

# Machine Accessories

## QUICK CHANGE TOOL POSTS & TOOL HOLDERS

### Quick Change Lathe Tool Post Sets

#### Piston Type

Piston Type Tool Post Sets

Each set consists of one piston type tool Post and one of each of 5 tool holders:

- Style1: Boring & Facing.
- Style2: Boring, Turing & Facing.
- Style4: Boring, Heavy duty.
- Style7: Universal Parting Blade.
- Style10: Knurling, Facing & Turning.



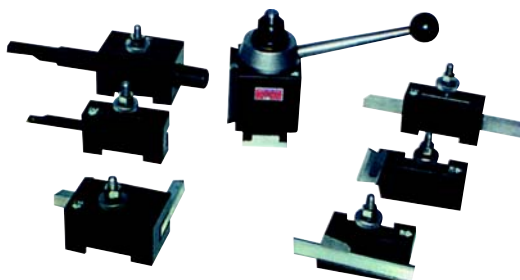
Tool Post		
Series	Swing	Model No.
100	Up To 12"	951-1100
200	10-15"	951-1200
300	13-18"	951-1300
400	14-20"	951-1400

#### Wedge Type

Piston Type Tool Post Sets

Each set consists of one piston type tool Post and one of each of 5 tool holders:

- Style1: Boring & Facing.
- Style2: Boring, Turing & Facing.
- Style4: Boring, Heavy duty.
- Style7: Universal Parting Blade.
- Style10: Knurling, Facing & Turning.

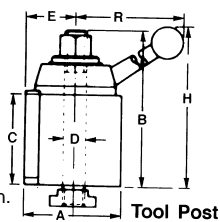


Tool Post		
Series	Swing	Model No.
100	Up To 12"	951-1111
200	10-15"	951-1222
300	13-18"	951-1333
400	14-20"	951-1444
500	17-48"	951-1555

### Quick Change Lathe Tool Posts

Features:

- All working parts hardened & ground.
- Maximum rigidity for chatter-free performance.
- No time wasted with shims.
- Holders fit "ALORRIS" & "YUASA" tool posts.
- Increases productivity of all lathe operations.
- Completely sealed for maintenance free operation.
- Change tools in seconds.



Tool Post Series	Width			Overall D	Height E	Fits Lathe		Size	Piston Type	Wedge Type
	A	B	C			H	R		Model No.	Model No.
100	2-1/2"	3-7/8"	2-1/4"	9/16"	1-3/8"	4-11/16"	5-3/4"	12"	950-1100	950-1111
200	3	4-5/8"	2-3/4"	5/8"	1-5/8"	5-9/16"	7-5/16"	10-15"	950-1200	950-1222
300	3-1/2"	5-1/8"	3	3/4"	1-7/8"	6-1/8"	7-7/8"	13-18"	950-1300	950-1333
400	4	6-1/4"	3-5/8"	7/8"	2-1/8"	7	9	14-20"	950-1400	950-1444
500	5	7-3/8"	4-5/8"		2-11/16"			17-48"	-----	950-1555

### Tool Holders Interchangeable with Aloris

Features:

- All working parts hardened & ground.
- Maximum rigidity for chatter-free performance.
- No time wasted with shims.

### Quick Change Lathe Tool Holders

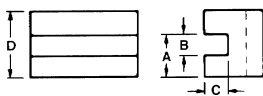
Features:

- All working parts hardened & ground.
- Maximum rigidity for chatter-free performance.
- No time wasted with shims.

### Turning & Facing Holders

Features:

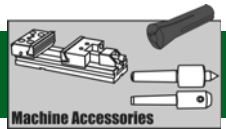
- Takes various sizes of bits.
- Turning and facing tools can be locked in together.
- Save time and labor when changing operations.



Style No. 1

Series	A	B	C	D	Tool Bit	Model No.
100(AXA)	15/16"	1/2"	7/16"	1-1/2"	3/16-1/2"	950-1101
200(BXA)	1-1/8"	5/8"	1/2"	1-3/4"	1/4-5/8"	950-1201
300(CXA)	1-7/16"	3/4"	5/8"	2-1/8"	1/2-3/4"	950-1301
400(CA)	1-11/16"	1"	3/4"	2-1/2"	1/2-1"	950-1401
500	3-3/16"	1-1/4"	1"	3-1/8"		950-1501

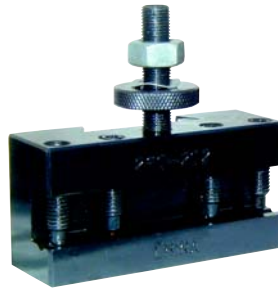
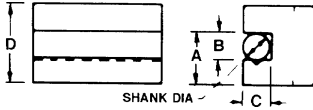
# Machine Accessories



## Boring, Turning & Facing Holders

### Features:

- "V" groove holds round shank boring bars and tools as well as square tool bits
- Boring Bar not included.



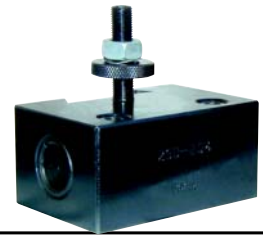
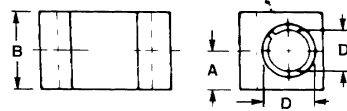
### Style No. 2

Series	A	B	C	D	Tool Bit	Shank	Model No.
100(AXA)	15/16"	1/2"	7/16"	1-1/2"	3/16-1/2"	7/16	950-1102
200(BXA)	1-1/8	5/8	1/2	1-3/4	1/4-5/8	1/2	950-1202
300(CXA)	1-7/16	3/4	5/8	2-1/8	1/2-3/4	3/4	950-1302
400(CA)	1-11/16	1	3/4	2-1/2	1/2-1	13/16	950-1402
500	3-3/16	1-1/4	1	3-1/8			950-1502

## Heavy Duty Boring Holders

### Features:

- Equipped with a split bushing to accommodate a boring bar of smaller dia.
- It grips with extreme rigidity, cuts smoothly without chatter.
- Holders supplied with split bushing.



### Style No. 4

Series	A	B	Inside D	D1	Model No.
100(AXA)	3/4	1-1/2	3/4	5/8	950-1104
200(BXA)	1	2	2	3/4	950-1204
300(CXA)	1	2	1	3/4	950-1304
400(CA)	1-3/8	2-3/4	1-1/4	1	950-1404
500	1-9/16	3-1/8	1-1/2	1-1/4	950-1504

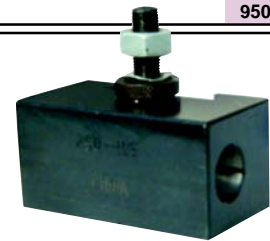
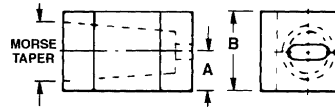
### Style No. 41

Series	A	B	Inside D	D1	Model No.
100(AXA)	7/8	1-3/4	1	3/4	950-1141
200(BXA)	1	2	1-1/4	1	950-1241
300(CXA)	1-1/8	2-1/4	1-1/4	1	950-1341
400(CA)	1-3/8	2-3/4	1-1/2	1-1/4	950-1441
500					950-1541

## Morse Taper Holders

### Features:

- Drills with carriage by using power feed instead of tail stock
- Easily centered.
- For 2,3 and 4 Morse Taper drills.
- Drill not included.



### Style No. 5

Series	A	B	Taper Hole Size	Model No.
100(AXA)	3/4	1-1/2	2M.T.	950-1105
200(BXA)	7/8	1-3/4	2M.T.	950-1205
300(CXA)	1	2	3M.T.	950-1305
400(CA)	1-1/4	2-1/2	3M.T.	950-1405
500				950-1505

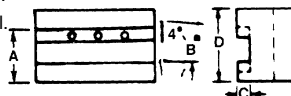
### Style No. 53

Series	A	B	Taper Hole Size	Model No.
100(AXA)	3/4	1-1/2	3M.T.	950-1153
200(BXA)	7/8	1-3/4	3M.T.	950-1253
300(CXA)	1-1/16	2-1/8	4M.T.	950-1353
400(CA)	1-1/4	2-1/2	4M.T.	950-1453
500				950-1553

## Universal Parting Blade Holders

### Features:

- For bevel as well as T-cut blades.
- Absence of vibration prevents breaking blades.
- Blade additional.



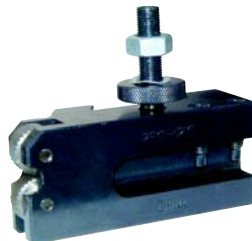
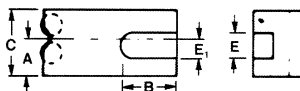
### Style No. 7

Series	A	B	C	D	Height	Model No.
100(AXA)	13/16	1/2	13/16	1-1/2	1/2	950-1107
200(BXA)	1	11/16	13/16	1-3/4	11/16	950-1207
300(CXA)	1-3/16	3/4	13/16	2	3/4	950-1307
400(CA)	1-7/16	7/8	1/4	2-1/2	7/8	950-1407
500		1-3/16	1/4	2-3/4		950-1507

## Knurling, Facing & Turning Holders

### Features:

- For turning and facing as knurling.
- Supplied with a set of high speed precision round lapped medium diamond knurls.
- Dimensions 3/4x3/8x1/4"

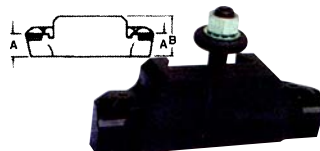


### Style No. 10

Series	A	B	C	E	E1	Tool Bit	Model No.
100(AXA)	7/8"	7/8"	1-6/19"	1/2"	3/8"	3/16-1/2"	950-1110
200(BXA)	1	1	1-3/4	5/8	1/2	1/4-5/8	950-1210
300(CXA)	1-3/16	1-3/16	2	3/4	5/8	1/2-3/4	950-1310
400(CA)	1-7/16	1-7/16	2-1/2	1	3/4	1/2-1	950-1410
500	1-7/8	1-7/8	3-1/8	1-1/4	1		950-1510

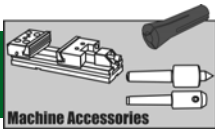
## Combination Facing & Turning Holders For Carbide Triangular Inserts

Accommodates standard triangular positive rack inserts. Unique design permits both right hand and left hand turning and facing. Supplied with carbide shims to protect the holder. Inserts not included.



### Style No. 16

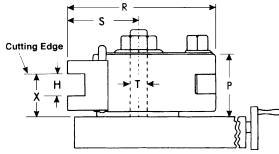
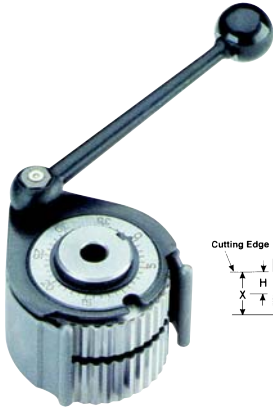
Rate	A	B	I.C.	Thick	Model No.
POS.	7/8"	1-3/8"	3/8"	1/8	950-1116
POS.	1	1-3/4	3/8	1/8	950-1216
POS.	1-3/16	2	3/8	1/8	950-1316
POS.	1-1/2	2-1/4	1/2	3/16	950-1416



# Machine Accessories

## 40-POSITION QUICK CHANGE TOOL POSTS & HOLDERS

### Tool Post & Technical Specifications



The best designed Quick Change Tool Post & Holder system in the industry for its accuracy, rigidity and productivity now at affordable price!

- Two-year guarantee.
- 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.

Each set includes:  
1 Tool Post  
3 "D" Holders  
1 "B" Holder

### 40-Position Quick Change Tool Posts

Specifications	Model No. 950-2100	Model No. 950-2200	Model No. 950-2300	Model No. 950-2400	Model No. 950-2500	Model No. 950-2600
Size of Tool Post	A0	A	E	B	C	D
Lathe Swing	Up to 10"/ 120-220mm	6-13"/ 150-300mm	10-18"/ 200-400mm	13-20"/ 300-500mm	18-30"/ 400-700mm	30"-40"/ 800-1000mm
Max. Driving Power (HP)	1.5	3	6	9	18	27
R max	2.99	4.13	5.14	6.00	7.90	9.49
S max	1.36	2.07	2.57	2.95	3.62	4.80
P	1.26	1.83	2.30	2.68	3.90	4.53
T	0.51	0.79	0.79	1.26	1.57	1.57
H	0.51	0.83	0.94	1.00	1.26	1.61
X min	0.79	1.18	1.37	1.46	1.86	2.44
X max	1.18	1.61	2.04	2.25	3.43	4.56

### 40-Position Quick Change Tool Post Sets

Tool Post Series	Lathe Swing	Sets Model No.
A0	Up to 10" (120-220mm)	950-2705
A1	6-13" (150-300mm)	950-2710
E5	10-18" (200-400mm)	950-2715
B2	13-20" (300-500mm)	950-2722
C3	18-30" (400-700mm)	950-2725
D1	30" up (600-1000mm)	950-2730

### CUT-OFF TOOL HOLDER A



Fits Post Size	Blade Thickness	Blade Width	Holder Length	Model No.
A	7/64"	13/32"	3-5/32"	950-2401
E	11/64"	5/8"	4"	950-2402
B	11/64"	5/8"	4-3/4"	950-2403
C	7/32"	3/4"	6"	950-2404

### BORING, TURNING & FACING HOLDER B



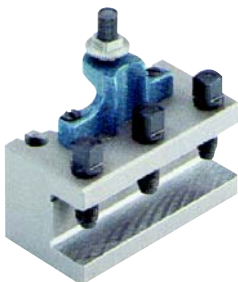
Fits Post Size	Facing Height	Holder Length	Model No.
A0	15/32"	2"	950-2201
A	3/4"	3-5/32"	950-2202
E	1-3/16"	4"	950-2203
B	1-1/4"	5-1/8"	950-2204
C	1-1/4"	6-5/16"	950-2205
C	1-5/8"	6-5/16"	950-2206
D	2"	7-3/32"	950-2207
A	4/5"	3-3/5"	950-2210
B	18/25	4-4/5"	950-2211
C	2	6-5/16"	950-2212
D <sub>1</sub>	2-1/2"	7-1/5"	950-2213
D <sub>2</sub>	2-4/5"	8-4/5"	950-2214

### DRILL & BORING BAR HOLDER S



Fits Post Size	Facing Height	Holder Length	Model No.
A0	19/32"	2"	950-2301
A	1-3/16"	3-5/32"	950-2302
E	1-3/16"	4"	950-2303
E	1-5/8"	4"	950-2304
B	1-5/8"	4-3/4"	950-2305
C	1-5/8"	6-2/5"	950-2306
C	2"	6-2/5"	950-2307
D	2-1/2"	7-3/32"	950-2308
D	2-1/2"	8-4/5"	950-2309

### TURNING AND FACING HOLDER D



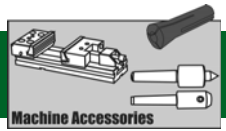
Fits Post Size	Facing Height	Holder Length	Model No.
A0	15/32"	2"	950-2101
A	3/4"	3-5/32"	950-2102
E	3/4"	4"	950-2103
E	1"	4"	950-2104
B	1"	4-3/4"	950-2105
B	1"	5-1/2"	950-2106
B	1-1/4"	4-3/4"	950-2107
B	1-1/4"	5-1/2"	950-2108
C	1-1/4"	6"	950-2109
C	1-1/4"	6-11/16"	950-2110
C	1-5/8"	6"	950-2111
C	1-5/8"	6-11/16"	950-2112
C	1-3/4"	6-11/16"	950-2113
D <sub>1</sub>	1-5/8"	7-3/32"	950-2114
D <sub>1</sub>	2"	7-3/32"	950-2115
D <sub>1</sub>	2-1/2"	7-3/32"	950-2116
D <sub>2</sub>	2"	8-4/5"	950-2122
D <sub>2</sub>	2-1/2"	8-4/5"	950-2123
A	16/25"	3-5/32"	950-2124
A	16/25"	3-3/5"	950-2125
A	4/5"	3-3/5"	950-2126

### BUSHINGS FOR DRILL & BORING BAR HOLDER



Drill & Boring Bar Holder Model No.	Bushings Diameters	Hole M.T. Size	Bushing Model No.
950-2302	1-3/16"	1mt	950-2501
950-2302	1-3/16"	2mt	950-2502
950-2303	1-3/16"	2mt	950-2503
950-2304	1-5/8"	3mt	950-2504
950-2305	1-5/8"	3mt	950-2505
950-2305	1-5/8"	4mt	950-2506
950-2306	1-5/8"	3mt	950-2507
950-2306	1-5/8"	4mt	950-2508
950-2307	2"	4mt	950-2509
950-2308	2-1/2"	5mt	950-2510

# Machine Accessories

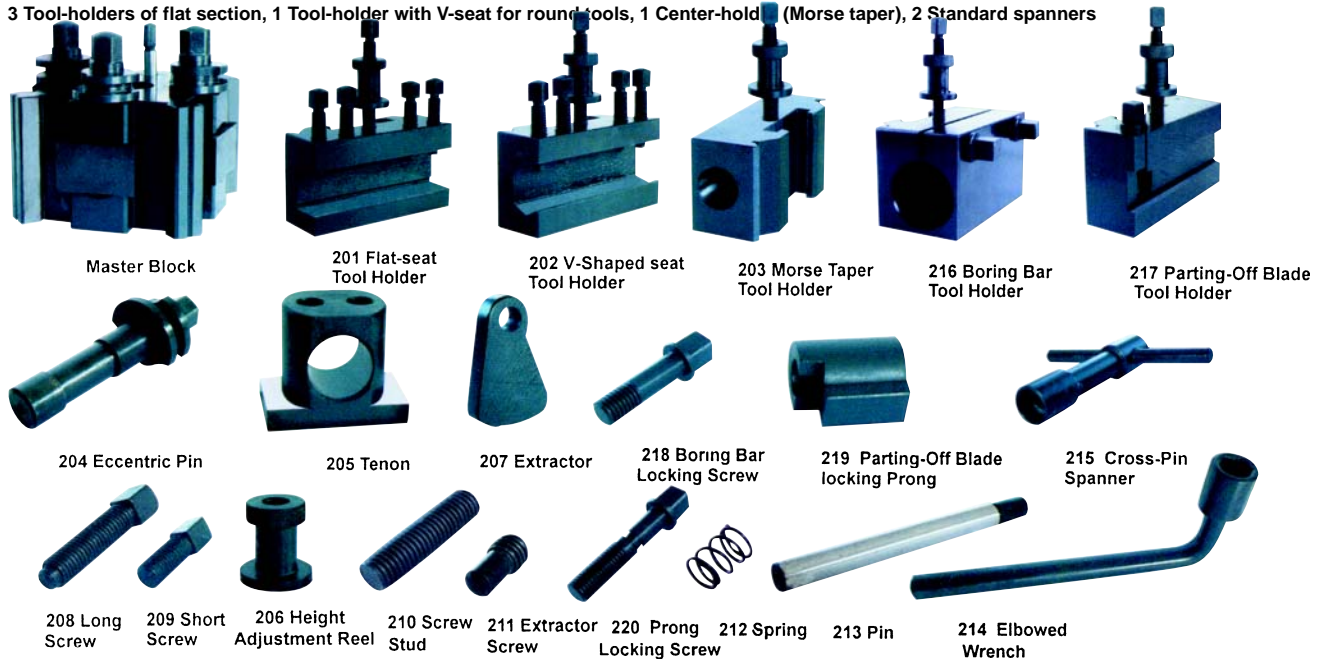


## QUICK CHANGE TOOL POST AND SETS

The quick change tool post is a major spare part of the ordinary lathes . It is composed of the cutter-cartridge body and the tool-holder for various cutting tools for processing works like cylindrical facing, end facing, cutting, knurling, drilling, enlarging boring and reaming, etc. The height of tools can be regulated and positioned relative to the centerline of machine spindle. It features external tool-mounting, too-matching, quick tool-changing, great precision in positing and great hardness etc.

Set Includes:

3 Tool-holders of flat section, 1 Tool-holder with V-seat for round tools, 1 Center-hold (Morse taper), 2 Standard spanners



Size	For Lathes with Swing	Dimensions of Turret Body	Max. Height Square and Rectangular Tools	Max. Diameter Round Tool	Taper Shank	Max. Adjust Tool Holder	Sets Model No.
MK	Up to 7"	1-7/8x1-7/8x1-1/4	3/8	3/8		5/16	951-5100
M	7-10"	2-3/4x2-3/4x1-3/4	5/8	1/2	1	1/2	951-5200
A	10-14"	3-7/8x3-7/8x2-3/8	3/4	5/8	2	9/16	951-5300
B	16-18"	5x5x3-3/8	1-1/8	13/16	3	15/16	951-5400
C	18-24"	5-5/8x5-5/8x3-3/4	1-1/4	15/16	4	1	951-5500
D	Over	6-7/8x6-7/8x4-3/4	1-1/2	1-1/4	4	1-1/2	951-5600
E	Over	7-7/8x7-7/8x5-5/16	2	1-3/8	5	1-5/8	951-5700
F	Over	8-7/8x8-7/8x5-7/8	2	1-3/8	5	2-1/4	951-5800
Ba	14-16"						951-5900

Fig.	Description	Ba	MK	M	A	B	C	D	E	F
	Master Block		950-5100	950-5200	950-5300	950-5400	950-5500	950-5600	950-5700	950-5800
201	Flat-Seat Tool Holder	950-5921	950-5121	950-5221	950-5321	950-5421	950-5521	950-5621	950-5721	950-5821
202	V-Tool Holder	950-5922	950-5122	950-5222	950-5322	950-5422	950-5522	950-5622	950-5722	950-5822
203	Morse Taper Tool Holder	950-5923	950-5123	950-5223	950-5323	950-5423	950-5523	950-5623	950-5723	950-5823
217	Parting-off Blade Holder	950-5917	950-5117	950-5217	950-5317	950-5417	950-5517	950-5617	950-5717	950-5817
216	Boring Bar Tool Holder	950-5916	950-5116	950-5216	950-5316	950-5416	950-5516	950-5616	950-5716	950-5816
204	Eccentric Clamp Pin		950-5124	950-5224	950-5324	950-5424	950-5524	950-5624	950-5724	950-5824
205	Tenon		950-5125	950-5225	950-5325	950-5425	950-5525	950-5625	950-5725	950-5825
212	Clamping Block Spring		-----	-----	950-5312	950-5412	950-5512	-----	-----	-----
213	Dowel Pin		950-5113	950-5213	950-5313	950-5413	950-5513	950-5613	950-5713	950-5813
210	Screw Stud		950-5110	950-5210	950-5310	950-5410	950-5510	950-5610	950-5710	950-5810
206	Height Adj. Screw		950-5106	950-5206	950-5306	950-5406	950-5506	950-5606	950-5706	950-5806
218	Boring Bar Locking Screw		950-5118	950-5218	950-5318	950-5418	950-5518	950-5618	950-5718	950-5818
220	Prong Locking Screw		-----	950-5220	950-5320	950-5420	950-5520	950-5620	950-5720	-----
219	Parting-off Blade Locking Prong		-----	950-5219	950-5319	950-5419	950-5519	950-5619	950-5719	-----
209	Short Screw		950-5109	950-5209	950-5309	950-5409	950-5509	950-5609	950-5709	950-5809
215	T-Key For Set Screws	950-5915	950-5115	950-5215	950-5315	950-5415	950-5515	950-5615	950-5715	950-5815
214	Hexagon Wrench	950-5914	950-5114	950-5214	950-5314	950-5414	950-5514	950-5614	950-5714	950-5814
207	Extractor		950-5107	950-5207	950-5307	950-5407	950-5507	950-5607	950-5707	950-5807
208	Long Screw		950-5108	950-5208	950-5308	950-5408	950-5508	950-5608	950-5708	950-5808
211	Extractor Screw		950-5111	950-5211	950-5311	950-5411	950-5511	950-5611	950-5711	950-5811