

Quick Change Tooling System

Piston Type Tool Post

· Heavy base provides unusual stability · #2 Morse taper centers

- Features:
- All working parts hardened and ground
 - Maximum rigidity for chatter-free performance
 - No time wasted with shims
 - Speed up your lathe operations 90%
 - Completely sealed for maintenance-free operation



Cuts Setup Time

Instant changing from one operation to another. A knurled nut on each toolholder provides for exact height adjustment, entirely eliminating the use of shims. You simply flip the handle and slide out the toolholder. Then slide in the next holder with the locked-in tool bit in the exact preset position, ready to run. Setups can be made on a benchplate, avoiding costly down time.

Turning:

The unequalled rigidity of this Tool Post and Toolholders insures smoother turning without chatter or vibration.

Drilling:

Enables you to drill by power feed with your carriage, instead of hand operation of tailstock. Easily centered.



Wedge Type Tool Post

Wedge type tool posts are precision-engineered to assure repetitive accuracy. Advanced design provides built-in quick tool changing versatility with positive rigidity to meet the most exacting working tolerances. Quickly and easily installed on an engine, bench or turret lathe for a wide range of operations, from fine, precise work to heavy-duty cutting.

Turning And Facing Holder

Takes various sizes of bits. Turning and facing tools can be locked in together. Saves time and labor when changing operations.



No.1

Boring, Turning And Facing Holder

V-groove holds round shank boring bars and tools, as well as square tool bits.



No.2

Heavy Duty Boring Bar Holder

Equipped with a split bushing to accommodate a boring bar of smaller diameter. Grips bar with extreme rigidity; cuts smoothly without chatter.



No.4
No.41 Larger Capacity

Universal Parting Blade Holder

For bevel as well as T-cut blades. Enable you to cut-off close to chuck. Absence of vibration prevents breaking blades.



No.7

Knurling, Facing And Turning Holder

For turning and facing, as well as knurling. Supplied with a set of high speed precision-ground and lapped medium diamond knurls. Easily replaceable.



No.10

Morse Taper Holder

Drill with carriage by using power feed, instead of tailstock. Easily centered. For No.2,3 & 4 Morse taper drills.



No.5
No.53 Larger Taper

Holders:	Capacity 12" Swing		Capacity 10" -15" Swing		Capacity 13" -18" Swing		Capacity 14" -20" Swing	
	Model No.	Bit Cap.	Model No.	Bit Cap.	Model No.	Bit Cap.	Model No.	Bit Cap.
Piston Type Tool Post:	QCTP-100		QCTP-200		QCTP-300		QCTP-400	
Wedge Type Tool Post:	QCTW-100		QCTW-200		QCTW-300		QCTW-400	
Turning & Facing Holder No.1	QCT-101	3/16-1/2"	QCT-201	1/4-5/8"	QCT-301	1/2-3/4"	QCT-401	1/2-1"
Boring Turning & Facing Holder No.2	QCT-102	Shank 7/16"	QCT-202	Shank 1/4-5/8"	QCT-302	Shank 1/2-3/4"	QCT-402	Shank 1/2-1"
Heavy Duty Boring Bar Holder No.4	QCT-104	5/8"	QCT-204	3/4"	QCT-304	3/4"	QCT-404	1"
Universal Parting Blade Holder No.7	QCT-107	1/2"	QCT-207	11/16"	QCT-307	3/4"	QCT-407	1-7/8"
Knurling Facing & Turning Holder No.10	QCT-110	3/16-1/2"	QCT-210	1/4-5/8"	QCT-310	1/2-3/4"	QCT-410	1/2-1"

Sets: Includes all of the above tools.	Piston Type Model No.		Piston Type Model No.		Piston Type Model No.		Piston Type Model No.	
	QCTPS-100		QCTPS-200		QCTPS-300		QCTPS-400	
	Wedge Type Model No.		Wedge Type Model No.		Wedge Type Model No.		Wedge Type Model No.	
	QCTWS-100		QCTWS-200		QCTWS-300		QCTWS-400	

Not included in set	Model No.	Bit Cap.	Model No.	Bit Cap.	Model No.	Bit Cap.	Model No.	Bit Cap.
Morse Taper Holder No.5	QCT-105	2 MT	QCT-205	2 MT	QCT-305	3 MT	QCT-405	3 MT
Heavy Duty Boring Bar Holder No.41	QCT-141	3/4"	QCT-241	1"	QCT-341	1"	QCT-441	1-1/4"
Morse Taper Holder No.53	QCT-153	3 MT	QCT-253	3 MT	QCT-353	4 MT	QCT-453	4 MT

40-Position Quick Change Tool Post Holder

Tool Post and Technical Specifications

The best designed quick change tool post and holder system in the industry for its accuracy, rigidity and productivity now at affordable price!

- Wear-free, tear-free, and maintenance-free
- Adjust tool to 40 different positions indicated by a marked position dial (index every 9°)

- Fully interchangeable with other brand 40-position quick change tool post & holder
- Heat-treated and precision-ground for very accurate repeatability
- Change tools in seconds
- Adjust height of cutting edge easily and accurately
- Reground tools without removal from holder-setting unchanged

40-Position Tool Post

Model No.	Series	Lathe swing (mm)	Height of cutting edge range (mm)
QC540-000	A0	120-220	D12 18.5-26.5
QC540-100	A1	150-300	D16 25.5-36.5 D20 29.5-40.5
QC540-200	E5	200-400	D20 32-49 D25 37-52
QC540-300	B2	300-500	D25 38-58 D32 46-57
QC540-400	C3	400-700	D32 47.5-87.5 D40 55.5-91.5 D45 61-91
QC540-500	D1	600-1000	D40 60-96 D50 72-102 D63 85-105

Turning & Facing Holder"D"

Model No.	Series	H(mm)	L(mm)	Model No.	Series	H(mm)	L(mm)
QC540-010	A0	12	50	QC540-313	B2	32	120
QC540-111	A1	16	75	QC540-314	B2	32	140
QC540-112	A1	16	80	QC540-411	C3	32	150
QC540-113	A1	16	90	QC540-412	C3	32	170
QC540-114	A1	20	75	QC540-413	C3	40	150
QC540-110	A1	20	80	QC540-414	C3	40	170
QC540-115	A1	20	90	QC540-415	C3	45	170
QC540-211	E5	20	100	QC540-511	D1	40	180
QC540-212	E5	25	100	QC540-512	D1	50	180
QC540-311	B2	25	120	QC540-513	D1	63	180
QC540-312	B2	25	140				

Boring Bar Holder"B"

Model No.	Series	Φdmax (mm)	L(mm)	Model No.	Series	Φdmax (mm)	L(mm)
QC540-020	A0	12	50	QC540-320	B2	32	130
QC540-121	A1	16	80	QC540-421	C3	32	160
QC540-120	A1	18	80	QC540-422	C3	40	160
QC540-122	A1	20	90	QC540-520	D1	50	180
QC540-220	E5	30	100	QC540-521	D1	63	180

Drilling & Boring Bar Holder"S"

Model No.	Series	ΦD (mm)	L(mm)	Model No.	Series	ΦD (mm)	L(mm)
QC540-030	A0	15	50	QC540-330	B2	40	120
QC540-130	A1	30	80	QC540-431	C3	40	150
QC540-131	A1	20	90	QC540-432	C3	50	150
QC540-231	E5	30	100	QC540-530	D1	63	180
QC540-232	E5	40	100				

Cut-Off Tool Holder"A"

Model No.	Series	Blade(mm)	L(mm)	Model No.	Series	Blade(mm)	L(mm)
QC540-040	A0	2.7 × 10	50	QC540-340	B2	4 × 16	120
QC540-140	A1	2.7 × 10	75	QC540-440	C3	5 × 18.5	150
QC540-240	E5	2.7 × 10	100				

M.T. Bushing"L"

Model No.	Series	ΦD (mm)	L(mm)	MK	Model No.	Series	ΦD (mm)	75	MK
QC540-151	A1	30	80	1	QC540-352	B2	40	140	4
QC540-152	A1	30	90	2	QC540-451	C3	40	140	3
QC540-251	E5	30	96	2	QC540-452	C3	40	150	4
QC540-252	E5	40	114	3	QC540-453	C3	50	150	4
QC540-351	B2	40	120	3	QC540-550	D1	63	185	5

5-Piece Sets

Model No.	Each set includes		
QCTOOA0	1 pc tool post 540-000(A0)	3 pcs 540-010(A0D12x50) and 1 pc 540-020(A0B12x50)	
QCTOOA1	1 pc tool post 540-100(A1)	3 pcs 540-115(A1D20x90) and 1 pc 540-122(A1B20x90)	
QCTOOE5	1 pc tool post 540-200(B5)	3 pcs 540-211(E5D20x100) and 1 pc 540-220(E5B30x100)	
QCTO0B2	1 pc tool post 540-300(B2)	3 pcs 540-311(B2D25x120) and 1 pc 540-320(B2B32x130)	
QCTOOC3	1 pc tool post 540-400(C3)	3 pcs 540-411(C3D32x150) and 1 pc 540-422(C3B40x160)	
QCTOOD1	1 pc tool post 540-500(D1)	3 pcs 540-511(D1D40x180) and 1 pc 540-520(D1B50x180)	

