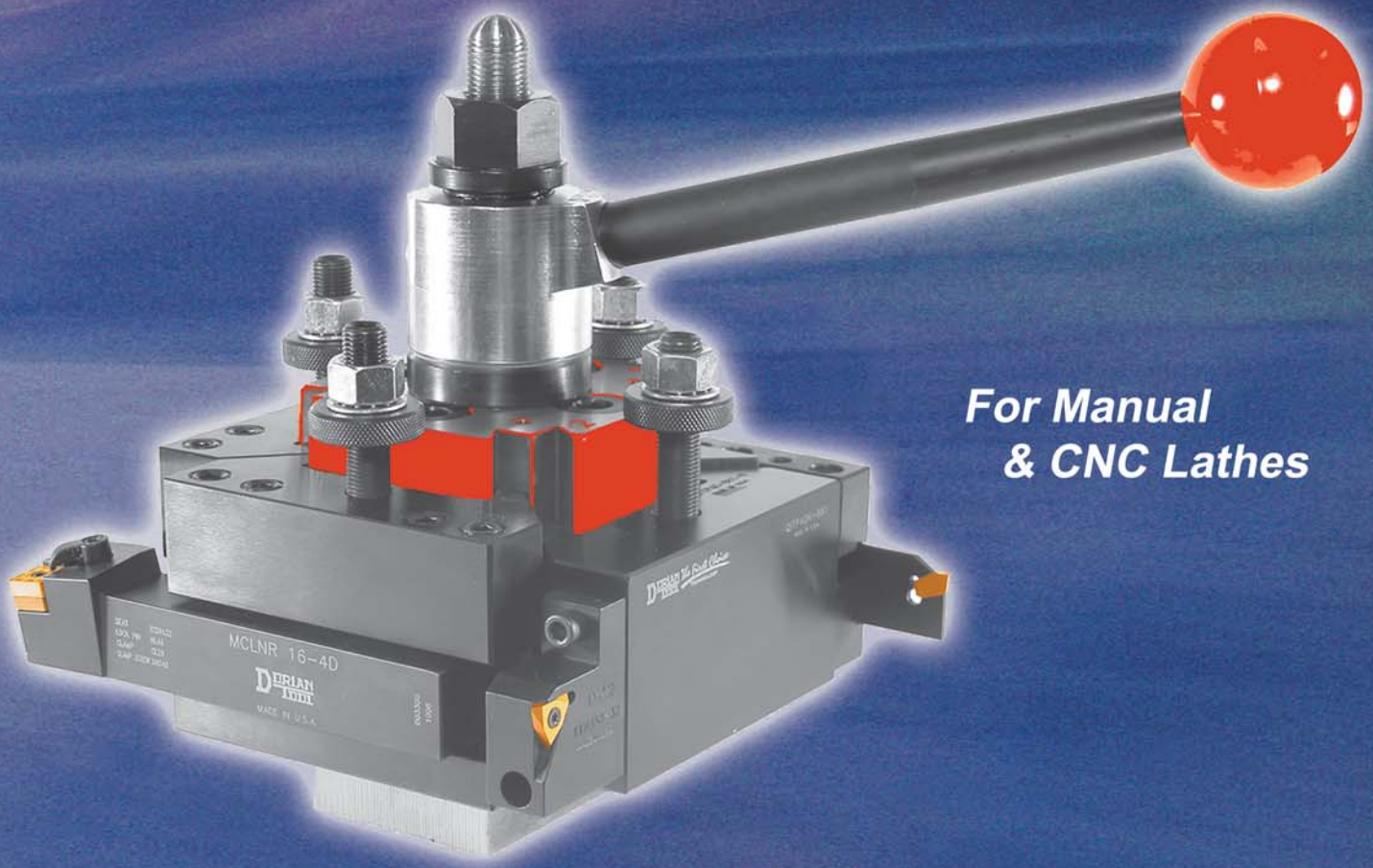
The First Choice™

TECHNOLOGY

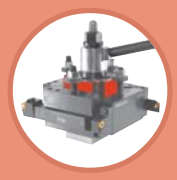
Tool Posts & Tool Holders

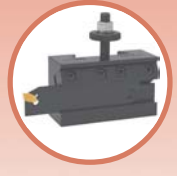


For Manual & CNC Lathes

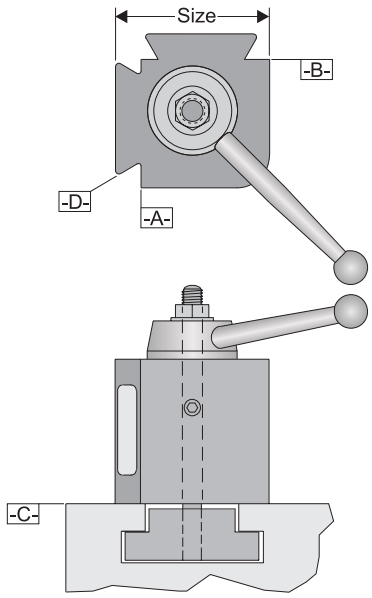
The Multi-Patented Tool Post with the Most Advanced Indexing & Locking Technology

DORIAN INTERNATIONAL TOOL

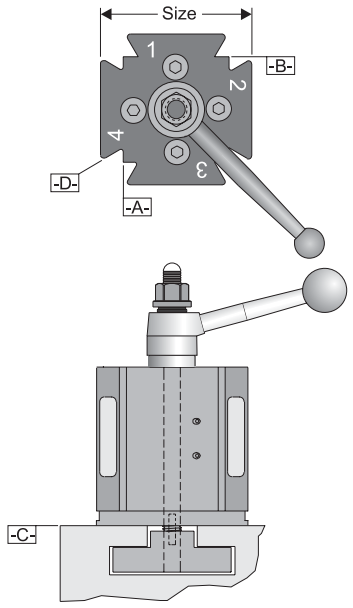




Super Quick Change Tool Post



Quadra Indexing Tool Post

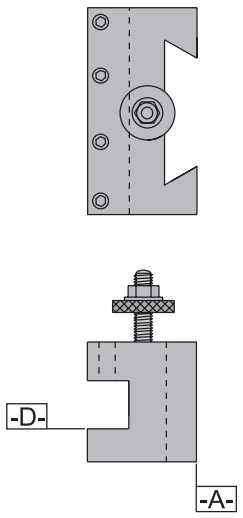


Tool Post Series	Square Dimension (Size)	
	Inches	Metric (mm)
25	2.5	64
30	3.0	76
35	3.5	89
40	4.0	102
50	5.0	127
60	6.0	152

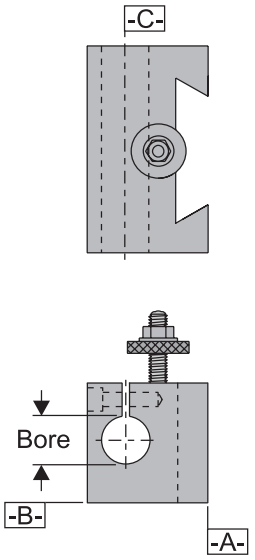
Tolerance			
Quick change repeatability		± .0001	± 0,00254
Same tool repeatability (Quadra Tool Post)		± .00005	± 0,00127
Tool-to-tool repeatability (Quadra Tool Post)		± .00005	± 0,00127
Face-to-face squareness	A-B*	± .0005	± 0,0127
Bottom-to-face squareness	A-C*	± .0005	± 0,0127
Bottom-to-dovetail squareness	C-D*	± .0005	± 0,0127

* Tolerance is per inches

Square Shank Holder



Boring Bar Holder



Holder Tolerance*	Inches	Metric (mm)
Quick change repeatability	± .0001	± 0,00254
Face-to-face squareness	± .0005	± 0,0127
Bottom-to-face squareness	± .0005	± 0,0127
Bottom-to-dovetail squareness	± .0005	± 0,0127

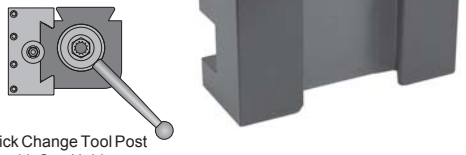
Square Shank Holder Tolerance*			
Tool slot taper	D	± .0002	± 0,0051
Tool slot squareness	D-A	± .0005	± 0,0127

Boring Bar Holder Tolerance*			
Bore circularity	Bore	± .0002	± 0,0051
Bore cylindricity	Bore	± .0005	± 0,0127
Boring parallelism	C-A C-B	± .0005	± 0,0127

*Tolerance is per inches

"D" Series Holders

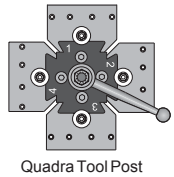
Designed to fit the "DN" and the "SDN" series tool posts.



Quick Change Tool Post with One Holder

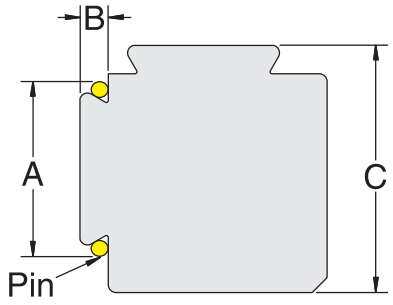
"QITP" Series Holders

A 45° chamfer allows four holders to fit simultaneously to the QITPN tool post.



Quadra Tool Post with Four Holders

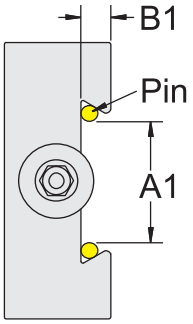
Tool Post Dovetail



Measuring the Dovetail

Toolpost Data				
Tool Post Series	C (nominal) in	C (nominal) mm	Pin Dia. in.	Pin Dia. mm
25	2.5	64	.1875	5
30	3.0	76	.1875	5
35	3.5	89	.2500	6
40	4.0	102	.2500	6
50	5.0	127	.3750	10
60	6.0	152	.5000	12

Tool Holder Dovetail

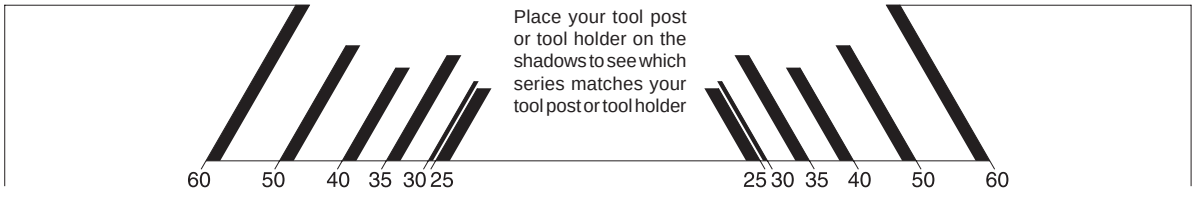


A1	B1	Pin Dia.

A1	B1	Pin Dia.

1. Measure the nominal dimension "C" across the flats of the toolpost, as shown above.
2. Cross reference the measurement in the table above to find which pin diameter to use.
3. Place the two (2) dowel pins in the dovetail.
4. To ensure accuracy, write down the pin size in the table provided.
5. Measure the distance across the pins, denoted as "A" and "A1".
6. Record your measurement in the table provided.
7. Measure the dovetail depth, denoted as "B" and "B1".
8. Record your measurement in the table provided.

Place Tool Post On This Side



Place Tool Holder On This Side

Quick Change Tool Post Crossover

Quadra Index Tool Post Crossover

Manufacturer	Dorian Tool		Aloris	DTM	Phasell	Dorian Tool	Aloris
Tool Post Type	Super Quick Change	Economy Quick Change	Quick Change	Quick Change	Quick Change	New Quadra Indexing Toolpost	Indexing Toolpost
Tool Post Size	SDN25AXA	DN25AXA	AXA	TP65A	250-100	QITP25N	—
	SDN30BXA	DN30BXA	BXA	TP75A	250-200	QITP30N	BXA-I
	SDN35CXA	DN35CXA	CXA	TP90A	250-300	QITP35N	—
	SDN40CA	DN40CA	CA	TP100A	250-400	QITP40N	CA-I
	SDN50DA	DN50DA	DA	TP125A	—	QITP50N	DA-I
	SDN60EA	DN60EA	EA	TP150A	—	QITP60N	—

Tool Post Type	Features	Application	Suggested Type of Lathe	Tool Post Size Selection Data		
				Lathe Swing (in.)	Tool Size (in.)	Tool Post Size
 New Quadra Indexing Tool Posts	• Indexing at 15° increments • 24 instant tool positions • 4 Quick Change holders locked simultaneously • Heat treated and precision ground alloy steel • Positive lock with absolute zero backlash • Precise tool repeatability of .00005" • Highest rigidity in industry	• Multi Operation Applications • High Performance • High Production • High Precision • Internal Operations • External Operations • Roughing • Finishing	CNC Lathe Turret Lathe Manual Lathe	Up to 12	1/2	QITP25N
				13 - 15	5/8	QITP30N
				14 - 17	3/4	QITP35N
				16 - 20	1	QITP40N
				17 - 32	1 1/4	QITP50N
				25 - XHD	1 1/2	QITP60N
 New Super Quick Change Tool Posts	• Positive lock with absolute zero backlash (20000 psi holding pressure) • Heat treated and precision ground alloy steel • Precise tool repeatability of .0001" • Industry standard • Maintenance free • Six different sizes	• Toolroom Applications • Maintenance Work • Limited Multi Operation Applications • Prototyping • High Precision • Internal Operations • External Operations • Roughing • Finishing	Manual Lathe	Up to 12	1/2	SDN25AXA
				13 - 15	5/8	SDN30BXA
				14 - 17	3/4	SDN35CXA
				16 - 20	1	SDN40CA
				17 - 32	1 1/4	SDN50DA
				25 - XHD	1 1/2	SDN60EA
 New Economy Quick Change Tool Posts	• Positive lock with absolute zero backlash • Heat treated and precision ground alloy steel • Precise tool repeatability of .0001" • Maintenance Free • Industry standard	• Back Up Tool Post Behind an Automated Turret • Maintenance Work • Prototyping • Limited Multi Operation Applications • Toolroom Work • High Precision • Roughing	Manual Lathe CNC Lathe (for turret back-up only)	Up to 12	1/2	DN25AXA
				13 - 15	5/8	DN30BXA
				14 - 17	3/4	DN35CXA
				16 - 20	1	DN40CA
				17 - 32	1 1/4	DN50DA
				25 - XHD	1 1/2	DN60EA
 Dorian Square Indexing Turrets	• Indexing at 15° increments • 24 instant tool positions • High tensile strength alloy steel for rigidity • Precise tool repeatability of .0001"	• Fixed Tooling Applications • High Production Applications Where Tool Change Is Not Necessary After First Setup • External Operations (Internal Operations Require Special Holder)	Manual Lathe Turret Lathe	Up to 12	1/4 - 3/8	DSIT-25
				13 - 15	3/8 - 1/2	DSIT-35
				14 - 17	5/8 - 1	DSIT-35B
				16 - 20	1/2 - 3/4	DSIT-45
				17 - 32	3/4 - 1	DSIT-45B
				25 - XHD	3/4 - 1 1/4	DSIT-60
 New Mini Quick Change Tool Posts	• Variety of Quick Change tool holders available • Precise tool repeatability of .0001" • American or European style mounting	• Miniature Scale Lathe Work • Jewelry, Model Making, Instrument Making, Watch Making Applications and for Opticians and Do-it-yourselfers • High Precision	Miniature Lathe	Up to 5	3/16	MDN10
				5 - 10	5/16	MDN15
				8 - 12	1/2	MDN20

Tool Post Mounting Data

Quote Number	
Purchase Order Number	

The First Choice™ TECHNOLOGY

If you need assistance, please complete the sections below and fax to (979) 282-2951

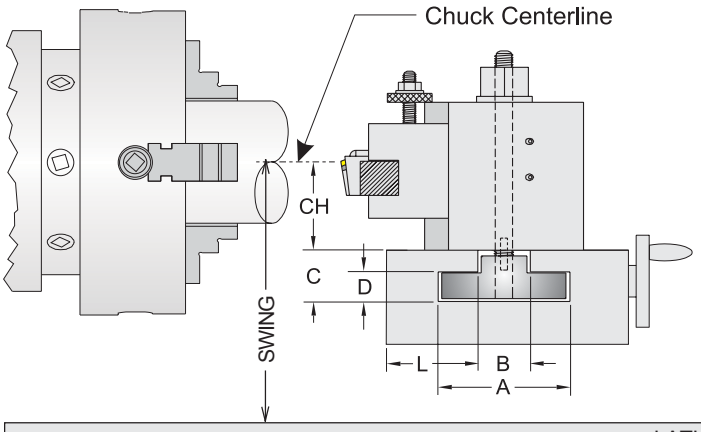
Company _____ Name _____

Address _____ Phone ( ) _____

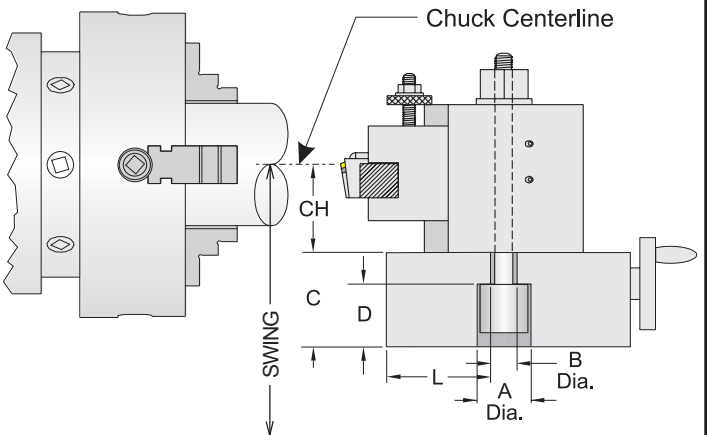
City _____ Fax ( ) _____

State _____ Zip _____ **Type of machine** _____

☐ **AMERICAN STYLE MOUNTING ("T-NUT")**



☐ **EUROPEAN STYLE MOUNTING (BOLT SHAFT)**

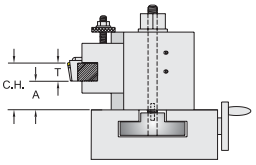


LATHE BED

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

Please fill in the information to ensure that you receive the proper tool post. Tool post is supplied with blank T-nut or bolt shaft that the customer machines to required specs. For custom machined T-nut or bolt shaft, at an additioanal cost, specify dimensions (including units, i.e. mm or in.).

How to measure tool center height "CH"



"CH" = Measured from top of compound to chuck center line
"A" = Measured from compound to tool seat
"T" = Tool size
"CH" = "A" + "T"

Factors that define the selection of a "Standard" tool post for a particular lathe:

1. Lathe swing
2. Center height
3. Tool size
4. Mounting Style

Factors that define the selection of the "Actual" tool post for a particular lathe:

1. Horsepower of Motor
2. RPM of Chuck
3. Type of Machine
4. Type of Work

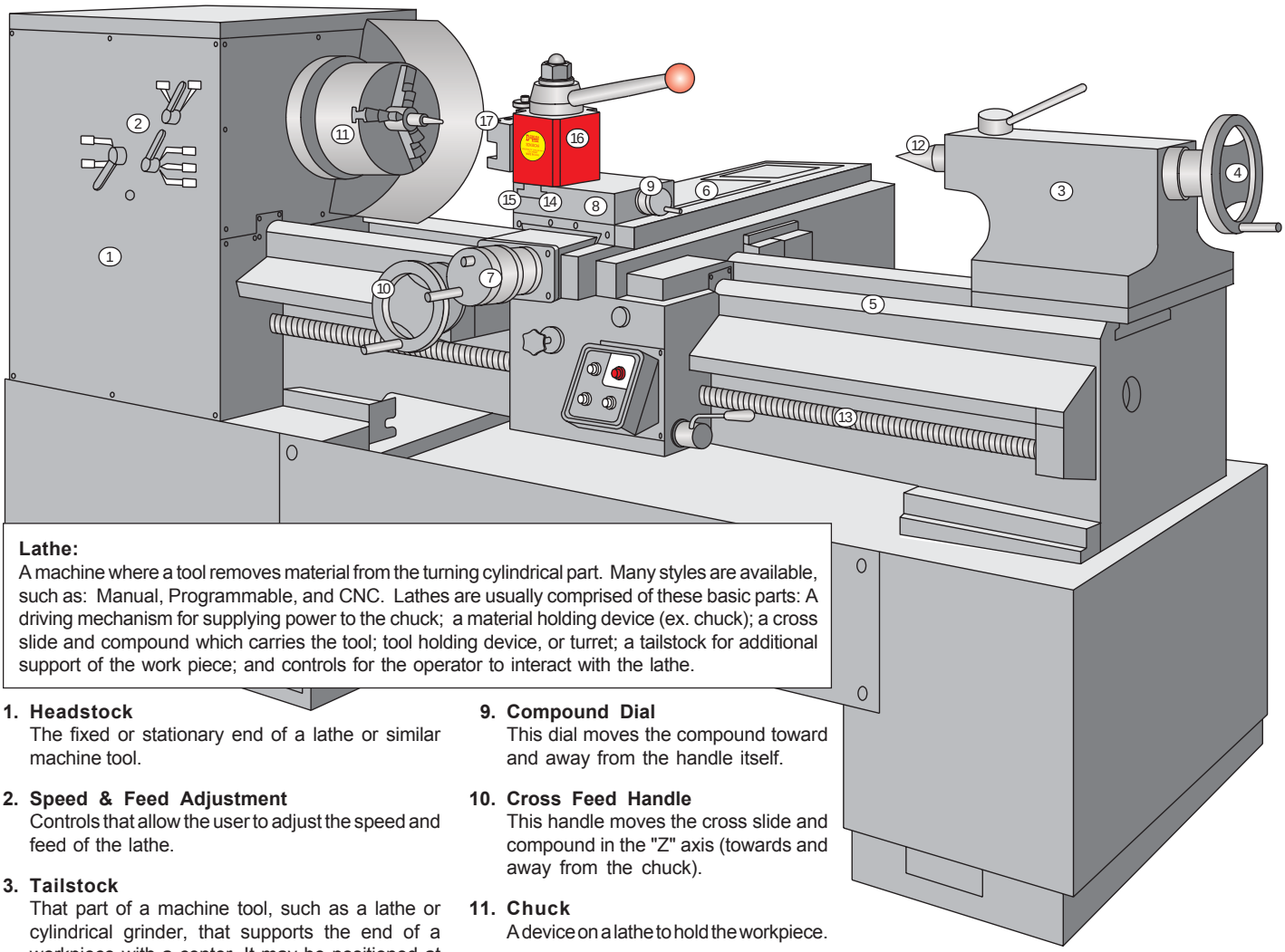
Factors that define the selection of the "Type" of tool post for a particular lathe:

1. Prototype or Production
2. Roughing or Finishing

	Qty.	FIRST CHOICE	
		Part Number	Description
Tool Post			
Tool Post Set			
Machined "T" nut			
Tool Holder			
Tool Holder			
Tool Holder			
Tool Holder			
Tool Holder			

	Qty.	SECOND CHOICE	
		Part Number	Description
Tool Post			
Tool Post Set			
Machined "T" nut			
Tool Holder			
Tool Holder			
Tool Holder			
Tool Holder			
Tool Holder			

DORIAN TOOL INT'L 615 COUNTY ROAD 219 EAST BERNARD, TX 77435 1-800-627-0266 979-282-2861 FAX: 979-282-2951



Lathe:
A machine where a tool removes material from the turning cylindrical part. Many styles are available, such as: Manual, Programmable, and CNC. Lathes are usually comprised of these basic parts: A driving mechanism for supplying power to the chuck; a material holding device (ex. chuck); a cross slide and compound which carries the tool; tool holding device, or turret; a tailstock for additional support of the work piece; and controls for the operator to interact with the lathe.

1. **Headstock**
   The fixed or stationary end of a lathe or similar machine tool.

2. **Speed & Feed Adjustment**
   Controls that allow the user to adjust the speed and feed of the lathe.

3. **Tailstock**
   That part of a machine tool, such as a lathe or cylindrical grinder, that supports the end of a workpiece with a center. It may be positioned at any point along the way of the bed, and may be offset from center to machine tapers.

4. **Tailstock Spindle Movement Handle**
   This handle moves the tail stock in the "Z" axis (towards and away from the chuck).

5. **Bed**
   One of the principal parts of a machine tool, having accurately machined ways or bearing surfaces for supporting and aligning other parts of the machine.

6. **Cross-Slide**
   The part of the lathe that moves across the bed. It also holds the compound where the tool holding device is mounted.

7. **Cross-Slide Dial**
   This dial moves the cross slide in the "X" axis (toward and away from the operator).

8. **Compound**
   The part of a lathe set on the carriage that carries the tool post and holder. It is designed to swing in any direction and to provide feed for turning short angles or tapers.

9. **Compound Dial**
   This dial moves the compound toward and away from the handle itself.

10. **Cross Feed Handle**
    This handle moves the cross slide and compound in the "Z" axis (towards and away from the chuck).

11. **Chuck**
    A device on a lathe to hold the workpiece.

12. **Live Center**
    A center that revolves with the work. Generally, this is the headstock center; however, the ball bearing type tailstock center is also called a live center.

13. **Lead Screw**
    The long, precision screw located in front of the lathe bed geared to the spindle and used for cutting threads. Also, the table screw on the universal milling machine when geared to the indexing head for helical milling.

14. **T-Slot**
    The slots made in the tables of machine tools for the square-head bolts used to clamp the workpiece, attachments, or work-holding fixtures in position for performing the machining operations.

15. **T-Nut**
    A rectangular nut that is slid into the T-Slot of the compound. It is used to secure a tool holding device to the compound.

16. **Quick Change Tool Post**
    A device for holding tooling on the compound of a lathe. It can be as simple as a fixed system for holding one tool or as complex as an indexing quick change system.

17. **Quick Change Holder**
    A device to hold a cutting tool on a lathe that uses a system to allow for quick changing of tooling from one operation to the next. It is generally applied by using a dovetail cavity that is slid over a male dovetail on a toolpost.

18. **Center Height**
    The distance from the centerline of the chuck to the top of the compound.

19. **Lathe Swing**
    The dimension of a lathe determined by the maximum diameter of the work that can be rotated over the ways of the bed.

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

The First Choice™ Technology

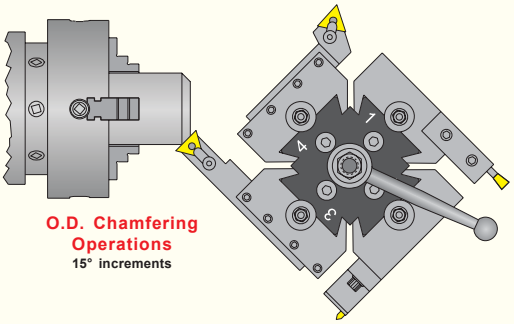
The NEW QUADRA® Indexing and Quick Change Tool Post

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

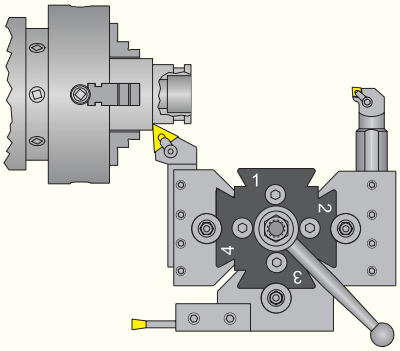
The Masterpiece of the Turning World

for
Manual Lathes
and
CNC Lathes

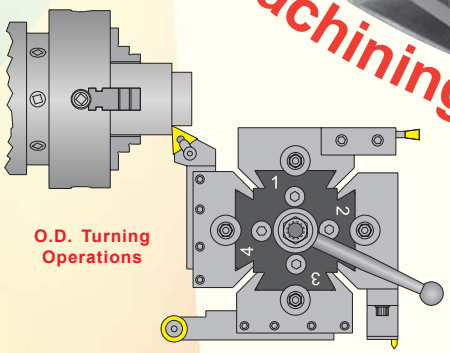
• Turns Machining into Profit!!! •



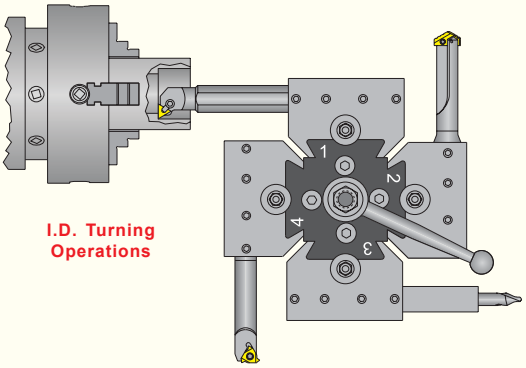
O.D. Chamfering Operations
15° increments



Combination O.D. & I.D. Operations



O.D. Turning Operations



I.D. Turning Operations

NEW LOCKING & INDEXING SYSTEM

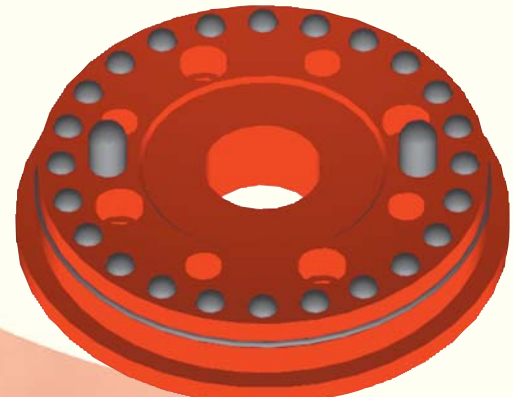
WITH 24 SUPER PRECISE POSITIONING BALL BEARINGS & 2 PRE-LOADED INDEXING PINS

Tool Post Indexing

- *Indexing Flexibility every 15°*
- *24 Locking Positions*
- *Instant Tool Repositioning*
- *From Prototypes to High Production*

Quick Change Tool Holders

- *4 Tool Holders Locked Simultaneously*
- *1 to 4 Tool Holders Ready to be Used*
- *Positive Lock with Absolute Zero Backlash*
- *Tool Holder Repeatability within .0001"*
- *Indexing Repeatability within .00005"*



Strong - Rigid - Precise

Tool Post Application

- *6 Sizes of Tool Posts Available*
- *From Tool Room to Oil Country Lathes*
- *Quick and Versatile for Finishing*
- *Strong for Heavy-Duty Roughing*
- *Easy to Install*
- *Maintenance Free*

DORIAN INTERNATIONAL TOOL

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

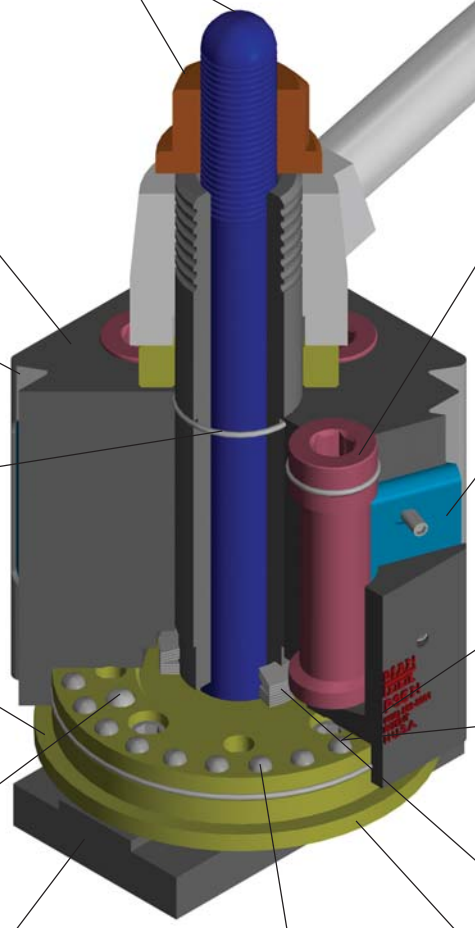
HOLDING POST AND FLANGE NUT
Secures the Tool Post on the lathe

TOOL POST BODY
Heavy Duty Construction
Hardened and Precision Ground
Alloy Steel

POSITIVE LOCKING
The eccentric tool holder locking pin excercises over 20,000 psi of positive locking force on the sliding gib with absolute zero backlash.

TOOL HOLDER STATION
4 super precision dovetail holding stations
1 to 4 tool holders locked simultaneously
1 to 4 tool holders locked independently

PATENTED QUICK CHANGE HOLDER LOCKING SYSTEM
The quick change tool holder locking system has a sliding gib which travels inside the fixed dovetail of the tool post. When pushed out by the locking pin, it pulls and locks the tool holder against the precision ground dovetail of the tool post within .0001" of repeatability.



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

PATENTED INDEXING SYSTEM
24 indexing positions
15° increments
Repeatability within .00005"

BOTTOM LOCKING PLATE
Holds the Tool Post in fixed position
Provides a mounting surface
Determines the rigidity, stability and the precise repeatability of the Tool Post

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

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

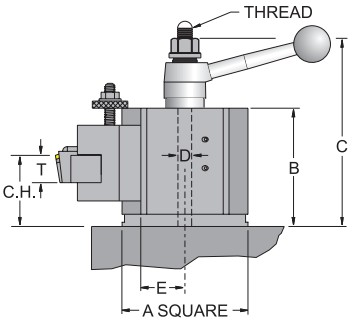
DISENGAGING SPRINGS
Lifts and disengages the Tool Post from the bottom locking plate in order to index to the desired position.

MOUNTING SYSTEM
Tool Post is provided with a T-nut for American mounting style or with a bolt shaft for European mounting style.

POSITIONING TOOL STEEL BALL BEARINGS
24 super precision and hardened tool steel ball bearings assure accuracy and precise repeatability when the tool post is locked.

LARGER SURFACE PLATE
A larger surface area provides more holding force.

Technical Specifications

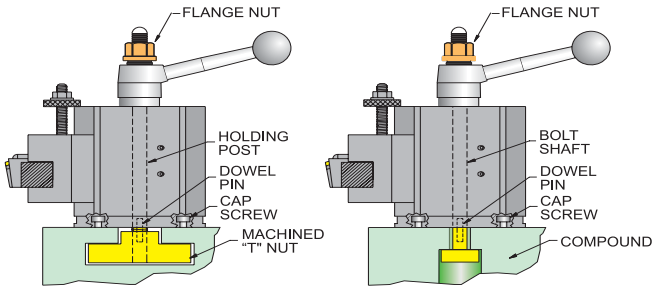


Description	QITP25N		QITP30N		QITP35N		QITP40N		QITP50N		QITP60N	
Part No. 733101-	00000		00002		00004		00006		00008		00010	
Lathe Swing	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
Over Bed	UP-12"	300,0	13-15"	320,0	14-17"	400,0	16-20"	450,0	17-32"	500,0	25-XHD	XHD
A	2.500	63,5	3.000	76,2	3.500	88,9	4.000	101,6	5.000	127,0	6.000	152,4
B	2.710	68,8	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	25,4	1.125	28,6
E	0.880	22,4	1.115	28,3	1.200	30,5	1.530	38,9	1.897	48,2	2.207	56,1
T-Tool Cap.	0.500	12,0	0.625	16,0	0.750	20,0	1.000	25,0	1.250	32,0	1.500	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	2.224	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

Tool Post supplied standard with blank T-nut. For a machined T-nut, at additional cost, please fill out the "Toolpost Mounting Data" sheet.

MOUNTING

Quick, Simple, & Rigid



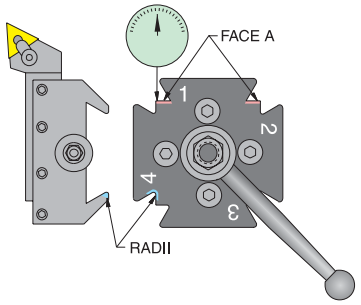
American Style **European Style**

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

Optional cap screws and dowel pins may be used to secure the toolpost directly to the compound. This is advantageous if there is tool post shifting during heavy or interrupted cuts.

INDICATING POSITION

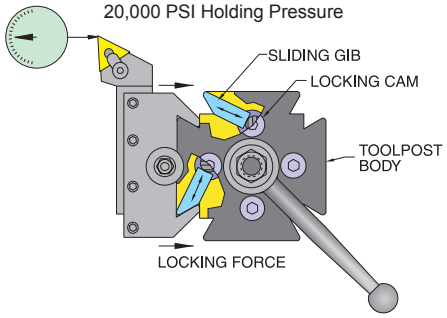
Repetitive accuracy of .00005"



The four dovetails are machined at 90° square (± .0005"). At mounting, it is necessary that the Face "A" to be set parallel to the lathe axis with an indicator in order for drills to work properly. The dovetail surfaces must be kept clean and lubricated at all times to prevent misalignment of the tool holder when locked on the tool post. Also, whenever the drilling operation produces vibration, the parallelism of the tool post must be checked and kept within ± .0005".

HOLDER LOCKING SYSTEM

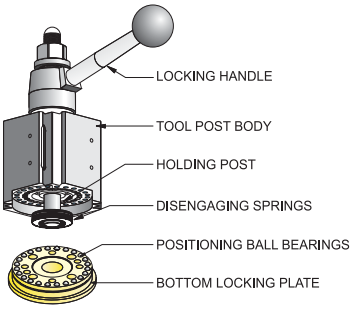
20,000 PSI Holding Pressure



The holder locking system of the Quadra Indexing Tool Post is based on the four Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam style Locking Pin, locking it positively. The cam rotates from 0° (Release Position) to approximately 45° (Locking Position). The repeatability of the tool post is ± .00005" and can be checked with a dial indicator, fixed on the tool post body as shown above. Each tool is independently locked, giving it flexibility to use from one to four tools simultaneously.

INDEXING SYSTEM

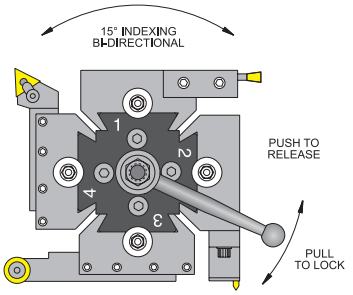
Repeatability Within .00005"



With the locking handle in unlocked position, the disengaging spring set lifts the toolpost from the bottom locking plate. Two pre-loaded index pins allow the toolpost to be indexed to any of the preset positions in 15° increments. Pulling the locking handle to the locked position engages the locking mechanism of the tool post for superior rigidity and repeatability.

OPERATION

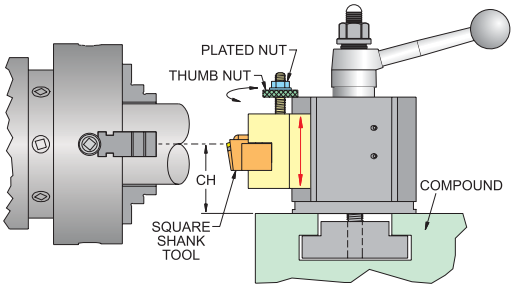
Index in Position in less than 1 Second Tool to Tool



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

HOLDER CENTER HEIGHT ADJUSTMENT

Positive Center Height Adjustment

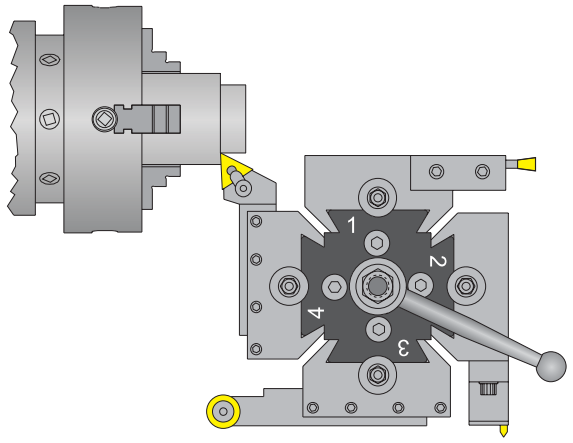


The Center Height Adjustment Assembly allows an easy and accurate adjustment of the cutting tool, first, by screwing or unscrewing the Thumb Nut until the desired height is reached, and next, by locking the Plated Nut to preserve it. **Maximum** center height has been reached when the top of the holder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

- Heavy duty construction
- Heat-treated alloy steel body
- Precision ground
- Four quick change tool holders locked simultaneously
- Industry Standard
- Positive lock with absolute zero backlash
- One to four tools ready to be used
- Precise tool repeatability of .00005" / ,00127 mm
- Instant tool positioning
- Highest locking rigidity in the industry
- Indexing flexibility every 15°
- 24 positive positions
- Wide range of holders
- Maintenance-free
- "T"-nut for easy mounting
- Ready to install

O.D. TURNING OPERATIONS

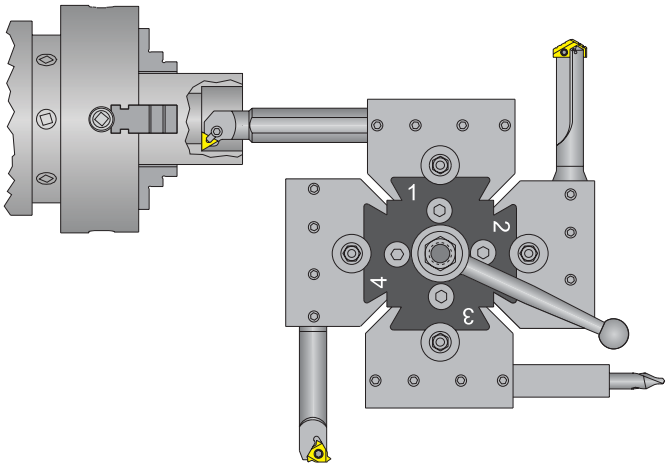
Finishing to Roughing or Threading



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

I.D. TURNING OPERATIONS

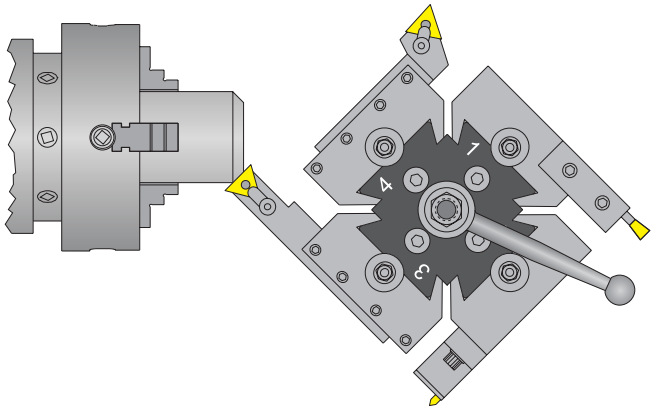
Finishing to Roughing or Threading



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

O.D. CHAMFERING OPERATIONS

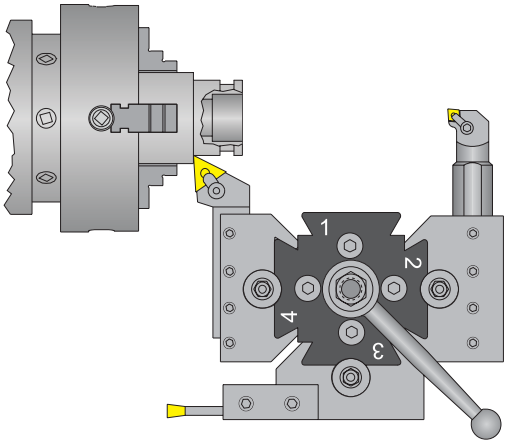
15° Increments



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

COMBINATION O.D. & I.D. OPERATIONS

Finishing to Roughing or Threading



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

The Quadra Indexing Tool Post will increase your production by 500% over the conventional Quick Change Tool Post

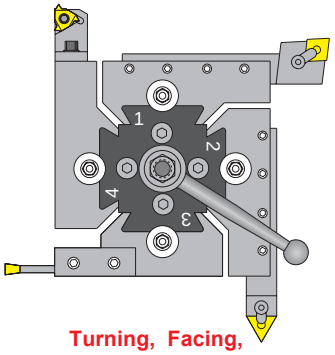
No tool change - No chips to clean - Just index and cut

- Easier to setup than any conventional tool post
- Multi-operations with a single tool, such as turning, facing, and chamfering, eliminates the need for extra tools
- Instant positioning by quick indexing with a .00005" repeatability
- 1 to 4 Quick Change tool holders locked independently in one setup
- After all the tools are set, you are ready for uninterrupted production runs, increasing your productivity over the conventional quick change tool post

Manual or CNC lathe + Quadra +

= High productivity

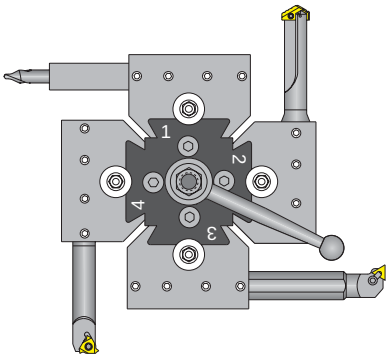
4 O.D. TOOL SET-UP



Turning, Facing, Threading, Chamfering and Cut-Off

The unique ability of indexing from one operation to another without removing the holders makes your manual lathe perform like a CNC lathe.

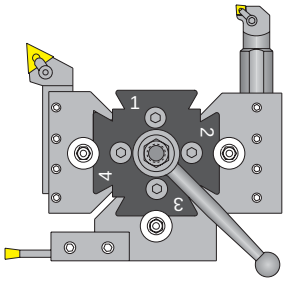
4 I.D. TOOL SET-UP



Drilling, Boring and I.D. Threading

The versatility of using any holder in any given job enables the lathe to be used as a turret lathe.

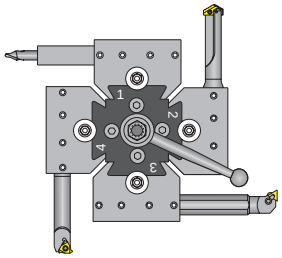
O.D., I.D. SET-UP

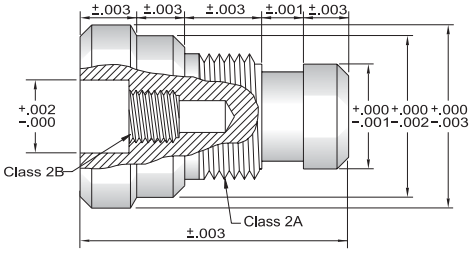


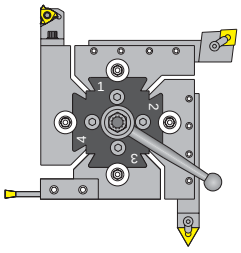
Combination - Boring, Turning and Cut-Off

The combination of O.D. and I.D. setup improves productivity and profitability.

Case Study: Increase Production Up To 500%



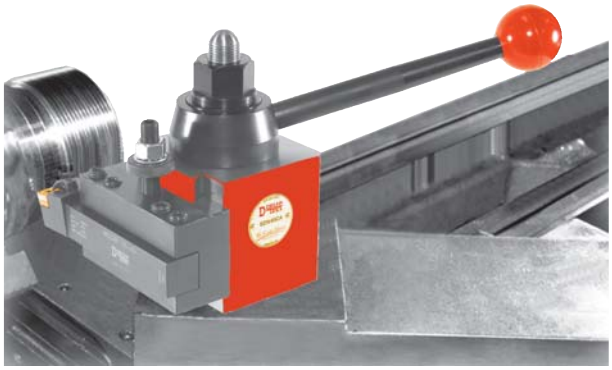




Machining Process Data			Cost Savings		
Tool Post Used	**Quick Change**	**Quadra**	**Time Saved**	**% Saved**	**Dollars Saved**
Total Tools Used	13	7			
Set Up Time	60 min.	36 min.	24 min.	40%	**$20.00**
Down Time	6 min.	40 sec.	5 min. 20 sec.	89%	**$4.45**
Production Time	11 min. 38 sec.	9 min. 38 sec.	2 min.	18%	**$1.65**
Total Time Used (1st Part)	77 min. 38 sec.	46 min. 18 sec.	31 min. 20 sec.	40%	**$26.11**
Total Time Used (2nd Part)	17 min. 38 sec.	10 min. 18 sec.	7 min. 20 sec.	41%	**$6.11**
Production Output			**Production Increase**	**Percentage Increase**	**Revenue Increase**
Total # Parts Produced in 1 Day	23 parts	43 parts	20	91%	**$347.77**
Total # Parts Produced in 1 Month	460 parts	860 parts	400	91%	**$6,955.40**

This case study was performed using a 17" Mori Seiki lathe. The Dorian Quadra Indexing Tool Post (QITP40N) was compared with the Dorian Quick Change Tool Post (SDN40CA) to measure production output and cost savings. Costs were based on a shop rate of $50.00 per hour.

DORIAN TOOL INT'L 615 COUNTY ROAD 219 EAST BERNARD, TX 77435 1-800-627-0266 979-282-2861 FAX: 979-282-2951



The First Tool is the Tool that You Will Have for a Lifetime!

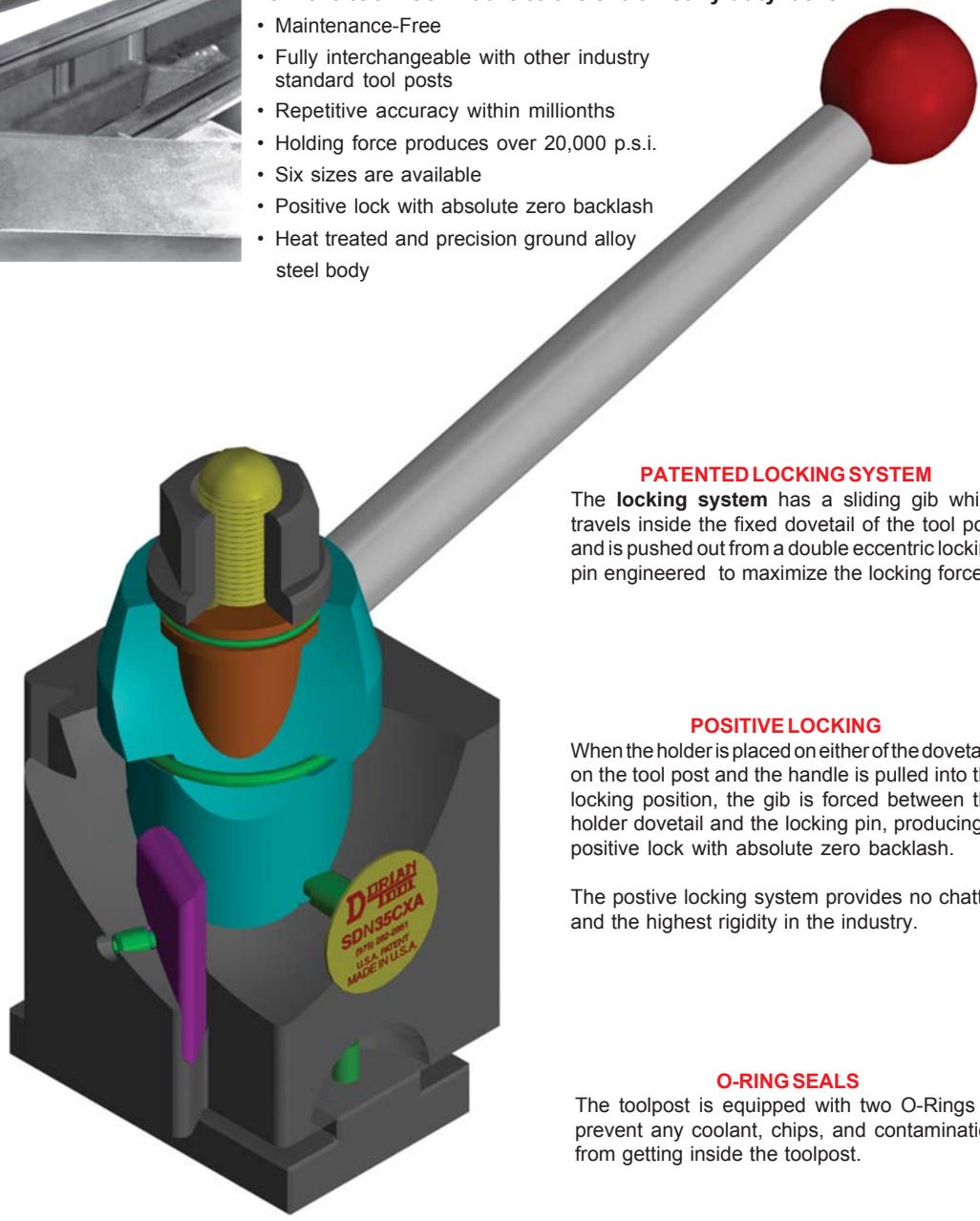
Engineered and built to perform with PRECISION, RIGIDITY, and SIMPLICITY from the tool-room lathe to the extra heavy duty lathe.

- Maintenance-Free
- Fully interchangeable with other industry standard tool posts
- Repetitive accuracy within millionths
- Holding force produces over 20,000 p.s.i.
- Six sizes are available
- Positive lock with absolute zero backlash
- Heat treated and precision ground alloy steel body

TOOL POST BODY
Heavy Duty Construction
Hardened and Precision Ground
Alloy Steel

INDUSTRY STANDARD
The Super Quick Change Tool Post is fully interchangeable with other industry standard tool posts.

45° LOCKING STROKE
The position of the locking handle will remain constant at 45° in the locked position, 0° in the released position.



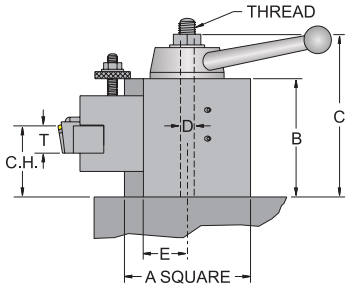
PATENTED LOCKING SYSTEM
The **locking system** has a sliding gib which travels inside the fixed dovetail of the tool post and is pushed out from a double eccentric locking pin engineered to maximize the locking force.

POSITIVE LOCKING
When the holder is placed on either of the dovetails on the tool post and the handle is pulled into the locking position, the gib is forced between the holder dovetail and the locking pin, producing a positive lock with absolute zero backlash.

The postive locking system provides no chatter and the highest rigidity in the industry.

O-RING SEALS
The toolpost is equipped with two O-Rings to prevent any coolant, chips, and contamination from getting inside the toolpost.

Technical Specifications

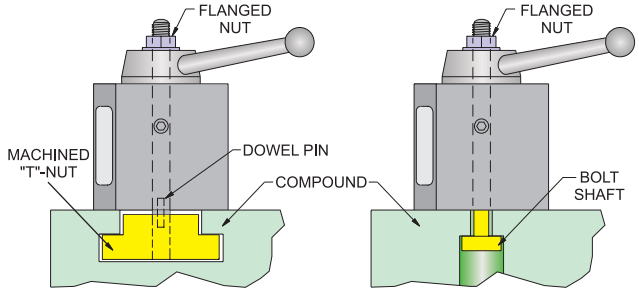


Description / Part No. 733101-	SDN25AXA 01000		SDN30BXA 01002		SDN35CXA 01004		SDN40CA 01006		SDN50DA 01008		SDN60EA 01010	
Lathe Swing Over Bed	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
	UP-12"	300,0	13-15"	320,0	14-17"	400,0	16-20"	450,0	17-32"	500,0	25-XHD	XHD
A	2.500	63,5	3.000	76,2	3.500	88,9	4.000	101,6	5.000	127,0	6.000	152,4
B	2.250	57,2	2.750	69,9	3.250	82,6	3.750	95,3	4.625	117,5	5.000	127,0
C	3.937	74,6	4.662	118,4	5.600	142,2	6.275	159,4	7.375	187,3	8.000	203,2
D	0.500	12,7	0.625	16,0	0.750	19,0	0.875	22,2	1.000	25,4	1.125	28,6
E	0.880	22,4	1.115	28,3	1.200	30,5	1.530	38,9	1.897	48,2	2.207	56,1
T - Tool Cap.	0.500	12,0	0.625	16,0	0.750	20,0	1.000	25,0	1.250	32,0	1.500	40,0
Optimum C.H.	1.257	31,9	1.569	39,9	1.757	44,6	2.194	55,7	2.695	68,5	3.007	76,4
C.H. MIN.	0.875	22,2	1.062	27,0	1.250	31,8	1.562	39,7	2.000	50,8	2.500	63,5
C.H. MAX	1.639	41,6	2.076	52,7	2.264	57,5	2.826	71,8	3.389	86,1	3.514	89,3
Thread	1/2-20	M12x1,75	5/8-18	M16x2,0	3/4-16	M18x2,5	7/8-14	M20x1,5	1.0-14	M24x3,0	1 1/8-12	M27x3,0

Tool Post supplied standard with blank T-nut. For a machined T-nut, at additional cost, please fill out the "Toolpost Mounting Data" sheet.

MOUNTING

Quick, Simple, and Rigid



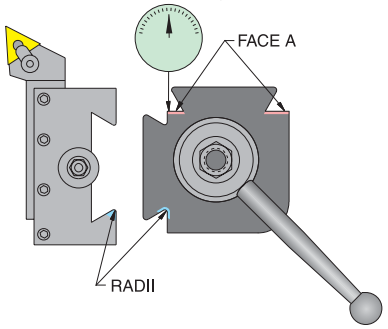
American Style **European Style**

The tool post mounting is accomplished quickly and easily with either a “T” Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flanged Nut will provide a rigid and reliable mounting of the tool post. The “T” Nut is provided blank or machined according to customer specification. Using the Bolt Shaft is the common mounting method on European lathes.

Optional dowel pins may be used to increase tool post mounting rigidity if tool post shifting is a concern under heavy or interrupted cuts.

INDICATING POSITION

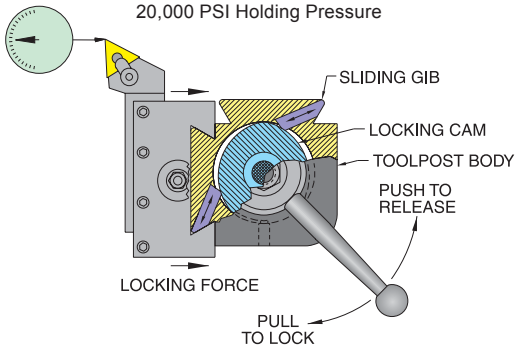
Repetitive accuracy of .0001"



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

PATENTED LOCKING SYSTEM

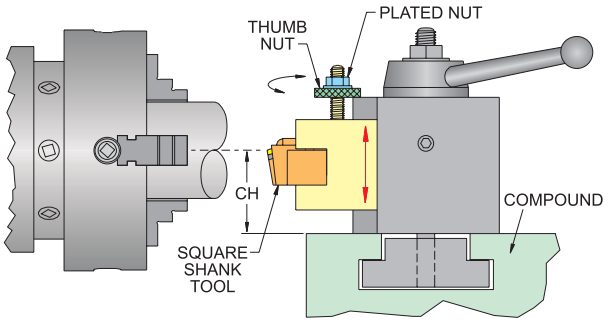
20,000 PSI Holding Pressure



The locking system of the Super Quick Change Tool Post is based on the two Sliding Gibs that travel inside the tool post body and are pushed against the holder by a cam, locking it positively. The handle rotates from 0° (Release Position) to approximately 45° (Locking Position). The repeatability of the tool post is ± .0001” and can be checked with a dial indicator, fixed on the tool post body as shown above.

HOLDER CENTER HEIGHT ADJUSTMENT

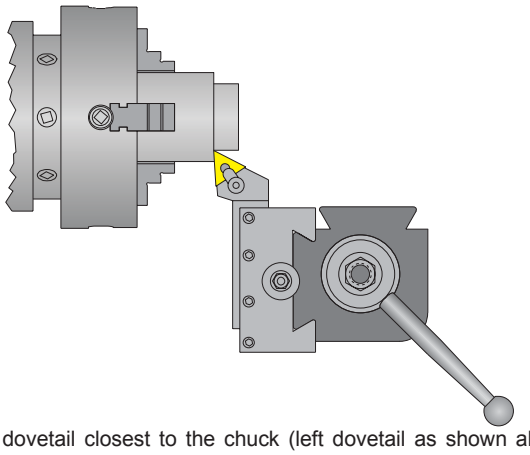
Positive Center Height Adjustment



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

O.D. TURNING OPERATIONS

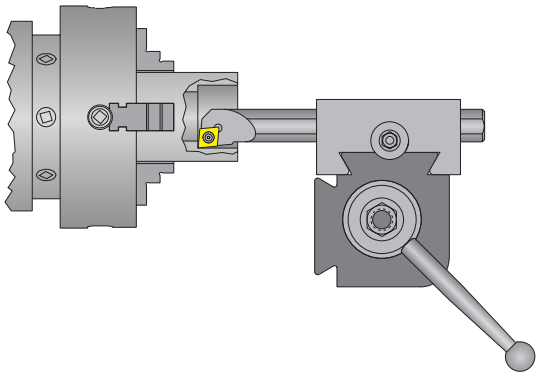
Turning, Threading, Cut-Off, Grooving, & Chamfering



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

I.D. TURNING OPERATIONS

Boring, Threading, Grooving, Drilling, & Center Drilling



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

The most rugged and compact Quick Change Tool Post in the industry

Built to operate simply and quickly

- Maintenance-Free
- Positive lock with absolute zero backlash
- Repetitive accuracy within millionths
- Heat-treated and precision ground alloy steel body
- Industry standard quick change tool holders

QUICK CHANGE SYSTEM WITH POSITIVE LOCKING

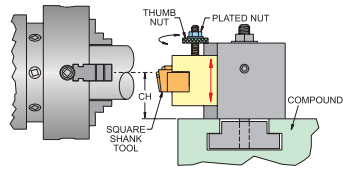
When the holder is placed on either of the dovetails on the tool post and the handle is pulled into the locking position, the gib is forced between the holder dovetail and the locking pin, producing a positive lock with absolute zero backlash.

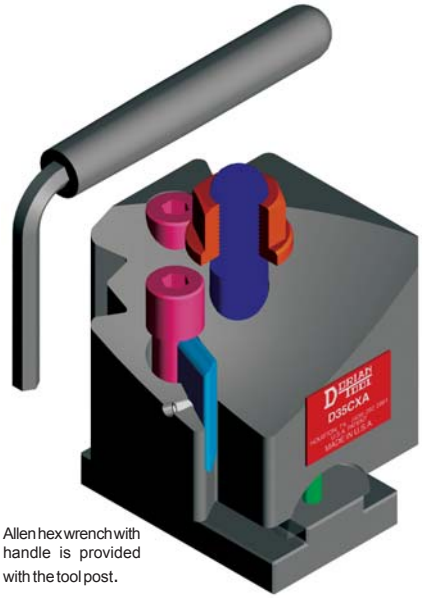
This system provides no chatter and the hightest rigidity in the industry.

HOLDER CENTER HEIGHT ADJUSTMENT

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

Positive Center Height Adjustment



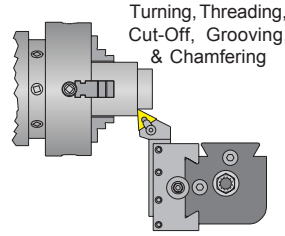


Allen hex wrench with handle is provided with the tool post.

O.D. TURNING OPERATIONS

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

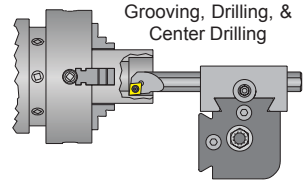
Turning, Threading, Cut-Off, Grooving, & Chamfering



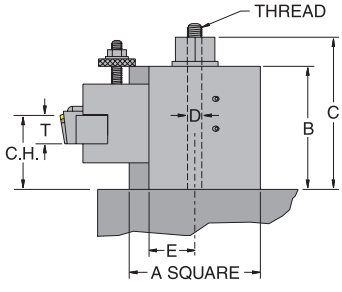
I.D. TURNING OPERATIONS

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

Boring, Threading, Grooving, Drilling, & Center Drilling



Technical Specifications



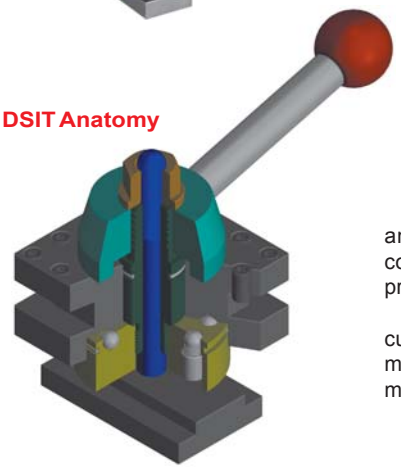
Description Part No. 733101-	DN25AXA 02000		DN30BXA 02002		DN35CXA 02004		DN40CA 02006		DN50DA 02008		DN60EA 02010	
Lathe Swing Over Bed	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
	UP-12"	300,0	13-15"	320,0	14-17"	400,0	16-20"	450,0	17-32"	500,0	25-XHD	XHD
A	2.500	63,5	3.000	76,2	3.500	88,9	4.000	101,6	5.000	127,0	6.000	152,4
B	2.000	50,8	2.500	63,5	3.000	76,2	3.500	88,9	4.500	114,3	5.000	127,0
C	2.688	68,3	3.312	84,1	4.000	101,6	4.625	117,5	5.750	146,1	6.250	158,8
D	0.500	12,7	0.625	16,0	0.750	19,0	0.875	22,2	1.000	25,4	1.125	28,6
E	0.880	22,4	1.115	28,3	1.200	30,5	1.530	38,9	1.897	48,2	2.207	56,1
T - Tool Cap.	0.500	12,0	0.625	16,0	0.750	20,0	1.000	25,0	1.250	32,0	1.500	40,0
Optimum C.H.	1.132	28,8	1.444	36,7	1.632	41,5	2.069	52,6	2.632	66,9	3.007	76,4
C.H. MIN.	0.875	22,2	1.062	27,0	1.250	31,8	1.562	39,7	2.000	50,8	2.500	63,5
C.H. MAX	1.389	35,3	1.826	46,4	2.014	51,2	2.576	65,4	3.264	82,9	3.514	89,3
Thread	1/2-20	M12x1,75	5/8-18	M16x2,0	3/4-16	M18x2,5	7/8-14	M20x1,5	1.0-14	M24x3,0	1 1/8-12	M27x3,0

Tool Post supplied standard with blank T-nut. For a machined T-nut, at additional cost, please fill out the "Toolpost Mounting Data" sheet.

Increase Your Productivity with The Super-Precise Square Index Turret Tool Post

- Multiple operation tool post
- Index to position in one second
- 24 positive indexing positions
- 15° increments
- Repeatability within millionths
- Interlocking face spline system assures rigidity and accuracy
- High tensile strength alloy steel for rigidity and precision

DSIT Anatomy

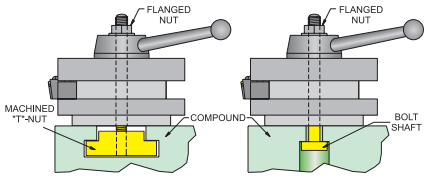


MOUNTING

The square index turret mounting is accomplished quickly and easily with either a "T" Nut that slides over the lathe compound or a Bolt Shaft. Tightening the Flanged Nut will provide a rigid and reliable mount of the tool post.

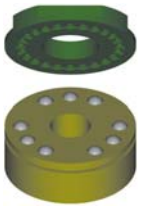
The "T" Nut is provided blank or machined according to customer specification. Using the Bolt Shaft is the common mounting method on European lathes. Optional cap screws may be used to secure the toolpost directly to the compound.

Quick, Simple, & Rigid



American Style European Style

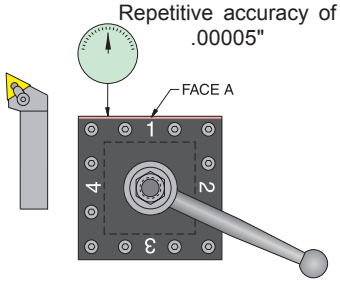
Locking Mechanism



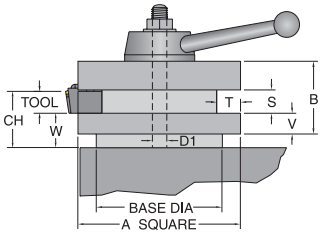
INDICATING POSITION

The four sides are machined at 90° square (± .0005"). At mounting, it is necessary that the Face "A" to be set parallel to the lathe axis with an indicator in order to ensure one side is square. The toolholder is slid in the slot and locked with the Set Screws.

Repetitive accuracy of .00005"



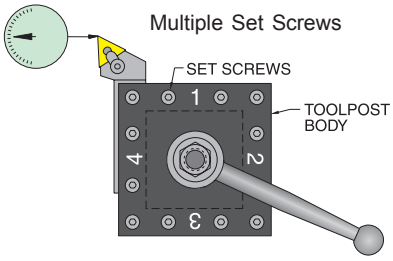
Specifications



HOLDER LOCKING SYSTEM

The locking system of the DSIT Square Index Turret is based on the set screws that surround the Main Block. Multiple set screws make contact with the tool holder ensuring even distribution of holding presure. Each tool is independently locked, giving it flexibility to use from one to four tools simultaneously.

Multiple Set Screws



Standard Square Index Turret Tool Post

Desc.	Part No. 733101-	Lathe Swing Over Bed in	mm	CH Center Height in	mm	Tool Capacity in	mm	A	B	D1	Base Dia.	S	T	V	W - Min in	mm	W - Max in	mm
DSIT-25	02500	UP-12"	300	1.050-1.380	26,7-35,0	.250-.375	6-10	2.5	1.25	0.375	2.000	0.442	.375	.450	0.800	20,3	1.005	25,5
DSIT-35	02502	10-13"	310	1.180-1.755	30,0-44,6	.375-0.50	10-12	3.5	1.75	0.500	2.875	0.630	.500	.500	0.805	20,4	1.255	31,9
DSIT-35B	02504	13-15"	320	1.530-2.355	38,9-59,8	.625-1.00	16-25	3.5	2.25	0.500	2.875	1.036	.562	.600	0.905	23,0	1.355	34,4
DSIT-45	02506	14-17"	400	1.380-2.380	35,1-60,5	.500-0.75	12-20	4.5	2.25	0.625	3.375	0.880	.687	.600	0.880	22,3	1.630	41,4
DSIT-45B	02508	16-20"	450	1.630-2.630	41,4-66,8	.750-1.00	20-25	4.5	2.75	0.750	3.375	1.294	.687	.600	0.880	22,3	1.630	41,4
DSIT-60	02510	17-24"	500	1.765-2.755	44,8-70,1	.750-1.25	20-32	6.0	3.25	0.875	4.500	1.567	.750	.750	1.015	25,8	1.505	38,2
Heavy Duty Square Index Turret Tool Post																		
HDSIT-45	02520	13-20"	400	1.625-2.620	41,3-66,5	0.75-1.00	20-25	4.5	3.00	0.750	3.375	1.275	.687	0.70	0.875	22,2	1.620	41,1
HDSIT-65	02522	16-24"	450	2.125-3.455	54,0-87,8	1.00-1.50	25-40	6.5	3.75	1.000	5.000	1.560	.890	1.00	1.125	28,6	1.955	49,7
HDSIT-70	02524	18-32"	500	2.375-3.565	60,3-90,6	1.25-1.75	32-45	7.0	4.50	1.000	5.000	2.010	1.00	1.00	1.125	28,6	1.815	46,1
HDSIT-80	02526	20-48"	600	2.875-3.795	73,0-96,4	1.50-2.00	40-45	8.0	4.75	1.125	6.000	2.300	1.15	1.20	1.375	34,9	2.045	51,9

You can order in either of two ways:

1. Machined to your specs with additional charges. (Be sure to specify maximum tool size to be used.)
2. With machinable base. Base portion of center post is semi-hard to facilitate machining to fit your lathe.

Tool Post supplied with blank "T" nut.
For a machined "T"nut, at an additional cost, please fill out the "Toolpost Mounting Data" sheet.

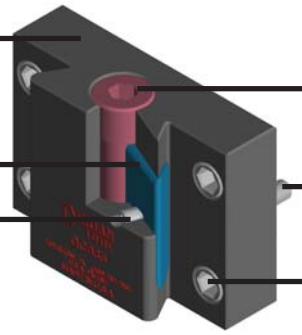
DORIAN TOOL INT'L 615 COUNTY ROAD 219 EAST BERNARD, TX 77435 1-800-627-0266 979-282-2861 FAX: 979-282-2951

DQCFB- Dorian Quick Change Flat Base

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

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

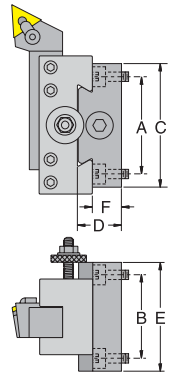
Gib Screw prevents the gib from falling out.



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

Dowel Pin for precise positioning.

Socket Head Cap Screw



Description	Part No. 733101-	Quick Change Tool Holder Series	A		B		C		S		W		Cap Screw		Dowel Pin
			in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	mm
DQCFB-20N		MD20	2.00	50,8	1.25	31,8	.500	12,7	.875	22,2	1.625	41.3	10-32	M5x0.8	M6
DQCFB-25N		D25AXA	2.50	63,5	1.75	44,5	.625	15,9	1.250	31,8	1.875	47,6	10-32	M5x0.8	M6
DQCFB-30N		D30BXA	3.00	76,2	2.25	57,2	.750	19,1	1.750	44,5	2.250	57,2	1/4-20	M6X1.0	M6
DQCFB-35N		D35CXA	3.50	88,9	2.50	63,5	.800	12,7	1.875	47,6	2.750	69,9	5/16-24	M8x1.25	M6
DQCFB-40N		D40CA	4.00	101,6	3.00	76,2	1.000	25,4	2.375	60,3	3.250	82,6	5/16-24	M8x1.25	M6
DQCFB-50N		D50DA	5.00	127,0	4.00	101,6	1.125	28,6	3.250	82,6	4.000	101,6	5/16-24	M8x1.25	M10
DQCFB-60N		D60EA	6.00	152,4	4.25	108,0	1.220	31,8	3.000	76,2	4.750	120,7	1/2-20	M12X1.75	M10

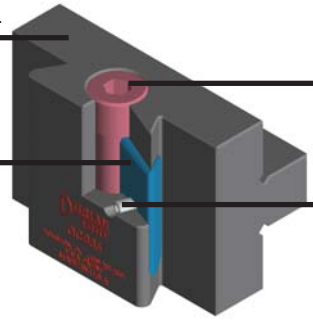
Tooling not included.

Dowel Pin and Cap Screws not included.

DQCB- Dorian Quick Change Base

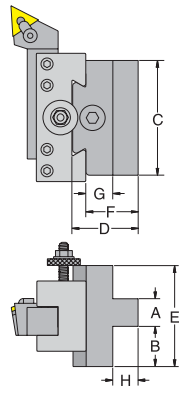
Quick Change Flat Base Body with industry standard dovetail. Heat treated and precision ground. Maintenance Free.

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



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

Gib Screw prevents the gib from falling out.



Description	Part No. 733101-	Square IndexTurret	Quick Change Tool Holder Series	A		B		C		S		T		W	
				in.	mm	in.	mm	in.	mm	in.	mm	in.	mm	in.	mm
DQCB-20N		DSIT-25	MD20	2.00	50,8	1.25	31,8	.500	12,7	.375	9,5	.375	10	.375	9,5
DQCB-25N		DSIT-35	D25AXA	2.50	63,5	1.75	44,5	.625	15,9	.500	12,7	.500	12	.625	15,9
DQCB-30N		DSIT-35B	D30BXA	3.00	76,2	2.25	57,2	.750	19,1	.625	15,9	.625	16	.812	20,6
DQCB-35N		DSIT-45 HDSIT-45	D35CXA	3.50	88,9	2.50	63,5	1.187	30,1	.750	19,1	.750	20	.875	22,2
DQCB-40N		DSIT-60 HDSIT-65	D40CA	4.00	101,6	3.00	76,2	1.031	26,2	1.000	25,4	1.000	25	1.000	25,4
DQCB-50N		DSIT-70	D50DA	5.00	127,0	4.00	101,6	1.312	33,3	1.250	31,8	1.250	32	1.375	34,9
DQCB-60N		HDSIT-80	D60EA	6.00	152,4	4.25	108,0	1.375	34,9	1.500	38,1	1.500	40	1.375	34,9

Tooling not included.

- Models MDN10 and MDN15
- Quick Change Holders
- Single dovetail tool post
- Precise within .0001"
- American or European style mounting

- Model MDN20
- Quick Change Holders
- Double dovetail tool post
- Precise within .0001"
- American or European style mounting

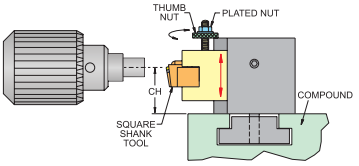
Combine Productivity with Artistic Ability

The Mini Quick Change Tool Post, designed with accurate precision and Swiss jeweler workmanship, provides the excitement of machining on a miniature lathe with the benefits of a large lathe.

Ideal for:
- Modelmakers
- Instrument Makers
- Opticians
- Jewelers
- Watchmakers
- Do-it-yourselfers

HOLDER CENTER HEIGHT ADJUSTMENT

Centerheight adjustment is easy, quick and accurate: screw/unscrew the thumb nut to desired height, then lock with plated nut to preserve the height. **Maximum** center height has been reached when the top of the holder is flush with the top of the tool post. **Minimum** center height has been reached when the bottom of the holder is flush with the top of the compound.

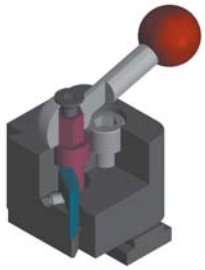


Positive Center Height Adjustment

QUICK CHANGE SYSTEM WITH POSITIVE LOCKING

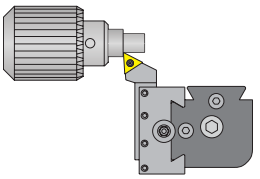
When the holder is placed on either of the dovetails on the tool post and the handle is pulled into the locking position, the gib is forced between the holder dovetail and the locking pin, producing a positive lock with absolute zero backlash.

This system provides no chatter and the highest rigidity in the industry.



O.D. TURNING OPERATIONS

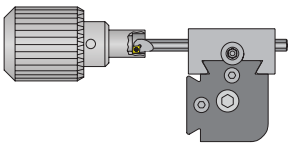
The dovetail closest to the chuck (left dovetail as shown above) is used for turning outside diameters. It holds the tool at the best location for clearance and rigidity when turning, threading, cut-off, grooving, and chamfering.



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

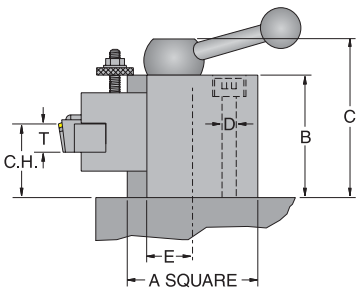
I.D. TURNING OPERATIONS

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

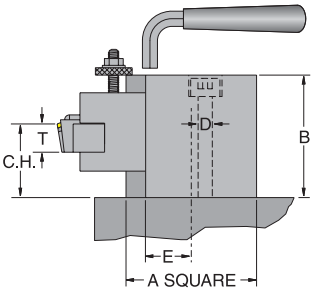


Boring, Threading, Grooving, Drilling, & Center Drilling

Technical Specifications



MDN10 & 15

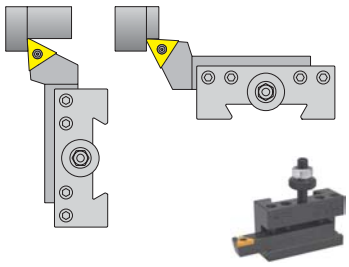


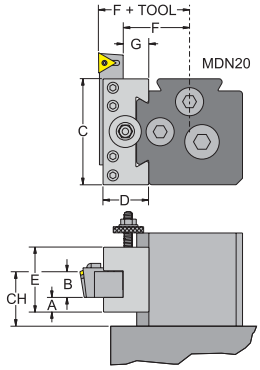
MDN20

Description	MDN10		MDN15		MDN20	
Part No. 733101-	02350		02352		02354	
Lathe Swing Over Bed	in	mm	in	mm	in	mm
	UP-5"	125,0	5-10"	200,0	8-12"	250,0
A	1.000	25,4	1.500	38,1	2.000	50,8
B	0.800	20,3	1.250	31,8	1.750	44,5
C	1.300	33,0	1.840	46,7	—	—
D	0.187	4,8	0.312	7,9	0.375	9,5
E	0.355	9,0	0.555	14,1	0.705	17,9
T - Tool Cap.	0.187	4,8	0.312	7,9	0.500	12,7
Optimum C.H.	0.467	11,1	0.598	12,8	1.005	22,4
C.H. MIN.	0.312	6,4	0.468	7,1	0.750	12,7
C.H. MAX	0.622	15,8	0.728	18,5	1.260	32,0

Tool Post supplied standard with blank T-nut. For a machined T-nut, at additional cost, please fill out the "Toolpost Mounting Data" sheet.

No. 1 Turning & Facing Holder

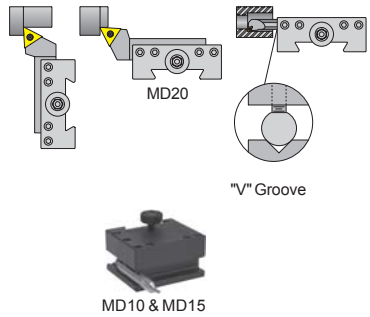


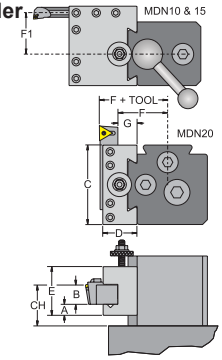


"MD" Series Desc.	Part No. 733101-	A in	B in	C in	D in	E in	F in	G in
MD10-1	02360	0.125	0.187	1.000	0.500	0.500	0.688	0.333
MD15-1	02400	0.156	0.312	1.500	0.625	1.000	0.919	0.364
MD20-1	02450	0.250	0.500	2.000	0.750	1.250	1.075	0.370

Supplied standard with inch components. Tooling not included

No. 2 Turning, Facing, & Boring Holder

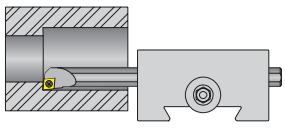


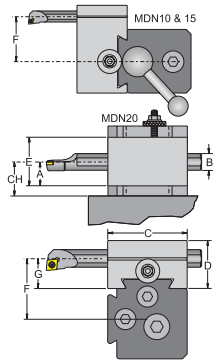


"MD" Series Desc.	Part No. 733101-	A in	B in	C in	D in	E in	F in	F1 in	G in
MD10-2	02362	0.125	0.187	1.200	1.000	0.625	1.188	0.615	0.833
MD15-2	02402	0.156	0.312	1.750	1.500	1.000	1.795	0.870	1.240
MD20-2	02452	0.250	0.375	2.000	0.750	1.250	1.075	1.263	0.370

Supplied standard with inch components. Tooling not included

No. 4 Boring Holder (Inch)

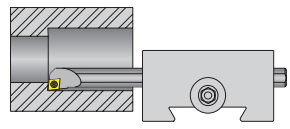


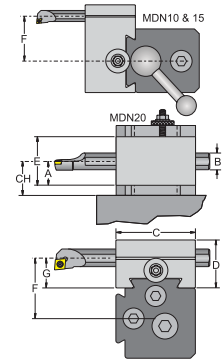


"MD" Series Desc.	Part No. 733101-	A in	B in	C in	D in	E in	F in	G in
MD10-4	02364	0.250	0.250	1.400	1.000	0.625	0.650	—
MD15-4	02404	0.437	0.375	2.250	1.500	1.000	1.125	—
MD20-4	02454	0.625	0.500	2.000	1.250	1.250	1.450	0.745

Supplied standard with inch components. Tooling not included

No. 4M Boring Holder (Metric)

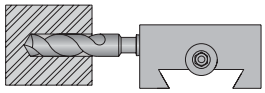


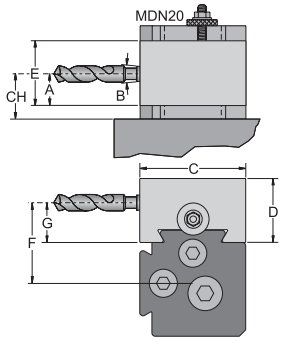


"MD" Series Desc.	Part No. 733101-	A mm	B mm	C mm	D mm	E mm	F mm	G mm
MD10-4M	02365	6,4	6	35,6	25,4	15,9	16,0	—
MD15-4M	02405	11,1	10	57,2	38,1	25,4	28,5	—
MD20-4M	02455	15,9	12	50,8	31,8	31,8	37,0	18,9

Supplied standard with metric components. Tooling not included

No. 5 Morse Taper Holder

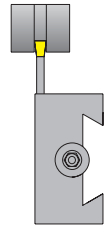


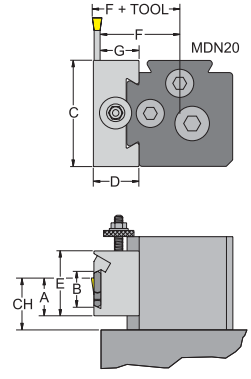


"MD" Series Desc.	Part No. 733101-	A in	B Morse Taper	C in	D in	E in	F in	G in
MD20-5	02456	0.625	1	2.250	1.250	1.250	1.450	0.745

Supplied standard with inch components. Tooling not included

No. 7-71C Cut-Off Holder

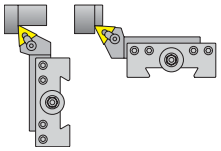


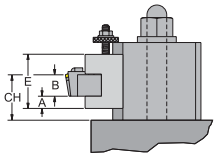


"MD" Series Desc.	Part No. 733101-	A in	"T" Type Blade	C in	D in	E in	F in	G in
MD15-7-71C	02408	0.600	P1N	1.500	0.625	1.000	1.100	0.545
MD20-7-71C	02460	0.750	P2	2.000	0.750	1.250	1.350	0.645

Supplied standard with inch components. Tooling not included

No. 1 Turning & Facing Holder





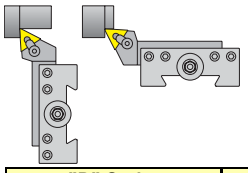
Tool Tips

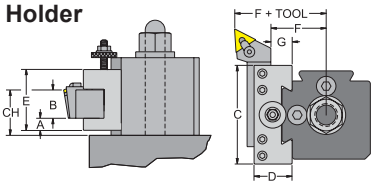
This holder is best used for holding high speed or carbide square shank tools close to the toolpost for more rigidity when turning, facing, and threading.

Tooling not included.

"D" Series Desc.	Part No. 733101-	"QITP" Series Desc.	Part No. 733101-	A in	A mm	B in	B mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-1	01100	QITP25N-1	00100	0.375	9,5	0.500	12	2.750	70	1.000	25,4	1.500	38,1	1.429	36,3	0.549	13,9
D30BXA-1	01250	QITP30N-1	00250	0.437	11,0	0.625	16	3.250	83	1.250	31,8	1.750	44,5	1.789	45,4	0.674	17,1
D35CXA-1	01400	QITP35N-1	00400	0.500	12,7	0.750	20	3.750	95	1.500	38,1	2.250	57,2	2.061	52,3	0.861	21,9
D40CA-1	01550	QITP40N-1	00550	0.562	14,3	1.000	25	4.500	114	1.750	44,5	2.500	63,5	2.516	63,9	0.986	25,0
D50DA-1	01700	QITP50N-1	00700	0.750	19,0	1.250	32	6.000	152	2.250	57,2	3.250	82,6	3.258	82,8	1.361	34,6
D60EA-1	01850	QITP60N-1	00850	1.000	25,4	1.500	40	7.000	178	3.000	76,2	4.000	101,6	3.943	100,2	1.736	44,1

No. 1S Oversized Turning & Facing Holder





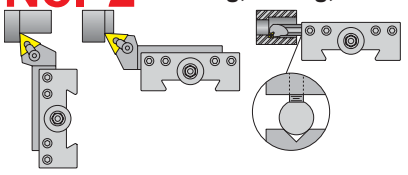
Tool Tips

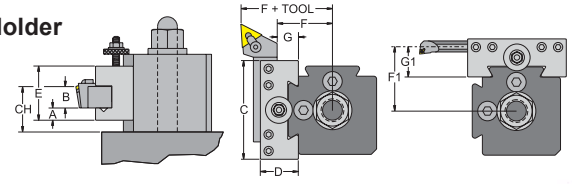
This holder is best used for holding ***larger*** high speed or carbide square shank tools close to the toolpost for more rigidity when turning, facing, and threading.

Tooling not included.

"D" Series Desc.	Part No. 733101-	"QITP" Series Desc.	Part No. 733101-	A in	A mm	B in	B mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-1-75	01102	QITP25N-1-75	00102	0.375	9,5	0.750	20	2.750	70	1.250	31,8	1.750	44,5	1.615	41,0	0.735	18,7
D30BXA-1-100	01252	QITP30N-1-100	00252	0.437	11,0	1.000	25	3.250	83	1.500	38,1	2.250	57,2	1.850	47,0	0.735	18,7
D35CXA-1-100	01402	QITP35N-1-100	00402	0.500	12,7	1.000	25	3.750	95	1.750	44,5	2.500	63,5	2.185	55,5	0.985	25,0
D40CA-1-125	01552	QITP40N-1-125	00552	0.562	14,3	1.250	32	4.500	114	2.000	50,8	3.000	76,2	2.515	63,9	0.985	25,0
D50DA-1-150	01702	QITP50N-1-150	00702	0.750	19,0	1.500	40	6.000	152	2.500	63,5	3.500	88,9	3.132	79,6	1.235	31,4
D60EA-1-200	01852	QITP60N-1-200	00852	1.000	25,4	2.000	50	7.000	178	3.250	82,6	4.250	108,0	3.692	93,8	1.485	37,7

No. 2 Turning, Facing, & Boring Holder





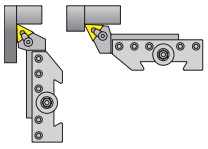
Tool Tips

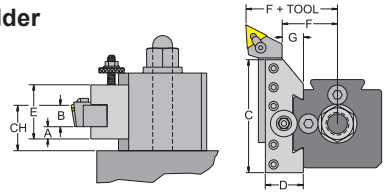
The "V" groove makes this holder more ***versatile*** so that it can hold either high speed or carbide square shank tools or boring bars.

Tooling not included.

"D" Series Desc.	Part No. 733101-	"QITP" Series Desc.	Part No. 733101-	A in	A mm	B * in	B * mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm	F1 in	F1 mm	G1 in	G1 mm
D25AXA-2	01104	QITP25N-2	00104	0.375	9,5	0.500	12	2.750	70	1.000	25,4	1.500	38,1	1.429	36,3	0.549	13,9	1.648	41,9	0.768	19,5
D30BXA-2	01254	QITP30N-2	00254	0.437	11,0	0.625	16	3.250	83	1.250	31,8	1.750	44,5	1.789	45,4	0.674	17,1	2.071	52,6	0.956	24,3
D35CXA-2	01404	QITP35N-2	00404	0.500	12,7	0.750	20	3.750	95	1.500	38,1	2.250	57,2	2.061	52,3	0.861	21,9	2.374	60,3	1.174	29,8
D40CA-2	01554	QITP40N-2	00554	0.562	14,3	1.000	25	4.500	114	1.750	44,5	2.500	63,5	2.516	63,9	0.986	25,0	2.891	73,4	1.361	34,6
D50DA-2	01704	QITP50N-2	00704	0.750	19,0	1.250	32	6.000	152	2.250	57,2	3.250	82,6	3.258	82,8	1.361	34,6	3.696	93,9	1.799	45,7
D60EA-2	01854	QITP60N-2	00854	1.000	25,4	1.500	40	7.000	178	3.000	76,2	4.000	101,6	3.943	100,2	1.736	44,1	4.568	116,0	2.361	90,0

No. 3 Extended Turning & Facing Holder





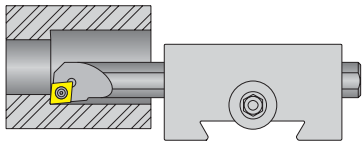
Tool Tips

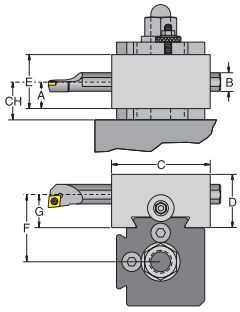
This holder is best used for holding ***extra long*** high speed or carbide square shank tools without sacrificing rigidity when turning, facing, and boring.

Tooling not included.

"D" Series Desc.	Part No.733101- R.H.	L.H.	"QITP" Series Desc.	Part No.733101- R.H.	L.H.	A in	A mm	B in	B mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-3-	01106	01108	QITP25N-3-	00106	00108	0.375	9,5	0.500	12	3.625	92	1.000	25,4	1.500	38,1	1.429	36,3	0.549	13,9
D30BXA-3-	01256	01258	QITP30N-3-	00256	00258	0.437	11,0	0.625	16	4.125	105	1.250	31,8	1.750	44,5	1.789	45,4	0.674	17,1
D35CXA-3-	01406	01408	QITP35N-3-	00406	00408	0.500	12,7	0.750	20	5.250	133	1.500	38,1	2.250	57,2	2.061	52,3	0.861	21,9
D40CA-3-	01556	01558	QITP40N-3-	00556	00558	0.562	14,3	1.000	25	6.000	152	1.750	44,5	2.500	63,5	2.516	63,9	0.986	25,0
D50DA-3-	01706	01708	QITP50N-3-	00706	00708	0.750	19,0	1.250	32	8.000	203	2.250	57,2	3.250	82,6	3.258	82,8	1.361	34,6
D60EA-3-	01856	01858	QITP60N-3-	00856	00858	1.000	25,4	1.500	40	10.00	254	3.000	76,2	4.000	101,6	3.943	100,2	1.736	44,1

Boring Bar Holders





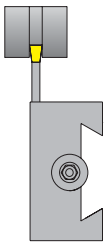
Tool Tips

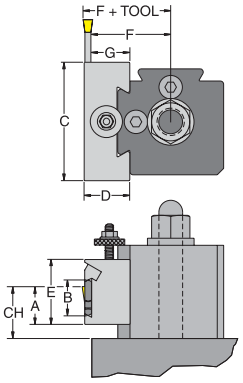
This holder is best used for holding inch ***boring bars.*** It has a precision ground bore with a 360° locking system giving it the best rigidity in metal removing without scarring the bar. It also has a double height adjustment, which makes the tool reversible for an extended center height range.

"D" Series Desc.	"D" Series Part No 733101-	"QITP" Series Desc.	"QITP" Series Part No 733101-	A	B	C	D	E	F	G	Bushing Desc.	Bushing Part No 733101-	O.D.	I.D.
No. 4		**Heavy Duty Boring Bar Holder (Inch)**												
D25AXA-4	01110	QITP25N-4	00110	0.625"	0.750"	2.750"	1.500"	1.500"	1.814"	0.934"	D25-4B	03705	0.750"	0.500"
D30BXA-4	01260	QITP30N-4	00260	0.750"	1.000"	3.250"	2.000"	2.000"	2.353"	1.238"	D30-4B	03707	1.000"	0.750"
D35CXA-4	01410	QITP35N-4	00410	1.000"	1.000"	3.750"	2.250"	2.250"	2.438"	1.238"	D35-4B	03709	1.000"	0.750"
D40CA-4	01560	QITP40N-4	00560	1.125"	1.250"	4.500"	2.500"	2.500"	3.018"	1.488"	D40-4B	03711	1.250"	1.000"
D50DA-4	01710	QITP50N-4	00710	1.500"	1.500"	6.000"	3.250"	3.250"	3.885"	1.988"	D50-4B	03713	1.500"	1.250"
D60EA-4	01860	QITP60N-4	00860	1.750"	2.000"	7.000"	4.250"	4.250"	4.695"	2.488"	D60-4B	03715	2.000"	1.500"
No. 4M		**Heavy Duty Boring Bar Holder (Metric)**												
D25AXA-4M	01112	QITP25N-4M	00112	16,0 mm	20 mm	70 mm	38,1 mm	38,1 mm	46,1 mm	23,7 mm	D25-4BM	03747	20 mm	12 mm
D30BXA-4M	01262	QITP30N-4M	00262	19,0 mm	25 mm	83 mm	50,8 mm	50,8 mm	59,8 mm	31,4 mm	D30-4BM	03749	25 mm	20 mm
D35CXA-4M	01412	QITP35N-4M	00412	25,4 mm	25 mm	95 mm	57,2 mm	57,2 mm	61,9 mm	31,4 mm	D35-4BM	03751	25 mm	20 mm
D40CA-4M	01562	QITP40N-4M	00562	28,5 mm	32 mm	114 mm	63,5 mm	63,5 mm	76,7 mm	37,8 mm	D40-4BM	03753	32 mm	25 mm
D50DA-M	01712	QITP50N-4M	00712	38,1 mm	40 mm	152 mm	82,6 mm	82,6 mm	98,7 mm	50,5 mm	D50-4BM	03755	40 mm	32 mm
D60EA-4M	01862	QITP60N-4M	00862	51,0 mm	50 mm	178 mm	108,0 mm	108,0 mm	119,3 mm	63,2 mm	D60-4BM	03757	50 mm	40 mm
No. 41		**Extra Heavy Duty Boring Bar Holder (Inch)**												
D25AXA-41	01114	QITP25N-41	00114	0.750"	1.000"	2.750"	1.750"	1.750"	1.930"	1.050"	D25-41B	03719	1.000"	0.750"
D30BXA-41	01264	QITP30N-41	00264	0.875"	1.250"	3.250"	2.500"	2.250"	2.478"	1.363"	D30-41B	03721	1.250"	1.000"
D35CXA-41	01414	QITP35N-41	00414	1.125"	1.250"	3.750"	2.500"	2.500"	2.563"	1.363"	D35-41B	03723	1.250"	1.000"
D40CA-41	01564	QITP40N-41	00564	1.500"	1.500"	4.500"	3.000"	3.000"	3.018"	1.488"	D40-41B	03725	1.500"	1.250"
D50DA-41	01714	QITP50N-41	00714	1.500"	2.000"	6.000"	3.500"	3.500"	3.885"	1.988"	D50-41B	03727	2.000"	1.500"
D60EA-41	01864	QITP60N-41	00864	2.000"	2.500"	7.000"	4.500"	4.500"	4.945"	2.738"	D60-41B	03729	2.500"	2.000"
No. 41M		**Extra Heavy Duty Boring Bar Holder (Metric)**												
D25AXA-41M	01116	QITP25N-41M	00116	19 mm	25 mm	70 mm	44,5 mm	44,5 mm	49,0 mm	26,7 mm	D25-41BM	03761	25 mm	20 mm
D30BXA-41M	01266	QITP30N-41M	00266	22 mm	32 mm	83 mm	63,5 mm	57,2 mm	62,9 mm	34,6 mm	D30-41BM	03763	32 mm	25 mm
D35CXA-41M	01416	QITP35N-41M	00416	28,5 mm	32 mm	95 mm	63,5 mm	63,5 mm	65,1 mm	34,6 mm	D35-41BM	03765	32 mm	25 mm
D40CA-41M	01566	QITP40N-41M	00566	38 mm	40 mm	114 mm	76,2 mm	76,2 mm	76,7 mm	37,8 mm	D40-41BM	03767	40 mm	32 mm
D50DA-41M	01716	QITP50N-41M	00716	38 mm	50 mm	152 mm	88,9 mm	88,9 mm	98,7 mm	50,5 mm	D50-41BM	03769	50 mm	40 mm
D60EA-41M	01866	QITP60N-41M	00866	51 mm	60 mm	178 mm	114,3 mm	114,3 mm	125,6 mm	69,5 mm	D60-41BM	03771	60 mm	50 mm
No. 41S		**Super Oversized Extra Heavy Duty Boring Bar Holder (Inch)**												
D25AXA-41-125	01118	QITP25N-41-125	00118	1.000"	1.250"	3.500"	2.500"	2.250"	2.368"	1.488"	D25-41SB	03733	1.250"	1.000"
D30BXA-41-150	01268	QITP30N-41-150	00268	1.250"	1.500"	4.000"	2.750"	2.750"	2.728"	1.613"	D30-41SB	03735	1.500"	1.250"
D35CXA-41-150	01418	QITP35N-41-150	00418	1.375"	1.500"	4.000"	3.000"	3.000"	2.938"	1.738"	D35-41SB	03737	1.500"	1.250"
D40CA-41-200	01568	QITP40N-41-200	00568	1.500"	2.000"	5.000"	3.500"	3.500"	3.518"	1.988"	D40-41SB	03739	2.000"	1.500"
D50DA-41-250	01718	QITP50N-41-250	00718	1.875"	2.500"	7.000"	4.500"	4.500"	4.635"	2.738"	D50-41SB	03741	2.500"	2.000"
D60EA-41-300	01868	QITP60N-41-300	00868	2.250"	3.000"	8.000"	5.000"	5.000"	5.195"	2.988"	D60-41SB	03743	3.000"	2.500"
No. 41SM		**Super Oversized Extra Heavy Duty Boring Bar Holder (Metric)**												
D25AXA-41M-32	01120	QITP25N-41M-32	00120	25,5 mm	32 mm	89 mm	63,5 mm	57,2 mm	60,1 mm	37,8 mm	D25-41SBM	03775	32 mm	25 mm
D30BXA-41M-40	01270	QITP30N-41M-40	00270	32 mm	40 mm	102 mm	69,9 mm	69,9 mm	69,3 mm	41,0 mm	D30-41SBM	03777	40 mm	32 mm
D35CXA-41M-40	01420	QITP35N-41M-40	00420	35 mm	40 mm	102 mm	76,2 mm	76,2 mm	74,6 mm	44,1 mm	D35-41SBM	03779	40 mm	32 mm
D40CA-41M-50	01570	QITP40N-41M-50	00570	38 mm	50 mm	127 mm	88,9 mm	88,9 mm	89,4 mm	50,5 mm	D40-41SBM	03781	50 mm	40 mm
D50DA-41M-60	01720	QITP50N-41M-60	00720	47,5 mm	60 mm	178 mm	114,3 mm	114,3 mm	117,7 mm	69,5 mm	D50-41SBM	03783	60 mm	50 mm
D60EA-41M-80	01870	QITP60N-41M-80	00870	57 mm	80 mm	203 mm	127,0 mm	127,0 mm	132,0 mm	75,9 mm	D60-41SBM	03785	80 mm	60 mm

Tooling not included.

Reversible Cut-Off Holders





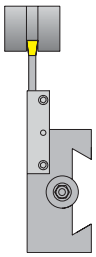
Tool Tips

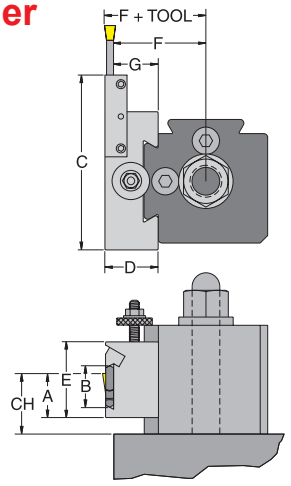
7-71C holder is best used for holding high speed and Slot Grip Cut-Off Blades. 71S holder is best used for holding ***larger*** high speed and Slot Grip Cut-Off Blades. Both holders have a taper lock system for maximum rigidity and performance in cutting and face grooving. They also have double center-height adjustments, which makes the tool reversible for downright positioning.

Tooling not included.

"D" Series Desc.	"D" Series Part No. 733101-	"QITP" Series Desc.	"QITP" Series Part No. 733101-	A in	A mm	B Slot Grip Blade	"T" Type Blade	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
No. 7-71C		**Reversible Cut-Off Blade Holder**															
D25AXA-7-71C	01126	QITP25N-7-71C	00126	0.875	22,2	19-2	P3	2.750	70	1.250	31,8	1.750	44,5	1.956	49,7	1.076	27,3
D30BXA-7-71C	01276	QITP30N-7-71C	00276	0.937	23,8			3.250	83	1.250	31,8	1.750	44,5	2.191	55,7	1.076	27,3
D35CXA-7-71C	01428	QITP35N-7-71C	00428	1.187	30,1	26-2 to 26-6	P5	3.750	95	1.500	38,1	2.250	57,2	2.466	62,6	1.266	32,2
D40CA-7-71C	01576	QITP40N-7-71C	00576	1.312	33,3			4.500	114	1.500	38,1	2.500	63,5	2.796	71,0	1.266	32,2
D50DA-7-71C	01726	QITP50N-7-71C	00726	1.594	40,5	32-3 to 32-9	P9	6.000	152	2.000	50,8	3.000	76,2	3.613	91,8	1.716	43,6
D60EA-7-71C	01876	QITP60N-7-71C	00876	1.719	43,7			7.000	178	2.250	57,2	3.250	82,6	4.173	106,0	1.966	49,9
No. 71S		**Extra Heavy Duty Reversible Cut-Off Blade Holder**															
D25AXA-71-26	01128	QITP25N-71-26	00128	1.125	28,6	26-2 to 26-6	P5	2.750	70	1.500	38,1	2.000	50,8	2.206	56,0	1.326	33,7
D30BXA-71-26	01278	QITP30N-71-26	00278	1.250	31,8			3.250	83	1.500	38,1	2.250	57,2	2.441	62,0	1.326	33,7
D35CXA-71-32	01430	QITP35N-71-32	00430	1.375	34,9	32-3 to 32-9	P9	3.750	95	1.750	44,5	2.500	63,5	2.716	69,0	1.516	38,5
D40CA-71-32	01578	QITP40N-71-32	00578	1.500	38,1			4.500	114	1.750	44,5	2.500	63,5	3.046	77,4	1.516	38,5

No. 771 Universal Cut-Off Holder



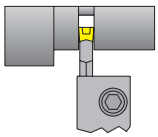


Tool Tips

This holder is best used for holding high speed and Slot Grip Cut-Off Blades. The most advanced design and complete cut-off toolholder offers maximum rigidity with ***extended reach***. Recommended to be used on the Quadra toolpost. A double dovetail locking system with vertical movement assures rigidity and adaptability for a variety of blade sizes.

Tooling not included.

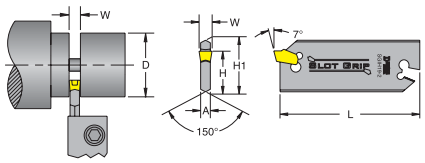
"D" Series Desc.	"D" Series Part No. 733101-	"QITP" Series Desc.	"QITP" Series Part No. 733101-	A in	A mm	B Slot Grip Blade	B - Blade Size in	B - Blade Size mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-771	01130	QITP25N-771	00130	0.937	23,8	19-2 to 26-6	.676x.094 to .874x.250	17x2,38 to 22x6,35	3.00	76,2	1.25	31,8	1.750	44,5	1.951	49,6	1.071	27,2
D30BXA-771	01280	QITP30N-771	00280	1.000	25,4				3.50	88,9	1.50	38,1	2.000	50,8	2.436	61,9	1.321	33,6
D35CXA-771	01432	QITP35N-771	00432	1.250	31,8	26-2 to 32-9	.874x.125 to 1.123x.313	22x3,18 to 29x7,94	4.50	114,3	1.50	38,1	2.500	63,5	2.466	62,6	1.266	32,2
D40CA-771	01580	QITP40N-771	00580	1.375	34,9				5.25	133,4	1.50	38,1	2.500	63,5	2.796	71,0	1.266	32,2
D50DA-771	01728	QITP50N-771	00728	1.625	41,3	32-3 to 32-9	1.123x.125 to 1.123x.313	29x3,18 to 29x7,94	6.50	165,1	2.00	50,8	3.000	76,2	3.623	92,0	1.726	43,8
D60EA-771	01878	QITP60N-771	00878	1.750	44,5				7.00	177,8	2.25	57,2	3.250	82,6	4.183	106,2	1.976	50,2



SGIH Slot Grip Cut-Off Blades

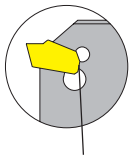
Slot Grip positive stop
for cut-off SGT (N/R/L) inserts

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.



Slot Grip Positive Stop Blade

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



Positive Stop

Description	Part 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						
SGIH26-4	62953	SGT(N/R/L)-4	.161	4	3.15	80,0	.125	3,18	4.33	110,0	.842	21,4	1.02	25,9
SGIH26-5	62954	SGT(N/R/L)-5	.201	5	3.15	80,0	.156	3,96						
SGIH26-6	62955	SGT(N/R/L)-6	.252	6	3.15	80,0	.203	5,16						
SGIH32-3	62956	SGT(N/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						
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	5.90	149,9	.984	25,0	1.25	31,8
SGIH32-8	62960	SGT(N/R/L)-8	.315	8	5.51	140,0	.268	6,81						
SGIH32-9	62961	SGT(N/R/L)-9	.378	9	5.51	140,0	.312	7,92						

Insert not included

SLOT GRIP

Cut-Off & Grooving Inserts

Chipbreaker Geometry

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

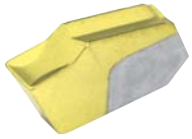
Application

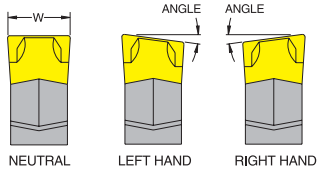
- Quickly inserted into adjustable blades
- For cut-off and grooving
- Fair for interrupted cuts

Cutting Data

Feed Per Revolution (In./Rev.) .006-.031

Surface Feet/Minute (Ft./Min.) 375-730



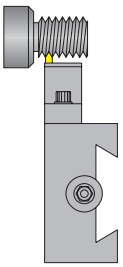


DK25 - Uncoated fine grain substrate grade insert for machining cast iron & stainless steel.
DP25 - Uncoated grade insert for carbon steel alloy and hardened steel.
DC656 - Titanium Nitride coated grade insert for alloy steel, stainless steel, and ductile iron. This grade has both high wear resistance and heat resistance increasing machining speeds up to 50%.

Insert Grade Cross Reference			
ANSI	C2	C5	C6
Dorian Grade	DK25	DP25	DC656

Desc.	Steel, Stainless Steel, & Cast Iron Low RPM<——>Interupted Cuts			Insert Size	Lead Angle	Width ± .004	
	DK25	DP25	DC656			Inches	Metric
SGTN-2	82220	82221	82222	2	0°	.087	2mm
SGTR-2-8	82248	82249	82250	2	8°	.087	2mm
SGTL-2-8	82276	82277	82278	2	8°	.087	2mm
SGTN-3	82224	82225	82226	3	0°	.122	3mm
SGTR-3-8	82252	82253	82254	3	8°	.122	3mm
SGTL-3-8	82280	82281	82282	3	8°	.122	3mm
SGTN-4	82228	82229	82230	4	0°	.161	4mm
SGTR-4-8	82256	82257	82258	4	8°	.161	4mm
SGTL-4-8	82284	82285	82286	4	8°	.161	4mm
SGTN-5	82232	82233	82234	5	0°	.201	5mm
SGTR-5-8	82260	82261	82262	5	8°	.201	5mm
SGTL-5-8	82288	82289	82290	5	8°	.201	5mm
SGTN-6	82236	82237	82238	6	0°	.252	6mm
SGTR-6-8	82264	82265	82266	6	8°	.252	6mm
SGTL-6-8	82292	82293	82294	6	8°	.252	6mm
SGTN-8	82240	82241	82242	8	0°	.315	8mm
SGTR-8-8	82268	82269	82270	8	8°	.315	8mm
SGTL-8-8	82296	82297	82298	8	8°	.315	8mm
SGTN-9	82244	82245	82246	9	0°	.378	9mm
SGTR-9-8	82272	82273	82274	9	8°	.378	9mm
SGTL-9-8	82300	82301	82302	9	8°	.378	9mm

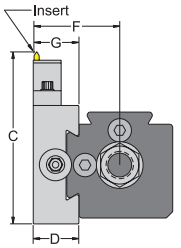
No. 881 O.D. or I.D. Threading Holder

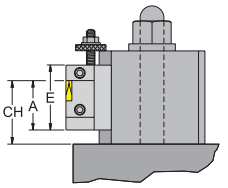


The TIH cartridge is the only cartridge supplied. Inserts not included. Threading bar is not supplied with the holder.

Tool Tips

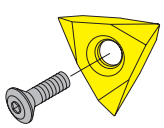
This holder is capable of covering all ***threading*** requirements. It uses standard carbide inserts. The holder is supplied with a cartridge for external threading with an On-Edge insert.

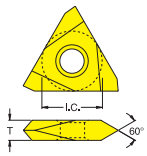




"D" Series Desc.	Part No. 733101-	"QITP" Series Desc.	Part No. 733101-	A in	A mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm	Cartridge Desc.	Part No. 733101-	TNMC Insert	Torx Screw	Torx Key
D25AXA-881	01132	QITP25N-881	00132	0.875	22,2	3.869	98	1.000	25,4	1.500	38,1	1.936	49,2	1.056	26,8	TIH253 -32	03621	32	GTS-1	T-10
D30BXA-881	01282	QITP30N-881	00282	1.000	25,4	4.369	111	1.250	31,8	1.750	44,5	2.421	61,5	1.306	33,2					
D35CXA-881	01434	QITP35N-881	00434	1.250	31,8	5.119	130	1.500	38,1	2.000	50,8	2.693	68,4	1.493	37,9	TIH354 -32	03623	32	GTS-1	T-10
D40CA-881	01582	QITP40N-881	00582	1.500	38,1	5.619	143	1.500	38,1	2.250	57,2	3.023	76,8	1.493	37,9					

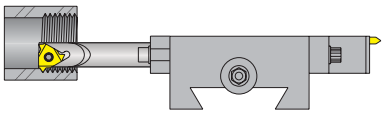
On Edge Threading Insert
TNMC - NV "V" Thread





Description	Steel First Choice DVP656	Stainless Steel, Cast Iron, & Aluminum First Choice DVK10	I.C. in	I.C. mm	Thick in	Thick mm	Hole Dia. in	Hole Dia. mm	Depth in	Depth mm
TNMC-32NV	72003	72004	.375	9,5	.1250	3,18	.150	3,81	.150	3,81
TNMC-43NV	72010	72011	.500	12,7	.1875	4,76	.203	5,16	.230	5,84
TNMC-54NV	72031	72032	.625	15,9	.2500	6,35	.250	6,35	.292	7,42

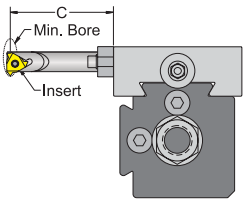
No. 881 Internal Laydown Threading Insert Bar

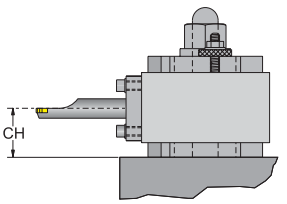


Right hand shown, left hand opposite. When ordering threading bar, specify right or left. Inserts not included.

Tool Tips

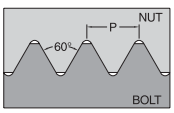
This cartridge is to be used on the #881 holder. It is used for internal threading with a ***laydown insert***. It can be mounted on either end of the base holder.

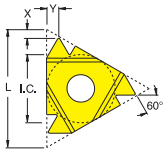




Series Number	Righ Hand Desc.	Righ Hand Part No. 733101-	Righ Hand Insert	Left Hand Desc.	Left Hand Part No. 733101-	Left Hand Insert	Min. Bore in	Min. Bore mm	C in	C mm	Pitch TPI	Pitch Metric	Insert I.C.	Torx Screw	Torx Key
25, 30, 35, & 40	NL50R	03661	11IR-A60	NL50L	03669	11IL-A60	0.500	12,7	2.375	60,3	16-48	0,5-1,5	.250	TS-25.45-6M1	T-8
25, 30, 35, & 40	NL75R	03663	16IR-AG60	NL75L	03671	16IL-AG60	0.750	19,1	2.875	73,0	8-48	0,5-3,0	.375	TS-16	T-10
35 & 40	NL125R	03665	22IR-N60	NL125L	03673	22IL-N60	1.250	31,8	3.375	85,7	5-7	3,5-5,0	.500	TS-22	T-20

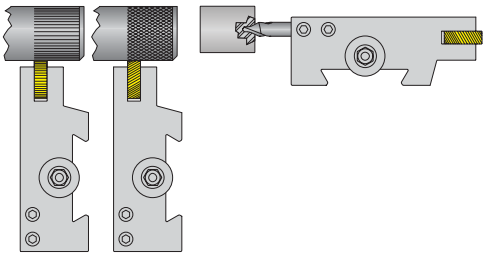
Laydown Threading Insert
60° Partial Profile

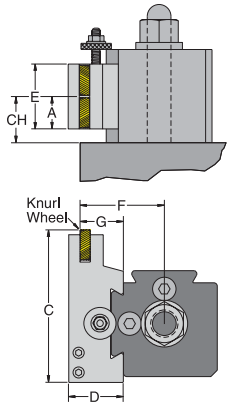




Internal Right Hand	Steel DVP656	Stainless Steel, Cast Iron, & Aluminum DVK10	Internal Left Hand	Steel DVP656	Stainless Steel, Cast Iron, & Aluminum DVK10	L mm	I.C. in	Pitch TPI	Pitch Metric	X mm	Y mm
11IR-A60	74056	74057	11IL-A60	74060	74061	11	.250	16-48	0,5-1,5	0,8	0,9
16IR-A60	74064	74065	16IL-A60	74068	74069	16	.375	16-48	0,5-1,5	0,8	0,9
16IR-G60	74072	74073	16IL-G60	74076	74077	16	.375	8-14	1,75-3,0	1,2	1,7
16IR-AG60	74080	74081	16IL-AG60	74084	74085	16	.375	8-48	0,5-3,0	1,2	1,7
22IR-N60	74088	74089	22IL-N60	74092	74093	22	.500	5-7	3,5-5,0	1,7	2,5

No. 10 Knurling and Facing Holder





Tool Tips

This holder is best used for ***knurling*** diamond or straight patterns. The knurl wheels are mounted between thrust washers to ensure smooth and even rotation of the knurl wheels while knurling is performed. This tool can also be used to hold small facing tools and center drills.

"D" Series		"QITP" Series		A		C		D		E		F		G		Knurl Wheel			Knurl Pin	
Desc.	Part No. 733101-	Desc.	Part No. 733101-	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	Series	Size in	Size mm	Desc.	Part No. 733101-
D25AXA-10	01134	QITP25N-10	00134	0.750	19,1	3.125	79,4	1.000	25,4	1.500	38,1	1.693	43,0	0.813	20,7	S	3/4	19,1	A60464	28620
D30BXA-10	01284	QITP30N-10	00284	0.875	22,2	3.875	98,4	1.250	31,8	1.750	44,5	2.178	55,3	1.063	27,0		1/4	6,35		
D35CXA-10	01436	QITP35N-10	00436	1.125	28,6	4.625	117,5	1.500	38,1	2.250	57,2	2.500	63,5	1.300	33,0		1/4	6,35		
D40CA-10	01584	QITP40N-10	00584	1.125	28,6	5.125	130,2	1.500	38,1	2.250	57,2	2.830	71,9	1.300	33,0	A	3/4	19,1	A60465	28625
																	3/8	9,52		
																	1/4	6,35		

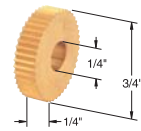
Supplied with one set of 25 TPI diagonal knurl wheels for a diamond pattern.

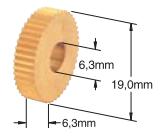
Other tooling not included

Knurling Wheels

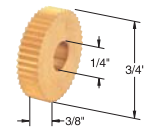
Teeth Per Inch (TPI)	Metric Pitch	Included Tooth Angle	"S" Series - Circular Pitch			"A" Series - Circular Pitch		
			Straight	Diagonal Right	Diagonal Left	Straight	Diagonal Right	Diagonal Left
			High Speed Bevel			High Speed Bevel		
16	1,6mm	90°	SS-16-HS 73310126839	SDR-16-HS 73310126961	SDL-16-HS 73310127085	AS-16-HS 73310123541	ADR-16-HS 73310123673	ADL-16-HS 73310123805
20	1,2mm	90°	SS-20-HS 73310126841	SDR-20-HS 73310126963	SDL-20-HS 73310127087	AS-20-HS 73310123543	ADR-20-HS 73310123675	ADL-20-HS 73310123807
25	1,0mm	90°	SS-25-HS 73310126843	SDR-25-HS 73310126965	SDL-25-HS 73310127089	AS-25-HS 73310123545	ADR-25-HS 73310123677	ADL-25-HS 73310123809
30	0,8mm	90°	SS-30-HS 73310126845	SDR-30-HS 73310126967	SDL-30-HS 73310127091	AS-30-HS 73310123547	ADR-30-HS 73310123679	ADL-30-HS 73310123811

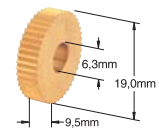
"S" Series





"A" Series



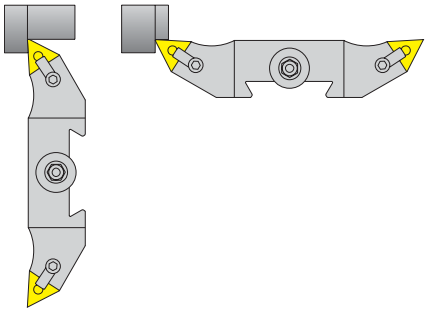


Please inquire about our whole selection of knurling wheels and tools for all of your applications.
Please call us for more information or to request a knurling catalog.

Common Knurling Problems

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

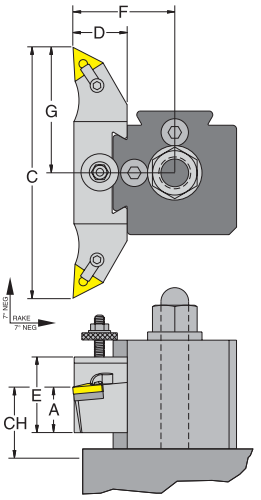
No. 12C 60° Negative Triangle Insert Tool Holder



TNMG Insert

Tool Tips

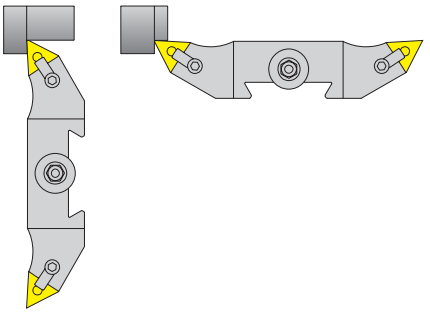
This holder is best used for ***turning*** to a square shoulder or ***facing***. It uses a versatile negative 60° triangle insert with a 3° lead.



"D" Series Desc.	Part No. 733101-	A in	A mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm	TNMG Gage Insert	Seat	Lock Pin	Clamp	Clamp Screw
D25AXA-12C	01154	0.875	22,2	4.750	120,7	1.000	25,4	1.500	38,1	1.880	47,8	2.375	60,3	322	ITSN -322	NL-34	CL-6	XNS-36
D30BXA-12C	01302	1.000	25,4	5.500	139,7	1.250	31,8	1.750	44,5	2.365	60,1	2.750	69,9					
D35CXA-12C	01456	1.250	31,8	6.500	165,1	1.500	38,1	2.000	50,8	2.700	68,6	3.250	82,6					
D40CA-12C	01604	1.500	38,1	7.000	177,8	1.500	38,1	2.250	57,2	3.030	77,0	3.500	88,9	432	ITSN -433	NL-46	CL-9	XNS-59

Inserts not included.

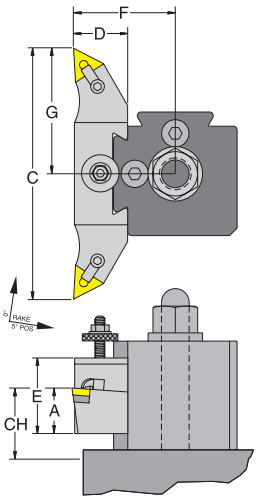
No. 16C 60° Positive Triangle Insert Tool Holder



TPG Insert

Tool Tips

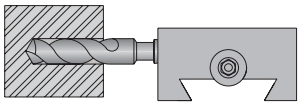
This holder is best used for turning to a square shoulder or facing. It uses a positive 60° triangle insert with a 3° lead. It is rugged for ***roughing*** but also precise for ***finishing***. The chip flow is controlled by the triangle insert and the chip breaker.

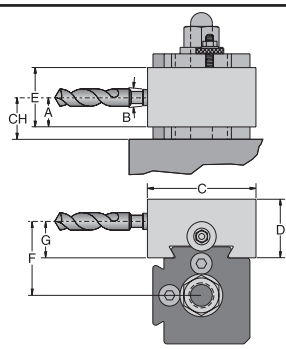


"D" Series Desc.	Part No. 733101-	A in	A mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm	TPG Gage Insert	Seat	Seat Screw	Clamp	Clamp Screw	Optional Chip Breaker
D25AXA-16C	01156	0.875	22,2	4.750	120,7	1.000	25,4	1.500	38,1	1.880	47,8	2.375	60,3						
D30BXA-16C	01304	1.000	25,4	5.500	139,7	1.250	31,8	1.750	44,5	2.365	60,1	2.750	69,9	322	SM-41	S-4	CL-7	XNS-36	T3AE
D35CXA-16C	01458	1.250	31,8	6.500	165,1	1.500	38,1	2.000	50,8	2.700	68,6	3.250	82,6						
D40CA-16C	01606	1.500	38,1	7.000	177,8	1.500	38,1	2.250	57,2	3.030	77,0	3.500	88,9	432	SM-37	S-6	CL-12	XNS-59	T4AE

Inserts not included.

No. 5 Morse Taper Holder





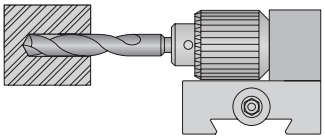
Tooling not included.

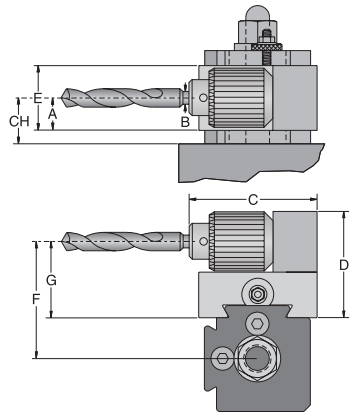
Tool Tips

This holder is best used for holding ***morse taper*** tooling. It can be used for drilling, boring, or reaming operations.

"D" Series Desc.	"D" Series Part No. 733101-	"QITP" Series Desc.	"QITP" Series Part No. 733101-	A in	A mm	B Morse Taper	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-5-2	01122	QITP25N-5-2	00122	0.750	19,1	2	2.750	70	1.500	38,1	1.500	38,1	1.810	46,0	0.930	23,6
D30BXA-5-3	01272	QITP30N-5-3	00272	1.000	25,4	3	3.125	80	2.000	50,8	2.000	50,8	2.365	60,1	1.250	31,8
D35CXA-5-4	01424	QITP35N-5-4	00424	1.125	28,6	4	3.750	95	2.500	63,5	2.250	57,2	2.815	71,5	1.615	41,0
D40CA-5-4	01572	QITP40N-5-4	00572	1.250	31,8	4	4.500	114	2.500	63,5	2.500	63,5	3.145	79,9	1.615	41,0
D50DA-5-5	01722	QITP50N-5-5	00722	1.750	44,5	5	5.000	127	3.500	88,9	3.500	88,9	4.137	105,1	2.240	56,9
D60EA-5-5	01872	QITP60N-5-5	00872	1.750	44,5	5	6.000	152	3.500	88,9	3.500	88,9	4.447	113,0	2.240	56,9

No. 35 Dovetail Drill Chuck Holder





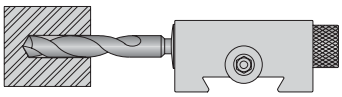
Tooling not included.

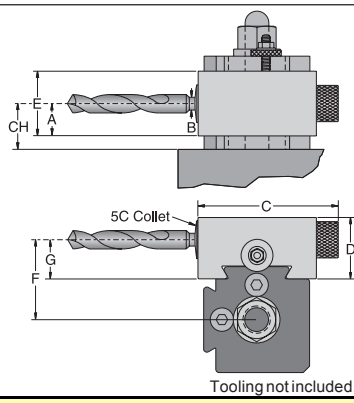
Tool Tips

This holder is best used for holding drills, reamers, taps, etc., without tailstock mounting. It uses a ***drill chuck*** mounted directly to a quick change holder.

"D" Series Desc.	"D" Series Part No. 733101-	"QITP" Series Desc.	"QITP" Series Part No. 733101-	A in	A mm	B-Capacity in	B-Capacity mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-35	01140	QITP25N-35	00140	1.000	25,4	0-.50	0-13	4.175	106,0	3.101	78,8	2.000	50,8	2.943	74,8	2.063	52,4
D30BXA-35	01290	QITP30N-35	00290	1.000	25,4	0-.50	0-13	4.175	106,0	3.101	78,8	2.000	50,8	3.178	80,7	2.063	52,4
D35CXA-35	01442	QITP35N-35	00442	1.125	28,6	0-.50	0-13	4.673	118,7	3.726	94,6	2.250	57,2	3.825	97,2	2.625	66,7
D40CA-35	01590	QITP40N-35	00590	1.125	28,6	0-.50	0-13	4.673	118,7	3.726	94,6	2.250	57,2	4.016	102,0	2.625	66,7

No. 36 5C Collet Holder





Tooling not included.

Tool Tips

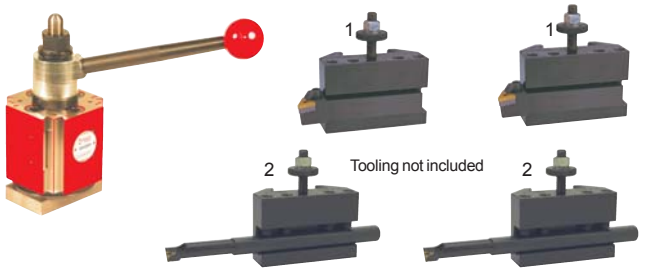
This holder's wide range of ***collet adaptability*** makes this tool ideal for holding drills, taps, chucks, & boring bars. These tools can be held with extreme rigidity without scarring them.

"D" Series Desc.	"D" Series Part No. 733101-	"QITP" Series Desc.	"QITP" Series Part No. 733101-	A in	A mm	C in	C mm	D in	D mm	E in	E mm	F in	F mm	G in	G mm
D25AXA-36	01142	QITP25N-36	00142	1.125	28,6	4.250	108,0	2.500	63,5	2.250	57,2	2.380	60,5	1.500	38,1
D30BXA-36	01292	QITP30N-36	00292	1.125	28,6	4.250	108,0	2.500	63,5	2.250	57,2	2.615	66,4	1.500	38,1
D35CXA-36	01444	QITP35N-36	00444	1.375	34,9	4.500	114,3	2.750	69,9	2.750	69,9	2.825	71,8	1.625	41,3
D40CA-36	01592	QITP40N-36	00592	1.375	34,9	4.500	114,3	2.750	69,9	2.750	69,9	3.155	80,1	1.625	41,3

Dorian Tool Post & Holder Sets

Making it easier to tool up your machines

QUADRA® TURNING Set



1 Toolpost
4 Holders

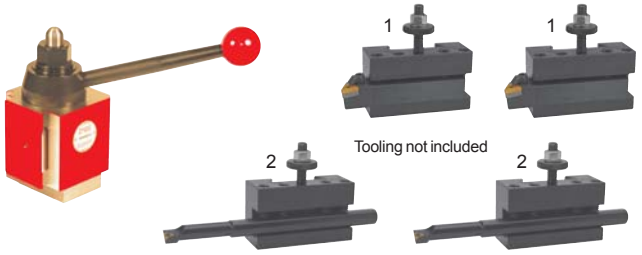
Increase Production Up To 500%

The Multi-Patented Toolpost with the most advanced locking and indexing technology

- Positive Lock with Absolute Zero backlash
- 4 quick change tool holders locked simultaneously, ready to be used
- Instant tool repositioning for high efficiency production runs
- Indexing repeatability of .00005”
- 24 positions, every 15°

Part No. 733101-	00014	00015	00016	00017	00018	00019
Toolpost Style	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
Lathe Swing	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Max. Tool Cap.	0.500	0.625	0.750	1.000	1.250	1.500
Opt. C.H.	1.422	1.747	1.835	2.202	2.995	3.440
(5) Five Piece Set Includes:						
(1) Tool Post	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
(2) No. 1 Holder	QITP25N-1	QITP30N-1	QITP35N-1	QITP40N-1	QITP50N-1	QITP60N-1
(2) No. 2 Holder	QITP25N-2	QITP30N-2	QITP35N-2	QITP40N-2	QITP50N-2	QITP60N-2

SUPER TURNING Set



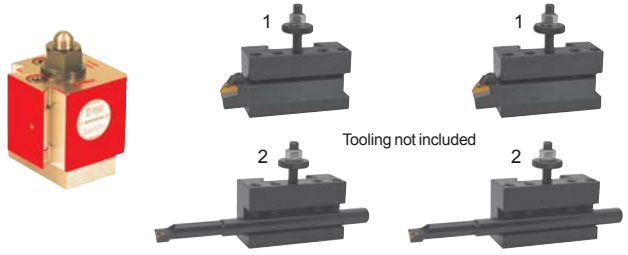
1 Toolpost
4 Holders

The First Tool is the Tool That You Will Have For A Lifetime!

- Maintenance-Free
- Positive Locking with Absolute zero backlash
- 20,000 p.s.i. holder locking pressure
- Repetitive accuracy of .0001”
- Interchangeable with industry standard tool posts and tool holders
- Heat treated and precision ground alloy steel body

Part No. 733101-	01014	01015	01016	01017	01018	01019
Toolpost Style	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
Lathe Swing	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Max. Tool Cap.	0.500	0.625	0.750	1.000	1.250	1.500
Opt. C.H.	1.257	1.569	1.757	2.194	2.695	3.007
(5) Five Piece Set Includes:						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
(2) No. 1 Holder	D25AXA-1	D30BXA-1	D35CXA-1	D40CA-1	D50DA-1	D60EA-1
(2) No. 2 Holder	D25AXA-2	D30BXA-2	D35CXA-2	D40CA-2	D50DA-2	D60EA-2

ECONOMY TURNING Set



1 Toolpost
4 Holders

Built to operate simply & quickly with precise repeatablity

- Maintenance-Free
- Positive Lock with Absolute zero backlash
- Repetitive accuracy of .0001”
- Interchangeable with all industry standard tool posts and tool holders
- Heat treated and precision ground alloy steel body

Part No. 733101-	02014	02015	02016	02017	02018	02019
Toolpost Style	DN25AXA	DN30BXA	DN35CXA	DN40CA	DN50DA	DN60EA
Lathe Swing	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Max. Tool Cap.	0.500	0.625	0.750	1.000	1.250	1.500
Opt. C.H.	1.132	1.444	1.632	2.069	2.632	3.007
(5) Five Piece Set Includes:						
(1) Tool Post	DN25AXA	DN30BXA	DN35CXA	DN40CA	DN50DA	DN60EA
(2) #1 Holder	D25AXA-1	D30BXA-1	D35CXA-1	D40CA-1	D50DA-1	D60EA-1
(2) #2 Holder	D25AXA-2	D30BXA-2	D35CXA-2	D40CA-2	D50DA-2	D60EA-2

MINI TURNING Set

1 Toolpost
4 Holders

Combine Productivity with Artistic Ability

Ideal for:

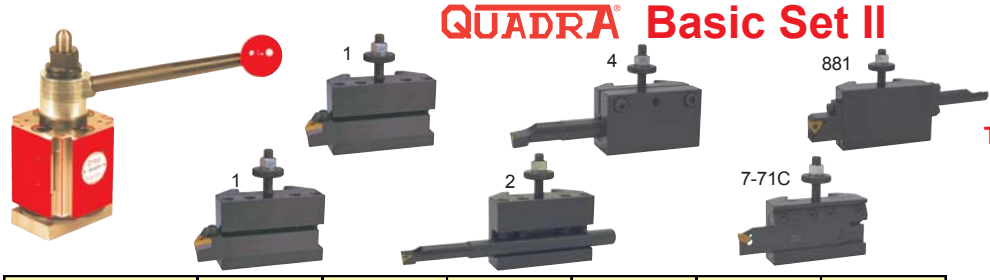
- Modelmakers
- Instrument Makers
- Opticians
- Jewelers
- Watchmakers
- Do-it-yourselfers

Part No. 733101-	02340	02342	02344
Toolpost Style	MDN10	MDN15	MDN20
Lathe Swing	Up-5"	5-10"	8-12"
Max. Tool Cap.	0.187	0.312	0.500
Opt. C.H.	0.467	0.598	1.005
(5) Five Piece Set Includes:			
(1) Tool Post	MDN10	MDN15	MDN20
(2) #1 Holder	MD10-1	MD15-1	MD20-1
(2) #2 Holder	MD10-2	MD15-2	MD20-2

Dorian Tool Post & Holder Sets

Making it easier to tool up your machines

QUADRA® Basic Set II



Part No. 733101-	00026	00027	00028	00029	00030	00031
Toolpost Style	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
Lathe Swing Over Bed	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Maximum Tool Capacity	0.500	0.625	0.750	1.000	1.250	1.500
Optimum Center Height	1.422	1.757	1.835	2.202	2.995	3.440
(7) Seven Piece Set Includes *:						
(1) Tool Post	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
(2) #1 Holder	QITP25N-1	QITP30N-1	QITP35N-1	QITP40N-1	QITP50N-1	QITP60N-1
(1) #2 Holder	QITP25N-2	QITP30N-2	QITP35N-2	QITP40N-2	QITP50N-2	QITP60N-2
(1) #4 Holder	QITP25N-4	QITP30N-4	QITP35N-4	QITP40N-4	QITP50N-4	QITP60N-4
(1) #7-71C Holder	QITP25N-7-71C	QITP30N-7-71C	QITP35N-7-71C	QITP40N-7-71C	QITP50N-7-71C	QITP60N-7-71C
(1) #881 Holder	QITP25N-881	QITP30N-881	QITP35N-881	QITP40N-881	*	*

* (6) Six piece set, The 50 and 60 series sets do not include the # 881 holder. Tooling not included

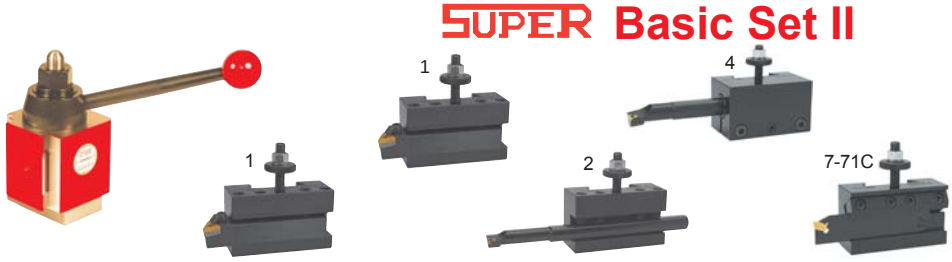
The Multi-Patented Toolpost with the most advanced locking and indexing technology

1 Toolpost
6 Holders

INCREASE PRODUCTION UP TO 500%

- Positive Lock with Absolute Zero backlash
- 4 quick change tool holders locked simultaneously, ready to be used
- Instant tool repositioning for high efficiency production runs
- Indexing repeatability of .00005"
- 24 positions, every 15°

SUPER Basic Set II



Part No. 733101-	01029	01031	01033	01035	01037	01039
Toolpost Style	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
Lathe Swing Over Bed	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Maximum Tool Capacity	0.500	0.625	0.750	1.000	1.250	1.500
Optimum Center Height	1.257	1.569	1.757	2.194	2.695	3.007
(7) Seven Piece Set Includes *:						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
(2) #1 Holder	D25AXA-1	D30BXA-1	D35CXA-1	D40CA-1	D50DA-1	D60EA-1
(1) #2 Holder	D25AXA-2	D30BXA-2	D35CXA-2	D40CAN-2	D50DA-2	D60EA-2
(1) #4 Holder	D25AXA-4	D30BXA-4	D35CXA-4	D40CA-4	D50DA-4	D60EA-4
(1) #7-71C Holder	D25AXA-7-71C	D30BXA-7-71C	D35CXA-7-71C	D40CA-7-71C	D50DA-7-71C	D60EA-7-71C
(1) #881 Holder	D25AXA-881	D30BXA-881	D35CXA-881	D40CA-881	*	*

* (6) Six piece set, The 50 and 60 series sets do not include the # 881 holder. Tooling not included

The First Tool is the Tool That You Will Have For A Lifetime!

1 Toolpost
6 Holders

- Maintenance-Free
- Positive Locking with Absolute zero backlash
- 20,000 p.s.i. holder locking pressure
- Repetitive accuracy of .0001"
- Interchangeable with industry standard tool posts and tool holders
- Heat treated and precision ground alloy steel body

ECONOMY Basic Set II

Part No. 733101-	02029	02031	02033	02035	02037	02039
Toolpost Style	DN25AXA	DN30BXA	DN35CXA	DN40CA	DN50DA	DN60EA
Lathe Swing Over Bed	Up-12"	13-15"	14-17"	16-20"	17-32"	25"-XHD
Maximum Tool Capacity	0.500	0.625	0.750	1.000	1.250	1.500
Optimum Center Height	1.132	1.444	1.632	2.069	2.632	3.007
(7) Seven Piece Set Includes *:						
(1) Tool Post	D25AXA	D30BXA	D35CXA	D40CA	D50DA	D60EA
(2) #1 Holder	D25AXA-1	D30BXA-1	D35CXA-1	D40CA-1	D50DA-1	D60EA-1
(1) #2 Holder	D25AXA-2	D30BXA-2	D35CXA-2	D40CA-2	D50DA-2	D60EA-2
(1) #4 Holder	D25AXA-4	D30BXA-4	D35CXA-4	D40CA-4	D50DA-4	D60EA-4
(1) #7-71C Holder	D25AXA-7-71C	D30BXA-7-71C	D35CXA-7-71C	D40CA-7-71C	D50DA-7-71C	D60EA-7-71C
(1) #881 Holder	D25AXA-881	D30BXA-881	D35CXA-881	D40CA-881	*	*

* (6) Six piece set, The 50 and 60 series sets do not include the # 881 holder. Tooling not included

Built to operate simply and quickly with precise repeatablity

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6 Holder

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- Positive Lock with Absolute zero backlash
- Repetitive accuracy of .0001"
- Interchangeable with all industry standard tool posts and tool holders
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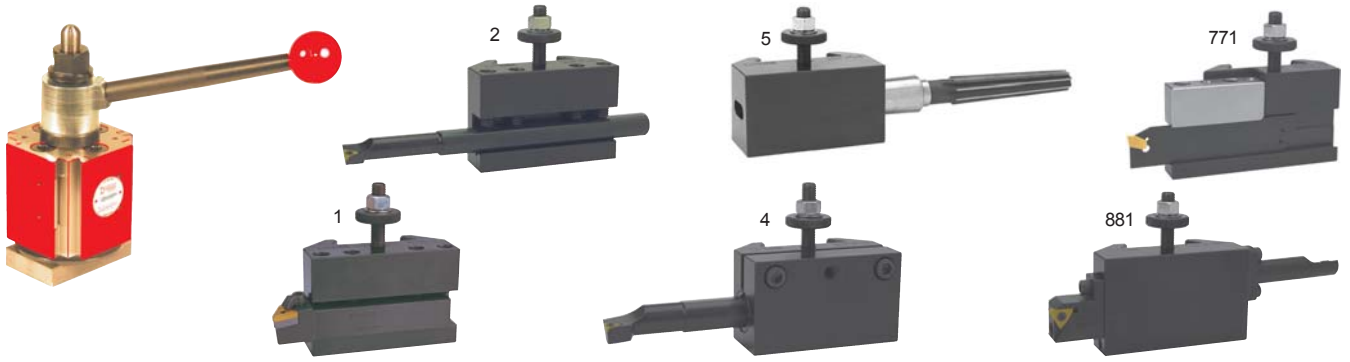
Dorian Tool Post & Holder Sets

Making it easier to tool up your machines

QUADRA CNC Set

INCREASE PRODUCTION UP TO 500%



1 Toolpost
6 Holders

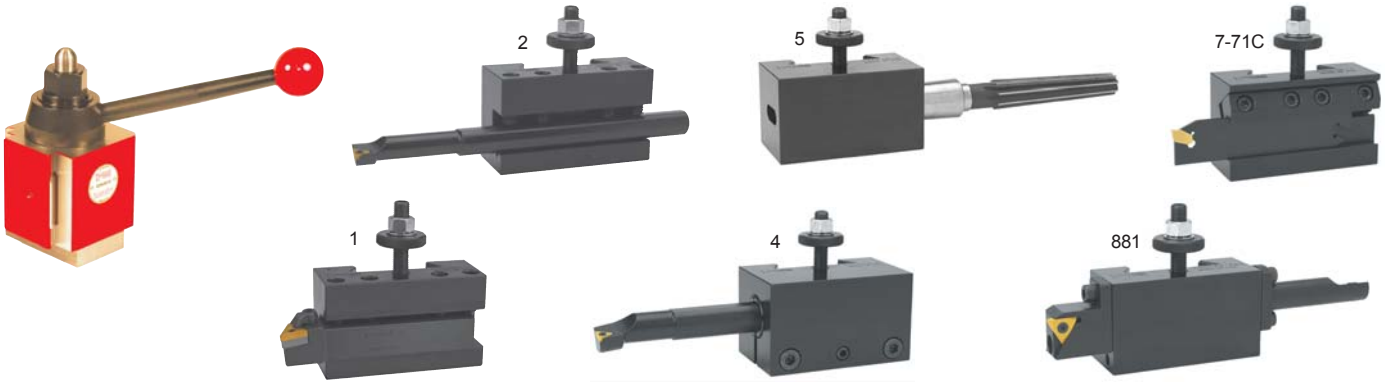
The Multi-Patented toolpost with the most advanced locking and indexing technology

- Positive Lock with Absolute Zero backlash
- 4 quick change tool holders locked simultaneously, ready to be used
- Instant tool repositioning for high efficiency production runs
- Indexing repeatability of .00005”
- 24 positions, every 15°

Part No. 733101-	00042	00044	00046	00048	00050	00052
Toolpost Style	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
Lathe Swing Over Bed	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Maximum Tool Capacity	0.500	0.625	0.750	1.000	1.250	1.500
Optimum Center Height	1.422	1.747	1.835	2.202	2.995	3.440
(9) Nine Piece Set Includes *:						
(1) Tool Post	QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
(2) #1 Holder	QITP25N-1	QITP30N-1	QITP35N-1	QITP40N-1	QITP50N-1	QITP60N-1
(2) #2 Holder	QITP25N-2	QITP30N-2	QITP35N-2	QITP40N-2	QITP50N-2	QITP60N-2
(1) #4 Holder	QITP25N-4	QITP30N-4	QITP35N-4	QITP40N-4	QITP50N-4	QITP60N-4
(1) #5 Holder	QITP25N-5	QITP30N-5	QITP35N-5	QITP40N-5	QITP50N-5	QITP60N-5
(1) #7-71C Holder	QITP25N-7-71C	QITP30N-7-71C	QITP35N-7-71C	QITP40N-7-71C	QITP50N-7-71C	QITP60N-7-71C
(1) #881 Holder	QITP25N-881	QITP30N-881	QITP35N-881	QITP40N-881	*	*

* (6) Six piece set, The 50 and 60 series sets do not include the # 881 holder. Tooling not included

SUPER CNC Set



1 Toolpost
6 Holders

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- Positive Locking with Absolute zero backlash
- 20,000 p.s.i. holder locking pressure
- Repetitive accuracy of .0001”
- Interchangeable with industry standard tool posts and tool holders
- Heat treated and precision ground alloy steel body

Part No. 733101-	01042	01044	01046	01048	01050	01052
Toolpost Style	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
Lathe Swing Over Bed	Up-12"	13-15"	14-17"	16-20"	17-32"	25-XHD
Maximum Tool Capacity	0.500	0.625	0.750	1.000	1.250	1.500
Optimum Center Height	1.257	1.569	1.757	2.194	2.695	3.007
(7) Seven Piece Set Includes *:						
(1) Tool Post	SDN25AXA	SDN30BXA	SDN35CXA	SDN40CA	SDN50DA	SDN60EA
(2) #1 Holder	D25AXA-1	D30BXA-1	D35CXA-1	D40CA-1	D50DA-1	D60EA-1
(2) #2 Holder	D25AXA-2	D30BXA-2	D35CXA-2	D40CA-2	D50DA-2	D60EA-2
(1) #4 Holder	D25AXA-4	D30BXA-4	D35CXA-4	D40CA-4	D50DA-4	D60EA-4
(1) #5 Holder	D25AXA-5	D30BXA-5	D35CXA-5	D40CA-5	D50DA-5	D60EA-5
(1) #7-71C Holder	D25AXA-7-71C	D30BXA-7-71C	D35CXA-7-71C	D40CA-7-71C	D50DA-7-71C	D60EA-7-71C
(1) #881 Holder	D25AXA-881	D30BXA-881	D35CXA-881	D40CA-881	*	*

* (6) Six piece set. The 50 and 60 series sets do not include the # 881 holder. Tooling not included

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"The Universal Tool Post"

INCREASE PRODUCTION UP TO 500%

When you buy the five piece Quadra Index Tool Post Set Dorian Tool will tool it up **FREE**

1 Toolpost
4 Holders
4 Toolholders
5 Inserts

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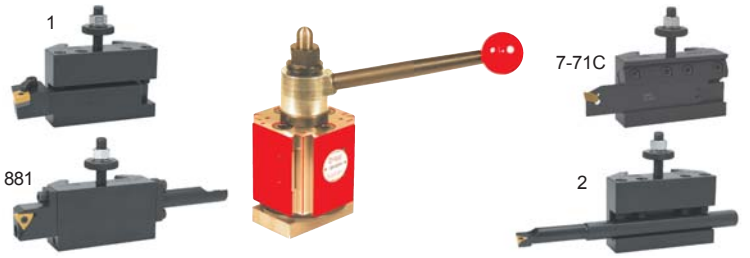
- 4 quick change tool holders locked simultaneously, ready to be used
- Instant tool repositioning for high efficiency production runs
- Indexing repeatability of .00005"
- 24 positions, every 15°

QUADRA® FIRST TIME BUYER Set



Description	Part No. 733101-	Lathe Swing	Set Includes (1) Tool Post	Set Includes (4) Holders	Free Tooling (4) Toolholders	Free Tooling (5) Inserts
QITP25N-FTB	00056	Up to 12"	QITP25N	QITP25N-1 QITP25N-2 QITP25N-7-71C QITP25N-881	STNCR08-2J STCMB06-2 SGIH19-2 NL50R	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DVP656 TNMC-32NV-DVP656 11IR-A60-DVP656
QITP30N-FTB	00058	13"-15"	QITP30N	QITP30N-1 QITP30N-2 QITP30N-7-71C QITP30N-881	STNCR10-2A STCMB08-2 SGIH19-2 NL50R	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DVP656 TNMC-32NV-DVP656 11IR-A60-DVP656
QITP35N-FTB	00060	14"-17"	QITP35N	QITP35N-1 QITP35N-2 QITP35N-7-71C QITP35N-881	STNCR12-3B STCMB10-2 SGIH26-3 NL75R	TCMT-32.51-UM-DVP656 TCMT-21.52-UM-DVP656 SGTN-3-DVP656 TNMC-32NV-DVP656 16IR-A60-DVP656
QITP40N-FTB	00062	16"-20"	QITP40N	QITP40N-1 QITP40N-2 QITP40N-7-71C QITP40N-881	STNCR64-3D STCMB12-3 SGIH26-3 NL75R	TCMT-32.51-UM-DVP656 TCMT-32.52-UM-DHCP25 SGTN-3-DVP656 TNMC-32NV-DVP656 16IR-A60-DVP656

SUPER FIRST TIME BUYER Set

When you buy the five piece Super Quick Change Tool Post Set Dorian Tool will tool it up **FREE**

1 Toolpost
4 Holders
4 Toolholders
5 Inserts

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- Maintenance-Free
- Positive Locking with Absolute zero backlash
- 20,000 p.s.i. holder locking pressure
- Repetitive accuracy of .0001"
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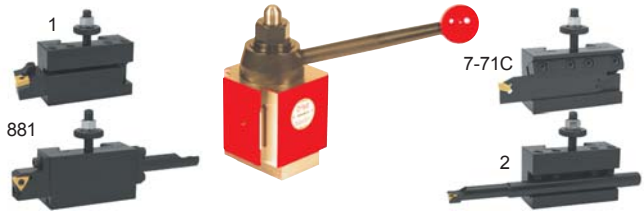
- Heat treated and precision ground alloy steel body



Description	Part No. 733101-	Lathe Swing	Set Includes (1) Tool Post	Set Includes (4) Holders	Free Tooling (4) Toolholders	Free Tooling (5) Inserts
SDN25AXA-FTB	01056	Up to 12"	SDN25AXA	D25AXA-1 D25AXA-2 D25AXA-7-71C D25AXA-881	STNCR08-2J STCMB06-2 SGIH19-2 NL50R	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DVP656 TNMC-32NV-DVP656 11IR-A60-DVP656
SDN30BXA-FTB	01058	13"-15"	SDN30BXA	D30BXA-1 D30BXA-2 D30BXA-7-71C D30BXA-881	STNCR10-2A STCMB08-2 SGIH19-2 NL50R	TCMT-21.51-UM-DHCP25 TCMT-21.52-UM-DHCP25 SGTN-2-DVP656 TNMC-32NV-DVP656 11IR-A60-DVP656
SDN35CXA-FTB	01060	14"-17"	SDN35CXA	D35CXA-1 D35CXA-2 D35CXA-7-71C D35CXA-881	STNCR12-3B STCMB10-2 SGIH26-3 NL75R	TCMT-21.51-UM-DHCP25 TCMT-32.52-UM-DHCP25 SGTN-3-DVP656 TNMC-32NV-DVP656 16IR-A60-DVP656
SDN40CA-FTB	01062	16"-20"	SDN40CA	D40CA-1 D40CA-2 D40CA-7-71C D40CA-881	STNCR64-3D STCMB12-3 SGIH26-3 NL75R	TCMT-32.51-UM-DHCP25 TCMT-32.52-UM-DHCP25 SGTN-3-DVP656 TNMC-32NV-DVP656 16IR-A60-DVP656

APKT Inserts

The New Generation

New Grades

New Geometry

Unchallenged Performance!!

APKX-1.2 Forte™

.063 Radius, Serrated Chip Breaker to Maximize Chip Control and Tough Cutting Edge; Designed to be the Best Insert for Roughing Milling Application

APKT-1.2 Bravo™

0.063 Radius, Strong and Tough Cutting Edge
Designed to be the Best Insert
for All Around Milling Application

APKT Rapido™

.031 Radius, Strong Cutting Edge
Designed to be the Best Insert
for High Speed Finishing Application

Ferrous Grade

Insert Description		Applications			Part No.
Description	Radius	Finishing	General Purpose	Roughing	
APKT-1003					
APKT-1003-PDER	0.019	DPAT20M			94855
APKT-1003-PDER	0.019		DASP35M		94853
APKT-1003-PDER	0.019			DHP435M	94874
APKT-1604					
APKT-1604-PDER	0.031	DPAT20M			94891
APKT-1604-PDER-1.2	0.063		DASP35M		94903
APKX-1604-PDSR-1.2	0.063			DHP440M	94920

**Suggested starting conditions are based on a 0.100 axial depth of cut and nonheat-treated material.
Cutting speed should be adjusted according to the depth and Rockwell of material.

Grade Info.	**For Ferrous Metals: Carbon Steel, Alloy Steel, Martensitic-Ferritic, 400 Series, and PH Stainless Steel**
DPAT20M	**Very High Heat Resistant Properties, High Wear-Resistance, and Dry Milling TiAlN Multi Coating; Cutting Speed: Very High; Cutting Conditions: Dry First Choice: For machining very hard material at high speeds and velocity**
DASP35M	**Heat Resistant, High-Performance for Dry and High Speed Machining TiAlCN (ML) Coating; Cutting Speed: High; Cutting Conditions: Dry First Choice: For milling applications, roughing to finishing**
DHP440M	**High Toughness, High Hardness, High Heat Resistance and Low Friction Coefficient; TiAlN Coating; Cutting Speed: Medium; Cutting Cond.: Wet-Dry First Choice: For tough and roughing milling application**
DHPCP35M	**High Toughness, High Hardness, High Heat Resistance and Low Friction Coefficient; TiAlN Coating; Cutting Speed: Medium; Cutting Cond.: Wet-Dry First Choice: For tough and roughing milling application**

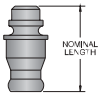
Non-Ferrous Grade

Insert Description		Applications			Part No.
Description	Radius	Finishing	General Purpose	Roughing	
APKT-1003					
APKT-1003-PDFR	0.019	DKAT10M			94853
APKT-1003-PDFR	0.019		DASK25M		94869
APKT-1003-PDFR	0.019			DHK425M	94873
APKT-1604					
APKT-1604-PDFR	0.031	DKAT10M			94879
APKT-1604-PDFR-1.2	0.063		DASK25M		94901
APKX-1604-PDER-1.2	0.063			DHK425M	94916

**Suggested starting conditions are based on a 0.100 axial depth of cut and nonheat-treated material.
Cutting speed should be adjusted according to the depth and Rockwell of material.

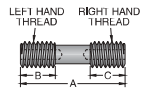
Grade Info.	**For Non Ferrous Metals: Stainless Steel, Cast Iron, Copper , Brass, High Temper Alloys**
DKAT10M	**Very High Heat Resistant Properties, High Wear-Resistance, and Dry Milling TiAlN Multi Coating; Cutting Speed: Very High; Cutting Conditions: Dry First Choice: For machining very hard material at high speeds and velocity**
DASK25M	**Very High Heat Resistant Properties, High Wear-Resistance, and Dry Milling TiAlCN (ML) Coating; Cutting Speed: High; Cutting Conditions: Dry First Choice: For machining very hard material at high speeds and velocity**
DHK425M	**High Toughness, High Hardness, High Heat Resistance and Low Friction Coefficient; TiAlN Coating; Cutting Speed: Medium; Cutting Cond.: Wet-Dry First Choice: For tough and roughing milling application**

Lock Pins



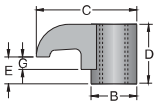
Desc.	Part No. 733101-	Insert I.C.	Nominal Length	Thread	Hex Wrench Size	Pkg.
NL-34	90475	.375	.453	10-32	5/64	10
NL-46	90479	.500	.672	1/4-28	3/32	

Clamp Screws



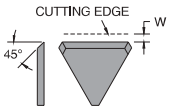
Desc.	Part No. 733101-	A	B	C	Thread Size	Hex Wrench Size	Pkg.
XNS-36	90902	0.750	.25	.25	10-32	3/32	10
XNS-59	90911	1.125	.47	.41	5/16-24	5/32	

Finger Clamps



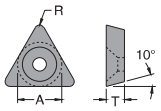
Desc.	Part No. 733101-	B	C	D	E	G	Thread	Pkg.
CL-6	90681	.310	.58	.440	.187	.094	10-32	10
CL-7	90682	.310	.64	.310	.082	—	10-32	
CL-9	90683	.430	.75	.660	.344	.125	5/16-24	
CL-12	90684	.430	.88	.660	.344	.125	5/16-24	

Tri. Chipbreakers



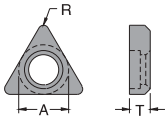
Desc.	Part No. 733101-	I.C.	Effective Width W	Pkg.
T3AC	90452	.375	.060	10
T3AE	90453	.375	.090	
T3AG	90454	.375	.125	
T4AC	90459	.500	.060	
T4AE	90460	.500	.090	
T4AG	90461	.500	.125	

Pos. Tri. Shim Seat



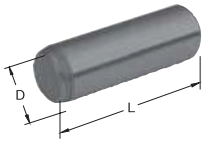
Desc.	Part No. 733101-	A	T	R	Pkg.
SM-41	90367	.332	.125	.0156	10
SM-37	90366	.452	.125	.0312	

Neg. Triangle Shim Seat



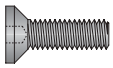
Desc.	Part No. 733101-	A	T	R	Pkg.
ITSN-322	90084	.375	.1250	.0312	10
ITSN-323	90085	.375	.1250	.0469	
ITSN-324	90086	.375	.1250	.0625	
ITSN-433	90093	.500	.1875	.0469	
ITSN-434	90094	.500	.1875	.0625	

A Series Knurling Pins



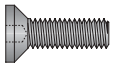
High Speed Desc.	High Speed Part No. 733101-	Carbide Desc.	Carbide Part No. 733101-	D	L
A60464	28620	A60464C	28720	1/4	5/8
A60465	28625	A60465C	28725	1/4	3/4

No. 881 Holder TNMC Insert Lock Screw



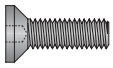
Desc.	Part No. 733101-	I.C.	Torx Key	Pkg.
GTS-1	90965	.375	T-10	10

No. 881 Holder Laydown Insert Lock Screw



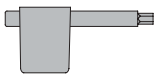
Desc.	Part No. 733101-	I.C.	Torx Key	Pkg.
TS-25.45-6M1	91310	.250	T-8	10
TS-16	91311	.375	T-10	
TS-22	91312	.500	T-20	

No. 16 Holder Seat Screw



Desc.	Part No. 733101-	I.C.	Hex Wrench Size	Pkg.
S-4	91005	.375	1/16	10
S-6	91006	.500	3/32	

Torx Key



Desc.	Part No. 733101-
T-8	92003
T-10	92005
T-20	92007

Height Adjustments

Quick Change Holder Height Adjustments *

D25AXA	D30BXA	D35CXA	D40CA	D50DA	D60EA
DHAA-25	**DHAA-30**	**DHAA-35**	**DHAA-40**	**DHAA-56**	**DHAA-56**
03887	03889	03891	03893	03897	03897

Quadra Holder Height Adjustments *

QITP25N	QITP30N	QITP35N	QITP40N	QITP50N	QITP60N
DHAA-25	**DHAA-30**	**DHAA-35**	**DHAA-40Q**	**DHAA-56**	**DHAA-56**
03887	03889	03891	03893	03897	03897

* Price each

Set Screws

Quadra Holder Set Screws *

QITP25N -SS-STD	QITP30N -SS-STD	QITP35N -SS-STD	QITP40N -SS-STD	QITP50N -SS-STD	QITP60N -SS-STD
03929	03931	03933	03935	03937	03939

Quick Change Holder Metric Set Screws For Holders # 1, 2, 3, & 10 *

D25-SSM	D30-SSM	D35-SSM	D40-SSM	D50-SSM	D60-SSM
03917	03919	03921	03923	03925	03927

Quadra Holder Metric Set Screws *

QITP25N -SSM	QITP30N -SSM	QITP35N -SSM	QITP40N -SSM	QITP50N -SSM	QITP60N -SSM
03941	03943	03945	03947	03949	03951

* Price per pkgs of 10.