch Threading</b> Neutral Rake Angle	<b>ND-60° "V" Rotary Shoulder</b>  	<b>Right &amp; Left</b>	Right	Left	Right	Left	Right	Left
			ND-3040R	ND-3040L	84372	84376	84374	84378
			ND-3038R	ND-3038L	84380	84384	84382	84386
			ND-4040R	ND-4040L	84388	84392	84390	84394
			ND-4038R	ND-4038L	84396	84400	84398	84402
			ND-4050R	ND-4050L	84404	84408	84406	84410
	<b>NDC-RD 60° "V" Round</b>  	<b>Right &amp; Left</b>	Right	Left	Right	Left	Right	Left
			NDC-38RDR-75	NDC-38RDL-75	84460	84464	84462	84466
			NDC-310RDR-75	NDC-310RDL-75	84468	84472	84470	84474
			Internal	External	Internal	External	Internal	External
			L43-425-E	L43-425-I	88117	88121	88118	88122
			L43-428-E	L43-428-I	88125	88129	88126	88130
L43-435-E	L43-435-I	88141	88145	88142	88146			
L43-438-E	L43-438-I	88149	88153	88150	88154			
L43-530-E	L43-530-I	88157	88162	88158	88163			
L53-425-E	L53-425-I	88174	88178	88175	88179			
L53-428-E	L53-428-I	88182	88186	88183	88187			
L53-435-E	L53-435-I	88198	88202	88199	88203			
L53-438-E	L53-438-I	88206	88210	88207	88211			
L53-530-E	L53-530-I	88214	88218	88215	88219			
<b>L43/ L53 Round</b>  	<b>Internal &amp; External</b>	Internal	External	Internal	External	Internal	External	
		L43-8RD-E	L43-8RD-I	88230	88234	88231	88235	
		L43-10RD-E	L43-10RD-I	88238	88242	88239	88243	
		L53-8RD-E	L53-8RD-I	88246	88250	88247	88251	
		Internal	External	Internal	External	Internal	External	



## On Edge Threading

MTVO-A - On Edge Threading Toolholder					
Inch Description	UPC No. 733101-		Shank Size	TNMA Gage Insert	
	R.H.	L.H.			
MTVOR/L08-3B-A	58126	58127	0.500		
MTVOR/L16-3D-A	58138	58139	1.000		322
MTVOR/L12-4B-A	58142	58143	0.750		
MTVOR/L16-4D-A	58146	58147	1.000		432
MTVOR/L20-4D-A	58150	58151	1.250		
MTVOR/L16-5D-A	58158	58159	1.000		543
MTVOR/L20-5D-A	58162	58163	1.250		

STVO - On Edge Threading Toolholder					
Inch Description	UPC No. 733101-		Shank Size	TNMC Gage Insert	
	R.H.	L.H.			
STVOR/L08-3A	58070	58071	0.500		
STVOR/L10-3B	58074	58075	0.625		
STVOR/L12-3B	58078	58079	0.750		322
STVOR/L16-3D	58082	58083	1.000		
STVOR/L12-4B	58086	58087	0.750		
STVOR/L16-4D	58090	58091	1.000		432
STVOR/L20-4D	58094	58095	1.250		
STVOR/L16-5D	58102	58103	1.000		543
STVOR/L20-5D	58106	58107	1.250		

MTHO-A - On Edge Threading Bar					
Inch Description	UPC No. 733101-		Bar Size	Min. Bore	TNMA Gage Insert
	R.H.	L.H.			
S16T-MTHOR/L-3-A	58346	58347	1.000	1.388	322
S20U-MTHOR/L-4-A	58354	58355	1.250	1.812	
S24U-MTHOR/L-4-A	58358	58359	1.500	2.250	432
S32V-MTHOR/L-4-A	58362	58363	2.000	3.000	
S32V-MTHOR/L-5-A	58366	58367	2.000	3.500	543
S40V-MTHOR/L-5-A	58370	58371	2.500	3.750	
S40V-MTHOR/L-66-A	58378	58379	2.500	4.000	663

MTHO-C - On Edge Threading Bar					
Inch Description	UPC No. 733101-		Bar Size	Min. Bore	TNMC Gage Insert
	R.H.	L.H.			
S16T-MTHOR/L-3-C	58300	58301	1.000	1.388	
S20U-MTHOR/L-3-C	58304	58305	1.250	1.656	322
S20U-MTHOR/L-4-C	58308	58309	1.250	1.812	
S24U-MTHOR/L-4-C	58312	58313	1.500	2.250	432
S32V-MTHOR/L-4-C	58316	58317	2.000	3.000	
S32V-MTHOR/L-5-C	58320	58321	2.000	3.500	543
S40V-MTHOR/L-5-C	58324	58325	2.500	3.750	

## Laydown Threading

SE - Laydown Threading Toolholder					
Inch Description	UPC No. 733101-		Shank Size	Gage Insert	
	R.H.	L.H.			
SER/L050-4-11	58424	58425	0.500		11-A60
SER/L062-4-16	58428	58429	0.625		
SER/L075-5-16	58432	58433	0.750		16-G60
SER/L100-5-16	58436	58437	1.000		
SER/L125-6-22	58444	58445	1.250		22-N60

SE - Laydown Qualified Threading Toolholder					
Inch Description	UPC No. 733101-		Shank Size	Gage Insert	
	R.H.	L.H.			
SER075-5-16Q	58492		0.750		16-G60
SER100-6-16Q	58496		1.000		
SER125-6-22Q	58508		1.250		22-N60

SN - Small Shank Laydown Threading Bar					
Inch Description	UPC No. 733101-		Bar Size	Min. Bore	Gage Insert
	R.H.	L.H.			
SNR037-40-11	58600		0.375	0.500	
SNR050-55-11	58604		0.500	0.600	11-A60
SNR062-60-16	58608		0.625	0.750	
SNR075-70-16	58612		0.750	0.950	16-G60
SNR100-80-16	58616		1.000	1.150	

SN - Laydown Threading Bar					
Inch Description	UPC No. 733101-		Bar Size	Min. Bore	Gage Insert
	R.H.	L.H.			
SNR/L075-07-16	58636		0.750	0.950	
SNR/L100-08-16	58640		1.000	1.150	
SNR/L150-12-16	58648		1.500	1.700	16-G60
SNR/L200-14-16	58656		2.200	2.000	
SNR/L125-10-22	58664		1.250	1.500	
SNR/L150-12-22	58668		1.500	1.800	22-N60
SNR/L200-14-22	58676		2.000	2.300	

## DorNotch Threading

NS - DorNotch Threading Toolholder					
Inch Description	UPC No. 733101-		Shank Size	Gage Insert	
	R.H.	L.H.			
NSR/L12-2B	58782	58783	0.750		NG-2R*
NSR/L16-2C	58786	58787	1.000		NG-2L**
NSR/L12-3B	58794	58795	0.750		
NSR/L16-3D	58802	58803	1.000		NG-3R*
NSR/L20-3D	58806	58807	1.250		NG-3L**
NSR/L16-4D	58814	58815	1.000		NG-4R*
NSR/L20-4D	58822	58823	1.250		NG-4L**

\*\*For Left Hand Tool, \*For Right Hand Tool

S-NE - DorNotch Threading Bar					
Inch Description	UPC No. 733101-		Bar Size	Min. Bore	Gage Insert
	R.H.	L.H.			
S10S-NER/L-2	58970	58971	0.625	1.000	NG-2R*, NG-2L**
S16T-NER/L-3	58978	58979	1.000	1.375	
S20U-NER/L-3	58982	58983	1.250	1.750	NG-3R*, NG-3L**
S24U-NER/L-3	58986	58987	1.500	2.000	





\*For Left Hand Tool, \*\*For Right Hand Tool

# **MILLING CUTTERS** **AND INSERTS**





## Non Ferrous Material

Material		Insert Grade	DKU10HM	DKU25GM	DUP15VM	DUP25GM	DUP35RM	Cutting Data		
Insert Coating								Uncoated	Uncoated	PVD-AICrN
Insert	Description	Radius	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-	SFM	Doc	Fz
	APKT-1003-PDER-0.019"	.019" .5mm	94852					123-3300	0.080"	.003"-.020mm
	APKT-1003-PDER-0.019"				94837					
	APKT-1003-PDER-0.032"	.032" .8mm		94851				99-2800	0.080"	.003"-.020mm
	APKT-1003-PDER-0.032"					94839		165-3960		
	APKT-1003-PDER-0.032"							94857		
	APKT-1604-PDER-0.032"	.032" .8mm	94878					132-3300	0.080"	.003"-.020mm
	APKT-1604-PDER-0.032"				94843			198-4950		
	APKX-1604-PDER-1.2"	.047" 1.2mm		94915				99-2800	0.080"	.003"-.020mm
	APKX-1604-PDER-1.2"					94845		165-3960		
	APKX-1604-PDER-1.2"							94861		

\* Insert should be used dry, however for some materials wet condition is recommended. (SFM = Surface Foot Per Minute, fz = Chip load, d.o.c. = Depth of Cut)

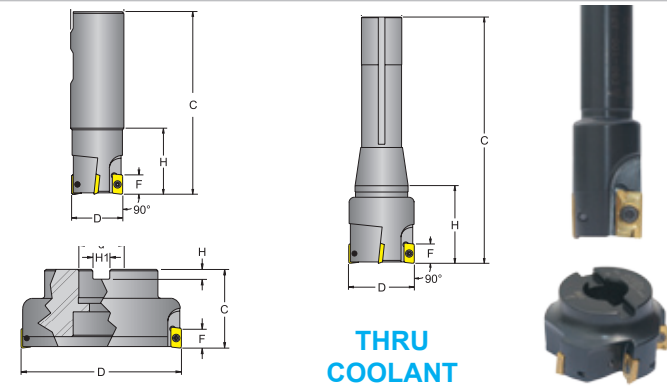
## Ferrous Material

Material		Insert Grade	DPP15HM	DPC25UM	DPP35UM	DPP35RM	DMC35UM	DKC10UM	Cutting Data		
Insert Coating									PVD-TiAlN	CVD TiN/Al2O3/TiCN	PVD-TiN+TiAlN+TiN
Insert	Description	Radius	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-	UPC 733101-	SFM	Doc	Fz
	APKT-1003-PDER-0.019"	.019" .5mm	94757						310-875	0.080"	.003"-.020mm
	APKT-1003-PDER-0.019"			94758					230-790		
	APKT-1003-PDER-0.019"					94759			200-760		
	APKT-1003-PDER-0.019"						94754		320-680		
	APKT-1003-PDER-0.019"							94753	265-530		
	APKT-1003-PDER-0.032"	.032" .8mm			94841				200-800	0.080"	.003"-.020mm
	APKT-1003-PDER-0.032"					94775			200-760		
	APKT-1604-PDSR-0.032"	.032" .8mm	94767						310-875	0.080"	.003"-.020mm
	APKT-1604-PDSR-0.032"			94768					230-790		
	APKT-1604-PDSR-0.032"					94769			200-760		
	APKT-1604-PDSR-0.032"						94764		320-680		
	APKT-1604-PDSR-0.032"							94763	265-530		
	APKT-1604-PDER-1.2"	0.047" 1.2mm			94847				200-800	0.080"	.003"-.020mm
	APKT-160416-SR-			94771					230-790		
	APKT-160424-SR-			94772					230-790		
	APKT-160432-SR-			94774					230-790		

\* Insert should be used dry, however for High Temper Alloy wet condition is recommended. (SFM = Surface Foot Per Minute, fz = Chip load, d.o.c. = Depth of Cut)

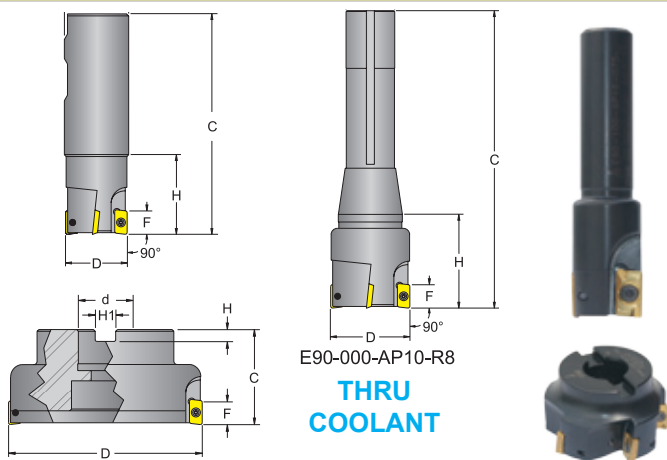


## HIGH POSITIVE 90° APKT MILLING CUTTER



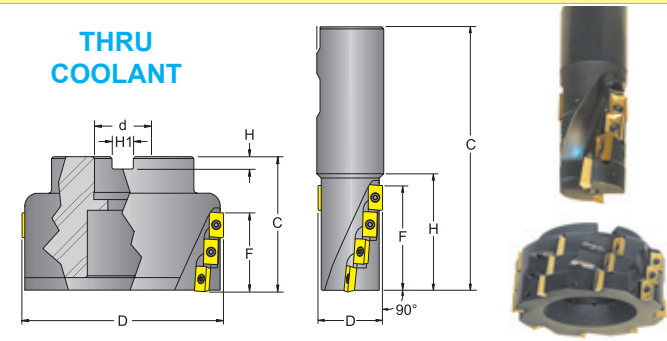
End Mills Description	C	D	Shank Size	F	H		Insert Qty.	APKT Gage Insert	UPC No. 733101-
E90-100-AP16-075	4.000	1.00	0.75	.618	1.625		2	1604	65646
E90-100-AP16-100	4.500	1.00	1.00	.618	1.750		2		65648
E90-125-AP16-100	4.500	1.25	1.00	.618	1.625		3		65650
E90-150-AP16-100	4.500	1.50	1.00	.618	1.625		3		65652
E90-150-AP16-125	4.500	1.50	1.25	.618	1.625		3		65654
E90-200-AP16-125	4.500	2.00	1.25	.618	1.625		5		65656
E90-200-AP16-R8	5.625	2.00	R8	.618	1.640		5	65658	
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.	APKT Gage Insert	UPC No. 733101-
E90A-200-AP16-075	1.570	2.00	0.750	.618	.187	.312	5	1604	65662
E90A-250-AP16-100	1.750	2.50	1.000	.618	.219	.375	5		65664
E90A-300-AP16-100	1.750	3.00	1.000	.618	.219	.375	5		65666
E90A-400-AP16-150	2.000	4.00	1.500	.618	.375	.625	8		65668
E90A-500-AP16-150	2.380	5.00	1.500	.618	.375	.625	10		65670

## HIGH POSITIVE 90° APKT MILLING CUTTER



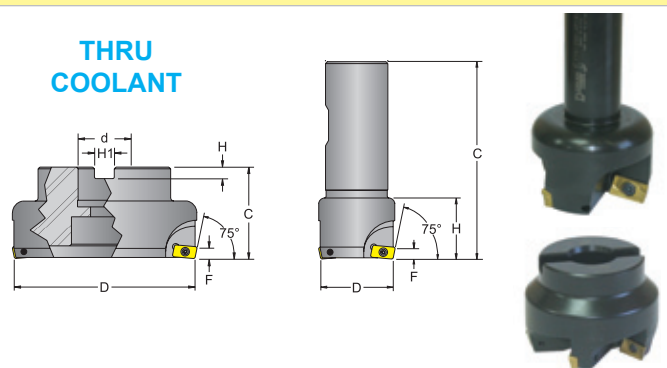
End Mills Description	C	D	Shank Size	F	H		Insert Qty.	APKT Gage Insert	UPC No. 733101-
E90-038-AP10-050	3.000	0.375	0.500	.390	1.000		1	1003	65600
E90-044-AP10-062	3.250	0.437	0.625	.390	1.062		1		65601
E90-050-AP10-062	3.250	0.500	0.625	.390	1.062		1		65602
E90-062-AP10-062	3.250	0.625	0.625	.390	1.062		2		65604
E90-075-AP10-075	3.375	0.750	0.750	.390	1.125		2		65606
E90-087-AP10-075	3.375	0.875	0.750	.390	1.125		3		65608
E90-100-AP10-075	3.500	1.000	0.750	.390	1.125		3		65610
E90-100-AP10-100	4.000	1.000	1.000	.390	1.250		3		65612
E90-125-AP10-100	4.000	1.250	1.000	.390	1.250		4		65614
E90-150-AP10-100	4.000	1.500	1.000	.390	1.250		5		65616
E90-200-AP10-100	4.000	2.000	1.000	.390	1.250		6	65618	
E90-200-AP10-R8	5.625	2.000	R8	.390	1.640		6	65619	
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.	APKT Gage Insert	UPC No. 733101-
E90A-200-AP10-075	1.570	2.000	0.750	.390	.187	.312	6	1003	65632
E90A-250-AP10-100	1.750	2.500	1.000	.390	.219	.375	8		65634
E90A-300-AP10-100	1.750	3.000	1.000	.390	.219	.375	10		65636

## EXTENDED 90° APKT MILLING CUTTER



End Mills Description	C	D	Shank Size	F	H		Insert Qty.	Flutes Qty.	APKT Gage Insert	UPC No. 733101-
EX90-075-AP10-075	3.50	0.75	0.75	1.125	1.500		4	1	1003	65680
EX90-100-AP10-100	4.25	1.00	1.00	1.500	1.875		8	2		65682
EX90-125-AP10-125	4.50	1.25	1.25	1.875	2.125		12	4		65684
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.		APKT Gage Insert	UPC No. 733101-
EX90A-200-AP16-100	2.00	2.00	1.00	1.000	.219	.375	6	3	1604	65690
EX90A-250-AP16-100	2.50	2.50	1.00	1.750	.219	.375	12	4		65692
EX90A-300-AP16-125	2.50	3.00	1.25	1.750	.281	.500	15	5		65694
EX90A-400-AP16-150	2.50	4.00	1.50	1.750	.375	.625	18	6		65696
EX90A-500-AP16-150	2.50	5.00	1.50	1.750	.375	.625	24	8		65698

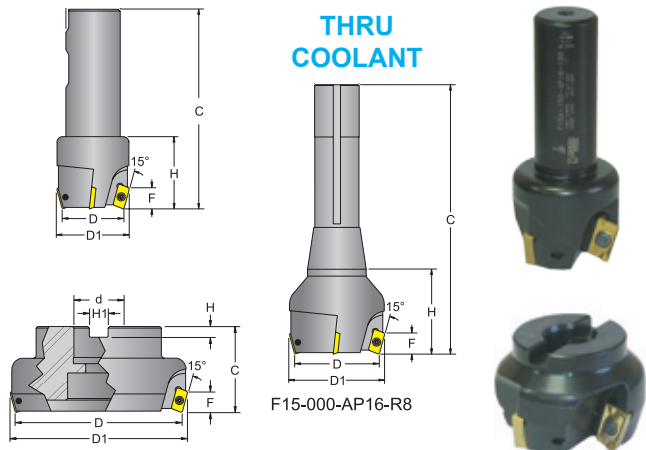
## HIGH POSITIVE 75° APKT MILLING CUTTER



End Mills Description	C	D	Shank Size	F	H		Insert Qty.	APKT Gage Insert	UPC No. 733101-
F75-125-AP10-075	3.500	1.25	0.75	.150	1.00		3	1003	65778
F75-150-AP10-100	3.750	1.50	1.00	.150	1.25		3	1003	65780
F75-200-AP16-100	4.000	2.00	1.00	.270	1.50		3	1604	65782
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.	APKT Gage Insert	UPC No. 733101-
F75A-200-AP10-075	1.570	2.00	0.75	.150	.312	.187	5	1003	65786
F75A-300-AP10-100	1.750	3.00	1.00	.150	.375	.219	6	1003	65788
F75A-200-AP16-075	1.570	2.00	0.75	.270	.312	.187	3	1604	65790
F75A-250-AP16-100	1.750	2.50	1.00	.270	.375	.219	4	1604	65792
F75A-300-AP16-100	1.750	3.00	1.00	.270	.375	.219	5	1604	65794

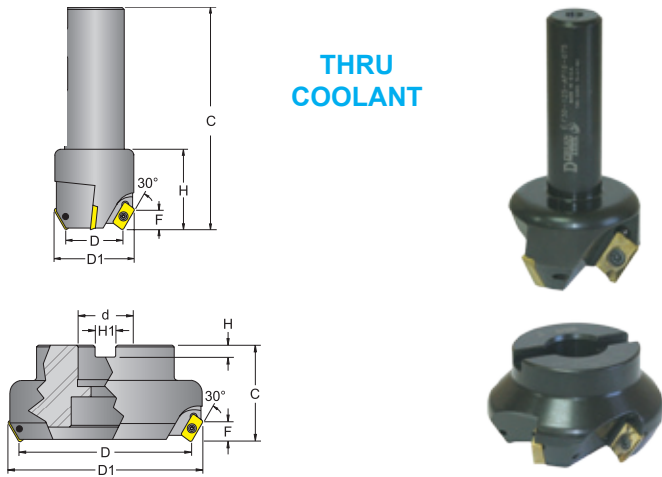


## HIGH POSITIVE 15° APKT MILLING CUTTER



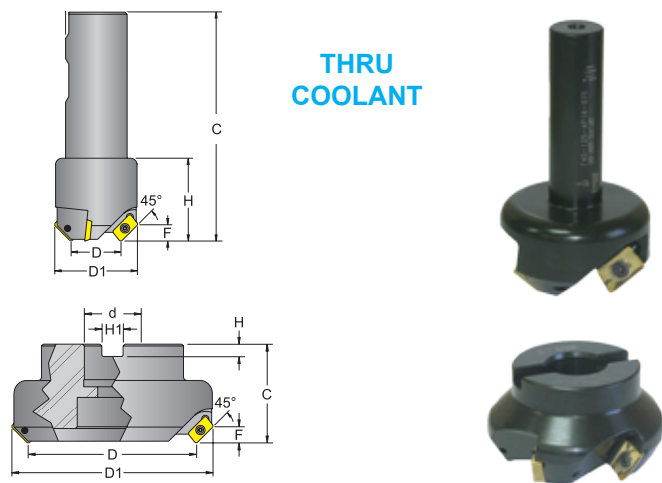
End Mills Description	C	D	Shank Size	F	H		Insert Qty.	APKT Gage Insert	UPC No. 733101-
F15-150-AP16-100	4.000	1.50	1.00	.586	1.50		3	1604	65712
F15-200-AP16-R8	5.625	2.00	R8	.586	1.64		4		65714
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.	APKT Gage Insert	UPC No. 733101-
F15A-200-AP16-075	1.57	2.00	0.75	.586	.187	.312	4	1604	65720
F15A-300-AP16-100	1.75	3.00	1.00	.586	.219	.375	6		65724

## HIGH POSITIVE 30° APKT MILLING CUTTER



End Mills Description	C	D	Shank Size	F	H		Insert Qty.	APKT Gage Insert	UPC No. 733101-
F30-125-AP16-075	3.750	1.25	0.75	.516	1.25		3	1604	65730
F30-150-AP16-100	4.000	1.50	1.00	.516	1.50		3		65732
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.	APKT Gage Insert	UPC No. 733101-
F30A-200-AP16-075	1.57	2.00	0.75	.516	.187	.312	4	1604	65740
F30A-250-AP16-100	1.75	2.50	1.00	.516	.219	.375	5		65742
F30A-300-AP16-100	1.75	3.00	1.00	.516	.219	.375	6		65744
F30A-400-AP16-150	2.00	4.00	1.50	.516	.375	.625	8		65746
F30A-500-AP16-150	2.38	5.00	1.50	.516	.375	.625	8		65748

## HIGH POSITIVE 45° APKT MILLING CUTTER



End Mills Description	C	D	Shank Size	F	H		Insert Qty.	APKT Gage Insert	UPC No. 733101-
F45-125-AP16-075	3.750	1.25	0.75	.416	1.25		3	1604	65754
F45-150-AP16-100	4.000	1.50	1.00	.416	1.50		3		65756
Face Mills Description	C	D	Shank Size	F	H	H1	Insert Qty.	APKT Gage Insert	UPC No. 733101-
F45A-200-AP16-075	1.57	2.00	0.75	.416	.187	.312	4	1604	65764
F45A-250-AP16-100	1.75	2.50	1.00	.416	.219	.375	5		65766
F45A-300-AP16-100	1.75	3.00	1.00	.416	.219	.375	6		65768
F45A-400-AP16-150	2.00	4.00	1.50	.416	.375	.625	6		65770
F45A-500-AP16-150	2.38	5.00	1.50	.416	.375	.625	8		65772





CONVEX RADIUS CUTTER			Description		C	D	D1	Shank Size	H	R-Range		Insert Qty.	SDGX Insert	UPC No. 733101-
			Min.	Max.										
Cutting Rake - 15° for 15° positive square convex radius SDGX inserts			QV-062-S304-050		3.000	0.625	0.503	0.500	1.000	.0156	.0625	1	09C_	65101
			QV-062-S304-062		3.250	0.625	0.503	0.625	1.000	.0156	.0625	1		65103
			QV-100-S608-075		3.500	1.000	0.754	0.750	1.000	.0781	.1250	1		65118
			QV-100-S608-100		3.625	1.000	0.754	1.000	1.125	.0781	.1250	1		65120
			QV-200-S608-100		3.750	2.000	1.750	1.000	1.250	.0781	.1250	3		65122
			QV-100-S612-075		3.500	1.000	0.632	0.750	1.000	.1406	.1875	1	19C_	65124
			QV-100-S612-100		3.625	1.000	0.632	1.000	1.125	.1406	.1875	1		65126
			QV-100-S616-075		3.500	1.000	0.510	0.750	1.000	.2031	.2500	1		65130
			QV-100-S616-100		3.625	1.000	0.510	1.000	1.125	.2031	.2500	1		65132
			QV-200-S616-100		3.750	2.000	1.500	1.000	1.250	.2031	.2500	3		65134

15° DOVETAIL CUTTER			Description		C	D	Shank Size	F	H	Insert Qty.	TDEX Gage Insert	UPC No. 733101-
			D15X-050-TD11-037		2.42	0.500	0.375	.359	0.42	1	110204	65225
			D15X-100-TD11-050		2.42	1.000	0.500	.359	0.42	3		65226
			D15X-187-TD16-075		3.20	1.875	0.750	.550	0.75	3	160308	65227
			D15X-250-TD22-100		3.75	2.500	1.000	.750	1.00	3	220408	65228

45° DOVETAIL CUTTER			Description		C	D	Shank Size	F	H	Insert Qty.	TDEX Gage Insert	UPC No. 733101-
			D45X-050-TD09-037		2.39	0.500	0.375	.247	.125	1		65233
			D45X-075-TD09-037		2.39	0.750	0.375	.247	.214	2	090202	65234
			D45X-100-TD09-050		2.39	1.000	0.500	.250	.244	3		65235
			D45X-137-TD17-062		2.94	1.375	0.625	.375	.320	2	17T304	65236
			D45X-187-TD17-075		2.94	1.875	0.750	.468	.444	3		65237
			D45X-225-TD25-100		3.50	2.250	1.000	.700	.696	2	250404	65238
D45X-250-TD25-100		3.50	2.500	1.000	.700	.700	3		65239			

60° DOVETAIL CUTTER			Description		C	D	Shank Size	F	H	Insert Qty.	TDEX Gage Insert	UPC No. 733101-
			D60X-050-TD11-037		2.390	0.500	0.375	.325	.142	1		65244
			D60X-075-TD11-037		2.390	0.750	0.375	.325	.282	2	110204	65245
			D60X-100-TD11-050		2.390	1.000	0.500	.325	.375	3		65246
			D60X-137-TD16-062		2.862	1.375	0.625	.510	.550	3		65247
			D60X-187-TD16-075		3.000	1.875	0.750	.510	.550	3	160308	65248
			D60X-225-TD22-100		3.500	2.250	1.000	.700	.750	3	220408	65249
D60X-250-TD22-100		3.500	2.500	1.000	.700	.750	3		65250			

DOUBLE 45° CHAMFER MILL			Description		C	D	D1	Shank Size	F	H	Insert Qty.	SDHW Gage Insert	UPC No. 733101-		
			C45-112-SD09-075		3.375	0.625	1.125	0.750	0.230	0.750	2			65414	
			C45-125-SD09-075		3.375	0.772	1.250	0.750	0.230	0.750	2			65416	
			C45-150-SD09-100		3.500	1.040	1.500	1.000	0.230	1.000	3	090308		65418	
			C45XL-112-SD09-075		7.75	0.625	1.125	0.750	0.230	0.750	2			65420	
			C45XL-150-SD09-100		7.75	1.040	1.500	1.000	0.230	1.000	3			65421	
			Cutting Rake - 15° for 15° positive square SPHX inserts										Insert Qty.	SPHX Gage Insert	UPC No. 733101-
			C45-062-SP06-062		3.000	0.325	0.625	0.625	0.159	0.750	1			65410	
			C45-075-SP06-062		3.000	0.448	0.750	0.625	0.159	0.750	2	060304		65411	
			C45XL-062-SP06-062		7.75	.0325	0.625	0.625	0.159	0.750	2			65409	

T-SLOT CUTTER			Description		C	D	Shank Size	F	H	N	No. Inserts	No. Flutes	Gage Insert	UPC No. 733101-	
			SLOT-056-TE06-050		2.594	0.563	0.500	0.234	0.690	0.266	2	1	TEHW-0602		65171
			SLOT-066-TE06-050		2.688	0.656	0.500	0.266	0.810	0.328	2	1			65172
			SLOT-078-SP06-075		3.250	0.781	0.750	0.328	0.928	0.406	2	1			65183
			SLOT-097-SP06-075		3.438	0.969	0.750	0.390	1.100	0.531	4	2	SPHX-060304		65184
			SLOT-125-SP06-100		3.938	1.250	1.000	0.484	1.375	0.660	3	1			65185
			SLOT-147-SD09-100		4.438	1.469	1.000	0.624	1.757	0.781	4	2			65186
			SLOT-184-SD09-125		4.813	1.844	1.250	0.827	2.108	1.031	5	2	SDHW-090308		65187
SLOT-222-SD09-125		5.375	2.219	1.250	1.093	2.714	1.281	6	2			65188			
SLOT-266-SD09-125		5.906	2.656	1.250	1.343	3.440	1.531	8	2			65189			



# Milling Cutters

**CHAMFER MILL**

Cutting Rake - 11° for 11° positive triangle TPHT inserts

Description	O.A.L.	Shank Size	D	D1	F	H	Insert Qty.	TPHT Gage Insert	UPC No. 733101-
30° C30-062-TP3-075	3.500	0.625	1.600	0.750	.275	1.25	2	32.52	65400
45° C45-075-TP3-075	3.500	0.750	1.517	0.750	.392	1.25	2	32.52	65402
60° C60-100-TP3-075	3.500	1.000	1.560	0.750	.484	1.25	2	32.52	65404

**15° CNMG RECYCLE MILLING CUTTER**

Cutting Rake - Negative 7° for negative 80° diamond CNMG 432 inserts

**RECYCLE MILLING CUTTER**

After the cutting edges are used on your turning toolholder, do not throw the insert away. It can be used in these milling cutters to utilize four more cutting edges that were not used in your lathe work.

End Mills Description	C	D	D1	Shank Size	F	H	Insert Qty.	CNMG Gage Insert	UPC No. 733101-
REC 15-200-CN4-075	3.750	2.0	2.25	0.75	.45	1.50	3		65850
REC 15-200-CN4-100	4.000	2.0	2.25	1.00	.45	1.50	3	432	65852
REC 15-200-CN4-R8	5.625	2.0	2.25	R8	.45	1.75	3		65854

Face Mills Description	C	D	D1	Shank Size	F	H	H1	Insert Qty.	CNMG Gage Insert	UPC No. 733101-
REC 15A-300-CN4-100	1.750	3.0	3.23	1.00	.45	.250	.375	4		65856
REC 15A-400-CN4-150	2.000	4.0	4.23	1.50	.45	.375	.625	5	432	65858
REC 15A-500-CN4-150	2.000	5.0	5.23	1.50	.45	.375	.625	6		65860

**90° FACE MILL**

Cutting Rake - 15° for 15° positive square SDMT inserts

**4 Cutting Edges**

Description	C	D	Shank Size	F	H	H1	Insert Qty.	SDMT Gage Insert	UPC No. 733101-
M172D150	1.58	1.58	0.75	0.50	.187	.312	4		65460
M172D200	1.58	1.97	1.00	0.50	.250	.375	5		65461
M172D250	1.58	2.48	1.00	0.50	.250	.375	6	1205	65462
M172D300	1.97	3.14	1.50	0.50	.375	.625	7		65463
M172D400	1.97	3.94	1.50	0.50	.375	.625	8		65464

**WOODRUFF KEY SEAT CUTTER**

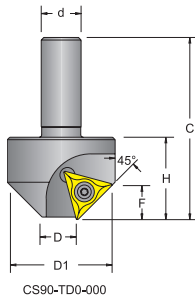
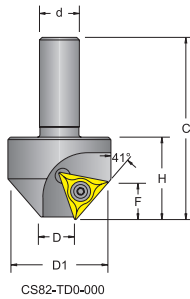
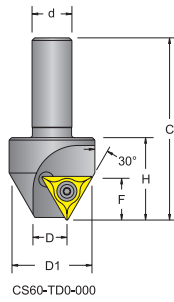
Cutting Rake - 20° for positive TEHW inserts

American Standard Size	Description	C	D	d	F	Insert Qty.	TEHW Gage Insert	Insert Torx Screw	Torx Key	Part No. 733101-
606	DWKC-606-TEO6-050	2.188	0.750	0.500	0.188	2				65140
806	DWKC-806-TEO6-050	2.250	0.750	0.500	0.250	2				65141
607	DWKC-607-TEO6-050	2.188	0.875	0.500	0.188	2				65142
707	DWKC-707-TEO6-050	2.219	0.875	0.500	0.219	2	0602	TS-06	T-6	65143
807	DWKC-807-TEO6-050	2.250	0.875	0.500	0.250	2				65144
608	DWKC-608-TEO6-050	2.188	1.000	0.500	0.188	3				65145
708	DWKC-708-TEO6-050	2.219	1.000	0.500	0.219	3				65146
808	DWKC-808-TEO6-050	2.250	1.000	0.500	0.250	3	0602	TS-06	T-6	65147
1008	DWKC-1008-TEO6-050	2.313	1.000	0.500	0.313	3				65148
1208	DWKC-1205-TEO6-050	2.375	1.000	0.500	0.375	3				65149
609	DWKC-609-TEO6-050	2.188	1.125	0.500	0.188	4				65150
709	DWKC-709-TEO6-050	2.219	1.125	0.500	0.219	4	0602	TS-06	T-6	65151
809	DWKC-809-TEO6-050	2.250	1.125	0.500	0.250	4				65152
1009	DWKC-1009-TEO6-050	2.313	1.125	0.500	0.313	4				65153
610	DWKC-610-TEO6-050	2.188	1.250	0.500	0.188	6				65154
710	DWKC-710-TEO6-050	2.219	1.250	0.500	0.219	6				65155
810	DWKC-810-TEO6-050	2.250	1.250	0.500	0.250	6	0602	TS-06	T-6	65156
1010	DWKC-1010-TEO6-050	2.313	1.250	0.500	0.313	6				65157
1210	DWKC-1210-TEO6-050	2.375	1.250	0.500	0.375	6				65158
811	DWKC-811-TEO6-050	2.250	1.375	0.500	0.250	6				65159
1011	DWKC-1011-TEO6-050	2.313	1.375	0.500	0.313	6	0602	TS-06	T-6	65160
1211	DWKC-1211-TEO6-050	2.375	1.375	0.500	0.375	6				65161
812	DWKC-812-TEO6-050	2.250	1.500	0.500	0.250	6				65162
1012	DWKC-1012-TEO6-050	2.313	1.500	0.500	0.313	6	0602	TS-06	T-6	65163
1212	DWKC-1212-TEO6-050	2.375	1.500	0.500	0.375	6				65164



## COUNTERSINK

Cutting Rake -  
11° & 15° for  
11° & 15° positive  
triangle TDGH &  
TPGH inserts



### 60° Countersink For Manual Machines

Description	C	d	D	D1	F	H	Insert Qty.	TDGH & TPGH Gage Insert	Insert Torx Screw	Torx Key	Part No. 733101-
CS60-TD5-037	2.00	.375	.125	0.375	.227	0.375	1	TDGH 520	TS-06	T-6	65300
CS60-TD2-037	2.25	.375	.250	0.750	.336	1.000	1	TDGH 21.51	TS-25.45-6M1	T-8	65302
CS60-TD3-050	2.50	.500	.500	1.250	.523	1.000	1	TDGH 321	TS-4.7-8M1	T-15	65304
CS60-TP3-075	3.50	.750	.600	2.500	.523	1.250	1	TPGH 321	TS-4.7-8M1	T-15	65307

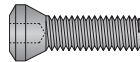
### 82° Countersink For Manual Machines

Description	C	d	D	D1	F	H	Insert Qty.	TDGH & TPGH Gage Insert	Insert Torx Screw	Torx Key	Part No. 733101-
CS82-TD5-037	2.00	.375	.125	0.469	.197	0.375	1	TDGH 520	TS-06	T-6	65308
CS82-TD2-037	2.25	.375	.250	0.687	.291	1.000	1	TDGH 21.51	TS-25.45-6M1	T-8	65310
CS82-TD3-050	2.50	.500	.500	1.250	.455	1.000	1	TDGH 321	TS-4.7-8M1	T-15	65312
CS82-TP3-075	3.50	.750	.600	2.500	.455	1.250	1	TPGH 321	TS-4.7-8M1	T-15	65315

### 90° Countersink For Manual Machines

Description	C	d	D	D1	F	H	Insert Qty.	TDGH & TPGH Gage Insert	Insert Torx Screw	Torx Key	Part No. 733101-
CS90-TD5-037	2.00	.375	.125	0.500	.185	0.375	1	TDGH 520	TS-06	T-6	65316
CS90-TD2-037	2.25	.375	.250	0.750	.272	1.000	1	TDGH 21.51	TS-25.45-6M1	T-8	65318
CS90-TD3-050	2.50	.500	.500	1.250	.426	1.000	1	TDGH 321	TS-4.7-8M1	T-15	65320
CS90-TP3-075	3.50	.750	.560	2.500	.426	1.250	1	TPGH 321	TS-4.7-8M1	T-15	65323

### Spare Parts Milling Insert Torx Screw



Description	UPC No. 733101-	PKG.
TS-06	91306	
TS-25.45-6M2	90972	10
TS-4.7-6M1	90975	
TS-4.7-8M1	90976	
TS-4.7-10M1	90982	
TS-1032-5M1	90960	10
TS-5.8-10M1	90986	



# Milling Inserts for Speciality Milling Cutters

**At Dorian Tool we have created a great insert to mill a wide spectrum of materials including;**

- Aerospace Inconel
- Titanium & High Temper Alloys
- Stainless Steel
- Cast Iron
- Copper
- Brass
- Hardened Alloy Steel to HRC 62

**New Coatings**  
Using the latest and most advanced technology for the coating to give the insert the optimum performance in any milling application and materials.

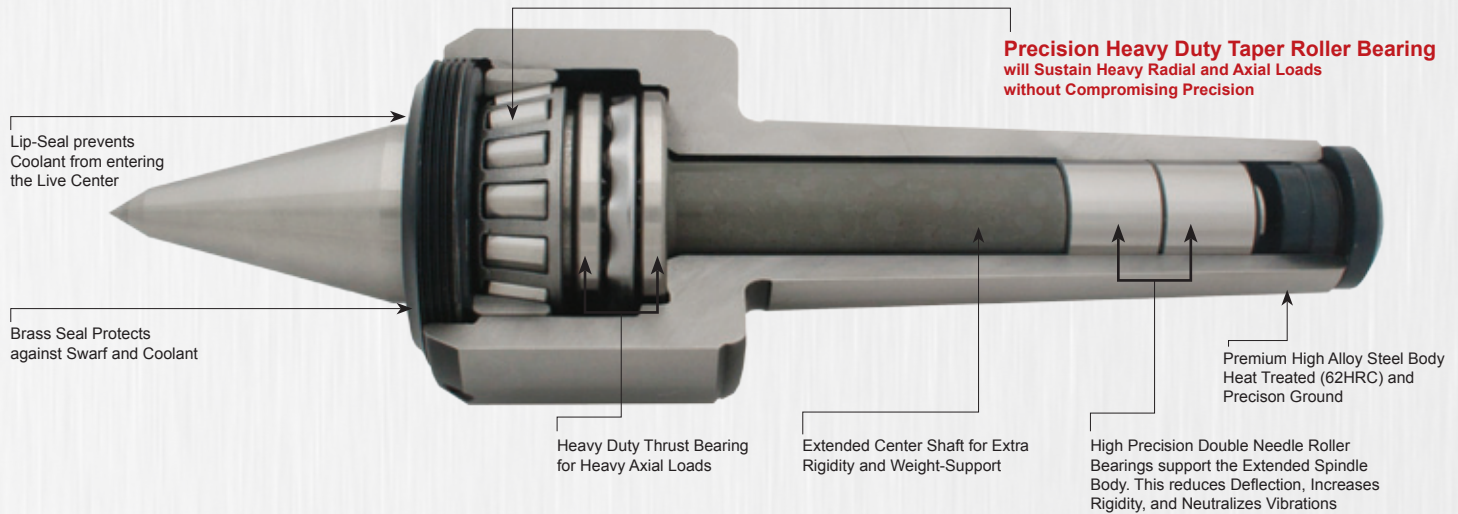
Cutting Condition	General Purpose			High Performance
Application	Non-Ferrous		Ferrous	Ferrous
Dorian Insert Grade	DASK25B	DUP25UT	DASP35B	DHP440F
Description	UPC No. 733101-			
SDMT-1205-ER-			95913	95907
TDEX-110204-EN	95422		95426	95428
TDEX-110208-EN	95432		95436	95438
TDEX-160304-EN	95442		95446	95448
TDEX-160308-EN	95452		95456	95458
TDEX-220404-EN	95462		95466	95468
TDEX-220408-EN	95472		95476	95478
TDEX-090202-EN	95492		95495	95496
TDEX-090204-EN	95502		95505	95506
TDEX-17T304-EN	95512		95515	95516
TDEX-17T308-EN	95522		95525	95526
TDEX-250404-EN	95532		95535	95538
TDEX-250408-EN	95542		95545	95548
TDGH-520-EZ			95350	
TDGH-21.51-EZ			95352	
TDGH-321-EZ			95354	
TEHW-0602-AEEN	95593		95595	95596
SDGX-09C01-E-		95299		
SDGX-09C02-E-		95303		
SDGX-09C03-E-		95307		
SDGX-09C04-E-		95311		
SDGX-19C05-E-		95250		
SDGX-19C06-E-		95254		
SDGX-19C07-E-		95258		
SDGX-19C08-E-		95262		
SDGX-19C09-E-		95266		
SDGX-19C10-E-		95270		
SDGX-19C11-E-		95274		
SDGX-19C12-E-		95278		
SDGX-19C13-E-		95282		
SDGX-19C14-E-		95286		
SDGX-19C15-E-		95290		
SDGX-19C16-E-		95294		
SDHW-090308-EN	94998		95002	
SPHX-060304-EN	95044		95046	95048

Insert Type
SDMT 
TDEX 60° 
TDEX 45° 
TDGH 
TEHW 
SDGX 
SDHW 
SPHX 

For more information you can download our Milling catalog at [www.doriantool.com](http://www.doriantool.com), or call 979-282-2861



# High Performance Perfetta™ Live Centers



## Precision General Purpose Live Center - High Quality • Long Life

- Maximum .00007" Runout
- High Speed Precision Triple Bearings
- The Bearings are Permanently Lubricated



Precision Live Center					
UPC 733101-	Description	Morse Taper	Max. RPM	Max. workpiece weight (lb)	Thrust load (lb)
48200	PLC-PRE-S60-MT1	1	8500	98	365
48201	PLC-PRE-S60-MT2	2	6000	220	792
48202	PLC-PRE-S60-MT3	3	5000	572	1144
48203	PLC-PRE-S60-MT4	4	4000	1078	1320
48204	PLC-PRE-S60-MT5	5	3000	1672	1430
48205	PLC-PRE-S60-MT6	6	2500	3388	3300

## Heavy Duty Live Center - For High Performance Heavy Duty Turning Applications

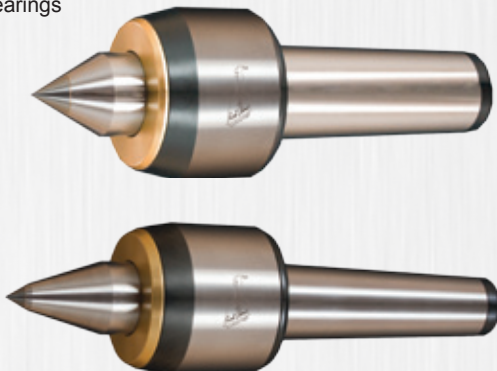
- Maximum .00007" Runout
- Super Heavy Duty Quad Bearings
- The Bearings are Permanently Lubricated



Heavy Duty Live Center					
UPC 733101-	Description	Morse Taper	Max. RPM	Max. workpiece weight (lb)	Thrust load (lb)
48206	PLC-HDA-S60-MT2	2	7500	506	1012
48207	PLC-HDA-S60-MT3	3	6000	2090	1144
48208	PLC-HDA-S60-MT4	4	4500	3300	1320
48209	PLC-HDA-S60-MT5	5	2800	4400	2460
48210	PLC-HDA-S60-MT6	6	2000	10560	3300
48211	PLC-HDA-S60-MT6-S	6	1700	19800	6600

## CNC High Speed Heavy Duty Live Center - For High Performance CNC Turning Applications

- Maximum .00005" Runout
- High Speed Precision
- Bearings Are Permanently Lubricated
- Quad Bearings

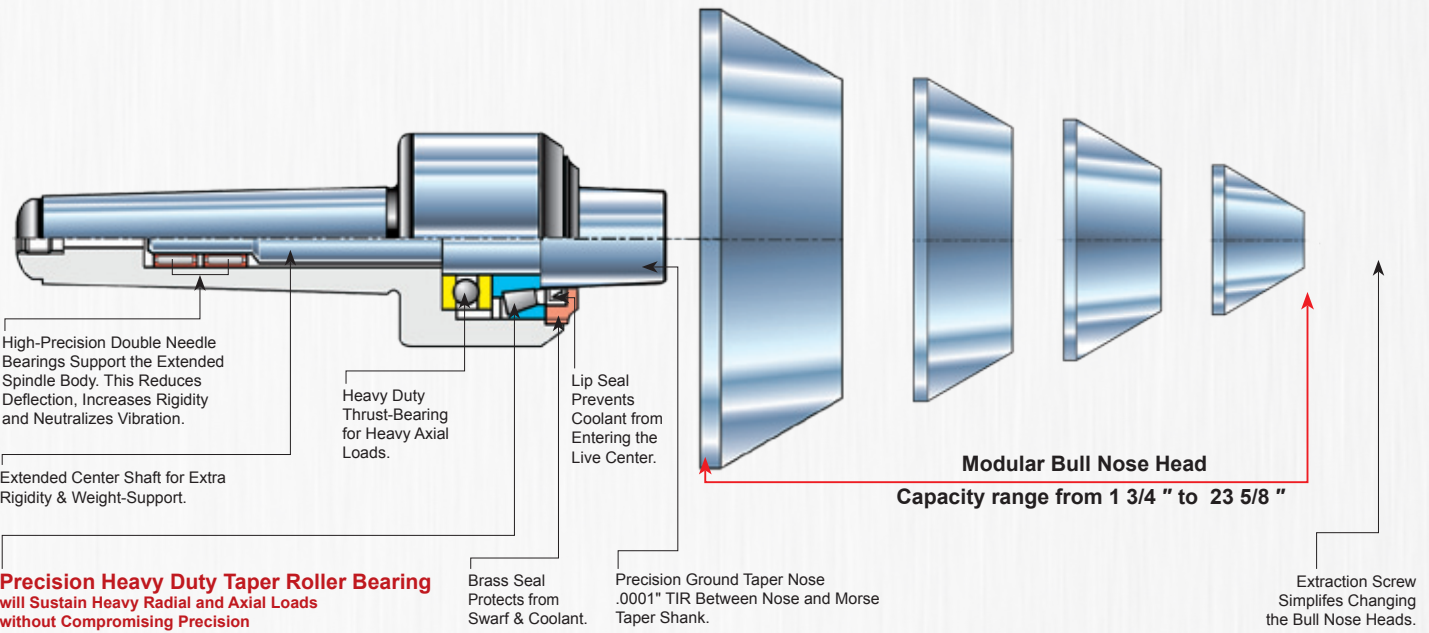


CNC High Speed Heavy Duty Live Center With 60° Steel Tip					
UPC 733101-	Description	Morse Taper	Max. RPM	Max. Workpiece Weight (lbs)	Thrust load (lbs)
48220	PLC-CNC-S60-MT3	3	7000	1386	1144
48221	PLC-CNC-S60-MT4	4	5500	1883	1439
48222	PLC-CNC-S60-MT5	5	4500	2860	2486
48223	PLC-CNC-S60-MT6	6	3200	3740	2508

CNC High Speed Heavy Duty Live Center With Extended Point					
UPC 733101-	Description	Morse Taper	Max. RPM	Max. Workpiece Weight (lbs)	Thrust load (lbs)
48232	PLC-CNC-EXS-MT3	3	7000	1386	1144
48233	PLC-CNC-EXS-MT4	4	5500	1883	1439
48234	PLC-EXS-EXS-MT5	5	4500	2860	2486
48235	PLC-EXS-EXS-MT6	6	3200	3300	2508



## Built for the Petroleum Industry



### Extra Heavy Duty Modular Bull Nose Live Center

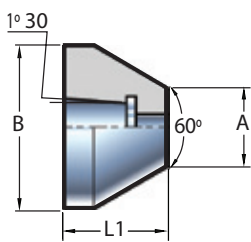


UPC No. 733101-	Description	Morse Taper	Max. RPM	Max. workpiece weight (lb)	Thrust load (lb)
48400	PLC-HDA-BN-MT3	3	6000	2090	1144
48401	PLC-HDA-BN-MT4	4	4500	3300	1320
48402	PLC-HDA-BN-MT5	5	2800	4400	2640
48403	PLC-HDA-BN-MT6	6	2000	10560	3300
48404	PLC-HDA-BN-MT6X	6	1700	19800	6600

### CNC Modular Bull Nose Dead Center

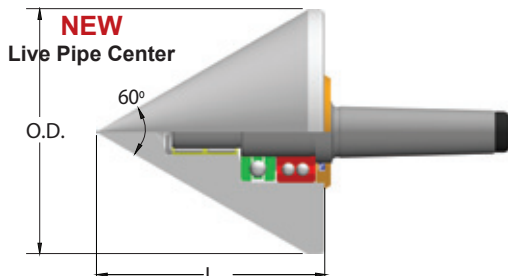


UPC 733101-	Description	Morse Taper
48406	PLC-CNC-BNDC-MT3	3
48407	PLC-CNC-BNDC-MT4	4
48408	PLC-CNC-BNDC-MT5	5
48409	PLC-CNC-BNDC-MT6	6



### Modular Bull Nose Head Adapters

UPC No. 733101-	48420	48421	48422	48423	48424	48425	48426	48427	48428	48429	48430
Description	PLCBN-HA-0177-0386	PLCBN-HA-0374-0583	PLCBN-HA-0571-0780	PLCBN-HA-0768-0977	PLCBN-HA-0965-1174	PLCBN-HA-1162-1371	PLCBN-HA-1359-1568	PLCBN-HA-1556-1765	PLCBN-HA-1753-1962	PLCBN-HA-1950-2147	PLCBN-HA-2147-2364
A	1.77	3.74	5.71	7.68	9.65	11.62	13.59	15.56	17.53	19.50	21.47
B	3.86	5.83	7.80	9.77	11.74	13.71	15.68	17.65	19.62	21.47	23.64
L1	2.17	2.17	2.17	2.17	2.17	2.17	2.17	2.17	2.17	2.17	2.17
Nose Taper	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°	60°



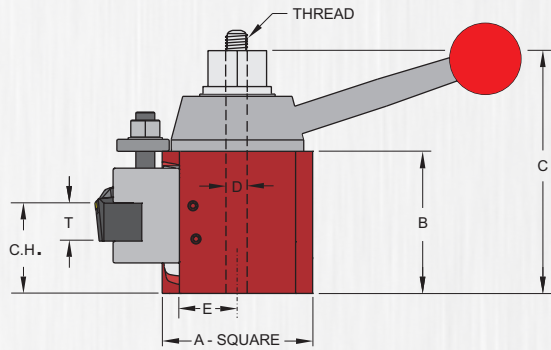
### Live Pipe Center

UPC 733101-	Description	OD in	L in	Morse Taper	Max. workpiece weight	Max. RPM	Thrust load
48390	PLC-MT4-6000	5.91	5.94	MT4	7700 lbs	4500	3372 lbs
48391	PLC-MT5-6000	5.91	5.94	MT5	7700 lbs	4500	3372 lbs
48392	PLC-MT6-6000	5.91	5.94	MT6	7700 lbs	4500	3372 lbs



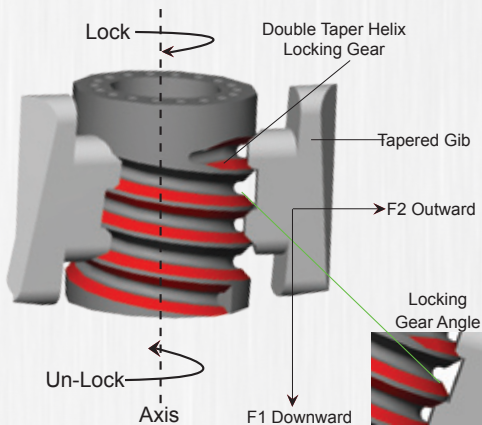
## SUPER Quick Change Tool Post with Triple Action Wedge Style Locking System

- Zero Backlash
- Triple Action Wedge Style Locking System
- Precise Repeatability within .0001
- 15° Locking Handle Position Adjustment
- Industry-Standard Interchangeable Holders
- Thousands of pounds of locking force with a finger tip



### Featuring The Triple Action Wedge-Locking System

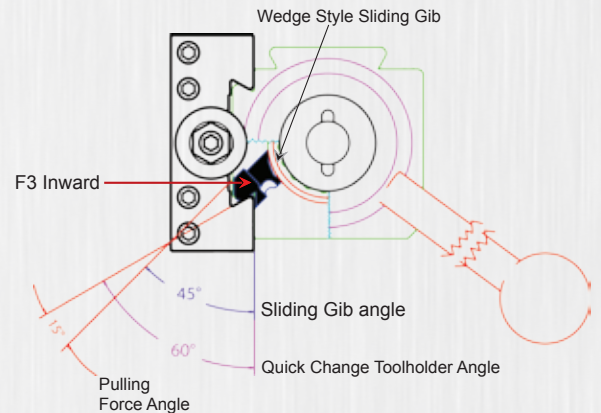
with a powerful combination of a downward, outward and inward force simultaneously locking the holder.



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

**2. F2 Outward Force:** (shown left) When the gibs make full contact with the toolholder dovetail, the double-angle helix of the locking gear forces the gib outward, neutralizing any backlash to zero.

**3. F3 Inward Force:** (shown below) The differential between the sliding gib angle and the quick change holder angle pulls the toolholder towards the tool post dovetail surface, creating a one-piece locking effect.



Description	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
Part No. 733101-	01000	01002	01004	01006	01008	01010
Lathe Swing Over Bed	≤12	13-15	14-17	16-20	17-32	≥25
A	2.625	3.000	3.500	4.000	5.000	6.000
B	2.500	2.750	3.250	3.750	4.625	5.000
C	4.240	4.710	5.650	6.335	7.435	8.060
D	0.500	0.625	0.750	0.875	1.000	1.125
E	0.880	1.115	1.199	1.530	1.900	2.207
T-Tool Capacity*	1/2-3/4	5/8-1.0	3/4-1.0	1.0-1 1/4	1 1/4-1 1/2	1 1/2
Optimum C.H.**	1.250	1.312	1.625	1.937	2.562	3.000
C.H. MIN.	0.875	1.062	1.250	1.562	2.000	2.500
C.H. MAX.	1.875	1.937	2.250	2.562	3.575	3.500
Thread	1/2-20	5/8-18	3/4-16	7/8-14	1.0-14	1 1/8-12

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



# SUPER Quick Change Toolholders

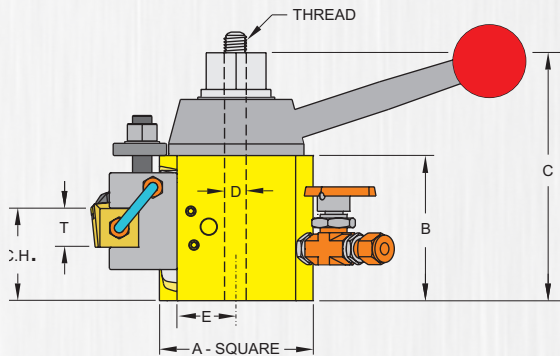
Use With SDN Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
<b>Turning &amp; Facing</b> 	D25AXA-1 Tool Capacity 1/2" to 3/4"	D30BXA-1 Tool Capacity 5/8" to 1"	D35CXA-1 Tool Capacity 3/4" to 1"	D40CA-1 Tool Capacity 1" to 1 1/4"	D50DA-1 Tool Capacity 1 1/4" to 1 1/2"	D60EA-1 Tool Capacity 1 1/2"
Part No.733101-	01100	01250	01400	01550	01700	01850
<b>Turning, Facing and Boring</b> 	D25AXA-2 Tool Capacity 1/2" to 3/4"	D30BXA-2 Tool Capacity 5/8" to 1"	D35CXA-2 Tool Capacity 3/4" to 1"	D40CA-2 Tool Capacity 1" to 1 1/4"	D50DA-2 Tool Capacity 1 1/4" to 1 1/2"	D60EA-2 Tool Capacity 1 1/2"
Part No.733101-	01104	01254	01404	01554	01704	01854
<b>Heavy Duty Boring</b> 	D25AXA-4-CNC Tool Capacity 3/4"	D30BXA-4-CNC Tool Capacity 1"	D35CXA-4-CNC Tool Capacity 1"	D40CA-4-CNC Tool Capacity 1 1/4"	D50DA-4-CNC Tool Capacity 1 1/2"	D60EA-4-CNC Tool Capacity 2"
Part No.733101-	01110	01260	01410	01560	01710	01860
<b>Extra Heavy Duty Boring</b> 	D25AXA-41-CNC Tool Capacity 1"	D30BXA-41-CNC Tool Capacity 1 1/4"	D35CXA-41-CNC Tool Capacity 1 1/4"	D40CA-41-CNC Tool Capacity 1 1/2"	D50DA-41-CNC Tool Capacity 2"	D60EA-41-CNC Tool Capacity 2 1/2"
Part No.733101-	01114	01264	01414	01564	01714	01864
<b>Oversized Extra Heavy Duty Boring</b> 	-	-	D35CXA-41-150-CNC Tool Capacity 1 1/2"	D40CA-41-200-CNC Tool Capacity 2"	D50DA-41-250-CNC Tool Capacity 2 1/2"	D60EA-41-300-CNC Tool Capacity 3"
Part No.733101-			01418	01568	01718	01868
<b>Morse Taper</b> 	D25AXA-5-2 Tool Capacity Morse Taper 2	D30BXA-5-3 Tool Capacity Morse Taper 3	D35CXA-5-4 Tool Capacity Morse Taper 4	D40CA-5-4 Tool Capacity Morse Taper 4	D50DA-5-5 Tool Capacity Morse Taper 5	D60EA-5-5 Tool Capacity Morse Taper 5
Part No.733101-	01122	01272	01424	01572	01722	01872
<b>Extra HD Cut-Off Blade Toolholder</b> 	D25AXA-7-71C Blade Size 19-2	D30BXA-7-71C Blade Size 19-2	D35CXA-7-71C Blade Size 26-2 to 26-6	D40CA-7-71C Blade Size 26-2 to 26-6	D50DA-7-71C Blade Size 32-3 to 32-9	D60EA-7-71C Blade Size 32-3 to 32-9
Part No.733101-	01126	01276	01428	01576	01726	01876
<b>ID &amp; OD Threading</b> 	D25AXA-881-OE On Edge for OD Laydown for ID	D30BXA-881-OE On Edge for OD Laydown for ID	D35CXA-881-OE On Edge for OD Laydown for ID	D40CA-881-OE On Edge for OD Laydown for ID	For more technical specifications, refer to our Lathe Accessories Catalog or call us at 800-627-0266. Specifications subject to change without notice. 	
Part No.733101-	01132	01282	01434	01582		
<b>Dovetail Drill Chuck Holder</b> 	D25AXA-35 Tool Capacity 0-12"	D30BXA-35 Tool Capacity 0-12"	D35CXA-35 Tool Capacity 0-12"	D40CA-35 Tool Capacity 0-12"		
Part No.733101-	01140	01290	01442	01590		
<b>5C Collet Holder</b> 	D25AXA-36 5C Collet	D30BXA-36 5C Collet	D35CXA-36 5C Collet	D40CA-36 5C Collet		
Part No.733101-	01142	01292	01444	01592		





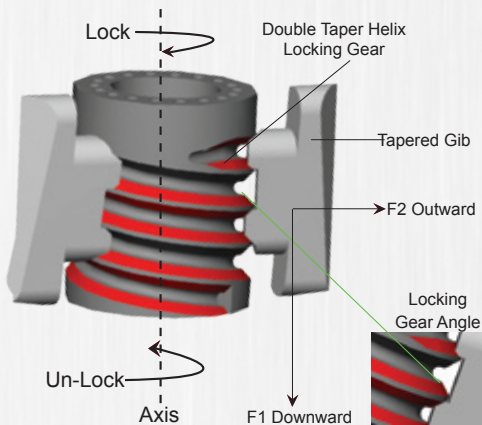
## Victory™ Automatic Thru Coolant Tool Post with Triple Action Wedge Style Locking System

- Zero Backlash
- Triple Action Wedge Style Locking System
- Precise Repeatability within .0001
- 15° Locking Handle Position Adjustment
- Industry-Standard Interchangeable Holders
- Thousands of pounds of locking force with a finger tip
- Automatic Thru Coolant Activation and Shut-off



### Featuring The Triple Action Wedge-Locking System

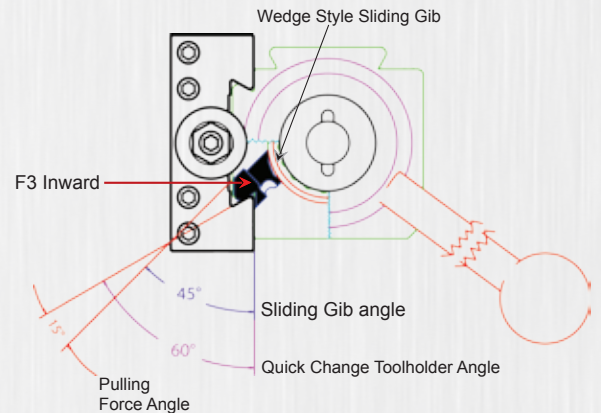
with a powerful combination of a downward, outward and inward force simultaneously locking the holder.



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

**2. F2 Outward Force:** (shown left) When the gibs make full contact with the toolholder dovetail, the double-angle helix of the locking gear forces the gib outward, neutralizing any backlash to zero.

**3. F3 Inward Force:** (shown below) The differential between the sliding gib angle and the quick change holder angle pulls the toolholder towards the tool post dovetail surface, creating a one-piece locking effect.



Description	V25tc	V30tc	V35tc	V40tc	V50tc	V60tc
Part No. 733101-	04200	04201	04202	04203	04204	04205
Lathe Swing Over Bed	≤12	13-15	14-17	16-20	17-32	≥25
A	2.625	3.000	3.500	4.000	5.000	6.000
B	2.500	2.750	3.250	3.750	4.625	5.000
C	4.240	4.710	5.650	6.335	7.435	8.060
D	0.500	0.625	0.750	0.875	1.000	1.125
E	0.880	1.115	1.199	1.530	1.900	2.207
T-Tool Capacity*	1/2-3/4	5/8-1.0	3/4-1.0	1.0-1 1/4	1 1/4-1 1/2	1 1/2
Optimum C.H.**	1.250	1.312	1.625	1.937	2.562	3.000
C.H. MIN.	0.875	1.062	1.250	1.562	2.000	2.500
C.H. MAX.	1.875	1.937	2.250	2.562	3.575	3.500
Thread	1/2-20	5/8-18	3/4-16	7/8-14	1.0-14	1 1/2-12

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



# Victory™ Automatic Thru Coolant Toolholders

Use With Victory™ Tool Post	V25tc	V30tc	V35tc	V40tc	V50tc	V60tc
<b>Turning &amp; Facing</b>  Tool Capacity 1/2" to 3/4" <b>Part No.733101-</b>	V25tc-1 04210	V30tc-1 04230	V35tc-1 04250	V40tc-1 04270	V50tc-1 04290	V60tc-1 04305
<b>Turning, Facing and Boring</b>  Tool Capacity 1/2" to 3/4" <b>Part No.733101-</b>	V25tc-2 04211	V30tc-2 04231	V35tc-2 04251	V40tc-2 04271	V50tc-2 04291	V60tc-2 04306
<b>Heavy Duty Boring</b>  Tool Capacity 3/4" <b>Part No.733101-</b>	V25tc-4-CNC 04212	V30tc-4-CNC 04232	V35tc-4-CNC 04252	V40tc-4-CNC 04272	V50tc-4-CNC 04292	V60tc-4-CNC 04307
<b>Extra Heavy Duty Boring</b>  Tool Capacity 1" <b>Part No.733101-</b>	V25tc-41-CNC 04214	V30tc-41-CNC 04234	V35tc-41-CNC 04254	V40tc-41-CNC 04274	V50tc-41-CNC 04294	V60tc-41-CNC 04309
<b>Oversized Extra Heavy Duty Boring</b>  <b>Part No.733101-</b>	-	-	V35tc-41-150-CNC Tool Capacity 1 1/2" 04256	V40tc-41-200-CNC Tool Capacity 2" 04276	V50tc-41-250-CNC Tool Capacity 2 1/2" 04296	V60tc-41-300-CNC Tool Capacity 3" 04311
<b>Morse Taper</b>  Tool Capacity Morse Taper 2 <b>Part No.733101-</b>	V25tc-5-2 04218	V30tc-5-3 04238	V35tc-5-4 04258	V40tc-5-4 04278	V50tc-5-5 04298	V60tc-5-5 Tool Capacity <b>Morse Taper 5</b> 04313
<b>Extra HD Cut-Off Blade Toolholder</b>  Blade Size 19-2 <b>Part No.733101-</b>	V25tc-7-71C 04219	V30tc-7-71C 04239	V35tc-7-71C 04259	V40tc-7-71C 04279	V50tc-7-71C 04299	V60tc-7-71C Blade Size <b>32-3 to 32-9</b> 04314
<b>ID &amp; OD Threading</b>  On Edge for OD Laydown for ID <b>Part No.733101-</b>	V25tc-881-OE 04220	V30tc-881-OE 04240	V35tc-881-OE 04260	V40tc-881-OE 04280	For more technical specifications, refer to our Lathe Accessories Catalog or call us at 800-627-0266. Specifications subject to change without notice. 	
<b>Dovetail Drill Chuck Holder</b>  Tool Capacity 0-12" <b>Part No.733101-</b>	V25tc-35 04222	V30tc-35 04242	V35tc-35 04262	V40tc-35 04282		
<b>5C Collet Holder</b>  5C Collet <b>Part No.733101-</b>	V25tc-36 04223	V30tc-36 04243	V35tc-36 04263	V40tc-36 04283		



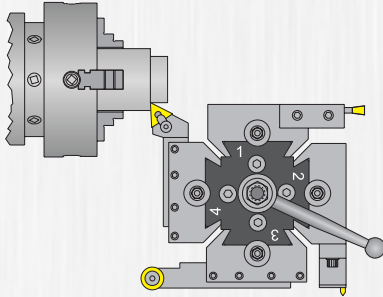
The Multi-Patented Tool Post with The Most Advanced Indexing and Locking Technology

## Locking and Indexing System

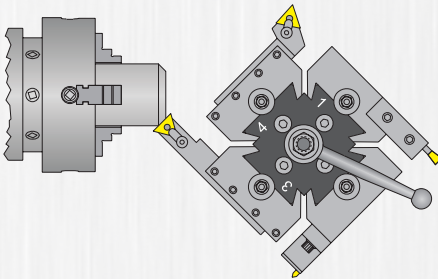
24 Super Precise Positioning Ball Bearings  
& 2 Pre-Loaded Indexing Pins

**Strong - Rigid - Precise!**

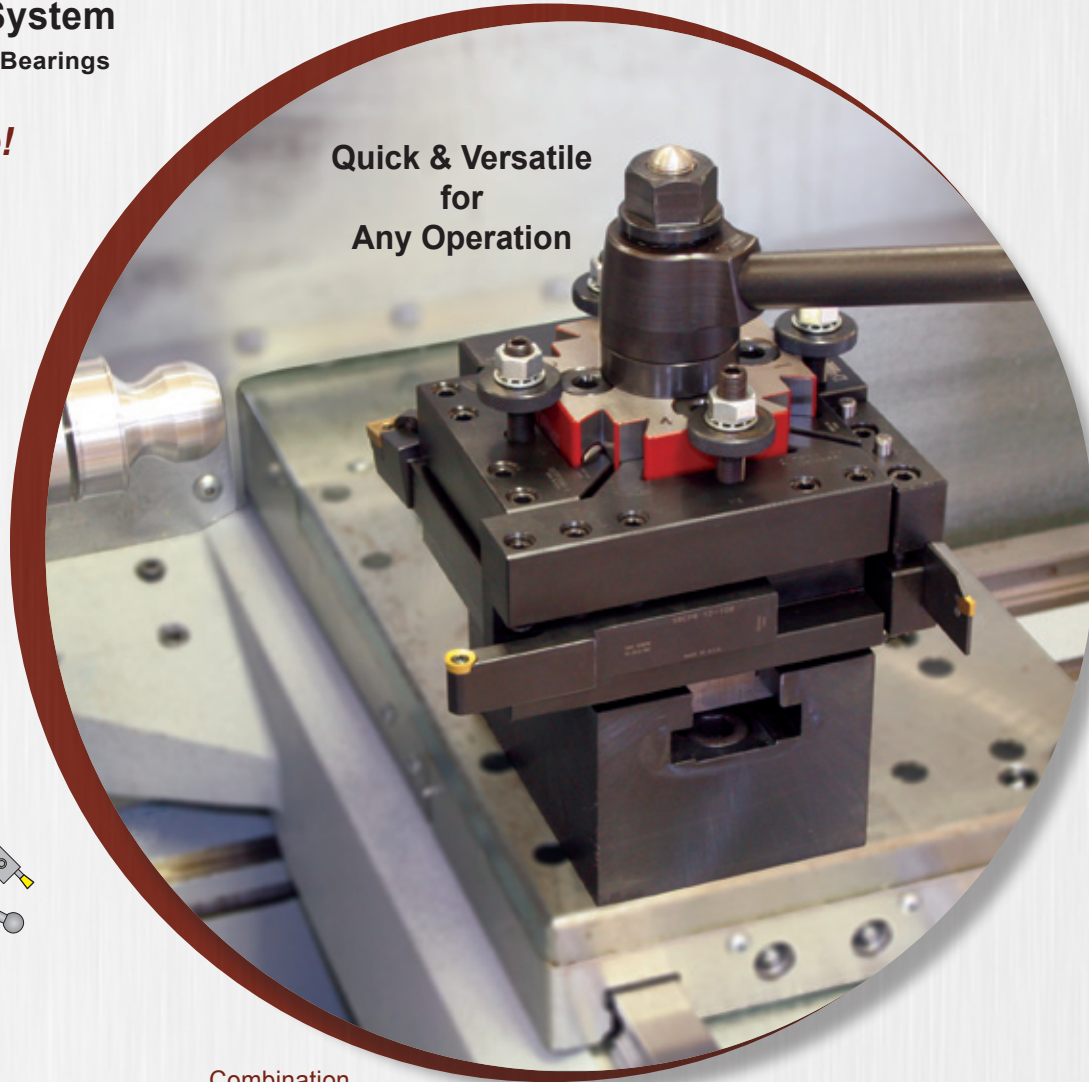
O.D. Turning Operations



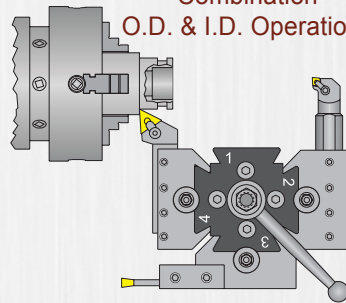
O.D. Chamfering Operations  
15° Increments



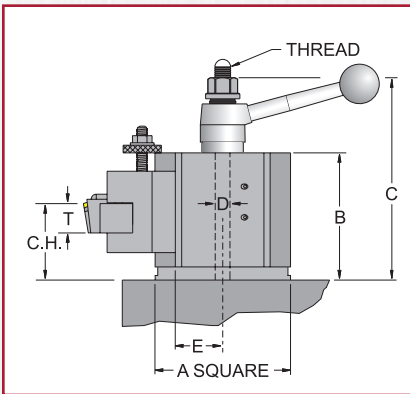
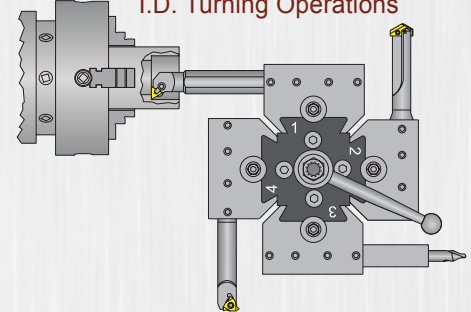
Quick & Versatile  
for  
Any Operation



Combination  
O.D. & I.D. Operations



I.D. Turning Operations



Description	QITP25N 00000		QITP30N 00002		QITP35N 00004		QITP40N 00006		QITP50N 00008		QITP60N 00010	
Part No. 733101-	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
Size	≤12"	≤300,0	13-15"	320,0	14-17"	400,0	16-20"	450,0	17-32"	500,0	≥25-XHD	XHD
Lathe Swing Over Bed												
A	2.500	63.5	3.000	76.2	3.500	88.9	4.000	101.60	5.000	127.0	6.000	152.4
B	2.570	65.3	3.205	81.4	3.460	87.9	4.070	103.4	5.230	132.8	5.615	142.6
C	5.210	132.3	5.720	145.3	6.415	162.9	7.525	191.1	9.135	232.0	9.855	250.3
D	0.500	12.7	0.500	12.7	0.625	16.0	0.750	19.0	1.000	25.40	1.125	28.6
E	0.880	22.4	1.115	28.3	1.245	31.6	1.530	38.9	1.897	48.2	2.207	56.1
T-Tool Capacity	1/2-3/4	12-20	5/8-1.0	16-25	3/4-1.0	20-25	1.0-1 1/4	25-32	1 1/4 - 1 1/2	32-40	1 1/2	40.0
Optimum C.H.*	1.422	36.1	1.747	44.4	1.835	46.6	2.202	55.9	2.995	76.1	3.440	87.4
C.H. MIN.	0.995	25.3	1.213	30.8	1.445	36.7	1.757	44.6	2.245	57.0	2.750	69.9
C.H. MAX.	1.849	50.0	2.282	58.0	2.225	56.5	2.646	67.2	3.744	95.1	4.129	104.9
Thread	1/2-20	M12x1,75	1/2-20	M12x1,75	5/8-18	M16x2,0	3/4-16	M18x2,5	1.0-14	M24x3,0	1 1/8-12	M27x3,0

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



# Quadra® Indexing Toolholders

Use With Quadra Tool Post	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
<b>Turning &amp; Facing</b>  Tool Capacity 1/2" to 3/4" <b>Part No.733101-</b>	QITP25N-1  00100	QITP30N-1  00250	QITP35N-1  00400	QITP40N-1  00550	QITP50N-1  00700	QITP60N-1  00850
<b>Turning, Facing and Boring</b>  Tool Capacity 1/2" to 3/4" <b>Part No.733101-</b>	QITP25N-2  00104	QITP30N-2  00254	QITP35N-2  00404	QITP40N-2  00554	QITP50N-2  00704	QITP60N-2  00854
<b>Heavy Duty Boring</b>  Tool Capacity 3/4" <b>Inch Part No.733101-</b>	QITP25N-4-CNC  00110	QITP30N-4-CNC  00260	QITP35N-4-CNC  00410	QITP40N-4-CNC  00560	QITP50N-4-CNC  00710	QITP60N-4-CNC  00860
<b>Extra Heavy Duty Boring</b>  Tool Capacity 1" <b>Part No.733101-</b>	QITP25N-41-CNC  00114	QITP30N-41-CNC  00264	QITP35N-41-CNC  00414	QITP40N-41-CNC  00564	QITP50N-41-CNC  00714	QITP60N-41-CNC  00864
<b>Morse Taper</b>  Tool Capacity Morse Taper 2 <b>Part No.733101-</b>	QITP25N-5-2  00122	QITP30N-5-3  00272	QITP35N-5-4  00424	QITP40N-5-4  00572	QITP50N-5-5  00722	QITP60N-5-5  00872
<b>Extra HD Cut-Off Blade Toolholder</b>  Blade Size 19-2 <b>Part No.733101-</b>	QITP25N-7-71C  00126	QITP30N-7-71C  00276	QITP35N-7-71C  00428	QITP40N-7-71C  00576	QITP50N-7-71C  00726	QITP60N-7-71C  00876
<b>ID &amp; OD Threading Toolholder</b>  <i>Laydown Threading Bar Sold Separately</i> On Edge for OD Laydown for ID <b>Part No.733101-</b>	QITP25N-881-OE  00132	QITP30N-881-OE  00282	QITP35N-881-OE  00434	QITP40N-881-OE  00582	For more technical specifications, refer to our Lathe Accessories Catalog or call us at 800-627-0266. Specifications subject to change without notice. 	
<b>5C Collet Holder</b>  5C Collet <b>Part No.733101-</b>	QITP25N-36  00142	QITP30N-36  00292	QITP35N-36  00444	QITP40N-36  00592		

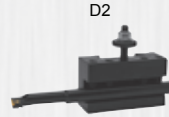


# Standard Tool Post & Toolholders Sets

## Super Quick Change Standard Sets

(1) Tool Post  
(4) Holders

Tooling Not Included

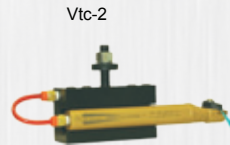


Part No. 733101-	01020	01021	01022	01023	01024	01025
Description	SDN25AXA-INSS	SDN30BXA-INSS	SDN35CXA-INSS	SDN40CA-INSS	SDN50DA-INSS	SDN60EA-INSS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
<b>5 Piece Standard Set Includes</b>						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	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

## Victory™ Thru Coolant Standard Sets

(1) Tool Post  
(4) Holders

Tooling Not Included

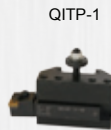


Part No. 733101-	04174	04175	04176	04177	04178	04179
Description	V25tc-SS	V30tc-SS	V35tc-SS	V40tc-SS	V50tc-SS	V60tc-SS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
<b>5 Piece Standard Set Includes</b>						
(1) Tool Post	V25tc	V30tc	V35tc	V40tc	V50tc	V60tc
(4) Holders	(1) V25tc-1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

## Quadra Indexing Standard Sets

(1) Tool Post  
(4) Holders

Tooling Not Included

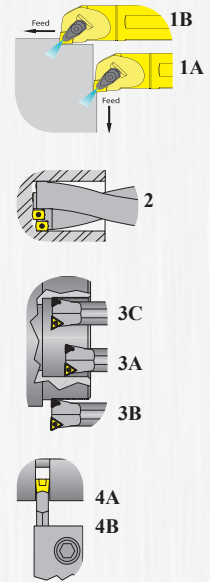
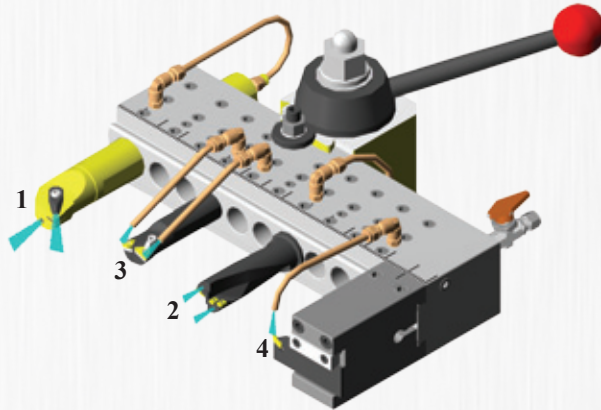
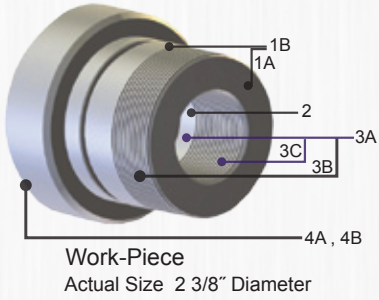


Part No. 733101-	00020	00021	00022	00023	00024	00025
Description	QITP25N-SS	QITP30N-SS	QITP35N-SS	QITP40N-SS	QITP50N-SS	QITP60N-SS
Lathe Swing	Up to 12"	13" to 15"	14" to 17"	16" to 20"	17" to 32"	≥ 25"
<b>5 Piece Standard Set Includes</b>						
(1) Tool Post	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
(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



So Simple!

One Set-Up → Full Automation → 8 Operations



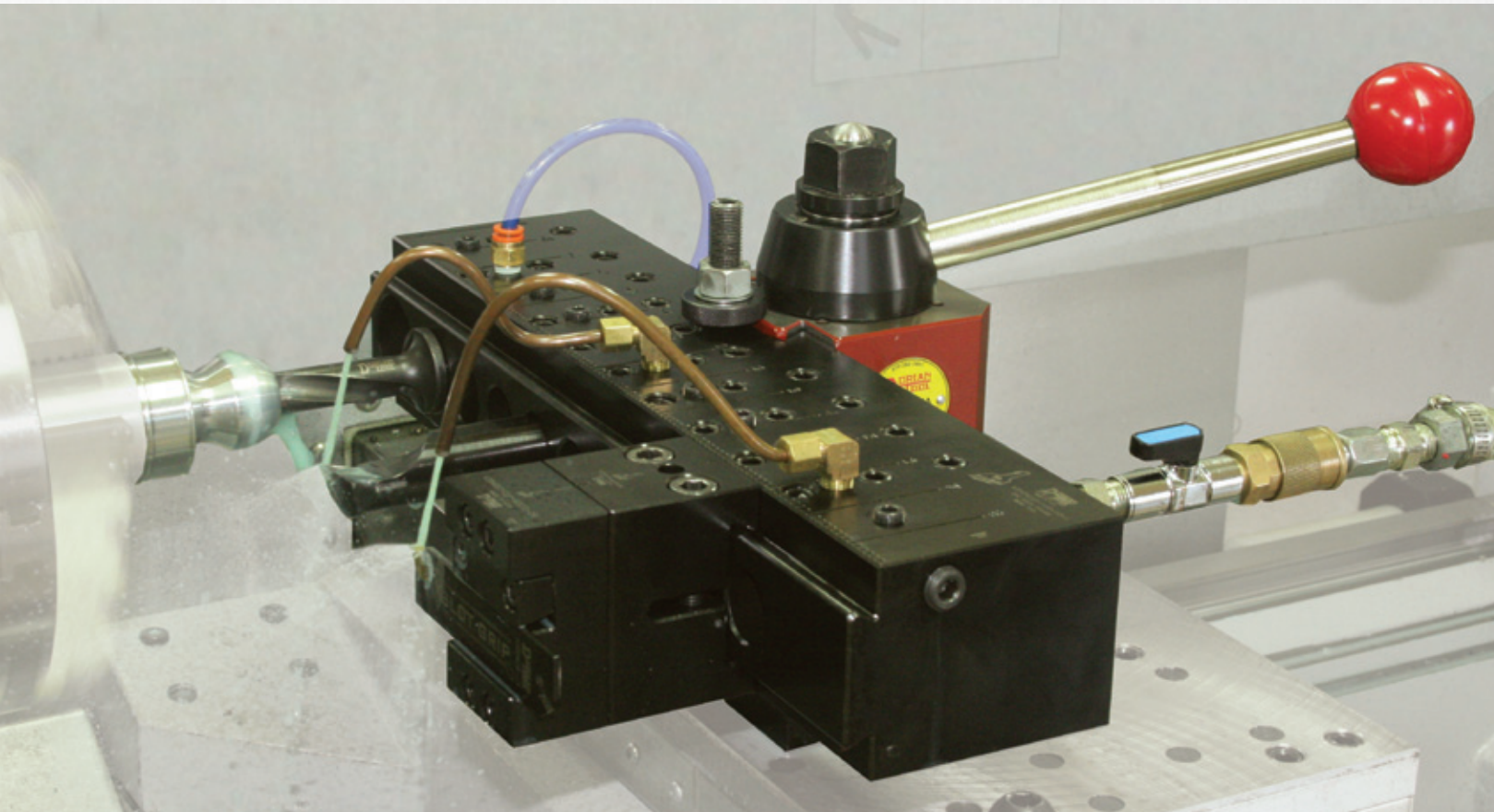
- 1. A Facing
- B Turning
- 2. Drilling
- 3. A Boring
- B O.D. Threading
- C I.D. Threading
- 4. A Grooving
- B Cut-off

Go From a Programmable Tool Room Lathe To a  
**True CNC Turning Center** and Back in Seconds

**Compact Size  
For 6 Tools**

UPC No. 733101-	Description	For use with Tool Post:	Max. T-TOOL CAP.	Max. No. of Tools
04351	V25CNCgt-075-6-I	SDN25AXA, V25TC, or QITP25N	3/4"	6
04352	V30CNCgt-075-6-I	SDN30AXA, V30TC, or QITP30N	3/4"	6
04355	V35CNCgt-100-7-I	SDN35CXA, V35TC, or QITP35N	1"	7
04356	V35CNCgt-100-10-I	SDN35CXA, V35TC, or QITP35N	1"	10
04358	V40CNCgt-100-7-I	SDN40CA, V40TC, or QITP40N	1"	7
04359	V40CNCgt-100-10-I	SDN40CA, V40TC, or QITP40N	1"	10

For more information about the gang tool please refer to our Lathe Accessories catalog.



# Installation & Setup

## How to Install

### The CNC Quick Change Gang Tool

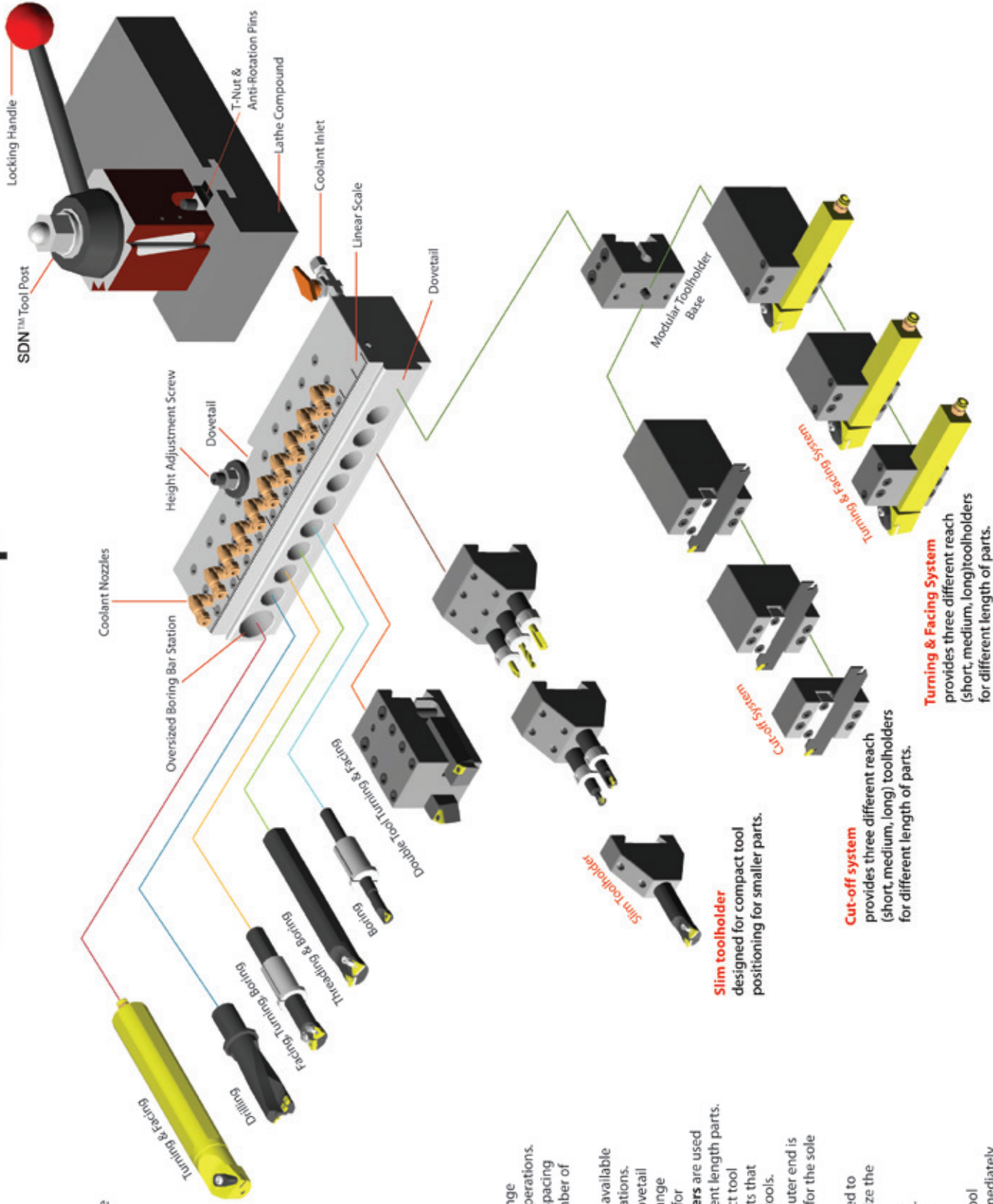
1. Align the toolpost on the cross-slide square with the x-axis.
2. Slide the CNC Quick Change Gang Tool onto the **tool post dovetail**. Lock in place with the **tool post locking handle**.
3. Connect the machine's coolant line to the **coolant inlet valve** of the CNC Quick Change Gang Tool.
4. Once the tools are installed, **adjust the center height** of the CNC Quick Change Gang Tool using the **center height adjustment screw**.

The **Modular Toolholder Base** provides fine center height adjustment for cut-off, and turning and facing systems.

## How to Setup

### The CNC Quick Change Gang Tool

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





# CNC Modular Knurling Tools

## Create any Knurling Tool Combination with Dorian's CNC Modular Knurling Tools

- Three standard shank sizes
- Seven standard knurling heads
- Shanks and Heads are all Interchangeable

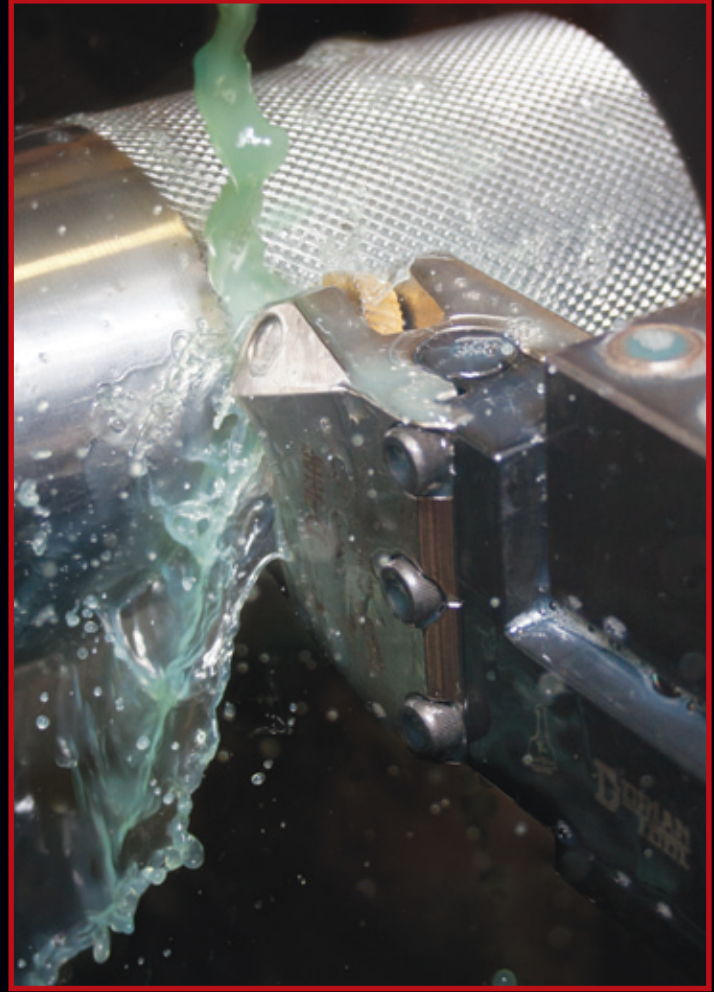
These tools offer better performance and flexibility. Every combination of knurl heads and knurl shanks, are listed on this page. Notice how many applications that can be accomplished with one CNC Modular Knurling Tool. Not only is this tool modular for a wide variety of applications it is also supplied with heavy duty parts.



CNC Modular Knurling Tool Shank

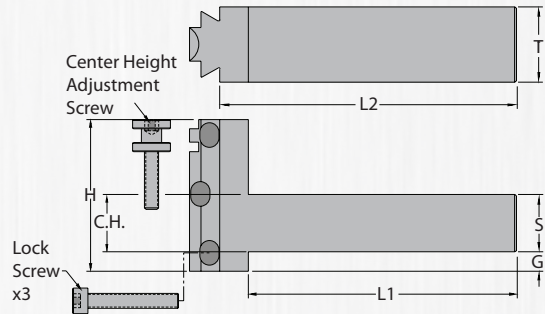


- Center height adjustment.
- Carbide knurl pin.
- Easy set-up.
- High productivity.
- Best knurl quality.
- Long knurl wheel life.
- Low production cost.
- Specifically designed for the CNC Lathe.
- Precision square shank with preset center height.
- Right or Left hand applications.
- Shanks and heads are all interchangeable.
- Supplied with TiN coated High Speed knurl wheels.



For more information refer to our 2012 Knurling Catalog.

### Three CNC Modular Knurling Tool Shank Sizes



Metric Description	UPC No. 733101-	C.H. & S mm	Inch Description	UPC No. 733101-	C.H. & S inch	G	H	L1	L2	T	Adjustment Screw		Lock Screw Set of 3	
											Description	UPC No. 733101-	Description	UPC No. 733101-
CNC-20	21005	20	CNC-75	21010	3/4"	0.250	2.000	3.500	3.875	1.000	CNC-1175	28505	CNC-1024	28515
CNC-25	21015	25	CNC-100	21020	1.0"	0.000	2.000	3.500	3.875	1.000				
CNC-32	21025	32	CNC-125	21030	1-1/4"	0.000	2.250	4.000	4.375	1.000				

Supplied with Lock Screw and Adjustment Screws.





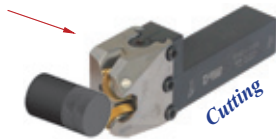
## 1 Light Duty 60° Diamond Cutting Knurling TOOL - Small Cutting Range 5/16" to 1-1/2" (8mm to 38mm)



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-1-2	20405	20	CNC-75-1-2	20410	3/4"	5 7/8"	SW2			
CNC-25-1-2	20415	25	CNC-100-1-2	20420	1"	5 7/8"	SW2	PSW-2.0S	29005	CNCKH-1-2
CNC-32-1-2	20425	32	CNC-125-1-2	20430	1 1/4"	6 3/8"	SW2			

Supplied with a set of straight high speed TiN coated knurl wheels, 30 TPI for a male diamond pattern.

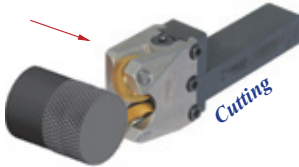
## 2 Heavy Duty 60° Diamond Cutting Knurling TOOL - Medium Cutting Range 1.0" to 5" (25mm to 125mm)



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-2-R	20505	20	CNC-75-2-R	20510	3/4"	5 7/8"	R			
CNC-25-2-R	20515	25	CNC-100-2-R	20520	1"	5 7/8"	R	KPS-25- 87-C	28925	CNCKH-2-R
CNC-32-2-R	20525	32	CNC-125-2-R	20530	1 1/4"	6 3/8"	R			

Supplied with a set of straight high speed TiN coated knurl wheels, 25 TPI for a male diamond pattern.

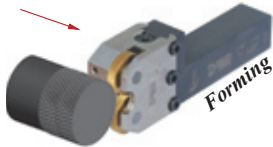
## 3 Extra Heavy Duty 60° Diamond Cutting Knurling TOOL - Large Cutting Range 2.0" & up (50mm & up)



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-3-M	20605	20	CNC-75-3-M	20610	3/4"	6"	M			
CNC-25-3-M	20615	25	CNC-100-3-M	20620	1"	6"	M	KPS-31-100-C	28945	CNCKH-3-M
CNC-32-3-M	20625	32	CNC-125-3-M	20630	1 1/4"	6 1/2"	M			

Supplied with a set of straight high speed TiN coated knurl wheels, 25 TPI for a male diamond pattern.

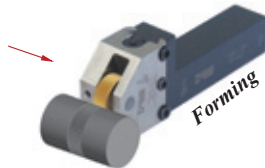
## 4 Double Wheel Forming Knurling TOOL - Diameter Range: 5/16" & up (8mm & up)



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-4-M	20640	20	CNC-75-4-M	20646	3/4"	6"	M			
CNC-25-4-M	20642	25	CNC-100-4-M	20648	1"	6"	M	KPS-31-125-C	28950	CNCKH-4-M
CNC-32-4-M	20644	32	CNC-125-4-M	20650	1 1/4"	6 1/2"	M			

Supplied with a set of diagonal high speed beveled TiN coated knurl wheels, 25 TPI for a male diamond pattern.

## 5 Single Wheel Forming Knurling TOOL - Straight Bump Unlimited Diameter



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-5-O	20705	20	CNC-75-5-O	20710	3/4"	5 3/4"	O			
CNC-25-5-O	20715	25	CNC-100-5-O	20720	1"	5 3/4"	O	KPS-31-125-C	28950	CNCKH-5-O
CNC-32-5-O	20725	32	CNC-125-5-O	20730	1 1/4"	6 1/4"	O			

Supplied with one straight high speed beveled TiN coated knurl wheel, 25 TPI for a straight pattern.

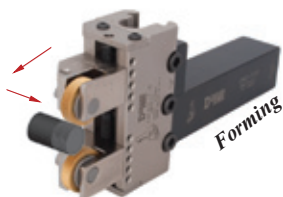
## 6 Shoulder Forming Knurling TOOL - Diameter Range: 5/16" & up (8mm & up)



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-6-4	20775	20	CNC-75-6-4	20780	3/4"	5 3/4"	SW4			
CNC-25-6-4	20785	25	CNC-100-6-4	20790	1"	5 3/4"	SW4	SW4.0P-2S	29085	CNCKH-6-4
CNC-32-6-4	20795	32	CNC-125-6-4	20800	1 1/4"	6 1/4"	SW4			

Supplied with a set of diagonal high speed beveled TiN coated knurl wheels, 25 TPI for a male diamond pattern.

## 7 Straddle Forming Knurling TOOL - Diameter Range: up to 1" (25mm)



Metric Description	UPC No. 733101-	Shank Size mm	Inch Description	UPC No. 733101-	Shank Size	Tool Length	Knurl Wheel Style	Knurl Pin Set		Modular Head Description
								Description	UPC No. 733101-	
CNC-20-7-R	20905	20	CNC-75-7-R	20910	3/4"	6 3/8"	R			
CNC-25-7-R	20915	25	CNC-100-7-R	20920	1"	6 3/8"	R	KPS-25-62-C	28915	CNCKH-7-R
CNC-32-7-R	20925	32	CNC-125-7-R	20930	1 1/4"	6 7/8"	R			

Supplied with a set of diagonal high speed beveled TiN coated knurl wheels, 30 TPI for a male diamond pattern.



# CNC Knurling Tools



SWFKT - Single Wheel Fixed Knurling Tool					
Description	UPC No. 733101-	Knurl Wheel Style	Knurl Pin Set		Shank Size
			Description	UPC No. 733101-	
SWFKT-50-D	21730	D*	KPS-18-50	28805	1/2
SWFKT-75-M	21740	M**	KPS-31-75	28840	3/4
SWFKT-100-O	21750	O**	KPS-31-100	28845	1

\* Supplied with 1 Straight Beveled Knurl Wheel 30 TPI.  
 \*\* Supplied with 1 Straight Beveled Knurl Wheel 25 TPI.

SCKN - Self-Centering Knurling Tool for C.N.C. Lathe					
Description	UPC No. 733101-	Knurl Wheel Style	Knurl Pin Set		Shank Size
			Description	Order No.	
SCKN-50-DW-D	22111	D*	KPS-18-50	28805	1/2
SCKN-75-DW-M	22121	M**	KPS-31-100	28845	3/4
SCKN-100-DW-M	22131	M**	KPS-31-100	28845	1

\* Supplied with 1 set of 30 TPI Diagonal Beveled Knurl Wheels for Diamond Pattern.  
 \*\* Supplied with 1 set of 25 TPI Diagonal Beveled Knurl Wheels for Diamond Pattern.

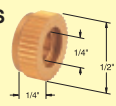
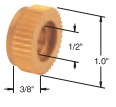
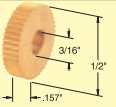
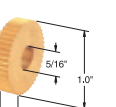

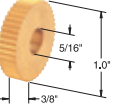
SSCK - Shoulder Self-Centering Knurling Tool for C.N.C. Lathe					
Description	UPC No. 733101-	Knurl Wheel Style	Knurl Pin Set		Shank Size
			Description	UPC No. 733101-	
SSCK-50-DW-2	22220	SW2*	SW2.0P-2S	29055	1/2
SSCK-75-DW-4	22240	SW4**	SW4.0P-2S	29085	3/4
SSCK-100-DW-4	22250	SW4**	SW4.0P-2S	29085	1

\* Supplied with 1 set of 30 TPI Diagonal Beveled Knurl Wheels for Diamond Pattern.  
 \*\* Supplied with 1 set of 25 TPI Diagonal Beveled Knurl Wheels for Diamond Pattern.

3SHKT - Three Swivel Head Knurling Tool					
Description	UPC No. 733101-	Knurl Wheel Style	Knurl Pin Set		Shank Size
			Description	UPC No. 733101-	
3SHKT-50-D	21510	D*	KPS-18-50	28805	1/2
3SHKT-75-M	21530	M**	KPS-31-100	28845	3/4
3SHKT-100-M	21540	M**	KPS-31-100	28845	1

\* Supplied (2) 20 TPI, (2) 30 TPI & (2) 40 TPI Diagonal Beveled Knurl Wheels for Diamond Pattern.  
 \*\* Supplied (2) 16 TPI, (2) 25 TPI & (2) 35 TPI Diagonal Beveled Knurl Wheels for Diamond Pattern.

Doriantool Knurl wheels are **TiN Coated** to reduce the coefficient of friction to increase the life of the knurl wheels.

Knurl Wheel Series	Description	Specifications			Circular Knurl Pitch							
		Pattern	Grade	Edge Prep	12 (TPI)	14 (TPI)	16 (TPI)	20 (TPI)	25 (TPI)	30 (TPI)	35 (TPI)	40 (TPI)
					UPC No. 733101-	UPC No. 733101-	UPC No. 733101-	UPC No. 733101-	UPC No. 733101-	UPC No. 733101-	UPC No. 733101-	UPC No. 733101-
<b>SW2-HS</b> 	SW2S-XX-HS	Straight	High Speed	Full Face				27403	27405	27407		
	SW2R-XX-HSB	Right Hand	High Speed	Beveled				27478	27480	27482		
	SW2L-XX-HSB	Left Hand	High Speed	Beveled				27528	27530	27532		
<b>SW4-HS</b> <b>SW4-C</b> 	SW4S-XX-HSB	Straight	High Speed	Beveled		28028		28032	28034	28036		
	SW4R-XX-HSB	Right Hand	High Speed	Beveled		28082		28086	28088	28090		
	SW4L-XX-HSB	Left Hand	High Speed	Beveled		28136		28140	28142	28144		
	SW4S-XX-C	Straight	Cobalt	Full Face		28002		28006	28008	28010		
	SW4R-XX-C	Right Hand	Cobalt	Full Face		28056		28060	28062	28064		
<b>D-HS</b> 	DS-XX-HSB	Straight	High Speed	Beveled				25030	25032	25034		25038
	DDR-XX-HSB	Right Hand	High Speed	Beveled				25084	25086	25088		25092
	DDL-XX-HSB	Left Hand	High Speed	Beveled				25138	25140	25142		25146
<b>M-HS</b> <b>M-C</b> 	MS-XX-HS	Straight	High Speed	Full Face		25307	25309	25311	25313	25315		
	MR-XX-HSB	Right Hand	High Speed	Beveled		25406	25408	25410	25412	25414		
	ML-XX-HSB	Left Hand	High Speed	Beveled		25472	25474	25476	25478	25480		
	MS-XX-C	Straight	Cobalt	Full Face		25308	25310	25312	25314	25316		
	MDR-XX-C	Right Hand	Cobalt	Full Face		25374	25376	25378	25380	25382		
<b>R-C-HS</b> 	RS-XX-HS	Straight	High Speed	Full Face	26503	26505	26507	26509	26511	26513	26515	26517
	RDL-XX-HSB	Right Hand	High Speed	Beveled					26604	26606	26608	
	RDL-XX-HSB	Left Hand	High Speed	Beveled					26666	26668	26670	
	RS-XX-C	Straight	Cobalt	Full Face		26504	26506	26508	26510	26512	26514	26516
<b>O-HS</b> 	OS-XX-HSB	Straight	High Speed	Beveled	25639	25641	25643	25645	25647			
	ODR-XX-HSB	Right Hand	High Speed	Beveled	25771	25773	25775	25777	25779			
	ODL-XX-HSB	Left Hand	High Speed	Beveled	25903	25905	25907	25909	25911			
	OF-XX-HS	Female Diamond	High Speed	Full Face				26074	26076			

For more information refer to our Knurling catalog



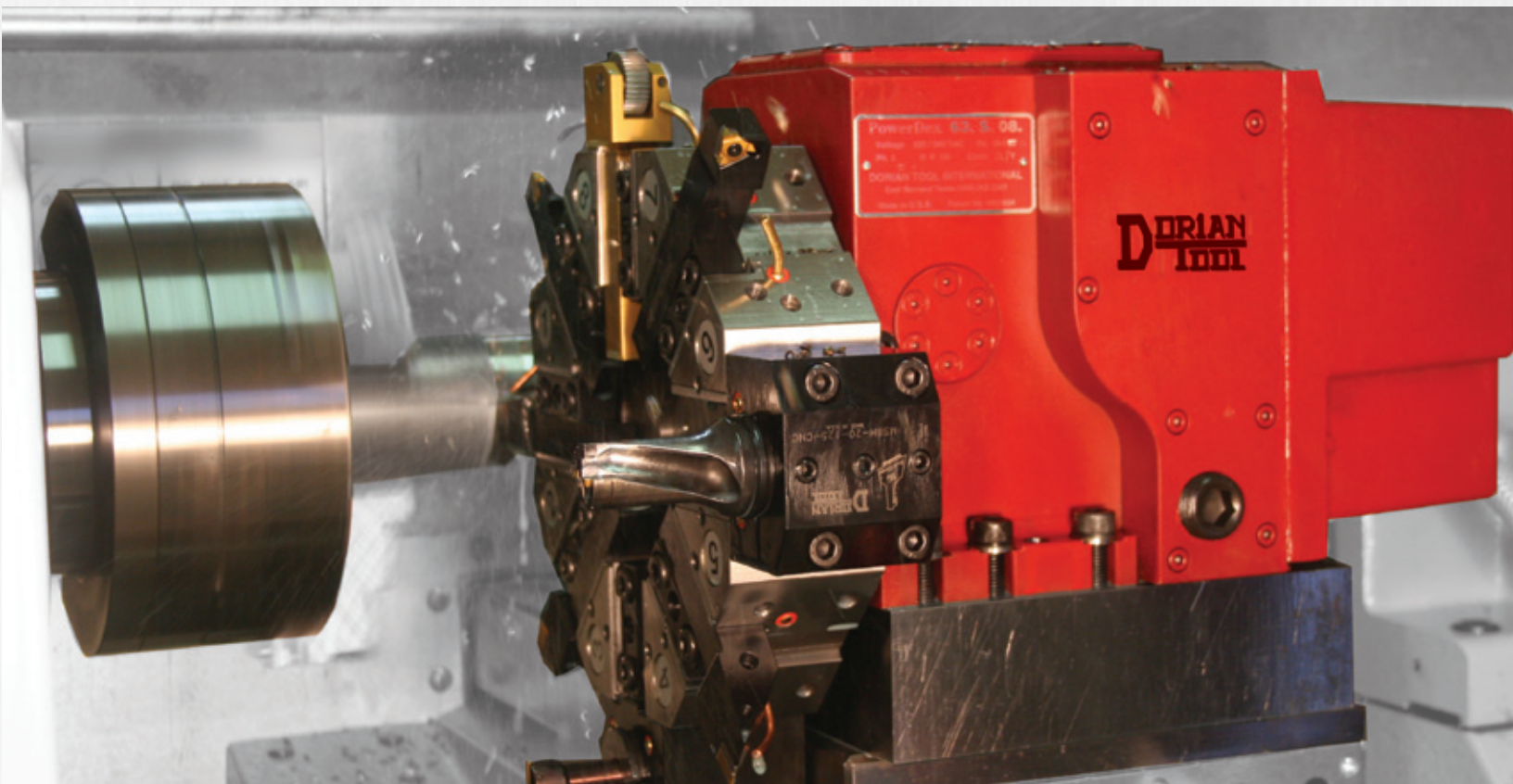
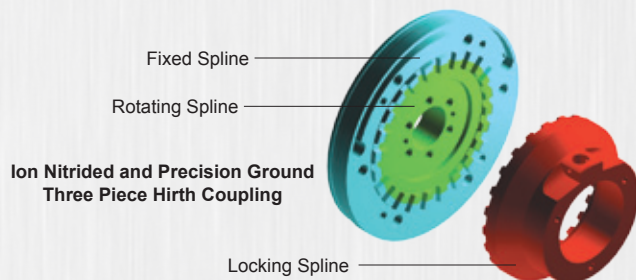
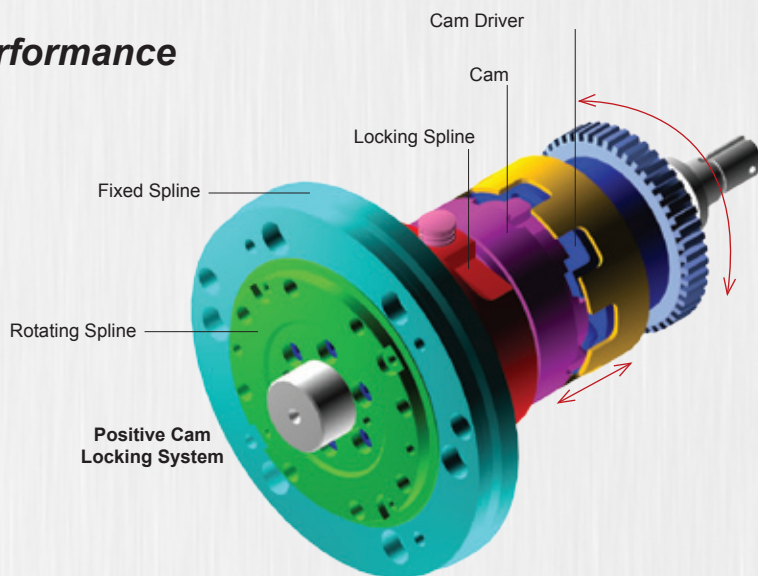
## Decrease the Payoff Time On Your CNC Lathe by Increasing its Performance

### Advantages of POWERDEX Turrets

- 8 Station Bi-Directional Indexing
  - Fast Cycle Times
  - +/- .0005 Positioning Accuracy
  - +/- .0002" Repeatability
  - Automatic Thru Coolant System
  - Meehanite Body, Heavy Duty Construction
  - Cartridge- Style, simple, reliable design
  - No maintenance necessary
- Positive Cam Locking System with three piece hirth coupling (shown Right) (splines) creates the most rigid turret locking mechanism (cam driver pushes the cam and therefore the locking spline to lock positively against the fixed and rotating splines).
  - Internal parts, such as splines, shaft, cam, cam driver, are made from high alloy steel, thru hardened, ion nitrided and precision ground.
  - Only highest quality, high precision and heavy duty bearings from first-class bearing manufacturers are being used on all Dorian Turrets
  - Choice of Milled Seat or VDI turret discs (for both metric and inch tools)

Description	*PDEX50N.08	PDEX63N.08	*PDEX80N.08	PDEX100N.08
UPC No.	11011	11021	11031	11041
Number of Stations	8	8	8	8
Recommended Square Shank Tooling Size	.750"	.750"	1.000"	1.250"
Center Height	1.969"	2.480"	3.150"	3.937"

\*PDEX50N & PDEX80N can be ordered, but are not a stock item. Milled-Seat Turret-Disc included with each PowerDex. For more technical information contact Dorian Tool.



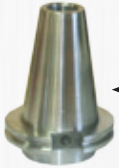


# CNC Adjustable Angle Heads

**All CNC Adjustable Angle Heads Feature Interchangeable V-Flange Toolholders**



**CAT 40 Holder  
ISO 40 Holder  
BT 40 Holder**



**CAT 50 Holder  
ISO 50 Holder  
BT 50 Holder**



**CNC Adjustable Angle Head**

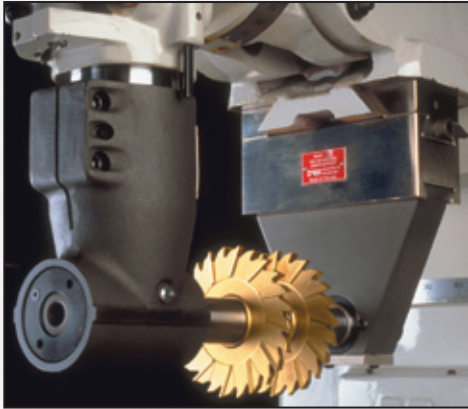
Spindle Taper Holder	UPC 733101-
CAT40	46001
CAT50	46002
BT40	46005
BT50	46006

Style	Features	Shank	Description	UPC NO. 733101-
 Universal CNC Adjustable Angle Head PLCNC-AAH25  <b>Toolholding:</b> ER25 Collet system	<ul style="list-style-type: none"> <li>• 4000 rpm max.</li> <li>• 11 lb.ft. torque</li> <li>• 1 to 1 Driving Ratio</li> <li>• 5/8" max tool shank size</li> <li>• 14.5 lb weight</li> <li>• Capable of machining in two axial positioning angles</li> <li>• Designed to perform any CNC medium duty operations</li> <li>• Interchangeable Taper Holder</li> <li>• Automatic tool change capability</li> </ul>	CAT40	PLCNC-AAH-ER25-CAT40	45953
		CAT50	PLCNC-AAH-ER25-CAT50	45957
		BT40	PLCNC-AAH-ER25-BT40	45952
		BT50	PLCNC-AAH-ER25-BT50	45956
 Universal CNC Adjustable Angle Head PLCNC-AAH32  <b>Toolholding:</b> ER32 Collet System	<ul style="list-style-type: none"> <li>• 3500 RPM max.</li> <li>• 30 lb.ft. torque</li> <li>• 1 to 1 Driving Ratio</li> <li>• 3/4" max tool shank size</li> <li>• 46 lb weight</li> <li>• Capable of machining in two axial positioning angles</li> <li>• Designed to perform any CNC medium duty operations</li> <li>• Interchangeable Taper Holder</li> <li>• Automatic tool change capability</li> </ul>	CAT40	PLCNC-AAH-ER32-CAT40	45943
		CAT50	PLCNC-AAH-ER32-CAT50	45963
		BT40	PLCNC-AAH-ER32-BT40	45942
		BT50	PLCNC-AAH-ER32-BT50	45962
 90° CNC Adjustable Angle Head 90CNC-AAH-ER16  <b>Toolholding:</b> ER16 Collet System	<ul style="list-style-type: none"> <li>• 4000 RPM max.</li> <li>• 5 lb.ft. torque</li> <li>• 1 to 1 Driving Ratio</li> <li>• 3/8" max tool shank size</li> <li>• 14.5 lb weight</li> <li>• Fixed 90 Degree head with 0-360 degree circular rotation</li> <li>• Designed to perform any CNC light duty operations</li> <li>• Interchangeable Taper Holder</li> <li>• Automatic tool change capability</li> </ul>	CAT40	90CNC-AAH-ER16-CAT40	45968
		CAT50	90CNC-AAH-ER16-CAT50	45972
		BT40	90CNC-AAH-ER16-BT40	45967
		BT50	90CNC-AAH-ER16-BT50	45971
 90° CNC Adjustable Angle Head 90CNC-AAH-ER25  <b>Toolholding:</b> ER25 Collet System	<ul style="list-style-type: none"> <li>• 3500 RPM max.</li> <li>• 15 lb.ft. torque</li> <li>• 1 to 1 Driving Ratio</li> <li>• 5/8" max tool shank size</li> <li>• 14.5 lb weight</li> <li>• Fixed 90 Degree head with 0-360 degree circular rotation</li> <li>• Designed to perform any CNC medium duty operations</li> <li>• Interchangeable Taper Holder</li> <li>• Automatic tool change capability</li> </ul>	CAT40	90CNC-AAH-ER25-CAT40	45977
		CAT50	90CNC-AAH25-CAT50	45981
		BT40	90CNC-AAH-ER25-BT40	45976
		BT50	90CNC-AAH-ER25-BT50	45980
 90° CNC Adjustable Angle Head 90CNC-AAH32  <b>Toolholding:</b> ER32 Collet System	<ul style="list-style-type: none"> <li>• 3500 RPM max.</li> <li>• 30 lb.ft. torque</li> <li>• 1 to 1 Driving Ratio</li> <li>• 3/4" max tool shank size</li> <li>• 44 lb weight</li> <li>• Fixed 90 Degree head with 0-360 degree circular rotation</li> <li>• Designed to perform any CNC heavy duty operations</li> <li>• Interchangeable Taper Holder</li> <li>• Automatic tool change capability</li> </ul>	CAT40	90CNC-AAH-ER32-CAT40	45986
		CAT50	90CNC-AAH-ER32-CAT50	45990
		BT40	90CNC-AAH-ER32-BT40	45985
		BT50	90CNC-AAH-ER32-BT50	45989
 90° CNC Adjustable Angle Head 90CNC-AAH-TP40  <b>Toolholding:</b> CAT40 ISO40 BT40	<ul style="list-style-type: none"> <li>• 2000 RPM max.</li> <li>• 30 lb.ft. torque</li> <li>• 1 to 1 Driving Ratio</li> <li>• 3/4" max tool shank size</li> <li>• 44 lb weight</li> <li>• Fixed 90 Degree head with 0-360 degree circular rotation</li> <li>• Designed to perform any CNC heavy duty operations</li> <li>• Interchangeable Taper Holder</li> <li>• Automatic tool change capability</li> </ul>	CAT40	90CNC-AAH-TP40-CAT40	45936
		CAT50	90CNC-AAH-TP40-CAT50	45996
		BT40	90CNC-AAH-TP40-BT40	45935
		BT50	90CNC-AAH-TP40-BT50	45995



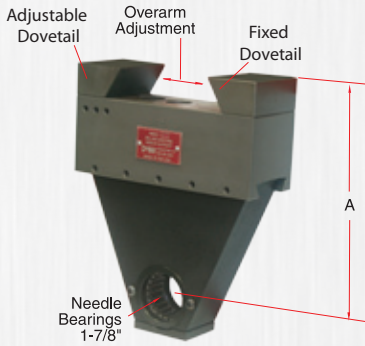
# Manual Milling Machine Right Angle Head

## R8 Right Angle Milling Attachment for Vertical Milling Machines



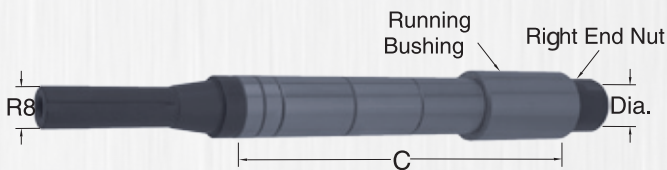
Features	Output	Shank	Description	UPC NO. 733101-
<ul style="list-style-type: none"> <li>• For Manual Machines</li> <li>• Ductile Iron Body</li> <li>• Precision Hardened &amp; Ground Spiral Bevel Gears</li> <li>• Sealed High Speed Bearings</li> <li>• 1.33 to 1 Gear Ratio</li> <li>• Grease Fitting</li> <li>• Alignment Flats on 2 Sides</li> <li>• R-8 Collet Spindle</li> </ul>	R8	3 3/8" Quill with R8 Taper	MMRAA-R8	04000

## Heavy Duty Milling Machine Arbor Support



Features	Machine Type	A	I.D. Boring	Arbor	Description	UPC NO. 733101-
<ul style="list-style-type: none"> <li>• Quick Lock System</li> <li>• Quick Center Line Adjustment</li> <li>• Double Dovetail Track</li> <li>• Precision Needle Bearing</li> <li>• Overarm Adjustment</li> <li>• Steel Support</li> <li>• Aluminum Body</li> <li>• Heat Treated and Precision Ground Dovetails</li> </ul>	Bridgeport 50° Dovetail	8.555	1.875	.875 - 1.00 - 1.25	MMAS-B-1	04052
	Alliant-Sharp 60° Dovetail	8.625	1.875	.875 - 1.00 - 1.25	MMAS-A-1	04056
	Index 45° Dovetail Widoover arm	9.730	1.875	.875 - 1.00 - 1.25	MMAS-I-1	04060
	Clausing Kondia 55° Dovetail	8.555	1.875	.875 - 1.00 - 1.25	MMAS-K-1	04064

## R8 Right Angle Milling Machine Arbor



The Milling Machine Arbor is designed for slotting operations. It is used with the Right Angle Head and the Arbor Support.

Dia.	C Length	Running Bushing	Description	UPC NO. 733101-
0.875	10.0	1.875	R8MMA-87-BI	04070
1.000	10.0	1.875	R8MMA-100-BI	04072
1.250	10.0	1.875	R8MMA-125-BI	04074

## Draw Bar



Standard Draw Bar				
Machine Type	Bar Length	Hex Length	Description	UPC NO. 733101-
1 J Head Bridgeport Step Pully	18.000	2.500	SDB-1J	04080
2 J Head Bridgeport Variable Speed	18.000	5.500	SDB-2J	04082
Alliant-Sharp	18.000	6.500	SDB-AS	04084
Index Lagun	18.000	8.500	SDB-IL	04086

Special Draw Bar for MMRAA				
Machine Type	Bar Length	Hex Length	Description	UPC NO. 733101-
Bridgeport Kondia	18.000	8.500	BDBRA-2J800	04090
Index Lagun	18.000	11.500	ILBRA-110	04092
Alliant-Sharp	18.000	9.500	ADBRA-190	04094

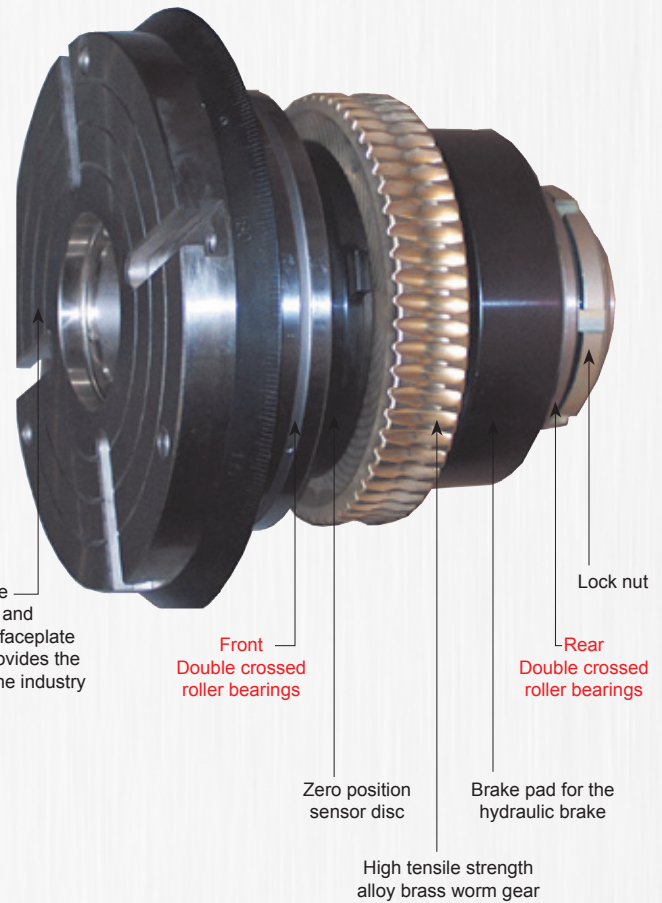
## 4 Piece Bridgeport Set

4 Piece Bridgeport Set Includes				Description	Set UPC NO. 733101-
(1) R8 Right Angle Milling Attachment UPC NO. 733101- 04000	(1) Bridgeport 50° Dovetail Arbor Support UPC NO. 733101-04052	(1) 1" Dia. Arbor UPC NO. 733101-04072	(1) Bridgeport Kondia Draw Bar UPC NO. 733101-04090	MMRASS	04076



## More than 5 times the clamping power, rigidity and strength than the closest competition!

- 100% leak proof
- High precision worm-gear
- High precision worm-screw
- Extra Large Thru-Holes
- Excellent Build-Quality
- Extra Heavy Duty for Oil Field Work
- Hydraulic Brake and Pump as Standard
- High Precision Indexing (10 Arcseconds Cumulative)
- Two Double Crossed Roller Bearings for very heavy workholding
- Easy to program Stand-Alone control as an option on each model



**2-Year Warranty**

4th Axis CNC Rotary Tables									
4th Axis Series		4th Axis Stand Alone Series		Table Diameter		Thru Hole Diameter		Center Height	
Model	UPC No. 733101-	Model	UPC No. 733101-	Ø in	Ø mm	Ø in	Ø mm	Ø in	Ø mm
TGV160	43001	TGV160-i	43007	6.30	160	1.67	42.5	5.31	135
TGV200	43002	TGV200-i	43008	7.87	200	2.03	51.5	5.91	150
TGV250	43003	TGV250-i	43009	9.84	250	2.78	70.5	6.89	175
TGV320	43004	TGV320-i	43010	12.60	320	4.33	110.0	9.06	230
TGV400	43005	TGV400-i	43011	15.75	400	5.12	130.0	9.06	230

Installation kits are Sold Separately.



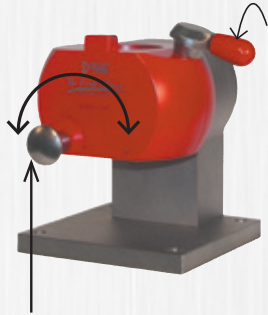
- Hand-held control on Stand-Alone Series Rotary Tables
- M-Function Activated



# High Performance Tool Presetters & Tightening Fixture

## Smart Tool-Setter™ Tightening Fixture

Heavy Duty & Versatile



Rotate the handle to lock the tool Positively.

**Toolholder Taper Protected From Chips & Scratches**

- Teflon Based Xylan Coating
- Quick Lock & Setting
- Multi-Position Setting
- Heavy Duty Construction
- Precise Quality & Workmanship

Pull the Knob to Unlock the Tool-Setter and Rotate to Position. Release the knob to Lock in Place.



UPC 733101-	Description	Tool Size
36001	DSTSCH-040	CAT-40 BT-40
36002	DSTSCH-050	CAT-50 BT-50
36003	DSTSHSK-063	HSK63A
36004	DSTSHSK-100	HSK100A

## QuiK-SET™ Tool Presetter

Built For Shop Environment



**Highest Technology At The Lowest Price In The Industry**

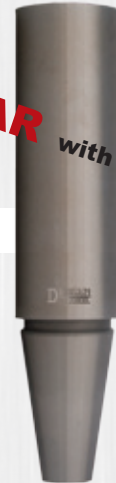
- Reduces Setup Time
- Measures All Types of Tools
- Excellent Precision & Repeatability
- CAT, BT, HSK, ISO and VDI Interchangeable Sleeves

UPC 733101-	42001
<b>QuiK-SET</b>	*QuiK-SET-Z300
Accuracy	+/- .0005
Height Capacity	12"
Diameter Capacity	10"
Measuring Method	Contact
Power input	Battery
Warranty	1 Year

\*Supplied with CAT40 Tool Sleeve.

Optional Tool Sleeves			
Style	BT30	CAT/BT40	HSK63
UPC 733101-	42066	42070	42078

**FREE TEST BAR** with the purchase of a presetter



## ACCU-SET PLUS™ Tool Presetter

**2 RS232 Serial Ports Send Your Tool Data to a Printer or a PC**

- Easy to Operate
- Fast & Precise
- Reduces Setup Time
- Rigid, All-Steel Construction
- High Precision Linear Guides and Bearings
- CAT, BT, HSK, ISO and VDI Interchangeable Sleeves

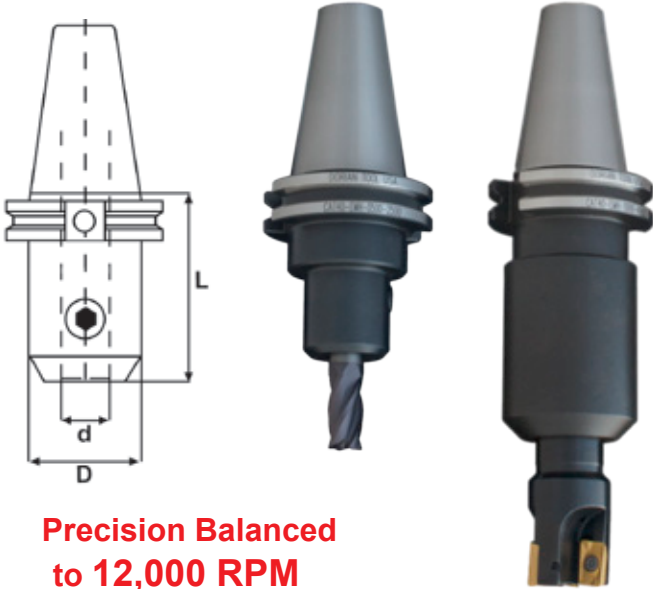
- Resolution .00005"/.001mm
- Accuracy ± .0002"/.005mm
- Repeatability ±.0002"/.005mm
- Axis Squareness .0002"/.005mm TIR



UPC 733101-	42007	42009
<b>ACCU-SET PLUS</b>	ACCU-SET PLUS-Z300	ACCU-SET PLUS-Z400
Accuracy	+/- .0002	
Height Capacity	12"	16"
Diameter Capacity	10"	
Measuring Method	Contact, Spring Loaded Indicator	
Measuring Device	High Precision Glass Scales	
Number of Different Machine Reference Points	99	
Total Tool Memory	9900 Tools	
Warranty	1 Year	
Power input	115 VAC	
Warranty	1 Year	

\*Supplied with CAT40 Tool Sleeve.

Optional Tool Sleeves			
Style	BT30	CAT/BT40	HSK63
UPC 733101-	42066	42070	42078



**Precision Balanced to 12,000 RPM**

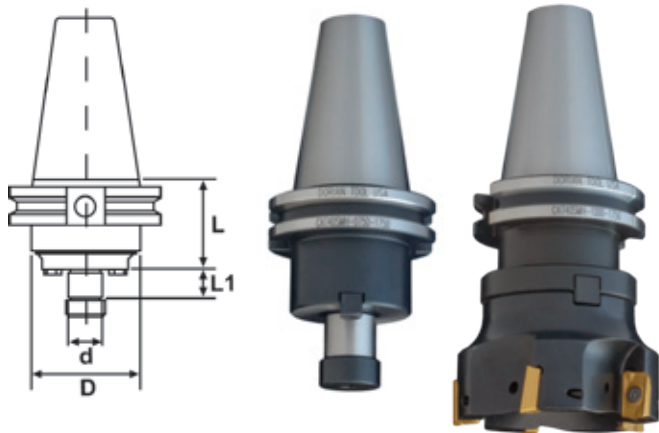
**Each holder comes with a Certificate of Inspection\***

- .0001" Taper-Bore Runout Tolerance.
- Made of 8620 Alloy Steel with Case Hardness of 56-60 HRC and Core
- Tapers Ground to AT-3 Specifications or BETTER.
- H5 Bore Tolerance for air-tight fit provides maximum contact surface area.
- Thru Coolant Feature
- Made In Italy.

### End Mill Holders

UPC No. 733101-	Description	Hole Dia. (d) (in)	Gage Length (L) (in)	Body Dia. (D) (in)
45011	CAT40 EMH-0250-2500	1/4	2.50	0.88
45017	CAT40 EMH-0375-2500	3/8	2.50	1.00
45023	CAT40-EMH-0500-2500	1/2	2.50	1.25
45026	CAT40 EMH-0625-1750	5/8	1.75	1.75
45027	CAT40 EMH-0625-3000	5/8	3.00	1.50
45030	CAT40 EMH-0750-1750	3/4	1.75	1.75
45031	CAT40 EMH-0750-3000	3/4	3.00	1.75
45037	CAT40 EMH-1000-2000	1	2.00	1.75
45038	CAT40 EMH-1000-4000	1	4.00	2.00
45069	CAT50 EMH-0500-4000	1/2	4.00	1.25
45079	CAT50 EMH-0750-4000	3/4	4.00	1.75
45080	CAT50 EMH-0750-6000	3/4	6.00	1.75
45086	CAT50 EMH-1000-4000	1	4.00	2.00
45087	CAT50 EMH-1000-6000	1	6.00	2.00
45090	CAT50 EMH-1250-4000	1-1/4	4.00	2.50
45091	CAT50 EMH-1250-6000	1-1/4	6.00	2.50
45094	CAT50 EMH-1500-4500	1-1/2	4.50	2.75
45095	CAT50 EMH-1500-7000	1-1/2	7.00	2.75

\* Shows balancing parameters as well as runout tolerance of each individually inspected tool holder. Signed by a Quality Assurance member.



**Precision Balanced to 12,000 RPM**

**Each holder comes with a Certificate of Inspection\***

- .0002" Taper-Arbor Runout Tolerance.
- Made of 8620 Alloy Steel with Case Hardness of 56-60 HRC and Core Hardness of 36-40 HRC.
- Tapers Ground to AT-3 Specifications or BETTER.
- H5 Arbor Tolerance.
- Made In Italy.

### Shell Mill Holders

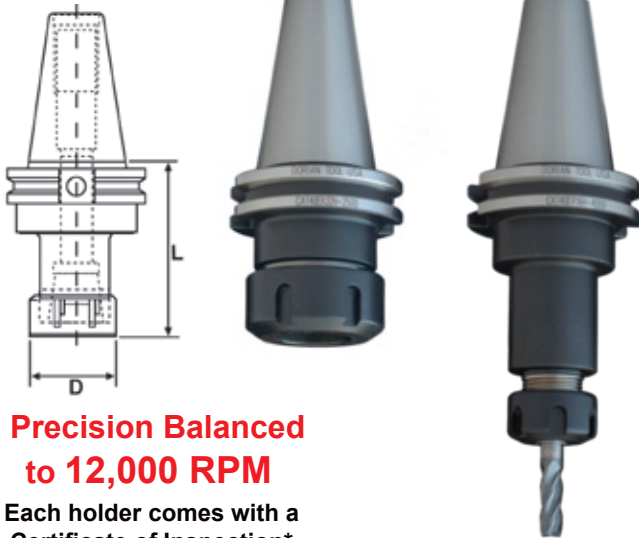
UPC No. 733101-	Description	Arbor Dia. (d) (in)	Arbor Length (L1) (in)	Gage Length (L) (in)	Body Dia. (D) (in)	Arbor Thread (AT) (in)	Key Size (in)
45121	CAT40 SMH-0750-1750	3/4	0.67	1.75	1.75	3/8-24	5/16
45123	CAT40 SMH-1000-1750	1	0.67	1.75	2.25	1/2-20	3/8
45125	CAT40 SMH-1250-2000	1-1/4	0.67	2.00	2.88	5/8-18	1/2
45127	CAT40 SMH-1500-2000	1-1/2	0.93	2.00	3.75	3/4-16	5/8
45138	CAT50 SMH-0750-1750	3/4	.68	1.75	2.75	3/8-24	5/16
45142	CAT50 SMH-1000-1750	1	.68	1.75	2.75	1/2-20	3/8
45146	CAT50 SMH-1250-1750	1-1/4	.68	1.75	2.75	5/8-18	1/2
45150	CAT50 SMH-1500-2000	1-1/2	.94	2.00	3.75	3/4-16	5/8
45154	CAT50 SMH-2000-2000	2	.94	2.00	4.88	1-14	5/8

\* Shows balancing parameters as well as runout tolerance of each individually inspected tool holder. Signed by a Quality Assurance member.





# Integral Keyless Drill Chuck Holders



**Precision Balanced  
to 12,000 RPM**

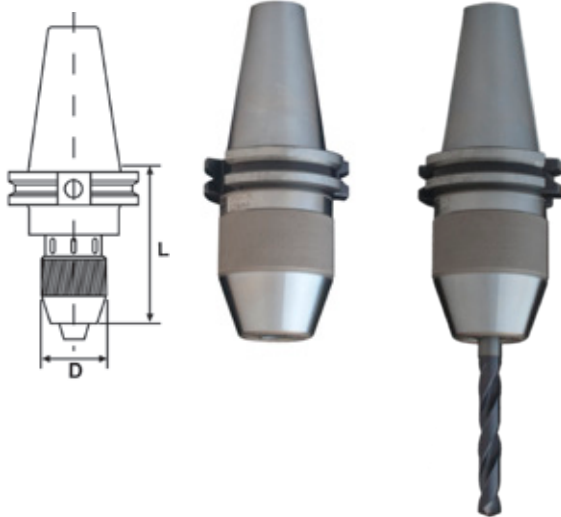
**Each holder comes with a  
Certificate of Inspection\***

- .0001" Taper-Bore Runout Tolerance.
- Made of 8620 Alloy Steel with Case Hardness of 56-60 HRC and Core Hardness of 36-40 HRC.
- Tapers Ground to AT-3 Specifications or BETTER
- Thru Coolant Feature. T
- Made In Italy.

## ER Collet Holder

UPC No. 733101-	Description	Collet Series	Collet Range (in)	Nose Dia. (D) (in)	Gage Length (L) (in)
45173	CAT40 ER11H-2500	ER11	.019-.275	0.63	2.50
45174	CAT40 ER11H-4000	ER11	.019-.275	0.63	4.00
45175	CAT40 ER11H-6000	ER11	.019-.275	0.63	6.00
45176	CAT40 ER16H-2500	ER16	.019-.406	1.26	2.50
45178	CAT40 ER16H-4000	ER16	.019-.406	1.26	4.00
45179	CAT40 ER16H-6000	ER16	.019-.406	1.26	6.00
45180	CAT40 ER20H-2500	ER20	.039-.511	1.38	2.50
45181	CAT40 ER20H-4000	ER20	.039-.511	1.38	4.00
45182	CAT40 ER20H-6000	ER20	.039-.511	1.38	6.00
45183	CAT40 ER25H-2500	ER25	.039-.629	1.65	2.50
45184	CAT40 ER25H-4000	ER25	.039-.629	1.65	4.00
45185	CAT40 ER25H-6000	ER25	.039-.629	1.65	6.00
45186	CAT40 ER32H-2500	ER32	.078-.787	1.97	2.50
45188	CAT40 ER32H-4000	ER32	.078-.787	1.97	4.00
45189	CAT40 ER32H-6000	ER32	.078-.787	1.97	6.00
45191	CAT40 ER40H-2500	ER40	.118-1.023	2.48	2.50
45193	CAT40 ER40H-4000	ER40	.118-1.023	2.48	4.00
45197	CAT50 ER16H-4120	ER16	.019" - .406"	1.26	4.12
45205	CAT50 ER25H-4000	ER25	.039" - .629"	1.65	4.00
45206	CAT50 ER25H-6000	ER25	.039" - .629"	1.65	6.00
45208	CAT50 ER32H-4000	ER32	.078" - .787"	1.97	4.00
45209	CAT50 ER32H-6000	ER32	.078" - .787"	1.97	6.00
45210	CAT50 ER32H-8000	ER32	.078" - .787"	1.97	8.00

\* Shows balancing parameters as well as runout tolerance of each individually inspected tool holder. Signed by a Quality Assurance member.



- Provides exceptionally high torque - up to three times the gripping strength of conventional drill chucks.
- Features a corrosion-resistant surface treatment to ensure durability.
- Chuck will not come off during operation.
- Replaceable chuck.

## Integral Keyless Drill Chuck Holders

UPC No. 733101-	Description	Capacity	Gage Length (L) (in)	Body Dia. (D) (in)
45307	CAT40-KDCH-13	1/32-1/2	3.50	2.00
45308	CAT40-KDCH-16	1/8-5/8	4.50	2.25

## Spare Parts

### ER Standard Nuts



Style	Description	UPC No. 733101-	Thread	Height (mm)	Body Dia. (mm)
ER11	ER11NTM16	49773	M13 X .075	12	16
ER16	ER16NTS32	49780	M22 X 1,5	17	32
ER20	ER20NTS35	49781	M25 X 1,5	19	35
ER25	ER25NTS42	49782	M32 X 1,5	20	42
ER32	ER32NTS50	49783	M40 X 1,5	22,5	50
ER40	ER40NTS63	49784	M50 X 1,5	25,5	63

### ER Standard Wrench



Style	Description	UPC No. 733101-	Wrench Type
ER11	ER11MNWR	49987	ER Mini
ER16	ER16STWR	49994	ER Standard
ER20	ER20STWR	49995	ER Standard
ER25	ER25STWR	49996	ER Standard
ER32	ER32STWR	49997	ER Standard
ER40	ER40STWR	49998	ER Standard



## Milling | Drilling | Reaming | Tapping

**100% Inspection:** Each and every collet is inspected to be precise within .0002" or better prior to shipping.

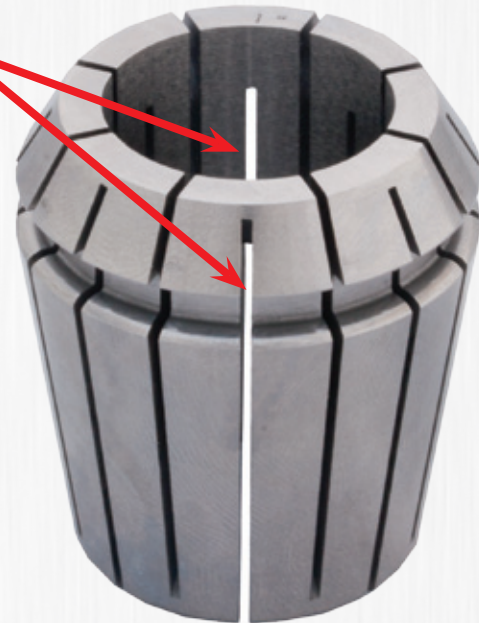
**Maximum Contact Surface Area:** Each Dorian ER Collet features 16 full length slits (instead of competition's 8), enabling the collet to collapse uniformly to provide a concentric and full 360° gripping surface.

**Material:** Premium Grade Special Alloy Steel with high a modulus of elasticity. Combined with the 16-slit design, this material provides full surface contact on the tool when collapsed.

**Inch and Metric Sizes:** Choice of inch and metric sizes optimizes contact surface area for ultra high precision applications.

## Ultra Precision 0.0002" TIR

16 Slits for Uniform Gripping



### Ultra Precision ER 11 Collets



Description	Part No. 733101-	Holding Capacity			
		Inch		Metric	
ER11-STIMC-10	46236	0.020	0.039	0.5	1.0
ER11-STIMC-15	46237	0.039	0.059	1.0	1.5
ER11-STIMC-20	46238	0.059	0.079	1.5	2.0
ER11-STIMC-0937	46249	0.074	0.094	1.9	2.4
ER11-STIMC-25	46239	0.079	0.098	2.0	2.5
ER11-STIMC-30	46240	0.098	0.118	2.5	3.0
ER11-STIMC-0125	46250	0.105	0.125	2.7	3.2
ER11-STIMC-35	46241	0.118	0.138	3.0	3.5
ER11-STIMC-40	46242	0.138	0.157	3.5	4.0
ER11-STIMC-45	46243	0.157	0.177	4.0	4.5
ER11-STIMC-0187	46251	0.168	0.188	4.3	4.8
ER11-STIMC-50	46244	0.177	0.197	4.5	5.0
ER11-STIMC-55	46245	0.197	0.217	5.0	5.5
ER11-STIMC-60	46246	0.217	0.236	5.5	6.0
ER11-STIMC-0250	46252	0.230	0.250	5.9	6.4
ER11-STIMC-65	46247	0.236	0.256	6.0	6.5
ER11-STIMC-70	46248	0.256	0.276	6.5	7.0

### Ultra Precision ER 16 Collets



Description	Part No. 733101-	Holding Capacity			
		Inch		Metric	
ER16-STIMC-10	46290	0.020	0.039	0.5	1.0
ER16-STIMC-15	46288	0.039	0.059	1.0	1.5
ER16-STIMC-20	46291	0.059	0.079	1.5	2.0
ER16-STIMC-0937	46275	0.074	0.094	1.9	2.4
ER16-STIMC-25	46289	0.059	0.098	1.5	2.5
ER16-STIMC-30	46292	0.079	0.118	2.0	3.0
ER16-STIMC-0125	46276	0.087	0.125	2.2	3.2
ER16-STIMC-40	46293	0.118	0.157	3.0	4.0
ER16-STIMC-0187	46278	0.150	0.188	3.8	4.8
ER16-STIMC-50	46294	0.157	0.197	4.0	5.0
ER16-STIMC-60	46295	0.197	0.236	5.0	6.0
ER16-STIMC-0250	46280	0.213	0.250	5.4	6.4
ER16-STIMC-70	46296	0.236	0.276	6.0	7.0
ER16-STIMC-80	46297	0.276	0.315	7.0	8.0
ER16-STIMC-90	46298	0.315	0.354	8.0	9.0
ER16-STIMC-0375	46284	0.335	0.375	8.5	9.5
ER16-STIMC-100	46299	0.354	0.394	9.0	10.0

### Ultra Precision ER 20 Collets



Description	Part No. 733101-	Holding Capacity			
		Inch		Metric	
ER20-STIMC-10	46353	0.020	0.039	0.5	1.0
ER20-STIMC-15	46354	0.039	0.059	1.0	1.5
ER20-STIMC-20	46355	0.059	0.079	1.5	2.0
ER20-STIMC-30	46356	0.079	0.118	2.0	3.0
ER20-STIMC-0937	46386	0.075	0.094	1.9	2.4
ER20-STIMC-0125	46387	0.087	0.125	2.2	3.2
ER20-STIMC-40	46358	0.118	0.157	3.0	4.0
ER20-STIMC-0187	46388	0.150	0.188	3.8	4.8
ER20-STIMC-50	46359	0.157	0.197	4.0	5.0
ER20-STIMC-60	46360	0.197	0.236	5.0	6.0
ER20-STIMC-0250	46389	0.213	0.250	5.4	6.4
ER20-STIMC-70	46361	0.236	0.276	6.0	7.0
ER20-STIMC-80	46362	0.276	0.315	7.0	8.0
ER20-STIMC-90	46363	0.315	0.354	8.0	9.0
ER20-STIMC-0375	46390	0.335	0.375	8.5	9.5
ER20-STIMC-100	46364	0.354	0.394	9.0	10.0
ER20-STIMC-110	46365	0.394	0.433	10.0	11.0
ER20-STIMC-120	46367	0.433	0.472	11.0	12.0
ER20-STIMC-0500	46391	0.461	0.500	11.7	12.7
ER20-STIMC-130	46368	0.472	0.512	12.0	13.0



## Ultra Precision ER Collets -SETS



Part Number	UPC No 733101-	Piece Per SET	Collet Size
ER11-MCS-13C	46768	13	1, 1.5, 2, 2.5, 3, 3.5, 4, 4.5, 5, 5.5, 6, 6.5, 7
ER16-MCS-10C	46769	10	1, 2, 3, 4, 5, 6, 7, 8, 9, 10
ER20-MCS-12C	46770	12	2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13
ER25-MCS-15C	46771	15	2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13,14, 15, 16
ER32-MCS-18C	46772	18	3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13,14, 15, 16, 17, 18, 19, 20
ER40-MCS-23C	46773	23	4, 5, 6, 7, 8, 9, 10, 11, 12, 13,14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26

### Ultra Precision ER 25 Collets



Description	Part No. 733101-	Holding Capacity			
		Inch		Metric	
ER25- STIMC- 10	46428	0.020	0.039	0.5	1.0
ER25- STIMC- 15	46429	0.039	0.059	1.0	1.5
ER25- STIMC- 20	46430	0.059	0.079	1.5	2.0
ER25- STIMC- 0937	46499	0.075	0.094	1.9	2.4
ER25- STIMC- 30	46431	0.079	0.118	2.0	3.0
ER25- STIMC- 0125	46500	0.086	0.125	2.2	3.2
ER25- STIMC- 40	46433	0.118	0.157	3.0	4.0
ER25- STIMC- 0187	46501	0.148	0.188	3.8	4.8
ER25- STIMC- 50	46434	0.157	0.197	4.0	5.0
ER25- STIMC- 60	46435	0.197	0.236	5.0	6.0
ER25- STIMC- 0250	46502	0.211	0.250	5.4	6.4
ER25- STIMC- 70	46436	0.236	0.276	6.0	7.0
ER25- STIMC- 80	46437	0.276	0.315	7.0	8.0
ER25- STIMC- 90	46438	0.315	0.354	8.0	9.0
ER25- STIMC- 0375	46503	0.336	0.375	8.5	9.5
ER25- STIMC- 100	46439	0.354	0.394	9.0	10.0
ER25- STIMC- 110	46440	0.394	0.433	10.0	11.0
ER25- STIMC- 120	46442	0.433	0.472	11.0	12.0
ER25- STIMC- 0500	46517	0.461	0.500	11.7	12.7
ER25- STIMC- 130	46443	0.472	0.512	12.0	13.0
ER25- STIMC- 140	46444	0.512	0.551	13.0	14.0
ER25- STIMC- 150	46445	0.551	0.591	14.0	15.0
ER25- STIMC- 0625	46518	0.586	0.625	14.9	15.9
ER25- STIMC- 160	46446	0.591	0.630	15.0	16.0

### Ultra Precision ER 32 Collets



Description	Part No. 733101-	Holding Capacity			
		Inch		Metric	
ER32- STIMC- 20	46521	0.059	0.079	1.5	2.0
ER32- STIMC- 0937	46543	0.075	0.094	1.9	2.4
ER32- STIMC- 30	46522	0.079	0.118	2.0	3.0
ER32- STIMC- 0125	46544	0.086	0.125	2.2	3.2
ER32- STIMC- 40	46524	0.118	0.157	3.0	4.0
ER32- STIMC- 0187	46545	0.148	0.188	3.8	4.8
ER32- STIMC- 50	46525	0.157	0.197	4.0	5.0
ER32- STIMC- 60	46526	0.197	0.236	5.0	6.0
ER32- STIMC- 0250	46546	0.211	0.250	5.4	6.4
ER32- STIMC- 70	46527	0.236	0.276	6.0	7.0
ER32- STIMC- 80	46528	0.276	0.315	7.0	8.0
ER32- STIMC- 90	46529	0.315	0.354	8.0	9.0
ER32- STIMC- 0375	46547	0.336	0.375	8.5	9.5
ER32- STIMC- 100	46530	0.354	0.394	9.0	10.0
ER32- STIMC- 110	46531	0.394	0.433	10.0	11.0
ER32- STIMC- 120	46533	0.433	0.472	11.0	12.0
ER32- STIMC- 0500	46569	0.461	0.500	11.7	12.7
ER32- STIMC- 130	46534	0.472	0.512	12.0	13.0
ER32- STIMC- 140	46535	0.512	0.551	13.0	14.0
ER32- STIMC- 150	46536	0.551	0.591	14.0	15.0
ER32- STIMC- 0625	46570	0.586	0.625	14.9	15.9
ER32- STIMC- 160	46537	0.591	0.630	15.0	16.0
ER32- STIMC- 170	46538	0.630	0.669	16.0	17.0
ER32- STIMC- 180	46539	0.669	0.709	17.0	18.0
ER32- STIMC- 190	46540	0.709	0.748	18.0	19.0
ER32-STIMC-0750	46571	0.713	0.750	18.1	19.1
ER32- STIMC- 200	46542	0.748	0.787	19.0	20.0

### Ultra Precision ER 40 Collets



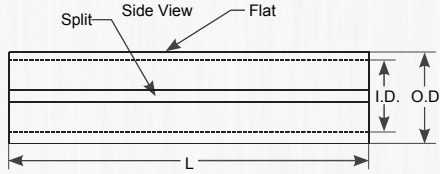
Description	Part No. 733101-	Holding Capacity			
		Inch		Metric	
ER40- STIMC- 30	46623	0.079	0.118	2.0	3.0
ER40- STIMC- 0125	46649	0.087	0.125	2.2	3.2
ER40- STIMC- 40	46624	0.118	0.157	3.0	4.0
ER40- STIMC- 0187	46650	0.150	0.188	3.8	4.8
ER40- STIMC- 50	46625	0.157	0.197	4.0	5.0
ER40- STIMC- 60	46626	0.197	0.236	5.0	6.0
ER40- STIMC- 0250	46651	0.213	0.250	5.4	6.4
ER40- STIMC- 70	46627	0.236	0.276	6.0	7.0
ER40- STIMC- 80	46628	0.276	0.315	7.0	8.0
ER40- STIMC- 90	46629	0.315	0.354	8.0	9.0
ER40- STIMC- 0375	46652	0.335	0.375	8.5	9.5
ER40- STIMC- 100	46630	0.354	0.394	9.0	10.0
ER40- STIMC- 110	46631	0.394	0.433	10.0	11.0
ER40- STIMC- 120	46633	0.433	0.472	11.0	12.0
ER40- STIMC- 0500	46653	0.461	0.500	11.7	12.7
ER40- STIMC- 130	46634	0.472	0.512	12.0	13.0
ER40- STIMC- 140	46635	0.512	0.551	13.0	14.0
ER40- STIMC- 150	46636	0.551	0.591	14.0	15.0
ER40- STIMC- 0625	46683	0.587	0.625	14.9	15.9
ER40- STIMC- 160	46637	0.591	0.630	15.0	16.0
ER40- STIMC- 170	46638	0.630	0.669	16.0	17.0
ER40- STIMC- 180	46639	0.669	0.709	17.0	18.0
ER40- STIMC- 190	46640	0.709	0.748	18.0	19.0
ER40- STIMC- 200	46642	0.748	0.787	19.0	20.0
ER40-STIMC-0750	46686	0.713	0.750	18.1	19.1
ER40- STIMC- 210	46643	0.787	0.827	20.0	21.0
ER40- STIMC- 220	46644	0.827	0.866	21.0	22.0
ER40- STIMC- 0875	46684	0.835	0.875	21.2	22.2
ER40- STIMC- 230	46645	0.866	0.906	22.0	23.0
ER40- STIMC- 240	46646	0.906	0.945	23.0	24.0
ER40- STIMC- 250	46647	0.945	0.984	24.0	25.0
ER40- STIMC- 1000	46685	0.961	1.000	24.4	25.4
ER40- STIMC- 260	46648	0.984	1.024	25.0	26.0



## Boring Bar Bushings



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

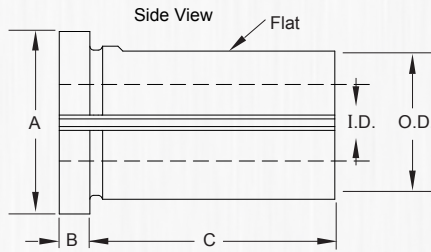


INCH Description	Part No. 733101-	O.D.	I.D.	L
D25-4B	03705	0.750	0.500	2.750
D30-4B	03707	1.000	0.750	3.250
D35-4B	03709	1.000	0.750	3.750
D40-4B	03711	1.250	1.000	4.500
D50-4B	03713	1.500	1.250	5.500
D60-4B	03715	2.000	1.500	6.500
D25-41B	03719	1.000	0.750	2.750
D30-41B	03721	1.250	1.000	3.250
D35-41B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

## Type B Reducer Bushings



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



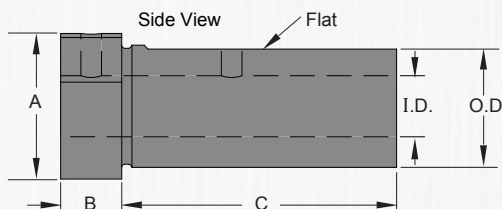
INCH Description	Part No. 733101-	O.D.	I.D.	A	B	C
THB75-25	93106		.250			
THB75-31	93107		.321			
THB75-38	93108	0.750	.375	1.00	0.25	1.50
THB75-50	93109		.500			
THB100-38	93110		.375			
THB100-50	93111	1.000	.500	1.25	0.25	1.75
THB100-62	93112		.625			
THB100-75	93113		.750			
THB125-38	93114		.375			
THB125-50	93115		.500			
THB125-62	93116	1.250	.625	1.50	0.25	2.00
THB125-75	93117		.750			
THB125-100	93118		1.000			
THB150-50	93119		.500			
THB150-62	93120		.625			
THB150-75	93121	1.500	.750	1.75	0.25	2.50
THB150-100	93122		1.000			
THB150-125	93123		1.250			
THB200-50	93124		.500			
THB200-62	93125		.625			
THB200-75	93126		.750			
THB200-100	93127	2.000	1.000	2.25	0.25	3.50
THB200-125	93128		1.250			
THB200-150	93129		1.500			
THB200-175	93130		1.750			
THB250-50	93131		.500			
THB250-62	93132		.625			
THB250-75	93133		.750			
THB250-100	93134		1.000			
THB250-125	93135	2.500	1.250	2.75	0.25	4.00
THB250-150	93136		1.500			
THB250-175	93137		1.750			
THB250-200	93138		2.000			
THB250-225	93139		2.250			

## Type LBF Reducer Bushings



Type LBF Reducer Bushings' are manufactured with two set screws for clamping drills, boring bars, and shank tools and a flat for clamping toolholders.

These bushings are also equipped with two clearance notches for coolant, are heat treated and precision ground. They are also used to adapt drills, boring bars and other shank tools.



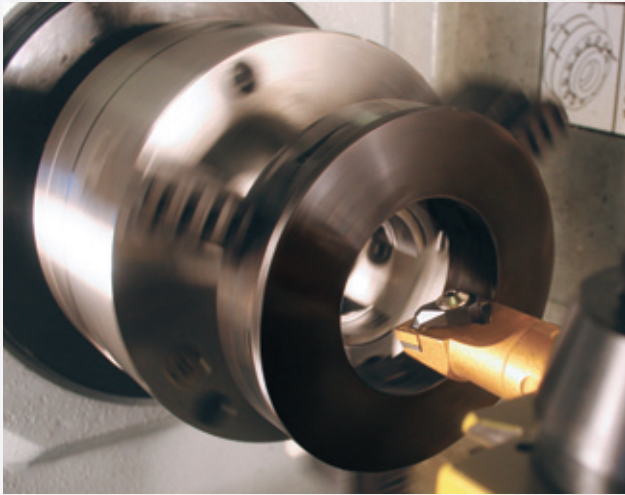
INCH Description	Part No. 733101-	O.D.	I.D.	A	B	C
LBF125-0375	93216		0.375			
LBF125-0500	93217		0.500			
LBF125-0625	93218	1.250	0.625	1.50	.625	2.813
LBF125-0750	93219		0.750			
LBF125-0875	93220		0.875			
LBF125-1000	93221		1.000			
LBF150-0250	93222		0.250			
LBF150-0375	93223		0.375			
LBF150-0500	93224		0.500			
LBF150-0625	93225	1.500	0.625	1.75	.625	3.156
LBF150-0750	93226		0.750			
LBF150-0875	93227		0.875			
LBF150-1000	93228		1.000			
LBF150-1000	93229		1.250			
LBF200-0500	93230		0.500			
LBF200-0625	93231		0.625			
LBF200-0750	93232		0.750			
LBF200-0875	93233	2.000	0.875	2.25	.750	3.750
LBF200-1000	93234		1.000			
LBF200-1250	93235		1.250			
LBF200-1500	93236		1.250			

For more information refer to our Lathe Accessories catalog



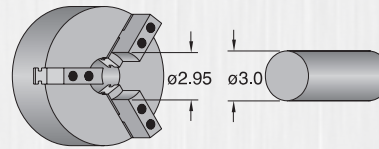
## TruJaws® Soft Jaw Machining Adapter

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



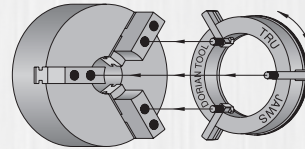
Using the TruJaws® is easy and requires very few steps

1



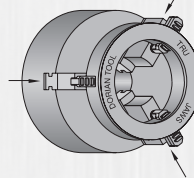
**Set the jaws for the required job.** The diameter of the jaws must be set smaller than the part diameter.

2



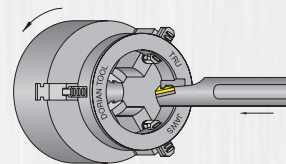
**Insert the knurled prong into the hole of the soft jaws.** Adjust the TruJaws to fit into the bolt holes of the soft jaws. Then, rotate the body of the TruJaws until snug, pulling the jaws rigid in the opposite direction of the clamping force (away from the part to be held).

3



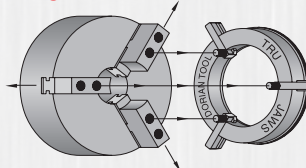
**Lock the chuck.** Jaws must be locked in the direction of the part to be held. The soft jaws will then be held rigidly by the TruJaws as if holding the part.

4



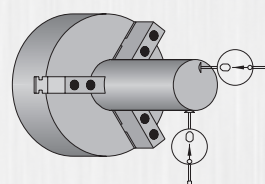
**Machine the diameter desired.** The bore diameter must be precise with the diameter of the part to be held.

5



**Remove the TruJaws.** Unlock the chuck opposite to the locking direction.

6

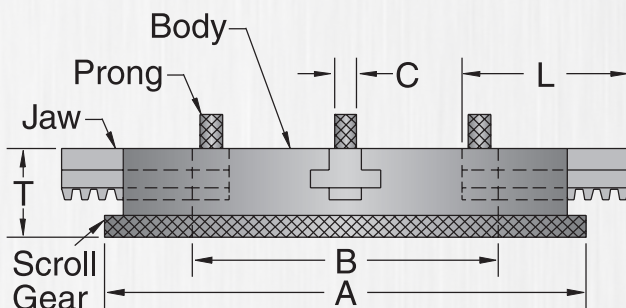


**Chuck the part.** If these steps are followed correctly, the part will be true within .0002" T.I.R.

### Features:

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

### Technical Specifications:



TruJaws® Soft Jaw Machining Adapter												
UPC No.	Description	Thick T	Weight		Prong Dia. C	Max. Boring Range B	Min. Outside Range A	Length of Jaws L	Chuck Range	Max. Load Capacity		Max. RPM Use
			Lbs	Kg						Lbs	Kg	
03540	TJP47-3	1.250	12	5,40	.500	3.250	6.125	3.00	UP-8"	8,000	3,360	900
03542	TJP52-3	1.750	28	12,7	.750	6.625	10.625	4.75	8-14"	20,000	9,070	600
03544	TJP57-3	1.750	43	19,5	.750	11.50	16.000	4.75	14-26"	15,000	6,800	250



# CNC Marker - Spring Loaded Mechanical Device

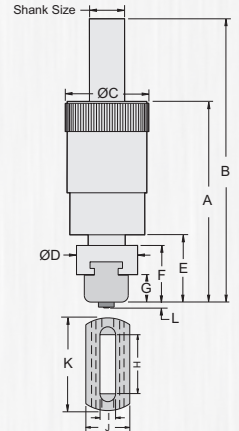


**The CNC Marker will replace punches, hammers, presses and secondary operations. You can stamp numbers, letters, and logos onto any material on your Manual or CNC Machine. Automatic Stamping Eliminates Secondary Operations & Labor Costs.**

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



Steel Stamp



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

## The CNC Marker Working Principle:

**Step 1:** Move (rapid) the CNC Marker towards to workpiece until the stamps make contact with the surface to be marked.

**Step 2:** From the position where the CNC Marker makes contact with the workpiece, advance the CNC Marker into the workpiece by a certain distance called "loading stroke" which is specified in the instructions manual of the CNC Marker.

**Step 3:** At the end of the "loading stroke", the spring loaded mechanism of the CNC Marker triggers and stamps the workpiece. Do not advance the CNC Marker into the workpiece after stamping.

**Step 4:** Retract the CNC Marker up. It automatically re-charges itself and at this point is ready for the next stamp.



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

CNC Lathe	CNC VMC	CNC HMC	Drill Arbor Press

## CNC Marker Stores in Machine's Tools Magazine for Automatic Tool Change\*

Carousel	Side Mount - Vertical	Side Mount - Horizontal

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



Featuring Modular Heads for One Boring Bar Body!



Featuring a NEW EXTENDED line of CARBIDE INSERTS!



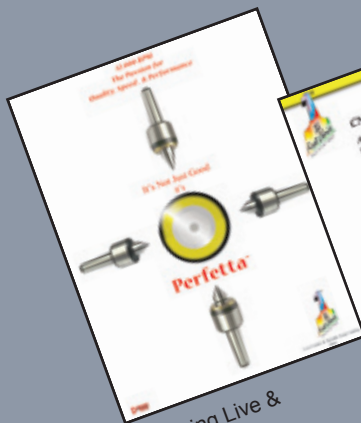
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Featuring 90° & Universal Angle Heads with Interchangeable Spindle Taper Holders!



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- **Jet-Stream™ Thru Coolant System Provides Chip Control**

**See pages 20-22**

