



ALORIS TOOL TECHNOLOGY CO., INC.

NEW REVISED CATALOG 2006



The Originator of Quick Change Tooling

SEE PAGES 47 THRU 54 FOR NEW PRODUCTS

REV 01/06



INTRODUCING

ALORIS INDEXABLE TOOL POSTS & SETS

New Product Built By The Originator of "The Quick Change Tool Post"
For Manual and CNC Lathes

The Aloris Indexable Tool Post allows 4 independent tool holders to be locked to the tool post simultaneously. This allows the operator to do multiple operations by means of indexing the tool post to any of the 24 locking positions. The index positioning and locking is accomplished by the same means as a turret on a CNC Lathe. This is the ultimate in productivity on Manual and CNC Lathes without indexing capabilities. Two standard Aloris Tool Holders can be mounted with no modification or you can modify some existing Aloris holders to fit the indexable tool post.



Increase Production By 75%



- Industry Standard
- Repeatability of .00005
- Some standard Aloris Tool Holders will fit if slightly modified
- All components heat treated and ground
- 24 position, 15° precision indexing through heat treated precision ground face gears
- Precision engineered to assure repetitive accuracy
- Full length wedge lock as featured on the traditional Aloris Tool Post for ultimate rigidity
- Optionally furnished with anti-rotation key precision fit to lathe compound (*eliminates rotation and movement of tool post under extreme cutting conditions*)
- The highest quality lathe tool accessories available
- Only 3 sizes required for up to 36 inch swing
- Over forty five years of machine tool manufacturing experience
- Mounting wrench included with tool post



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REV 01/06

PATENT PENDING

The originator of quick change tooling

INDEXABLE TOOL POSTS & SETS ON PAGES 30-33.

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ALORIS SUPER PRECISION QUICK CHANGE TOOL POSTS

FOR MANUAL AND CNC LATHES

GUARANTEED LASTING REPETITIVE ACCURACY TO WITHIN MILLIONTHS

FEATURES:

- ONLY A SECOND TO CHANGE TOOLS
- RUGGED — NO CHATTER OR VIBRATION
- NO TIME WASTED WITH SHIMS
- UNLIMITED VERSATILITY
- SAFE AND SIMPLE TO OPERATE
- SPEED YOUR LATHE OPERATIONS UP TO 90%
- GUARANTEED*

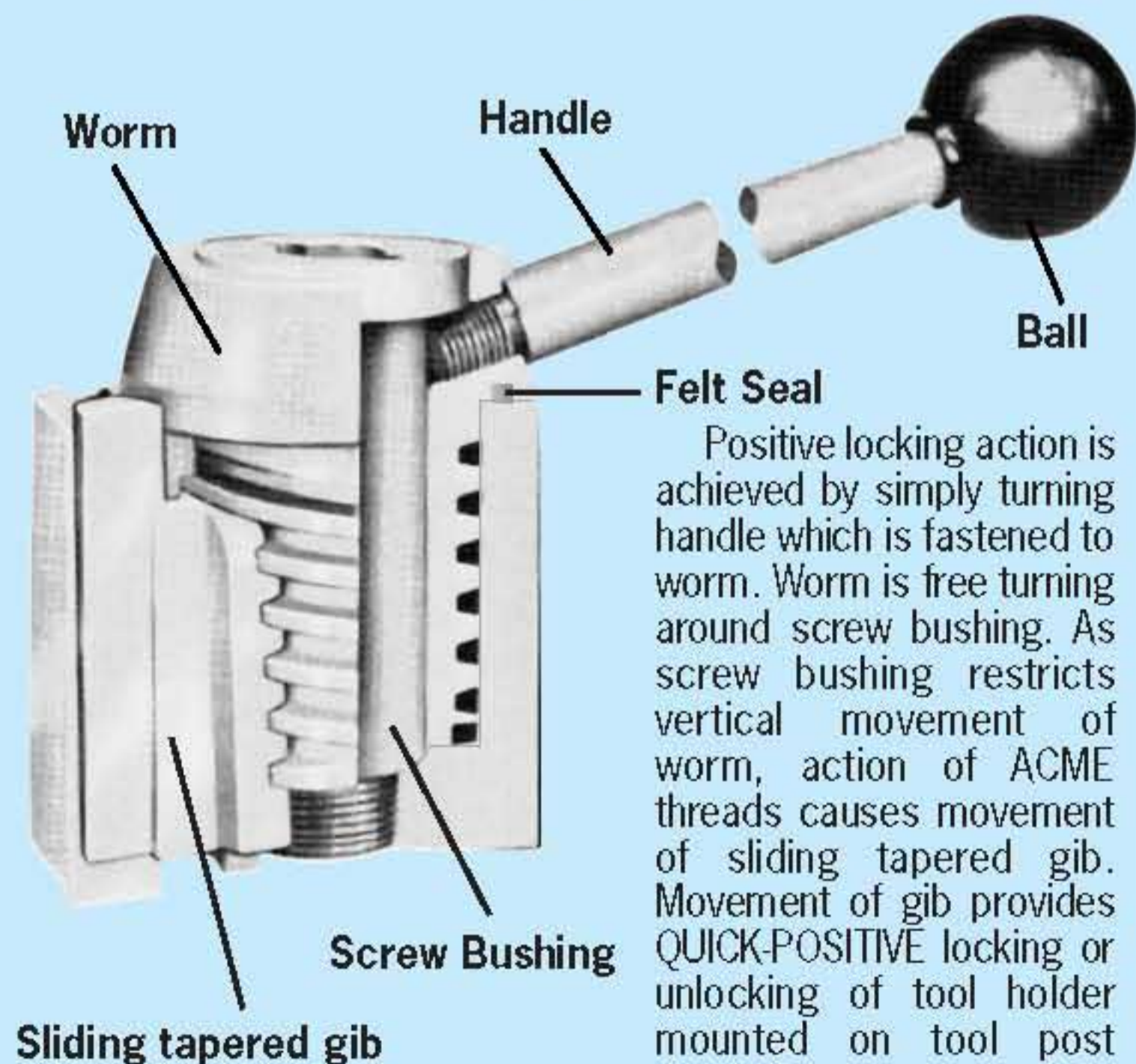


The ALORIS Super Precision tool post provides built-in quick tool changing versatility and flexibility combined with wide range, positive control and repetitive accuracy to meet the most exacting working tolerances. Whether for tool room or production work, the Aloris line of tool posts and holders will save set-up time and increase production on all types of lathe operations from fine precision work to heavy duty cutting without chatter or vibration.

Comparison with other tools will highlight Aloris superiority: the quick change tool holder eliminates time consuming set-up — no tool post indexing necessary, no indexing balls, no need for shims, no need to disturb the basic set-up.

This new catalog includes the newest developments produced by Aloris design engineers in their constant search for new and better products that will increase productivity and reduce operating costs of all machine tool operations.

Aloris super precision tool post Patented locking device assembly



Positive locking action is achieved by simply turning handle which is fastened to worm. Worm is free turning around screw bushing. As screw bushing restricts vertical movement of worm, action of ACME threads causes movement of sliding tapered gib. Movement of gib provides QUICK-POSITIVE locking or unlocking of tool holder mounted on tool post dovetail.

*This guarantee does not include repair or replacement due to misuse, abuse, accidental damage or normal wear.

ALORIS QUICK CHANGE TOOL POSTS

Aloris Super-Precision Tool Post

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 any engine lathe, bench or CNC lathe, for a wide range of operations — from fine precision work to heavy duty cutting.

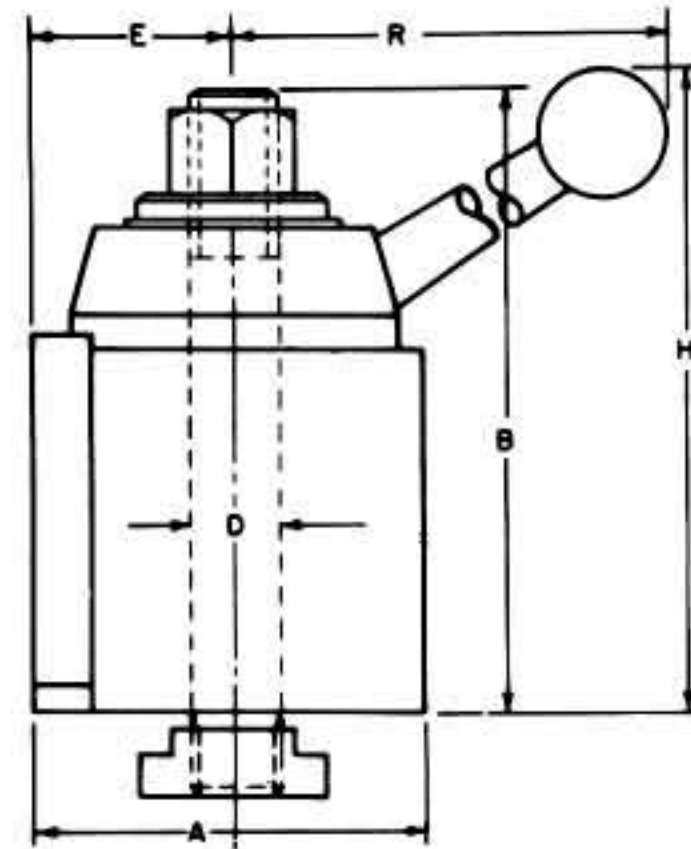
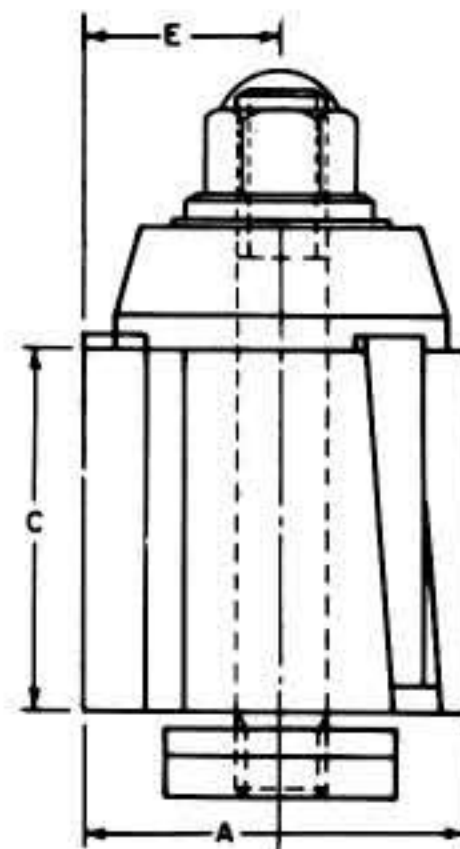
AXA-BXA-CXA-CA-DA-EA



AX-BX-CX

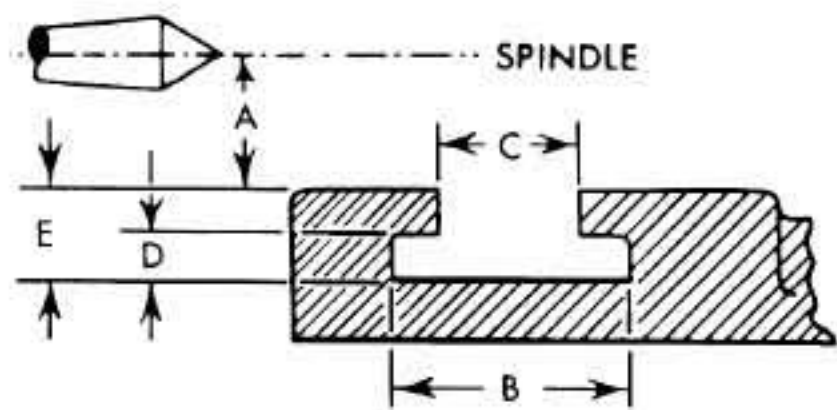
Aloris Piston Type Tool Post

Aloris piston type tool post provides built-in quick tool changing versatility with positive rigidity. Can be quickly and easily installed on any engine or bench lathe to increase production and cut operating costs.



ORDERING INFORMATION

AXA-AX SERIES		BXA-BX SERIES		CXA-CX SERIES		CA SERIES		DA SERIES		EA SERIES																																				
ORDER #: AXA ORDER #: AX		ORDER #: BXA ORDER #: BX		ORDER #: CXA ORDER #: CX		ORDER #: CA		ORDER #: DA		ORDER #: EA																																				
DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS		DIMENSIONS																																				
A	B	C	D	E	H	R	SWING UPTO	A	B	C	D	E	H	R	SWING UPTO	A	B	C	D	E	H	R	SWING UPTO	A	B	C	D	E	H	R	SWING UPTO	A	B	C	D	E	H	R	SWING UPTO							
2 1/2	3	2 1/4	1 1/8	1 1/2	4 1/8	5 1/4	12"	3	4	2 3/4	1 1/2	1 5/8	7 1/8	10-18"	3 1/2	5 1/2	3	3/4	1 1/2	6 1/4	7 1/2	13-18"	4	6 1/4	3 1/2	1 1/2	2 1/2	7	9	14-20"	5	7 1/2	4	1	2 1/8	8 3/4	10 1/4	17-48"	6	8 1/2	5	1 1/4	3 1/2	10	13 3/4	



MAKE OF LATHE	SWING	A	B	C	D	E

*To order tool holders see page 4 thru 25. *To order sets see pages 26 and 27.

*All Aloris Super Precision Quick Change Tool Posts are furnished with a completely machined "T" bolt to fit your machine at no charge. Please fill out chart and fax.

POSTS: REPLACEMENT PARTS

Not Interchangeable with Indexable Tool Post Parts.

"T" BOLTS						
ORDER #	AXA-TB*	BXA-TB*	CXA-TB*	CA-TB*	DA-TB*	EA-TB*


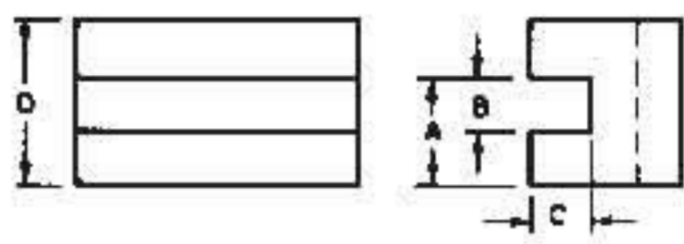

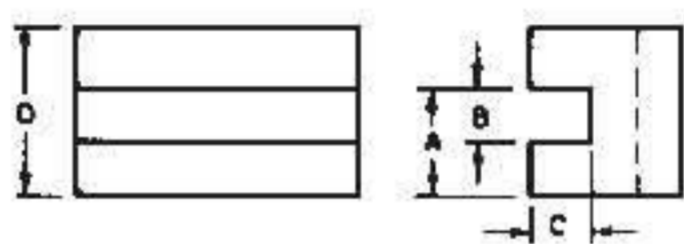

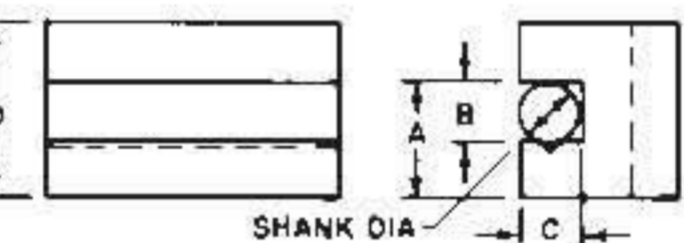

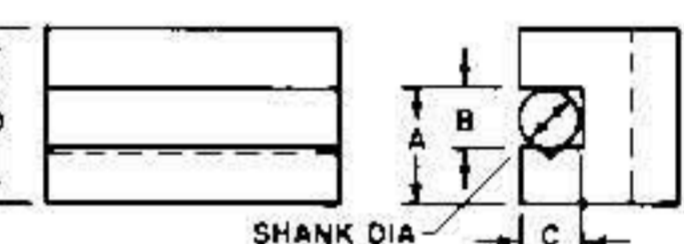

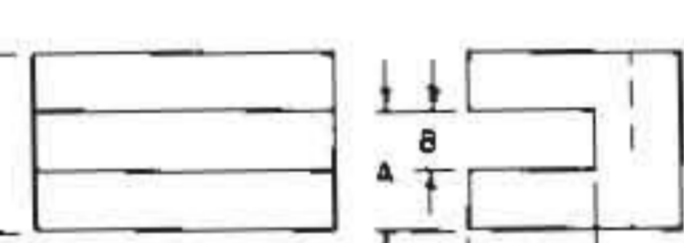

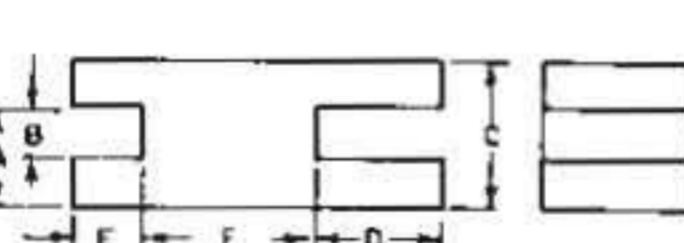

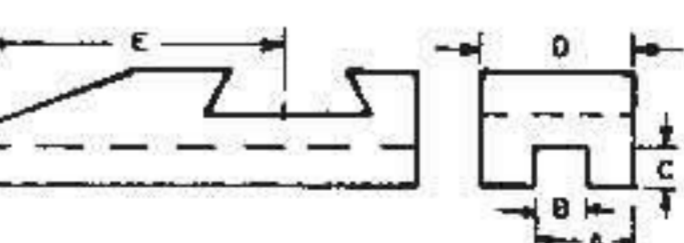

BALLS						
ORDER #	AXA-BALL*	BXA-BALL*	CXA-BALL*	CA-BALL*	DA-BALL*	EA-BALL*

HANDLES						
ORDER #	AXA-HDL*	BXA-HDL*	CXA-HDL*	CA-HDL*	DA-HDL*	EA-HDL*

FLANGE NUTS						
ORDER #	AXA-FN*	BXA-FN*	CXA-FN*	CA-FN*	DA-FN*	EA-FN*

QUICK CHANGE SHANK TOOL HOLDERS

AXA-AX SERIES

<p>#1</p> 	<p>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.</p>		<p>ORDER # AXA-1</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>Tool Bit</th> </tr> </thead> <tbody> <tr> <td>1⁵/₁₆</td> <td>1/2</td> <td>7/16</td> <td>1 1/2</td> <td>3/16-1/2</td> </tr> </tbody> </table>		A	B	C	D	Tool Bit	1 ⁵ / ₁₆	1/2	7/16	1 1/2	3/16-1/2				
A	B	C	D	Tool Bit														
1 ⁵ / ₁₆	1/2	7/16	1 1/2	3/16-1/2														
<p>#1S</p> 	<p>OVERSIZE TURNING AND FACING HOLDER Takes large sizes of bits. Turning and facing tools can be locked in together. Saves time and labor when changing operations. B dimension is oversize which allows larger tools to be used.</p>		<p>ORDER # AXA-1S</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>Tool Bit</th> </tr> </thead> <tbody> <tr> <td>1"</td> <td>3/8</td> <td>7/16</td> <td>1 1/2</td> <td>3/8 max</td> </tr> </tbody> </table>		A	B	C	D	Tool Bit	1"	3/8	7/16	1 1/2	3/8 max				
A	B	C	D	Tool Bit														
1"	3/8	7/16	1 1/2	3/8 max														
<p>#2</p> 	<p>BORING, TURNING AND FACING HOLDER "V" groove holds round shank boring bars and tools as well as square tool bits.</p>		<p>ORDER # AXA-2</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>Tool Bit</th> <th>Shank</th> </tr> </thead> <tbody> <tr> <td>1⁵/₁₆</td> <td>1/2</td> <td>7/16</td> <td>1 1/2</td> <td>3/16-1/2</td> <td>7/16</td> </tr> </tbody> </table>		A	B	C	D	Tool Bit	Shank	1 ⁵ / ₁₆	1/2	7/16	1 1/2	3/16-1/2	7/16		
A	B	C	D	Tool Bit	Shank													
1 ⁵ / ₁₆	1/2	7/16	1 1/2	3/16-1/2	7/16													
<p>#2S</p> 	<p>OVERSIZE BORING, TURNING AND FACING HOLDER "V" groove holds round shank boring bars and tools as well as square tool bits. B dimension is oversize which allows larger tools to be used.</p>		<p>ORDER # AXA-2S</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>Tool Bit</th> <th>Shank</th> </tr> </thead> <tbody> <tr> <td>1"</td> <td>3/8</td> <td>7/16</td> <td>1 1/2</td> <td>3/8 max</td> <td>1/2</td> </tr> </tbody> </table>		A	B	C	D	Tool Bit	Shank	1"	3/8	7/16	1 1/2	3/8 max	1/2		
A	B	C	D	Tool Bit	Shank													
1"	3/8	7/16	1 1/2	3/8 max	1/2													
<p>#6</p> 	<p>MULTIPLE TOOL HOLDER Versatile, ideal for repetitive work: for gang set-ups or form tool.</p>		<p>ORDER # AXA-6</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>Tool Bit</th> </tr> </thead> <tbody> <tr> <td>1"</td> <td>1/2</td> <td>1 1/8</td> <td>1 9/16</td> <td>1/4-1/2</td> </tr> </tbody> </table>		A	B	C	D	Tool Bit	1"	1/2	1 1/8	1 9/16	1/4-1/2				
A	B	C	D	Tool Bit														
1"	1/2	1 1/8	1 9/16	1/4-1/2														
<p>#9</p> 	<p>MULTI-PURPOSE HOLDER Ideal for multiple operations. Left or right turning and facing, working close to tail stock, form tool gang set-ups, etc. Extremely useful for short heavy duty boring or CNC gang tooling.</p>		<p>ORDER # AXA-9</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>E</th> <th>F</th> <th>Tool Bit</th> </tr> </thead> <tbody> <tr> <td>1⁵/₁₆</td> <td>3/8</td> <td>1 1/2</td> <td>1 7/8</td> <td>1"</td> <td>2 1/8</td> <td>3/16-3/8</td> </tr> </tbody> </table>		A	B	C	D	E	F	Tool Bit	1 ⁵ / ₁₆	3/8	1 1/2	1 7/8	1"	2 1/8	3/16-3/8
A	B	C	D	E	F	Tool Bit												
1 ⁵ / ₁₆	3/8	1 1/2	1 7/8	1"	2 1/8	3/16-3/8												
<p>#13 #13L</p> 	<p>EXTENSION TOOL HOLDER #13 & 13L A new addition to the versatile Aloris dovetail mounted quick-change tool holder series. The #13 provides an extremely rugged extended open slot featuring maximum rigidity for deep turning or facing operation. 13L - opposite hand.</p>		<p>ORDER # AXA-13</p> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>E</th> <th>Tool Bit</th> </tr> </thead> <tbody> <tr> <td>1⁵/₁₆</td> <td>1/2</td> <td>7/16</td> <td>1 1/2</td> <td>2 1/2</td> <td>3/16-1/2</td> </tr> </tbody> </table>	A	B	C	D	E	Tool Bit	1 ⁵ / ₁₆	1/2	7/16	1 1/2	2 1/2	3/16-1/2	<p>ORDER # AXA-13L</p>		
A	B	C	D	E	Tool Bit													
1 ⁵ / ₁₆	1/2	7/16	1 1/2	2 1/2	3/16-1/2													
<p>HEIGHT ADJUSTMENT ASSEMBLY</p> 		<p>ORDER # AXA-HA*</p>																
<p>TOOL HOLDER SET SCREWS (SET OF 4)</p>		<p>ORDER # AXA-SS*</p>																



BXA-BX SERIES					CXA-CX SERIES					CA SERIES					DA SERIES					EA SERIES												
ORDER # BXA-1					ORDER # CXA-1					ORDER # CA-1					ORDER # DA-1					ORDER # EA-1												
A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit								
1 1/8	5/8	1/2	1 3/4	1/4-5/8	1 7/16	3/4	5/8	2 1/8	1/2-3/4	1 11/16	1"	3/4	2 1/2	1/2-1"	2 3/16	1 1/4	1"	3 1/8	1/2-1 1/4	2 11/16	1 1/2	1 1/4	4"	3/4-1 1/2								
ORDER # BXA-1S					ORDER # CXA-1S					ORDER # CA-1S					ORDER # DA-1S																	
A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit													
1 3/16	3/4	1/2	1 3/4	3/4 max	1 9/16	1"	5/8	2 1/8	1" max	2"	1 1/4	3/4	2 1/2	1 1/4 max	2 5/16	1 1/2	1"	3 1/8	1 1/2 max													
ORDER # BXA-2					ORDER # CXA-2					ORDER # CA-2					ORDER # DA-2					ORDER # EA-2												
A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank			
1 1/8	5/8	1/2	1 3/4	1/4-5/8	1/2	1 7/16	3/4	5/8	2 1/8	1/2-3/4	3/4	1 11/16	1"	3/4	2 1/2	1/2-1"	1 9/16	2 3/16	1 1/4	1"	3 1/8	1/2-1 1/4	1"	2 1/16	1 1/2	1 1/4	4"	3/4-1 1/2	1 1/4			
ORDER # BXA-2S					ORDER # CXA-2S					ORDER # CA-2S					ORDER # DA-2S																	
A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank	A	B	C	D	Tool Bit	Shank									
1 3/16	3/4	1/2	1 3/4	3/4 max	5/8	1 9/16	1"	5/8	2 1/8	1" max	3/4	2"	1 1/4	3/4	2 1/2	1 1/4 max	1"	2 7/16	1 1/2	1"	3 1/8	1 1/2 max	1 1/4									
ORDER # BXA-6					ORDER # CXA-6					ORDER # CA-6					ORDER # DA-6					ORDER # EA-6												
A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit	A	B	C	D	Tool Bit			
1 1/16	1/2	1 9/16	1 3/4	1/4-1/2	1 5/16	5/8	1 7/16	2 1/8	3/8-5/8	1 9/16	3/4	1 7/8	2 1/2	1/2-3/4	2 1/8	1"	2 1/8	3 1/4	1/2-1"	2 5/8	1 1/4	2 5/8	4"	3/4-1 1/2								
ORDER # BXA-9					ORDER # CXA-9					ORDER # CA-9					ORDER # DA-9																	
A	B	C	D	E	F	Tool Bit	A	B	C	D	E	F	Tool Bit	A	B	C	D	E	F	Tool Bit	A	B	C	D	E	F	Tool Bit					
1 1/8	1/2	1 3/4	2 11/16	1 3/16	2 5/8	1/4-1/2	1 5/16	5/8	2"	3"	1 5/8	3 3/8	3/8-5/8	1 1/2	3/4	2 1/2	3 3/8	1 3/4	3 7/8	3/8-3/4	2"	1"	3"	4"	2 1/8	4 7/8	1/2-1"					
ORDER # BXA-13		ORDER # BXA-13L			ORDER # CXA-13		ORDER # CXA-13L			ORDER # CA-13		ORDER # CA-13L			ORDER # DA-13		ORDER # DA-13L			ORDER # EA-13		ORDER # EA-13L										
A	B	C	D	E	Tool Bit	A	B	C	D	E	Tool Bit	A	B	C	D	E	Tool Bit	A	B	C	D	E	Tool Bit	A	B	C	D	E	Tool Bit			
1 1/8	5/8	1/2	1 3/4	2 1/4	1/4-5/8	1 7/16	3/4	5/8	2 1/8	3 3/8	1/2-3/4	1 11/16	1"	3/4	2 1/2	3 3/4	1/2-1"	2 1/8	1 1/4	1"	3 1/8	5"	1/2-1 1/4	2 1/16	1 1/2	1 1/4	4"	6 1/2	3/4-1 1/2			
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*												
ORDER # BXA-SS*					ORDER # CXA-SS*					ORDER # CA-SS*					ORDER # DA-SS*					ORDER # EA-SS*												

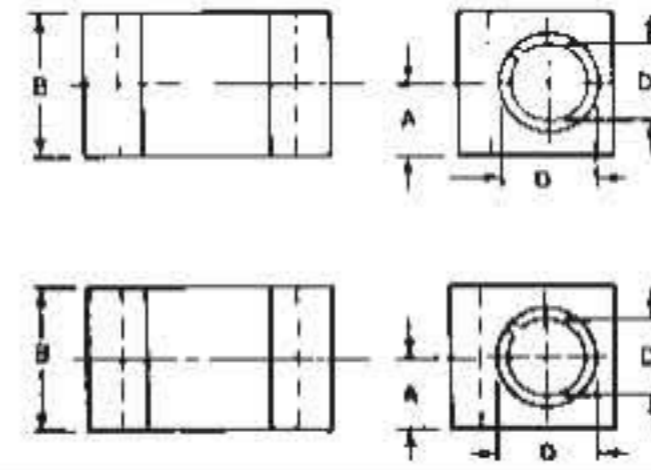
QUICK CHANGE BORING BAR TOOL HOLDERS

#4, #41



HEAVY DUTY BORING BAR HOLDER

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



PINS

(New Style) For Holders #4* - #41* (Set of 2)

JAM SCREWS

For Holders #4* - #41* (Set of 2)

AXA-AX SERIES

ORDER # AXA-4

A	B	D	D ₁
3/4	1 1/2	3/4	5/8

ORDER # AXA-41

A	B	D	D ₁
7/8	1 1/4	1"	3/4

ORDER # AXA-PINS*

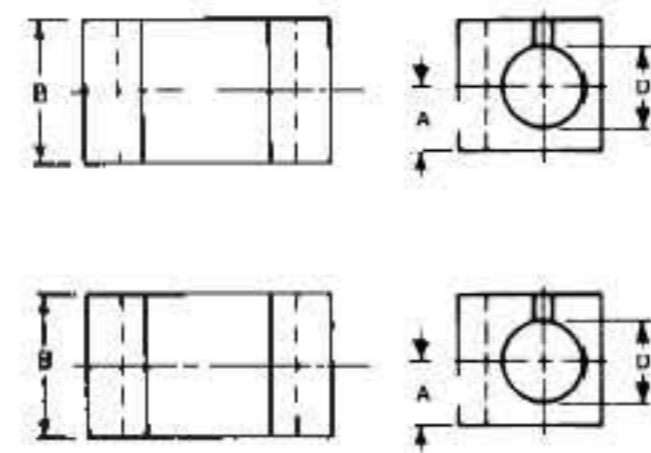
ORDER # AXA-JS*

#4D, #41D



BORING BAR HOLDER

Precision ground bore and split clamping design to accommodate excellent clamping pressure and the ability to adjust positive to negative cutting angle on boring bar. Bushings sold separately, see below.



ORDER # AXA-4D

A	B	D	
3/4	1 1/2	3/4	

ORDER # AXA-41D

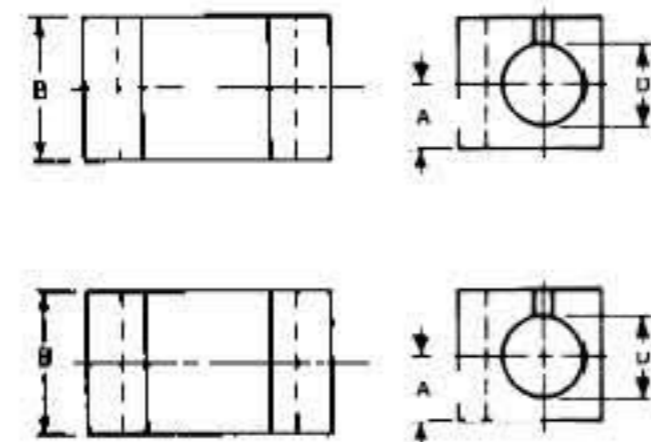
A	B	D	
7/8	1 1/4	1"	

#100, #104 & #141



BORING BAR HOLDER

Heavy duty boring bar holder with precision ground bore and set screw clamping to provide maximum rigidity and alignment of boring bars. Capacities listed in chart. Bushings sold separately, see below.



ORDER # AXA-100

A	B	D	
3/4	1 1/2	5/8	

ORDER # AXA-104

A	B	D	
3/4	1 1/2	3/4	

ORDER # AXA-141

A	B	D	
7/8	1 1/4	1"	

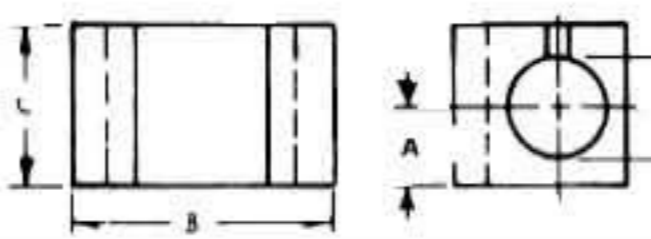
#42



BORING BAR HOLDER

A flick of the tool post handle locks both holder and boring bar. Precise alignment of boring bar is preset by means of a stop ring which is adjustable for both boring depth and cutting angle.

NOT FOR PISTON TYPE TOOL POST



STOP RINGS



HEIGHT ADJUSTMENT ASSEMBLY



BUSHINGS/STANDARD

ORDER # AXA-42

A	B	C	D
7/8	3"	1 1/4	3/4

ORDER # SR-1 (3/4 I.D.)*

ORDER # AXA-HA*

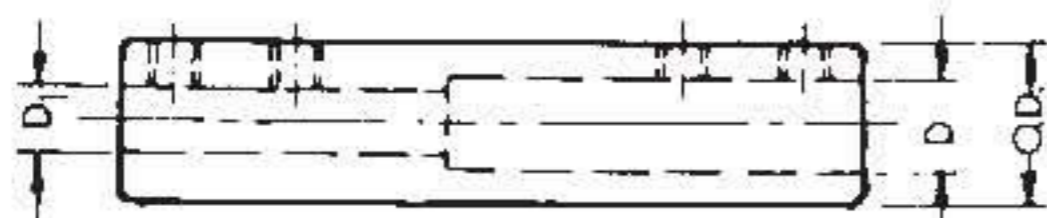
ORDER # AXA-STD*

BUSHINGS/SPECIAL (Non-returnable/cancelable item)

ORDER # AXA-SPL*

REDUCER BUSHINGS FOR BORING BAR TOOL HOLDERS

Designed to accommodate cutting tools of smaller shank diameters, such as drills, endmills, and small boring bars.



ORDERING INFORMATION	SIZES		
ORDER #	O.D.	D	D ₁
RB-31*	3/4	1/2	1/4
RB-32*	3/4	3/8	3/16
RB-41*	1"	5/8	3/16
RB-42*	1"	1/2	1/4
RB-51*	1 1/4	3/4	3/8
RB-52*	1 1/4	5/8	3/16



BXA-BX SERIES				CXA-CX SERIES				CA SERIES				DA SERIES				EA SERIES			
ORDER # BXA-4				ORDER # CXA-4				ORDER # CA-4				ORDER # DA-4				ORDER # EA-4			
A	B	D	D ₁	A	B	D	D ₁	A	B	D	D ₁	A	B	D	D ₁	A	B	D	D ₁
1"	2"	1"	¾"	1"	2"	1"	¾"	1⅜"	2¾"	1¼"	1"	1⅝"	3¼"	1½"	1¼"	2¼"	4½"	2½"	2"
ORDER # BXA-41				ORDER # CXA-41				ORDER # CA-41				ORDER # DA-41							
A	B	D	D ₁	A	B	D	D ₁	A	B	D	D ₁	A	B	D	D ₁				
1"	2"	1¼"	1"	1⅝"	2¼"	1¼"	1"	1⅜"	2¾"	1½"	1¼"	1¾"	3½"	2"	1½"				
ORDER # BXA-PINS*				ORDER # CXA-PINS*				ORDER # CA-PINS*				ORDER # DA-PINS*				ORDER # EA-PINS*			
ORDER # BXA-JS*				ORDER # CXA-JS*				ORDER # CA-JS*				ORDER # DA-JS*				ORDER # EA-JS*			
ORDER # BXA-4D				ORDER # CXA-4D				ORDER # CA-4D				ORDER # DA-4D				ORDER # EA-4D			
A	B	D		A	B	D		A	B	D		A	B	D		A	B	D	
1"	2"	1"		1"	2"	1"		1⅜"	2¾"	1¼"		1⅝"	3¼"	1½"		2¼"	4½"	2½"	
ORDER # BXA-41D				ORDER # CXA-41D				ORDER # CA-41D				ORDER # DA-41D							
A	B	D		A	B	D		A	B	D		A	B	D					
1"	2"	1¼"		1⅝"	2¼"	1¼"		1⅜"	2¾"	1½"		1¾"	3½"	2"					
ORDER # BXA-100				ORDER # CXA-100				ORDER # CA-100				ORDER # DA-100				ORDER # EA-100			
A	B	D		A	B	D		A	B	D		A	B	D		A	B	D	
1"	2"	¾"		1"	2"	¾"		1¼"	2½"	1"		1⅜"	2¾"	1¼"		1¾"	3½"	2"	
ORDER # BXA-104				ORDER # CXA-104				ORDER # CA-104				ORDER # DA-104				ORDER # EA-104			
A	B	D		A	B	D		A	B	D		A	B	D		A	B	D	
1"	2"	1"		1"	2"	1"		1¼"	2½"	1¼"		1½"	3"	1½"		2"	4"	2½"	
ORDER # BXA-141				ORDER # CXA-141				ORDER # CA-141				ORDER # DA-141				ORDER # EA-141			
A	B	D		A	B	D		A	B	D		A	B	D		A	B	D	
1"	2"	1¼"		1⅝"	2¼"	1¼"		1⅜"	2¾"	1½"		1¾"	3½"	2"		2¼"	4½"	3"	
ORDER # BXA-42				ORDER # CXA-42				ORDER # CA-42											
A	B	C	D	A	B	C	D	A	B	C	D								
⅞"	3"	1¼"	¾"	1"	3¾"	2"	1"	1⅝"	4¼"	2¼"	1"								
ORDER # SR-1 (¾ I.D.)*				ORDER # SR-2 (1" I.D.)*				ORDER # SR-2 (1" I.D.)*											
ORDER # BXA-HA*				ORDER # CXA-HA*				ORDER # CA-HA*				ORDER # DA-HA*				ORDER # EA-HA*			
ORDER # BXA-STD*				ORDER # CXA-STD*				ORDER # CA-STD*				ORDER # DA-STD*				ORDER # EA-STD*			
ORDER # BXA-SPL*				ORDER # CXA-SPL*				ORDER # CA-SPL*				ORDER # DA-SPL*				ORDER # EA-SPL*			




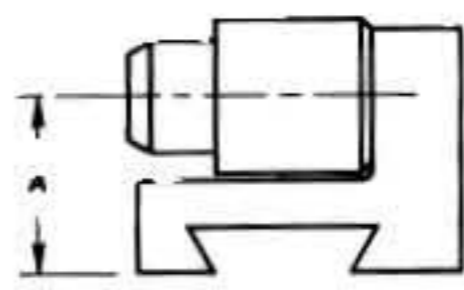

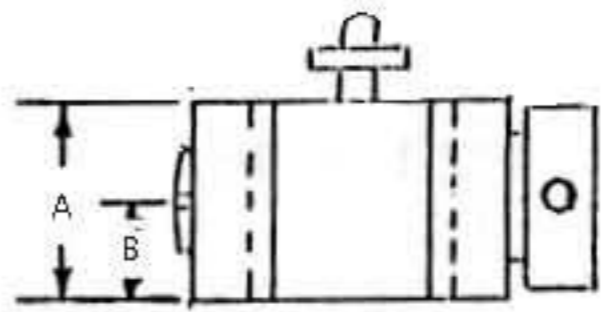

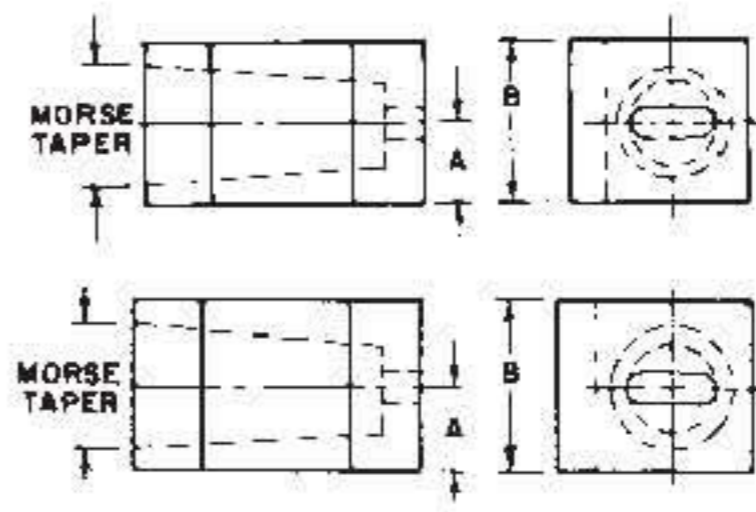

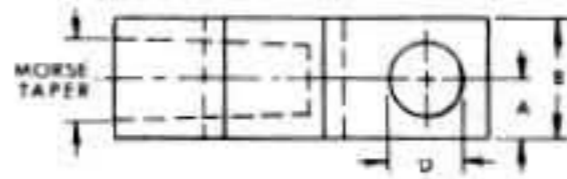

ALORIS TOOL TECHNOLOGY CO., INC.

397-407 GETTY AVENUE • P.O. BOX 1529 • CLIFTON, NJ 07015-1529
 TEL: 973.772.1201 • FAX: 973.772.8606
 E-MAIL: aloris@aloris.com • WEBSITE: <http://www.aloris.com>
ORDER ONLINE: www.aloris.com



*The originator of
quick change tooling*

QUICK CHANGE DRILLING HOLDERS

				AXA-AX SERIES				
#35		DOVETAIL CHUCK HOLDER The uniquely designed dovetail chuck holder permits quick and accurate mounting of drills, reamers, taps, boring bars, etc., and feed by means of your lathe's carriage power drive—it eliminates tailstock mounting and tailstock drive. The Aloris chuck holder offers all of the quick-change, repeat positioning accuracy and high-rigidity features found in all Aloris precision dovetail holders. The chuck is mounted in a recessed position for minimum overhang, permitting use of the entire usable length of the tool. Available in capacities up to 3/4-in. Dovetail holder supplied complete with chuck and key.		ORDER # AXA-35				
				A	CHUCK CAPACITY			
2	0 - 1/2							
#5C		5C COLLET HOLDER Can be used with a variety of shank tools: drills, reamers, C. bores, taps, end mills, boring bars and other tools. Collet not included.		ORDER # AXA-5C				
				A	B	COLLET SIZE		
1 7/8	1 5/16	5C						
#5, #53, #54, #55		MORSE TAPER HOLDER Drills with carriage by using power feed instead of tail stock. Easily centered.		ORDER # AXA-5				
				A	B	TAPER HOLE SIZE		
3/4	1 1/2	#2 M.T.						
				ORDER # AXA-53				
				A	B	TAPER HOLE SIZE		
3/4	1 1/2	#3 M.T.						
#21		DRILLING & BORING HOLDER Combines drilling and boring operations in a single unit. Used with the Aloris super precision tool post, the holder is simply switched – in seconds – from one dovetail to the other. Repeat positioning accuracy of .0001 inch is assured at all setting and adjustment points. A standard Morse Taper accommodates a wide range of drill diameters, permitting drilling by carriage and power feed instead of tailstock. The boring bar, reamer, tap or other straight shank tool can be quickly released and removed from the holder.		ORDER # AXA-21				
				A	B	D	TAPER HOLE SIZE	
7/8	1 3/4	3/4	#3 M.T.					
HEIGHT ADJUSTMENT ASSEMBLY				ORDER # AXA-HA*				

#44 BREECH-LOADING TAPER SOCKETS AND HOLDERS

...offers all of the advantages of the well known series 42 quick-change super-precision boring bar holder; with the addition of a gravity latch which allows the holder to accept the new breech-loading AMS Morse taper sockets shown below.

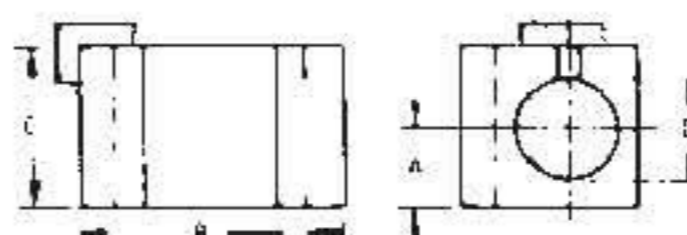
The latch provides positioning accuracy, prevents turning of the taper socket, and assures rigidity. The breech or back-end loading feature of the AMS Morse taper socket, reduces tool changeover time because the cross-slide remains fixed, eliminating re-centering.

The latch does not interfere with the holder's ability to accept Aloris series BB__ boring bars, with or without keyed lock stop rings, or any round shank tools.

A flick of the Aloris tool post handle locks both the holder and taper socket (or boring bar) in working position in one fast operation. Precise height adjustment is set and locked by means of a knurled stop and lock-nut on the holder, and positive repeat positioning accuracy to within 0.0001 inches is assured. Breech-loading taper sockets and holders shown on page 9.

NOT FOR PISTON TYPE TOOL POST

ORDER # CXA-44				ORDER # CA-44			
A	B	C	D	A	B	C	D
1"	3 3/4"	2"	1"	1 1/8"	4 1/4"	2 1/4"	1"



series 44 holders



BXA-BX SERIES				CXA-CX SERIES				CA SERIES				DA SERIES				EA SERIES			
ORDER # BXA-35				ORDER # CXA-35				ORDER # CA-35				ORDER # DA-35							
A	CHUCK CAPACITY			A	CHUCK CAPACITY			A	CHUCK CAPACITY			A	CHUCK CAPACITY						
2	0 – 1/2			2 9/16	0 – 1/2			2 9/16	3/16 – 3/4			2 13/16	3/16 – 3/4						
ORDER # BXA-5C				ORDER # CXA-5C				ORDER # CA-5C				ORDER # DA-5C							
A	B	COLLET SIZE		A	B	COLLET SIZE		A	B	COLLET SIZE		A	B	COLLET SIZE					
1 1/8	1 5/16	5C		2"	1"	5C		2 1/4	1 1/8	5C		3"	1 1/2	5C					
ORDER # BXA-5				ORDER # CXA-5				ORDER # CA-5				ORDER # DA-5				ORDER # EA-5			
A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE	
7/8	1 3/4	#2 M.T.		1"	2"	#3 M.T.		1 1/4	2 1/2	#3 M.T.		1 1/8	3 3/8	#4 M.T.		1 1/8	3 1/4	#5 M.T.	
ORDER # BXA-53				ORDER # CXA-54				ORDER # CA-54				ORDER # DA-55							
A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE		A	B	TAPER HOLE SIZE					
7/8	1 3/4	#3 M.T.		1 1/8	2 1/8	#4 M.T.		1 1/4	2 1/2	#4 M.T.		1 1/8	3 1/4	#5 M.T.					
ORDER # BXA-21				ORDER # CXA-21				ORDER # CA-21											
A	B	D	TAPER HOLE SIZE	A	B	D	TAPER HOLE SIZE	A	B	D	TAPER HOLE SIZE								
7/8	1 3/4	3/4	#3 M.T.	1"	2"	1"	#3 M.T.	1 1/8	2 1/4	1"	#4 M.T.								
ORDER # BXA-HA*				ORDER # CXA-HA*				ORDER # CA-HA*				ORDER # DA-HA*				ORDER # EA-HA*			

BREECH-LOADING TAPER SOCKETS AND HOLDERS

...designed to accept drills, reamers, taps, etc. with Morse taper shanks. Permits rapid interchanging of the two tools without disengaging the tapers, and without moving the cross-slide. The socket is notched at one-inch intervals so that machining depth can be repeated accurately from piece to piece. The gravity latch on the series 44 engages with the selected bar notch to assure accurate positioning and to prevent the bar from turning.

ORDER #	O.D.	MORSE TAPER
AMS-2	1"	#2



series AMS
breech-loading
Morse taper sockets

UNIVERSAL TOOL HOLDERS #20, #30, #22

FOR RIGHT OR LEFT HAND TURNING, FACING, CHAMFERING AND BORING (#22)

A unique design for models #20 & #30 holders provides for many angular turning, contouring and chamfering operations. The cartridge has 12 indexing positions at 15° intervals. See illustration below.

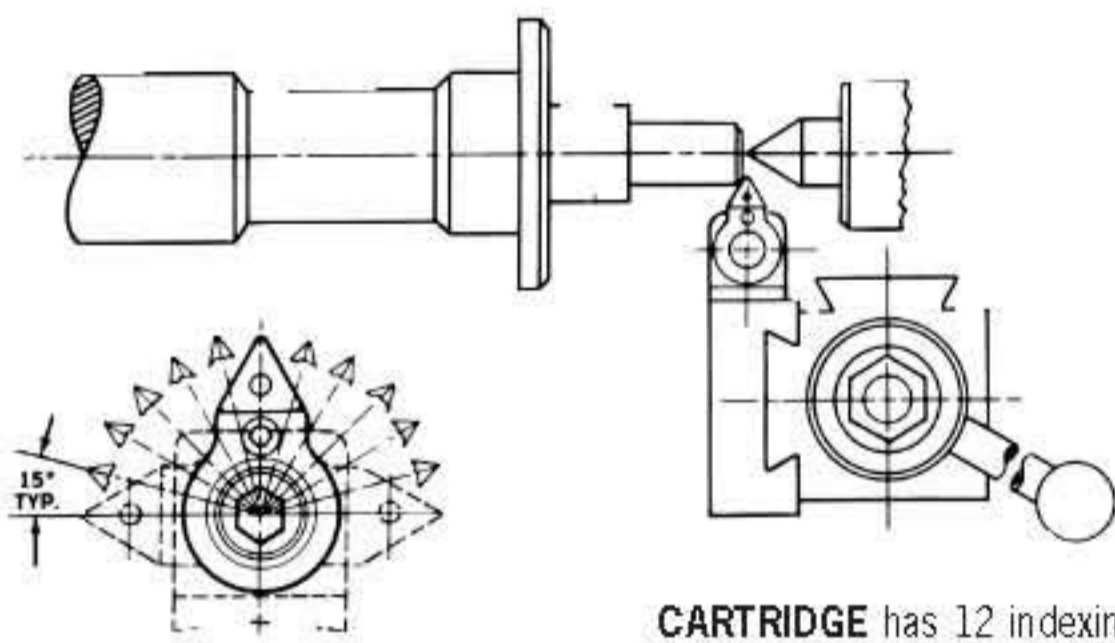
The model #22 with its two dovetail design leads to a wide range of applications by permitting front and rear turning, contouring, boring and facing operations.

All holders assure proper cutting edge and clearance angles at all indexing points.



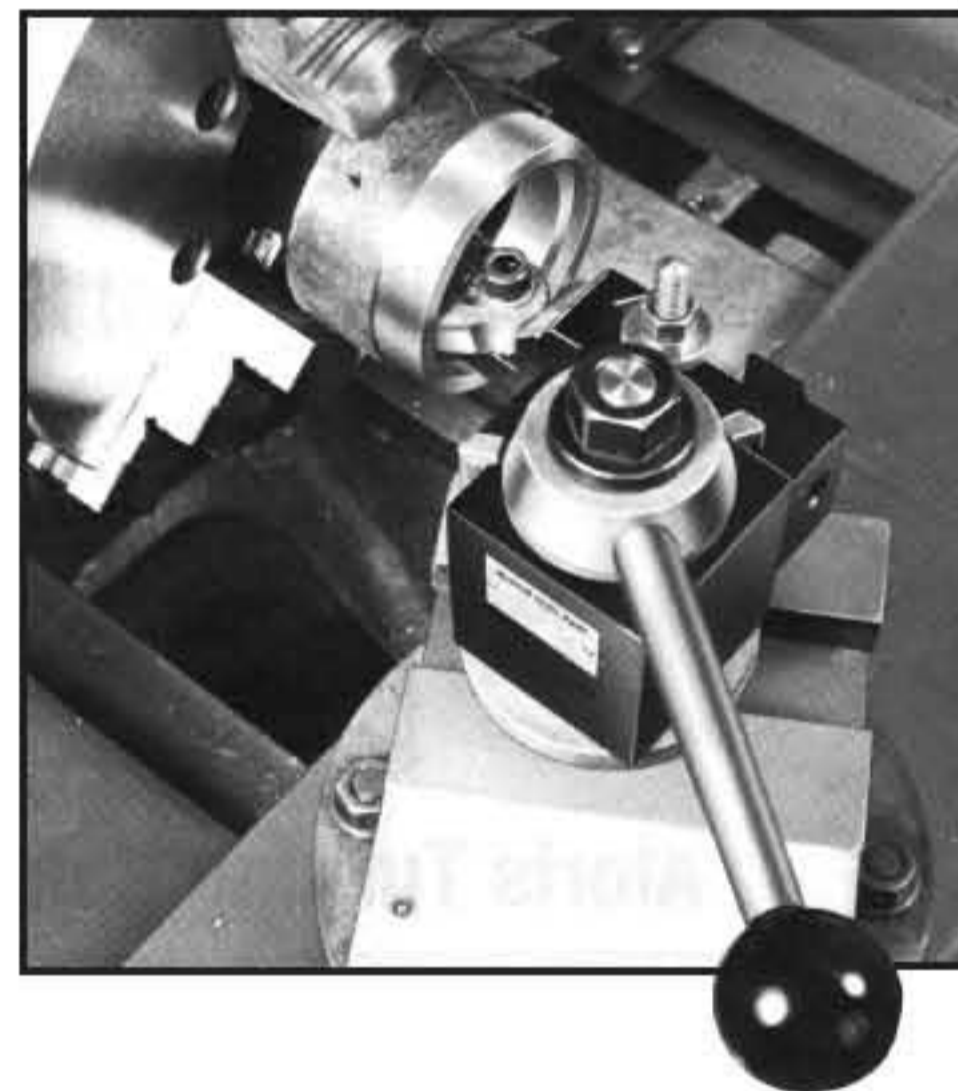
Tool Steel Cartridge adjusts every 15° for right or left hand turning, facing or chamfering. 12 positive lock positions. Exclusive positive lock with 2-way force holding insert down and tight against shoulder. Standard triangular carbide insert has 6 cutting edges.

ILLUSTRATIONS SHOW WHAT ONE SINGLE TOOL CAN ACCOMPLISH



PICTORIAL DIAGRAM OF CARTRIDGE

CARTRIDGE has 12 indexing positions at 15° intervals. This means many angular turning and chamfering jobs can be done faster and easier.



CARTRIDGE CRT-20, CRT-30, CRT-40 UNITS

Standard triangular carbide insert has 6 cutting edges.



Exclusive positive lock with 2-way force holding insert down and tight against shoulder.

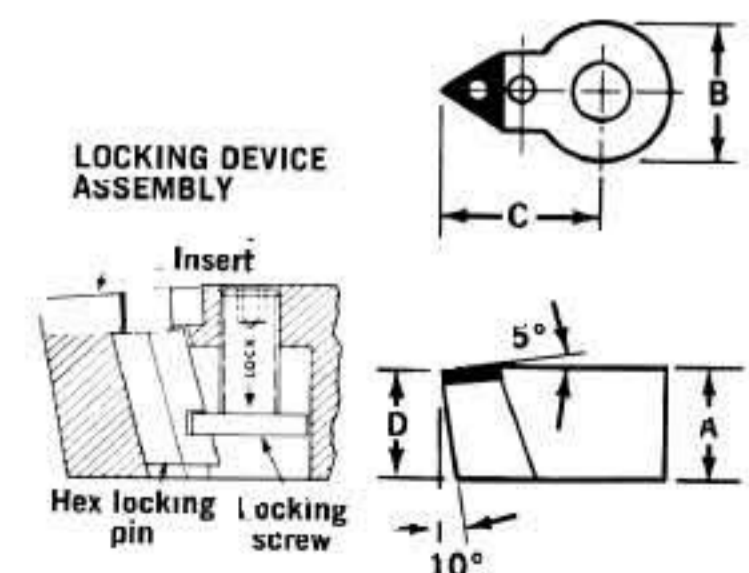
Tool Steel Cartridge adjuster every 15° for right or left hand turning facing or chamfering. 12 positive lock positions.

Can be easily adapted on bars, other special tools, to meet any customer's specifications. Cartridges can be supplied separately or combined with cartridge cradle.




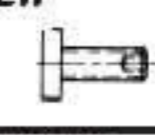

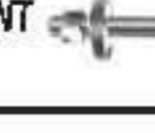


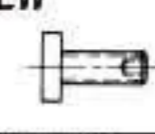





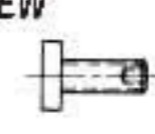

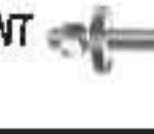
CARTRIDGE ORDER #	DIMENSIONS				INSERT SIZE	
	A	B	C	D	I.C.	THICK
CRT-20*	5/8"	1"	1 1/8"	9/16"	3/8"	1/8" - 3/16"
CRT-30*	7/8"	1 1/4"	1 11/16"	25/32"	1/2"	3/16" - 1/4"
CRT-40*	1"	1 1/4"	1 13/16"	15/16"	5/8"	1/4" - 5/16"

Choose from carbide style TNMS, TNMP, or TNMG. See page 38.

Cartridge CRT-30 and CRT-40 are interchangeable.



ORDERING INFORMATION FOR #20, #30, #22

	AXA-AX SERIES	BXA-BX SERIES	CXA-CX SERIES	CA SERIES	DA SERIES	EA SERIES
UNIVERSAL TOOL HOLDER #20 Holder supplied as shown less insert. 	ORDER # AXA-20	ORDER # BXA-20	ORDER # CXA-20	ORDER # CA-20		
	"A" DIM. = 1½	"A" DIM. = 1¾	"A" DIM. = 2"	"A" DIM. = 2½		
	"E" DIM. = 1¾	"E" DIM. = 1⅝	"E" DIM. = 1¾	"E" DIM. = 1¾		
	REPLACEMENT PARTS					
	CARTRIDGES 	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	
CRADLE 	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*		
LOCK SCREW 	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*		
HEX LOCKING PIN 	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*		
HEIGHT ADJUSTMENT ASSEMBLY 	ORDER # AXA-HA*	ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*		
UNIVERSAL TOOL HOLDER #30 				ORDER # CA-30	ORDER # DA-30	ORDER # EA-30
				"A" DIM. = 2½	"A" DIM. = 2¾	"A" DIM. = 3
				"E" DIM. = 1¾	"E" DIM. = 1⅝	"E" DIM. = 2⅜
	REPLACEMENT PARTS					
	CARTRIDGES 				ORDER # CRT-30*	ORDER # CRT-30*
LOCK SCREW 				ORDER # LS-30*	ORDER # LS-30*	ORDER # LS-40*
HEX LOCKING PIN 				ORDER # LP-30*	ORDER # LP-30*	ORDER # LP-40*
HEIGHT ADJUSTMENT ASSEMBLY 				ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*
UNIVERSAL TURNING & BORING HOLDER #22 	ORDER # AXA-22	ORDER # BXA-22	ORDER # CXA-22	ORDER # CA-22	ORDER # DA-22	ORDER # EA-22
	"A" DIM. = 1½	"A" DIM. = 1¾	"A" DIM. = 2"	"A" DIM. = 2½	"A" DIM. = 2¾	"A" DIM. = 3
	"E" DIM. = 1¾	"E" DIM. = 1⅝	"E" DIM. = 1¾	"E" DIM. = 1¾	"E" DIM. = 2	"E" DIM. = 2½
	MIN BORE DIM. = 2¼	MIN BORE DIM. = 2½	MIN BORE DIM. = 3	MIN BORE DIM. = 3½	MIN BORE DIM. = 4¼	MIN BORE DIM. = 5
	MAX BORE LENGTH = 2¼	MAX BORE LENGTH = 2¼	MAX BORE LENGTH = 2½	MAX BORE LENGTH = 2½	MAX BORE LENGTH = 3½	MAX BORE LENGTH = 4
	REPLACEMENT PARTS					
CARTRIDGES 	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-30*	ORDER # CRT-30*	ORDER # CRT-40*
CRADLE 	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-30*	ORDER # CC-30*	
LOCK SCREW 	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-30*	ORDER # LS-30*	ORDER # LS-40*
HEX LOCKING PIN 	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-30*	ORDER # LP-30*	ORDER # LP-40*
HEIGHT ADJUSTMENT ASSEMBLY 	ORDER # AXA-HA*	ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*

QUICK CHANGE CARBIDE INSERT CUTTING TOOLS WITH ADJUSTABLE CHIPBREAKER

#12



TURNING HOLDER FOR CARBIDE TRIANGULAR INSERTS

Accommodates standard triangular carbide insert **positive** rake. Furnished with fully adjustable carbide chipbreaker and carbide shim to protect the holder.

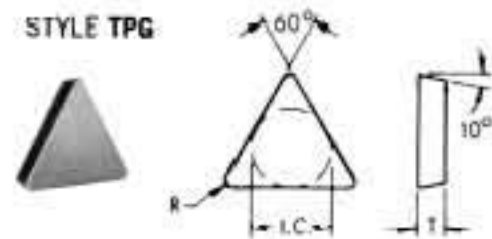


REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



R

REPLACEMENT CARBIDE SHIM

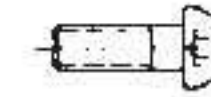


ORDER #	DIMENSIONS		
	I.C.	T	R
TPG-322*	3/8	1/8	1/32
TPG-432*	1/2	3/16	1/32

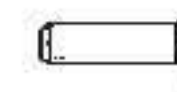
Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

CLAMP SCREW FOR CHIPBREAKER



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-12

A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE
7/8	1 3/8	3/8	1/8	POS.

ORDER # 1-R*

ORDER # SM-41*

ORDER # TPG-322†

GRADE

A2/A6

767

ORDER # SCR-12*

ORDER # SM-41SS*

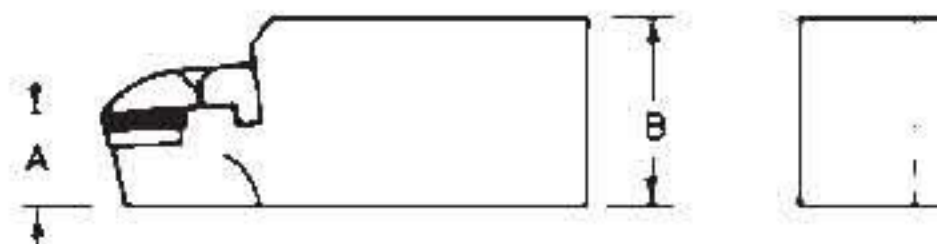
ORDER # AXA-HA*

#12N



TURNING HOLDER FOR CARBIDE TRIANGULAR INSERTS

Accommodates standard triangular carbide insert **negative** rake. Furnished with fully adjustable carbide chipbreaker and carbide shim to protect the holder.

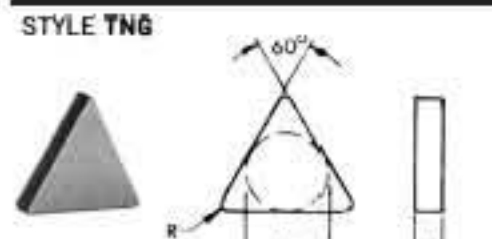


REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



R

REPLACEMENT CARBIDE SHIM

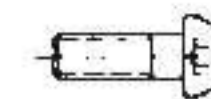


ORDER #	DIMENSIONS		
	I.C.	T	R
TNG-321*	3/8	1/8	1/32
TNG-432*	1/2	3/16	1/32
TNG-544*	5/8	1/4	1/16

Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

CLAMP SCREW FOR CHIPBREAKER



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXA-12N

A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE
7/8	1 3/8	3/8	1/8	NEG.

ORDER # 1-R*

ORDER # SM-42*

ORDER # TNG-321†

GRADE

A2/A6

767

ORDER # SCR-12*

ORDER # SM-42SS*

ORDER # AXA-HA*

†Sold in package of 10 pcs.



BXA-BX SERIES					CXA-CX SERIES					CA SERIES					DA SERIES					EA SERIES				
ORDER # BXA-12					ORDER # CXA-12					ORDER # CA-12					ORDER # DA-12					ORDER # EA-12				
A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE
1"	1¾"	⅜"	⅛"	POS.	1⅜"	2"	⅜"	⅛"	POS.	1½"	2¼"	½"	⅜"	POS.	1¾"	2⅞"	½"	⅜"	POS.	2⅞"	3½"	½"	⅜"	POS.
ORDER # 1-R*					ORDER # 1-R*					ORDER # 2-R*					ORDER # 2-R*					ORDER # 2-R*				
ORDER # SM-41*					ORDER # SM-41*					ORDER # SM-37*					ORDER # SM-37*					ORDER # SM-37*				
ORDER # TPG-322 [†]					ORDER # TPG-322 [†]					ORDER # TPG-432 [†]					ORDER # TPG-432 [†]					ORDER # TPG-432 [†]				
GRADE					GRADE					GRADE					GRADE					GRADE				
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6				
767					767					767					767					767				
ORDER # SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*				
ORDER # SM-41SS*					ORDER # SM-41SS*					ORDER # SM-37SS*					ORDER # SM-37SS*					ORDER # SM-37SS*				
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*				
ORDER # BXA-12N					ORDER # CXA-12N					ORDER # CA-12N					ORDER # DA-12N					ORDER # EA-12N				
A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE
1"	1¾"	⅜"	⅛"	NEG.	1⅜"	2"	⅜"	⅛"	NEG.	1½"	2¼"	½"	⅜"	NEG.	1¾"	2⅞"	½"	⅜"	NEG.	2⅞"	3½"	⅝"	¼"	NEG.
ORDER # 1-R*					ORDER # 1-R*					ORDER # 2-R*					ORDER # 2-R*					ORDER # 3-R*				
ORDER # SM-42*					ORDER # SM-42*					ORDER # SM-26*					ORDER # SM-26*					ORDER # SM-72*				
ORDER # TNG-321 [†]					ORDER # TNG-321 [†]					ORDER # TNG-432 [†]					ORDER # TNG-432 [†]					ORDER # TNG-544 [†]				
GRADE					GRADE					GRADE					GRADE					GRADE				
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6				
767					767					767					767					767				
ORDER # SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*				
ORDER # SM-42SS*					ORDER # SM-42SS*					ORDER # SM-26SS*					ORDER # SM-26SS*					ORDER # SM-72SS*				
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*				

[†]Sold in package of 10 pcs.

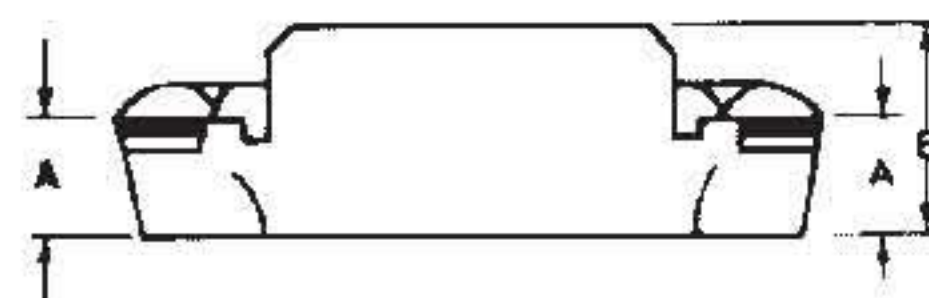
QUICK CHANGE COMBINATION CARBIDE INSERT CUTTING TOOLS WITH ADJUSTABLE CHIPBREAKER

#16



COMBINATION TURNING AND FACING HOLDER FOR CARBIDE TRIANGULAR INSERTS

Accommodates standard triangular **positive** rake carbide inserts. Unique design permits both right hand and left hand turning and facing. Supplied with fully adjustable carbide chipbreakers and carbide shims to protect the holder.



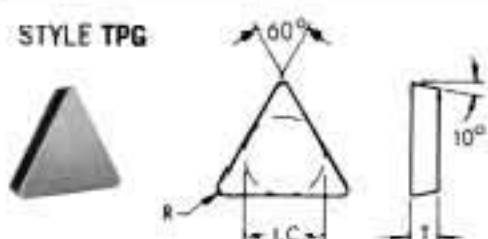
REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT



STYLE TPG



ORDER #	DIMENSIONS		
	I.C.	T	R
TPG-322*	3/8	1/8	1/32
TPG-432*	1/2	3/16	1/32

Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

BUTTON HEAD CHIPBREAKER/CLAMP SCREW 2 REQ'D/HOLDER



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-16

A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE
7/8	1 3/8	3/8	1/8	POS.

ORDER # 1-R*
ORDER # 1-L*

ORDER # SM-41*

ORDER # TPG-322†

GRADE

A2/A6

767

ORDER # SCR-12*

ORDER # SM-41SS*

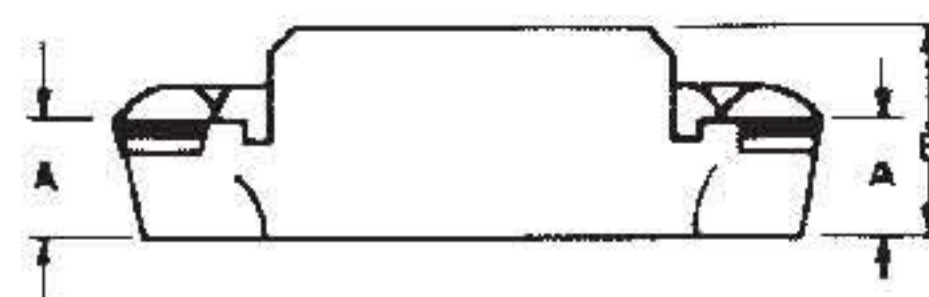
ORDER # AXA-HA*

#16N



COMBINATION TURNING AND FACING HOLDER FOR CARBIDE TRIANGULAR INSERTS

Accommodates standard triangular **negative** rake carbide inserts. Unique design permits both right hand and left hand turning and facing. Supplied with fully adjustable carbide chipbreakers and carbide shims to protect the holder.



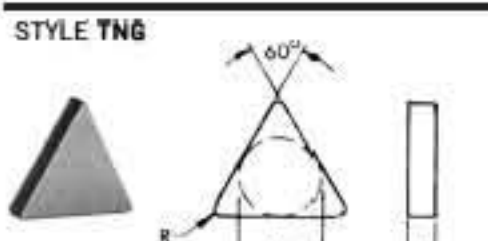
REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT



STYLE TNG

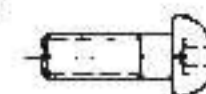


ORDER #	DIMENSIONS		
	I.C.	T	R
TNG-321*	3/8	1/8	1/32
TNG-432*	1/2	3/16	1/32
TNG-544*	5/8	1/4	1/16

Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

BUTTON HEAD CHIPBREAKER/CLAMP SCREW



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXA-16N

A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE
7/8	1 3/8	3/8	1/8	NEG.

ORDER # 1-R*
ORDER # 1-L*

ORDER # SM-42*

ORDER # TNG-321†

GRADE

A2/A6

767

ORDER # SCR-12*

ORDER # SM-42SS*

ORDER # AXA-HA*

*Sold in package of 10 pcs.



BXA-BX SERIES					CXA-CX SERIES					CA SERIES					DA SERIES					EA SERIES				
ORDER # BXA-16					ORDER # CXA-16					ORDER # CA-16					ORDER # DA-16					ORDER # EA-16				
A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE
1"	1¾"	⅜"	⅛"	POS.	1⅜"	2"	⅜"	⅛"	POS.	1½"	2¼"	½"	⅜"	POS.	1¾"	2⅞"	½"	⅜"	POS.	2⅞"	3½"	½"	⅜"	POS.
ORDER # 1-R* ORDER # 1-L*					ORDER # 1-R* ORDER # 1-L*					ORDER # 2-R* ORDER # 2-L*					ORDER # 2-R* ORDER # 2-L*					ORDER # 2-R* ORDER # 2-L*				
ORDER # SM-41*					ORDER # SM-41*					ORDER # SM-37*					ORDER # SM-37*					ORDER # SM-37*				
ORDER # TPG-322 [†]					ORDER # TPG-322 [†]					ORDER # TPG-432 [†]					ORDER # TPG-432 [†]					ORDER # TPG-432 [†]				
GRADE					GRADE					GRADE					GRADE					GRADE				
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6				
767					767					767					767					767				
ORDER # SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*				
ORDER # SM-41SS*					ORDER # SM-41SS*					ORDER # SM-37SS*					ORDER # SM-37SS*					ORDER # SM-37SS*				
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*				
ORDER # BXA-16N					ORDER # CXA-16N					ORDER # CA-16N					ORDER # DA-16N					ORDER # EA-16N				
A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE
1"	1¾"	⅜"	⅛"	NEG.	1⅜"	2"	⅜"	⅛"	NEG.	1½"	2¼"	½"	⅜"	NEG.	1¾"	2⅞"	½"	⅜"	NEG.	2⅞"	3½"	⅝"	¼"	NEG.
ORDER # 1-R* ORDER # 1-L*					ORDER # 1-R* ORDER # 1-L*					ORDER # 2-R* ORDER # 2-L*					ORDER # 2-R* ORDER # 2-L*					ORDER # 3-R* ORDER # 3-L*				
ORDER # SM-42*					ORDER # SM-42*					ORDER # SM-26*					ORDER # SM-26*					ORDER # SM-72*				
ORDER # TNG-321 [†]					ORDER # TNG-321 [†]					ORDER # TNG-432 [†]					ORDER # TNG-432 [†]					ORDER # TNG-544 [†]				
GRADE					GRADE					GRADE					GRADE					GRADE				
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6				
767					767					767					767					767				
ORDER # SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*				
ORDER # SM-42SS*					ORDER # SM-42SS*					ORDER # SM-26SS*					ORDER # SM-26SS*					ORDER # SM-72SS*				
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*				

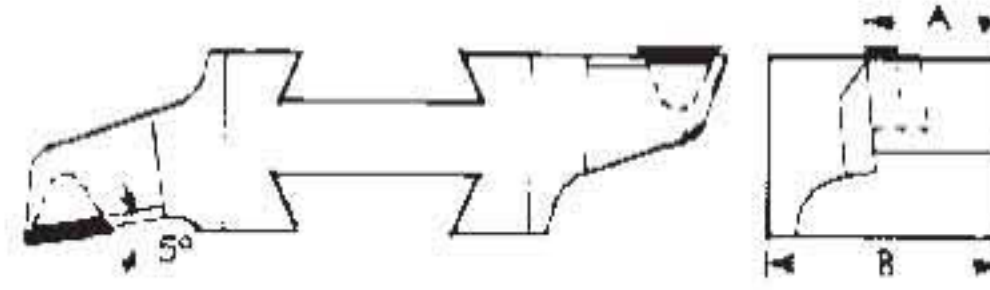
QUICK CHANGE CARBIDE INSERT CUTTING TOOLS

#23



TURNING AND FACING HOLDER

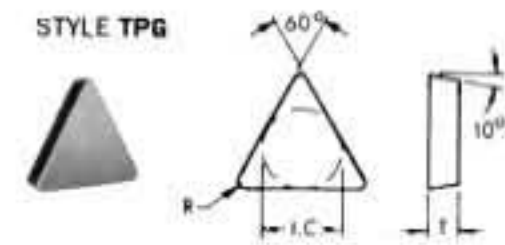
A combination holder with quick-reversibility. Position #1, with no offset and Position #2, with 5° offset; provides smooth, chatter-free turning and facing. Holder accommodates standard triangular **positive** rake inserts. Supplied with fully adjustable carbide chip breakers and shims to protect the holder.



REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT

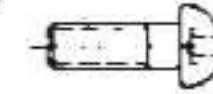


ORDER #	DIMENSIONS		
	I.C.	T	R
TPG-322*	3/8	1/8	1/32
TPG-432*	1/2	3/16	1/32

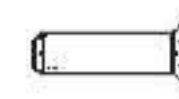
Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

BUTTON HEAD CHIPBREAKER/CLAMP SCREW



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-23

A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE
7/8	1 3/8	3/8	1/8	POS.

ORDER # 1-R*

ORDER # SM-41*

ORDER # TPG-322

GRADE

A2/A6

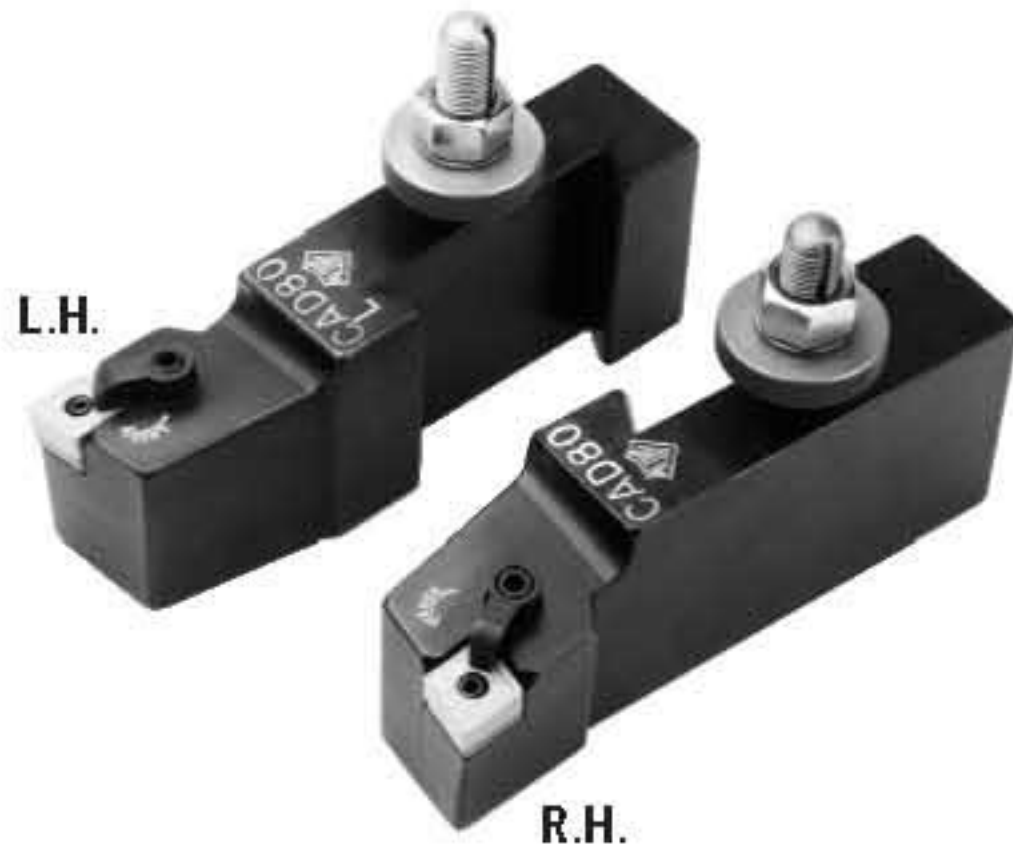
767

ORDER # SCR-12*

ORDER # SM-41SS*

ORDER # AXA-HA*

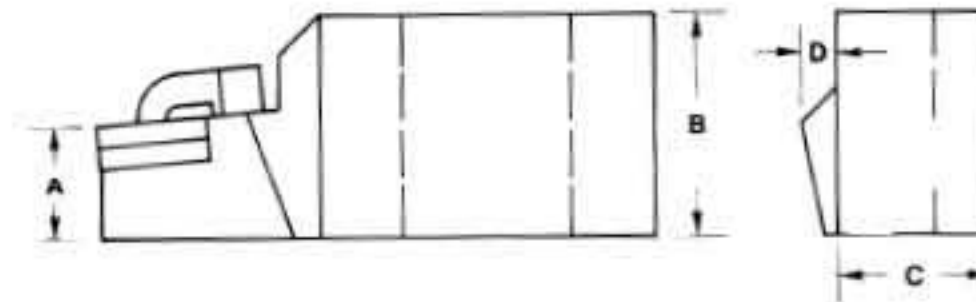
#80 & #80L



80° DIAMOND TURNING AND FACING TOOL

Aloris Series D80 and D80L dovetail holders accommodate all varieties of standard 80° diamond shaped carbide inserts — positive, negative or neutral rake and either left or right lead angle. Inserts are not supplied.

They are designed for use with Aloris quick change tool posts and allow turning and facing operations without removing the holder from the tool post. Repeat positioning accuracy within millionths is assured when used with Aloris tool posts.



SHIMS



PINS



80° CARBIDE INSERTS

ORDER NUMBER	DIMENSIONS			
	I.C.	H	R	T
CNMG-432*	1/2	.203	1/32	3/16
CNMG-543*	5/8	.250	3/64	1/4
CNMG-643*	3/4	.312	3/64	1/4

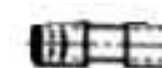
Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

CLAMP



CLAMP SCREW



HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXAD-80

ORDER # AXAD-80L

A	B	C	D	IC
1"	1 1/2	1 1/16	3/16	1/2

ORDER # SM-303*

ORDER # LP-56*

ORDER # CNMG-432

GRADE

A2/A6

767

ORDER # ACK-21*

ORDER # ASTC-20*

ORDER # AXA-HA*

See full selection of inserts on pages 49 - 54.



BXA-BX SERIES					CXA-CX SERIES					CA SERIES					DA SERIES					EA SERIES									
ORDER # BXA-23					ORDER # CXA-23					ORDER # CA-23																			
A	B	TRIANGULAR INSERT			POS.	A	B	TRIANGULAR INSERT			POS.	A	B	TRIANGULAR INSERT			POS.	A	B	TRIANGULAR INSERT			POS.	A	B	TRIANGULAR INSERT			POS.
		I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE							
1"	1 3/4"	3/8"	1/8"		1 3/16"	2"	3/8"	1/8"			1 1/2"	2 1/4"	1/2"	3/16"															
ORDER # 1-R*					ORDER # 1-R*					ORDER # 2-R*																			
ORDER # SM-41*					ORDER # SM-41*					ORDER # SM-37*																			
ORDER # TPG-322 [†]					ORDER # TPG-322 [†]					ORDER # TPG-432 [†]																			
GRADE					GRADE					GRADE																			
A2/A6					A2/A6					A2/A6																			
767					767					767																			
ORDER # SCR-12*					ORDER #: SCR-12*					ORDER #: SCR-12*																			
ORDER # SM-41SS*					ORDER # SM-41SS*					ORDER # SM-37SS*																			
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*																			
ORDER # BXAD-80		ORDER # BXAD-80L			ORDER # CXAD-80		ORDER #CXAD-80L			ORDER # CAD-80		ORDER # CAD-80L			ORDER # DAD-80		ORDER # DAD-80L			ORDER # EAD-80		ORDER # EAD-80L							
A	B	C	D	IC	A	B	C	D	IC	A	B	C	D	IC	A	B	C	D	IC	A	B	C	D	IC					
1 1/16"	1 5/8"	1 1/4"	3/16"	1/2"	1 1/16"	2"	1 1/4"	3/16"	1/2"	1 9/16"	2 1/4"	1 3/8"	3/8"	5/8"	1 3/4"	2 7/8"	1 9/16"	3/8"	5/8"	2 3/8"	3 1/2"	2"	3/8"	3/4"					
ORDER # SM-303*					ORDER # SM-303*					ORDER # SM-390*					ORDER # SM-390*					ORDER # SM-304*									
ORDER # LP-56*					ORDER # LP-57*					ORDER # LP-67*					ORDER # LP-67*					ORDER # LP-72*									
ORDER # CNMG-432 [†]					ORDER # CNMG-432 [†]					ORDER # CNMG-543 [†]					ORDER # CNMG-543 [†]					ORDER # CNMG-643 [†]									
GRADE					GRADE					GRADE					GRADE					GRADE									
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6									
767					767					767					767					767									
ORDER # ACK-21*					ORDER #: ACK-21*					ORDER #: ACK-12*					ORDER #: ACK-12*					ORDER #: ACK-12*									
ORDER # ASTC-20*					ORDER # ASTC-20*					ORDER # ASTC-4*					ORDER # ASTC-4*					ORDER # ASTC-4*									
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*									

[†]Sold in package of 10 pcs. ^{††}100 & up call for price.

See full selection of inserts on pages 49 – 54.

QUICK CHANGE PROFILING TOOL HOLDERS

#15 & #15L

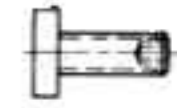


PROFILING TOOL HOLDERS

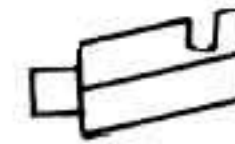
Available with right or left hand design for front or rear turning, profiling and contouring operations. Design features include: Unique, positive locking of insert is accomplished by the two-way force exerted by locking pin and the locking screw. Insert is held down and tight against the shoulders. Clamp lock insures extra rigidity of insert and holds chip-breaker, when used, securely in place. Choice of various diamond shaped inserts provides adaptation to positive or negative rake profiling. Available in Model #15 (right hand) or #15L (left hand), dovetail mounting design assures maximum repeating accuracy when used with standard Aloris Tool Post. Holder supplied with shim and clamp.



LOCK SCREWS



HEX LOCKING PINS



CLAMPS



CLAMP SCREW



CARBIDE SHIMS (SEATS)



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-15 ORDER # AXA-15L

A	B	PROFILING INSERT		
		I.C.	THICK	RAKE
1"	1 1/2"	3/8"	3/16" - 1/4"	POS. or NEG.

ORDER # LS-15*

ORDER # LP-15*

ORDER # ACK-12*

ORDER # ASTC-4*

ORDER # SM-117*

ORDER # AXA-HA*

Carbide inserts listed at bottom of this page, and full selection on pages 49 - 54.

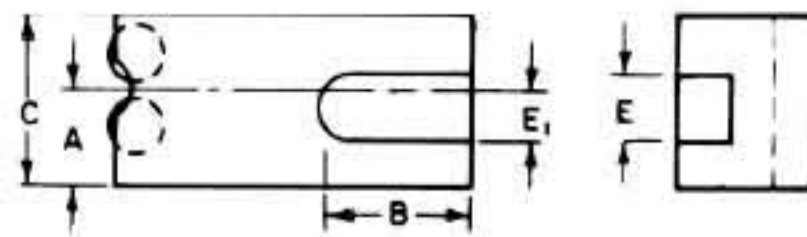
QUICK CHANGE KNURLING TOOL HOLDERS

#10



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. Holder supplied with 2 knurls.



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-10

A	B	C	E	E ₁	TOOL BIT
3/8"	2 1/2"	1 1/16"	1/2"	3/8"	3/16" - 1/2"

ORDER # AXA-HA*

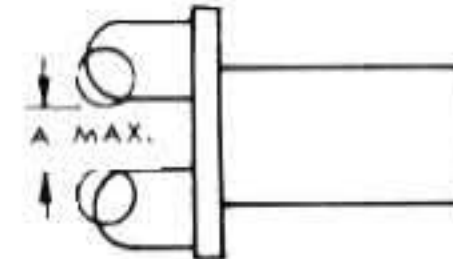
#19



ADJUSTABLE KNURLING HOLDER

...excellent knurling, with approach adjustability, is provided with the newly designed #19 knurling holder. The #19 is self-centering and is adjusted by means of a conveniently located knurled knob, providing the ideal near-vertical axis approach angle for a wide range of stock diameters. Spindle and cross-slide pressure are minimal, thus knurling of thin wall tubing is easily performed.

The Aloris #19, which is designed for use in any standard turret tool post or other open-slot holder, is also available with dovetail mounting (series 19) to fit Aloris tool posts. Precision ground, 3/4" O.D. x 7/8" wide, high-speed medium diamond knurls are supplied unless otherwise specified.



HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXA-19

A	KNURL SIZE
2"	3/4" x 1/4" x 3/8"

ORDER # AXA-HA*

CARBIDE PROFILING INSERTS FOR 15 & 15L PROFILE TOOLS*

STYLE DNGA - NEGATIVE RAKE	STYLE DNMG - 5° POSITIVE	STYLE DNMG - 5° NEGATIVE	STYLE DNMS - 15° POSITIVE	DIMENSIONS			INSERT ORDER #
				I.C.	T	R	
				3/8"	3/8"	1/2"	DNGA-532*
				3/8"	3/8"	1/2"	DNMG-532* DNMS-532
				3/8"	3/8"	1/2"	DNMG-542* DNMS-542

Inserts are priced individually, however, they must be purchased in packages of 10.



TECHNICAL DATA:
DIMENSIONS – CAPACITIES – MODELS

BXA-BX SERIES					CXA-CX SERIES					CA SERIES					DA SERIES					EA SERIES				
ORDER # BXA-15		ORDER # BXA-15L			ORDER # CXA-15		ORDER #CXA-15L			ORDER # CA-15		ORDER # CA-15L			ORDER # DA-15		ORDER # DA-15L							
A	B	PROFILING INSERT			A	B	PROFILING INSERT			A	B	PROFILING INSERT			A	B	PROFILING INSERT							
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE					
1"	1 1/8"	3/8"	3/16-1/4"	POS. or NEG.	1 3/8"	2"	5/8"	3/16-1/4"	POS. or NEG.	1 1/2"	2 1/4"	3/8"	3/16-1/4"	POS. or NEG.	1 3/4"	2 7/8"	5/8"	3/16-1/4"	POS. or NEG.					
ORDER # LS-15* PRICE EA. \$10.50					ORDER # LS-15* PRICE EA. \$10.50					ORDER # LS-15* PRICE EA. \$10.50					ORDER # LS-15* PRICE EA. \$10.50									
ORDER # LP-15*					ORDER # LP-15*					ORDER # LP-15*					ORDER # LP-15*									
ORDER # ACK-12* PRICE EA. \$12.00					ORDER # ACK-12* PRICE EA. \$12.00					ORDER # ACK-12* PRICE EA. \$12.00					ORDER # ACK-12* PRICE EA. \$12.00									
ORDER # ASTC-4*					ORDER # ASTC-4*					ORDER # ASTC-4*					ORDER # ASTC-4*									
ORDER # SM-117* PRICE EA. \$16.00					ORDER # SM-117* PRICE EA. \$16.00					ORDER # SM-117* PRICE EA. \$16.00					ORDER # SM-117* PRICE EA. \$16.00									
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*									



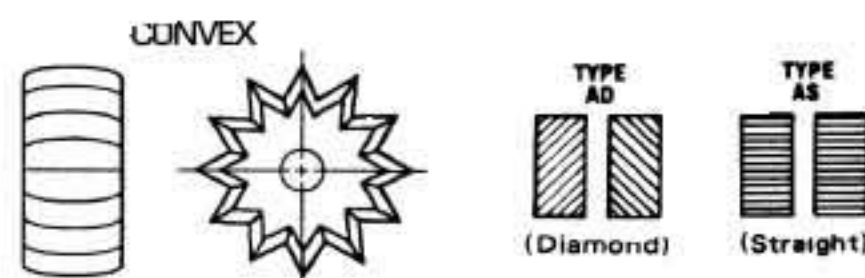
TECHNICAL DATA:
DIMENSIONS – CAPACITIES – MODELS

BXA-BX SERIES							CXA-CX SERIES							CA SERIES							DA SERIES							EA SERIES						
ORDER # BXA-10							ORDER # CXA-10							ORDER # CA-10							ORDER # DA-10													
A	B	C	E	E ₁	TOOL BIT		A	B	C	E	E ₁	TOOL BIT		A	B	C	E	E ₁	TOOL BIT		A	B	C	E	E ₁	TOOL BIT								
1"	2 5/8"	1 3/4"	5/8"	1/2"	1/4 - 5/8"		1 3/16"	3 3/8"	2"	3/4"	5/8"	1/2 - 3/4"		1 7/16"	3 3/4"	2 1/2"	1"	3/4"	1/2 - 1"		1 7/8"	4 1/2"	3 1/8"	1 1/4"	1"	1/2 - 1 1/4"								
ORDER # BXA-HA*							ORDER # CXA-HA*							ORDER # CA-HA*							ORDER # DA-HA*													
ORDER # BXA-19							ORDER # CXA-19							ORDER # CA-19							ORDER # DA-19													
A		KNURL SIZE					A		KNURL SIZE					A		KNURL SIZE					A		KNURL SIZE											
2"		3/4 x 1/4 x 3/8"					2"		3/4 x 1/4 x 3/8"					2"		3/4 x 1/4 x 3/8"					2"		3/4 x 1/4 x 3/8"											
ORDER # BXA-HA*							ORDER # CXA-HA*							ORDER # CA-HA*							ORDER # DA-HA*													

REPLACEMENT KNURLS

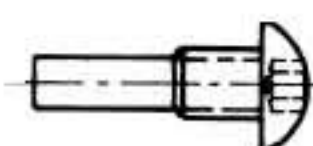
HIGH SPEED KNURLS

For #10 & #19 Holders:
AD-Diamond/AS-Straight/NEW – Convex
Hi-Cobalt (ACD-Spiral & ACS-Straight)




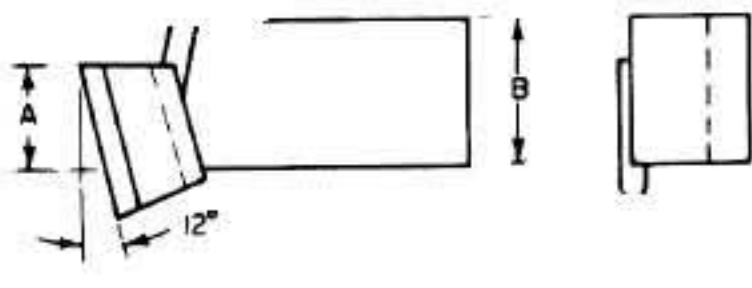


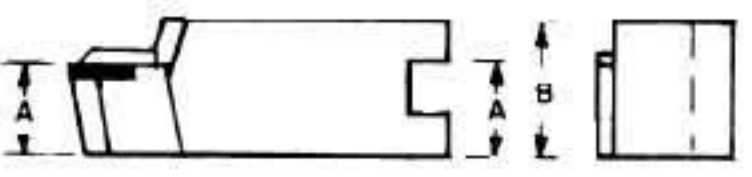


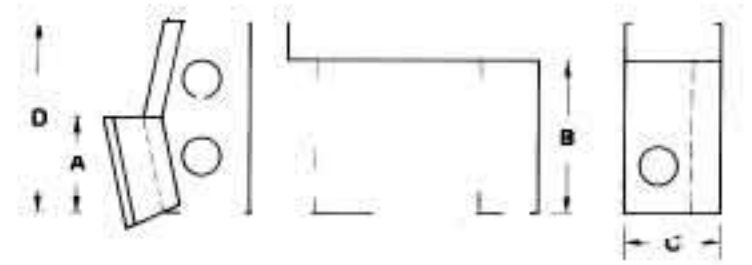

KNURL ORDER #	AD16R/AD16L/AS16* ACD16R/ACD16L/ACS16*	AD20R/AD20L/AS20/AD25R* AD25L/AS25/ACD20R/ACD20L* ACS20/ACD25R/ACD25L/ACS25*	AD50R/AD50L/AS50* ACD50R/ACD50L/ACS50*
	COARSE	MEDIUM	FINE

KNURL-LOCK SCREW








ORDER #	SCR-10*	Used with any #10 and 19 holder

QUICK CHANGE THREADING HOLDERS, BLADES & INSERTS

						AXA-AX SERIES		
#8		THREADING HOLDER #8 This universal threading holder comes with an interchangeable high speed threading blade which has two cutting edges. You may now reverse your spindle and cut a thread without fear of hitting shoulders. Speeds your threading. Also available with carbide insert blade. Holders supplied with blade as follows: AXA-P10, BXA-CXA-P6, CA-DA-EA-P4, or up to request.		ORDER # AXA-8				
				A	B	USED WITH		
				13/16	1 5/8	ANY THREADING BLADE SHOWN BELOW		
			HEIGHT ADJUSTMENT ASSEMBLY			ORDER # AXA-HA*		
#81		THREADING AND GROOVING TOOL HOLDER #81 Holder provides accurate threading and grooving. It is equipped with a threading insert holder (Aloris AT86) at the front – and an open slot for a grooving tool at the rear. Cutting tools are not included. Also available with high-speed blade. Holder supplied with AT86 insert holder less threading insert. Also available with high-speed blade.		ORDER # AXA-81				
				A	B	USED WITH		
				13/16	1 5/8	ANY THREADING BLADE SHOWN BELOW		
			HEIGHT ADJUSTMENT ASSEMBLY			ORDER # AXA-HA*		
#88		ADJUSTABLE THREADING HOLDERS WITH H.S. BLADE & AT88 HEAD The new Aloris Series 88 Adjustable Threading Holder for right and lefthand threading is designed for use with the new Aloris AT1H, AT1V or AT2V dual insert threading holders with two carbide cutting tips. In addition, the #88 Series holder will accommodate standard Aloris AT86 threading insert holders as well as standard high speed steel (HSS) Aloris P Series or AC Series. The key characteristics of the Series 88 holder is its adjustability feature which allows easy setting of the thread helix angle 10° to the left or right by means of two set screws, a direct-reading scale and a built-in locking feature.		ORDER # AXA-88				
				A	B	C	D	USED WITH
				1 1/8	1 5/8	1 1/2	2 1/4	ANY THREADING BLADE SHOWN BELOW
			HEIGHT ADJUSTMENT ASSEMBLY			ORDER # AXA-HA*		
ORDER #	AT-88							

Use with any #88 series holder.

BLADES & INSERTS

	HIGH SPEED THREADING BLADES – 60°	ORDER #	P-4	P-6	P-10								
	Exclusive blade design with two cutting edges, precision ground, assures unusually long life. To sharpen, simply grind the top surface. All blades are uniformly designed to fit any Aloris threading holder.	CAPACITY	4 or more T.P.I.	6 or more T.P.I.	10 or more T.P.I.								
	HIGH SPEED THREADING BLADES – ACME 29°	ORDER #	AC-3	AC-4	AC-5	AC-6	AC-7	AC-8	AC-9	AC-10	AC-12	AC-14	AC-16
	Exclusive blade design with two cutting edges, precision ground, assures unusually long life. To sharpen, simply grind the top surface. All blades are uniformly designed to fit any Aloris threading holder.	CAPACITY	3 T.P.I.	4 T.P.I.	5 T.P.I.	6 T.P.I.	7 T.P.I.	8 T.P.I.	9 T.P.I.	10 T.P.I.	12 T.P.I.	14 T.P.I.	16 T.P.I.
	THREADING BLADE GAUGE	ORDER #	GA #8										
	THREADING INSERT HOLDER AND INSERT – 60°	HOLDER ORDER #	CAPACITY										
	Blade is reversible and has an adjustable insert for sharpening purposes. Inserts are stocked in grade A2, A6, and TiN. When ordering specify grade desired, otherwise grade A6 will be supplied. Blade fits any Aloris threading holder.	AT-86	6 TO 48 T.P.I.										
	THREADING CARBIDE INSERT FOR HOLDER # AT-86	STYLE	TPI	INSERT ORDER #*									
		60°V	6 – 48	AT-4R*									

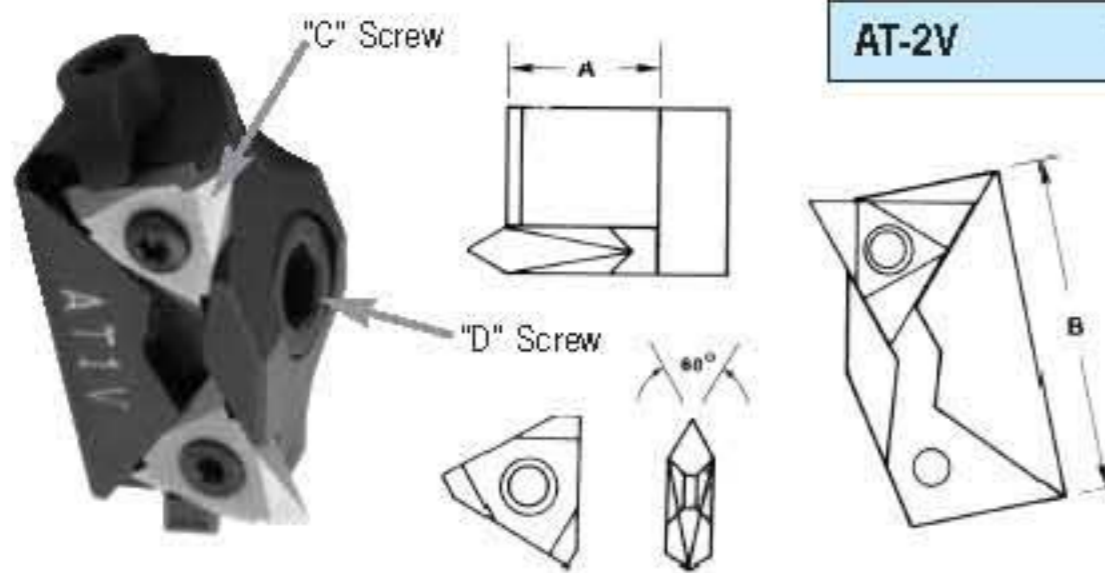


BXA-BX SERIES			CXA-CX SERIES			CA SERIES			DA SERIES			EA SERIES										
ORDER # BXA-8			ORDER # CXA-8			ORDER # CA-8			ORDER # DA-8			ORDER # EA-8										
A	B	USED WITH	A	B	USED WITH	A	B	USED WITH	A	B	USED WITH	A	B	USED WITH								
1"	1 3/4"	ANY THREADING BLADE SHOWN BELOW	1 1/8"	2"	ANY THREADING BLADE SHOWN BELOW	1 1/4"	2 1/4"	ANY THREADING BLADE SHOWN BELOW	1 1/2"	2 3/4"	ANY THREADING BLADE SHOWN BELOW	1 3/4"	3 1/4"	ANY THREADING BLADE SHOWN BELOW								
ORDER # BXA-HA*			ORDER # CXA-HA*			ORDER # CA-HA*			ORDER # DA-HA*			ORDER # EA-HA*										
ORDER # BXA-81			ORDER # CXA-81			ORDER # CA-81			ORDER # DA-81													
A	B	USED WITH	A	B	USED WITH	A	B	USED WITH	A	B	USED WITH											
1"	1 3/4"	ANY THREADING BLADE SHOWN BELOW	1 1/8"	2"	ANY THREADING BLADE SHOWN BELOW	1 1/4"	2 1/4"	ANY THREADING BLADE SHOWN BELOW	1 1/2"	2 3/4"	ANY THREADING BLADE SHOWN BELOW											
ORDER # BXA-HA*			ORDER # CXA-HA*			ORDER # CA-HA*			ORDER # DA-HA*													
ORDER # BXA-88			ORDER # CXA-88			ORDER # CA-88			ORDER # DA-88													
A	B	C	D	USED WITH	A	B	C	D	USED WITH	A	B	C	D	USED WITH								
1"	1 3/4"	1 1/2"	2 1/4"	ANY THREADING BLADE SHOWN BELOW	1 1/8"	2"	1 1/8"	2 1/4"	ANY THREADING BLADE SHOWN BELOW	1 1/8"	2 1/4"	1 1/8"	2 1/4"	ANY THREADING BLADE SHOWN BELOW	1 1/4"	2 3/4"	2"	2 5/8"	ANY THREADING BLADE SHOWN BELOW			
ORDER # BXA-HA*			ORDER # CXA-HA*			ORDER # CA-HA*			ORDER # DA-HA*													

INSERT CARTRIDGES

STAND UP INSERT CARTRIDGE

Aloris Series V Threading Cartridge for two triangular 60° threading inserts



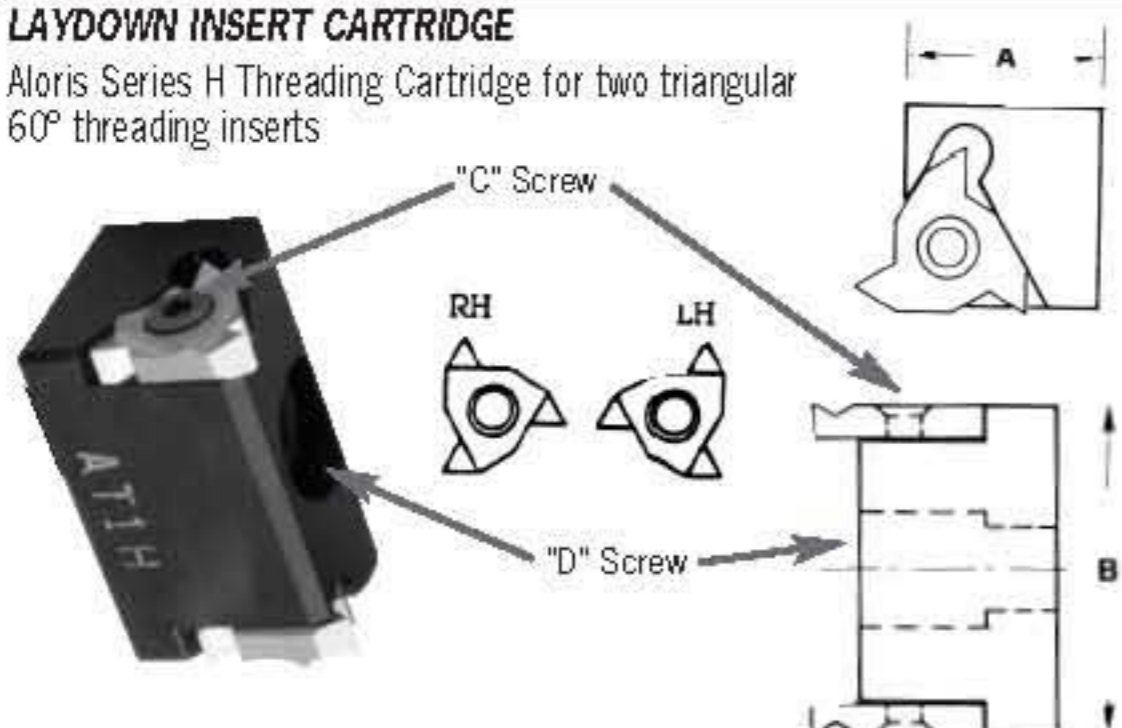
CARTRIDGE ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw #	"D" Replacement Screw #	CLAMP #	CLAMP SCREW #	INSERT IC	KEY #
AT-1V	3/4 sq.	1 5/16	AGTS-1*	5/16 - 18x3/4 shcs	ACK-19*	ASTC-9*	3/8	T-10*
AT-2V	7/8 sq.	1 5/8	AGTS-2*	5/16 - 18x3/4 shcs	ACK-19*	ASTC-9*	1/2	T-20*

INSERTS: EXTERNAL VERTICAL 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #*
60°	8+	3/8	Pos	AT-1V	TPMC-32NV*
60°	8+	3/8	Neg	AT-1V	TNMC-32NV*
60°	6+	1/2	Pos	AT-2V	TPMC-43NV*
60°	6+	1/2	Neg	AT-2V	TNMC-43NV*

LAYDOWN INSERT CARTRIDGE

Aloris Series H Threading Cartridge for two triangular 60° threading inserts



ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw	"D" Replacement Screw	INSERT IC	KEY #
AT-1H	3/4 sq.	1 1/4	ASA-3T*	5/16 - 24x3/4 lg shcs	3/8	T-10*
AT-2H	7/8 sq.	1 1/8	ASA-4T*	5/16 - 24x3/4 lg shcs	1/2	T-20*

INSERTS: PARTIAL PROFILE 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #*
60°V-RH	8 - 48	3/8	Pos	AT-1H	16ER-LAG60-RH*
60°V-LH	8 - 48	3/8	Pos	AT-1H	16ER-LAG60-LH*
60°V-RH	5 - 7	1/2	Pos	AT-2H	22ER-LN60-RH*
60°V-LH	5 - 7	1/2	Pos	AT-2H	22ER-LN60-LH*

*Sold in package of 10 pcs.

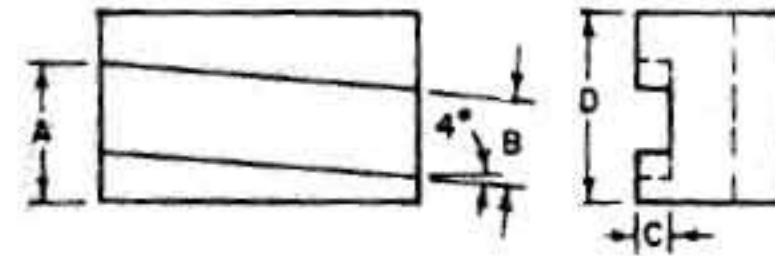
See full selection of inserts on pages 49 - 54.

QUICK CHANGE CUT-OFF & GROOVING HOLDERS

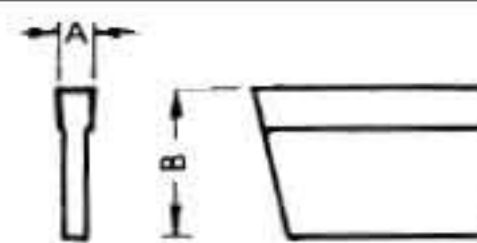
#7

UNIVERSAL PARTING BLADE HOLDER

#7 and #7R Holders are only for use with T-type blades shown below; or with bevel (wedge-shape) blades having parallel top and bottom edges, as shown below. For bevel (see drawing) as well as T-type blades. Enables you to cut-off close to chuck. Absence of vibration prevents breaking blades.



PARTING BLADES



WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-7

A	B	C	D	BLADE HEIGHT
1 ³ / ₁₆	1/2	3/16	1 1/2	1/2

ORDER # P-2*

WIDTH "A": 3/2	HEIGHT "B": 1/2
----------------	-----------------

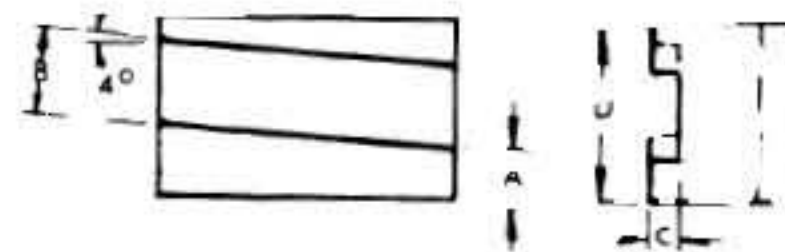
ORDER # WSA-1*

ORDER # AXA-HA*

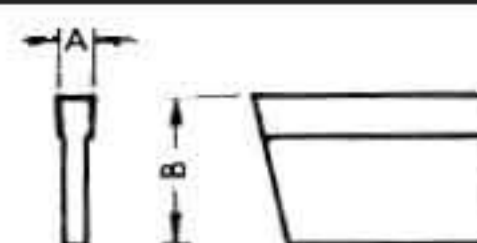
#7R

UNIVERSAL PARTING BLADE TOOL HOLDER - REVERSIBLE

Has the same features as #7 with the advantage of rear cut-off use.



PARTING BLADES



WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7



HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXA-7R

A	B	C	D	BLADE HEIGHT
1 ¹ / ₁₆	1/2	3/16	1 1/2	1/2

ORDER # P-2*

WIDTH "A": 3/2	HEIGHT "B": 1/2
----------------	-----------------

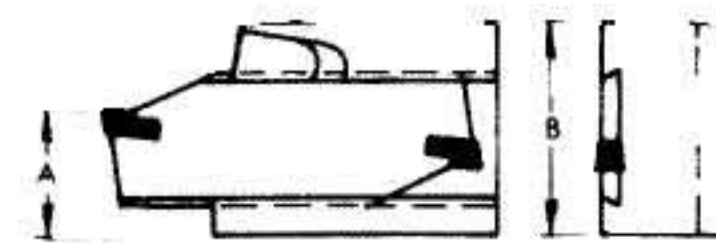
ORDER # WSA-1*

ORDER # AXA-HA*

#71

CUT-OFF AND GROOVING HOLDER

Designed for extremely high rigidity under heavy duty conditions, and cool chatter-free operation at higher speeds. Two different blades can be used with this holder: self-locking throwaway insert blade, or reversible blade with brazed-in carbide tips. The chip-breaker is an integral part of the blade and cannot be lifted by broken chips. Simplicity is but one of the major advantages of the Series 71. Adjustment of the blade position is simple, the locking is accomplished by one screw instead of the usual number of adjusting and clamping screws. The versatility of this tool is further increased by the availability of a wide range of cutting edge widths. Holder supplied less blade. When ordering brazed carbide blades, specify grade A2 or A6. For carbide cut-off inserts see page 54.



REVERSIBLE BLADES WITH BRAZED-IN CARBIDE TIPS



ORDER NUMBER

WIDTH x HEIGHT

PRICE

A	B	USED WITH BLADE WIDTHS
1 ⁵ / ₁₆	1 ¹³ / ₁₆	7/8, 3/16 or 1/4
71-125-1*	71-187-1*	71-250-1*
.120 x 1.50	.187 x 1.50	.250 x 1.50

SELF-LOCKING THROWAWAY INSERT BLADES



ORDER NUMBER

WIDTH x HEIGHT

PRICE

A	B	USED WITH BLADE WIDTHS
1 ⁵ / ₁₆	1 ¹³ / ₁₆	7/8, 3/16 or 1/4
71-125-1BSL*	71-187-1BSL*	71-250-1BSL*
.120 x 1.50	.187 x 1.50	.250 x 1.50

EXTRACTOR (For self-locking carbide insert removal)

ORDER # ESG-1*

WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #71



ORDER # WSA-6*

HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXA-HA*



BXA-BX SERIES					CXA-CX SERIES					CA SERIES					DA SERIES					EA SERIES									
ORDER # BXA-7					ORDER # CXA-7					ORDER # CA-7					ORDER # DA-7					ORDER # EA-7									
A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT					
1"	1 ¹ / ₁₆	3 ¹ / ₁₆	1 ³ / ₄	1 ¹ / ₁₆	1 ³ / ₁₆	3 ¹ / ₄	3 ¹ / ₁₆	2"	3 ¹ / ₄	1 ⁷ / ₁₆	7 ¹ / ₈	1 ¹ / ₄	2 ¹ / ₂	7 ¹ / ₈	1 ³ / ₄	1 ¹ / ₈	1 ¹ / ₄	2 ³ / ₄	1 ¹ / ₈	1 ⁷ / ₈	1 ¹ / ₈	1 ¹ / ₄	3"	1 ¹ / ₈					
ORDER # P-3*					ORDER # P-4C*					ORDER # P-3W*					ORDER # P-5*					ORDER # P-8*									
WIDTH "A": 1 ¹ / ₈ HEIGHT "B": 1 ¹ / ₁₆					WIDTH "A": 5 ¹ / ₃₂ HEIGHT "B": 1 ¹ / ₁₆					WIDTH "A": 1 ¹ / ₈ HEIGHT "B": 3 ¹ / ₄					WIDTH "A": 3 ¹ / ₁₆ HEIGHT "B": 7 ¹ / ₈					WIDTH "A": 3 ¹ / ₁₆ HEIGHT "B": 1 ¹ / ₈					WIDTH "A": 3 ¹ / ₁₆ HEIGHT "B": 1 ¹ / ₈				
ORDER # WSA-1*					ORDER # WSA-2*					ORDER # WSA-3*					ORDER # WSA-4*					ORDER # WSA-5*									
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*									
ORDER # BXA-7R					ORDER # CXA-7R					ORDER # CA-7R					ORDER # DA-7R					ORDER # EA-7R									
A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT	A	B	C	D	BLADE HEIGHT					
3 ¹ / ₄	1 ¹ / ₁₆	3 ¹ / ₁₆	1 ³ / ₄	1 ¹ / ₁₆	1"	1 ¹ / ₈	1 ³ / ₁₆	2"	3 ¹ / ₄	1 ⁷ / ₁₆	7 ¹ / ₈	1 ¹ / ₄	2 ¹ / ₂	7 ¹ / ₈	1"	1 ¹ / ₈	1 ¹ / ₄	2 ³ / ₄	1 ¹ / ₈	1"	1 ¹ / ₈	1 ¹ / ₄	3"	1 ¹ / ₈					
ORDER # P-3*					ORDER # P-4C*					ORDER # P-3W*					ORDER # P-5*					ORDER # P-8*									
WIDTH "A": 1 ¹ / ₈ HEIGHT "B": 1 ¹ / ₁₆					WIDTH "A": 5 ¹ / ₃₂ HEIGHT "B": 1 ¹ / ₁₆					WIDTH "A": 1 ¹ / ₈ HEIGHT "B": 3 ¹ / ₄					WIDTH "A": 3 ¹ / ₁₆ HEIGHT "B": 7 ¹ / ₈					WIDTH "A": 3 ¹ / ₁₆ HEIGHT "B": 1 ¹ / ₈					WIDTH "A": 3 ¹ / ₁₆ HEIGHT "B": 1 ¹ / ₈				
ORDER # WSA-1*					ORDER # WSA-2*					ORDER # WSA-3*					ORDER # WSA-4*					ORDER # WSA-5*									
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*									
ORDER # BXA-71					ORDER # CXA-71					CA-71 (2")		CA71-1 (1 ¹ / ₂)			ORDER # DA-71					ORDER # EA-71									
A	B	USED WITH BLADE WIDTHS			A	B	USED WITH BLADE WIDTHS			A	B	USED WITH BLADE WIDTH	A	B	USED WITH BLADE WIDTHS			A	B	USED WITH BLADE WIDTHS									
1 ⁵ / ₁₆	2"	1 ¹ / ₈ , 3 ¹ / ₁₆ or 1 ¹ / ₄			1 ¹⁵ / ₁₆	2 ³ / ₈	1 ¹ / ₈ , 3 ¹ / ₁₆ or 1 ¹ / ₄			1 ⁷ / ₈	3 ¹ / ₄	3 ¹ / ₁₆ , 1 ¹ / ₄	1 ⁵ / ₁₆	2 ¹ / ₂	71-1251BSL 1/4 \$46.00 71-1871BSL 3/8 \$51.75 71-2501BSL 1/4 \$55.20			2"	3 ¹ / ₄	3 ¹ / ₁₆ or 1 ¹ / ₄			2 ¹ / ₁₆	3 ³ / ₈	3 ¹ / ₁₆ or 1 ¹ / ₄				
71-125-1*	71-187-1*	71-250-1*			71-125-1*	71-187-1*	71-250-1*			71-187-2*	71-250-2*			71-187-2*	71-250-2*			71-187-2*	71-250-2*										
.120 x 1.50	.187 x 1.50	.250 x 1.50			.120 x 1.50	.187 x 1.50	.250 x 1.50			.187 x 2.00	.250 x 2.00			.187 x 2.00	.250 x 2.00			.187 x 2.00	.250 x 2.00										
71-125-1BSL*	71-187-1BSL*	71-250-1BSL*			71-125-1BSL*	71-187-1BSL*	71-250-1BSL*			71-187-2BSL*	71-250-2BSL*			71-187-2BSL*	71-250-2BSL*			71-187-2BSL*	71-250-2BSL*										
.120 x 1.50	.187 x 1.50	.250 x 1.50			.120 x 1.50	.187 x 1.50	.250 x 1.50			.187 x 2.00	.250 x 2.00			.187 x 2.00	.250 x 2.00			.187 x 2.00	.250 x 2.00										
ORDER # ESG-1*					ORDER # ESG-1*					ORDER # ESG-1*					ORDER # ESG-1*					ORDER # ESG-1*									
ORDER # WSA-7*					ORDER # WSA-8*					ORDER # WSA-9*					ORDER # WSA-10*					ORDER # WSA-11*									
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*									

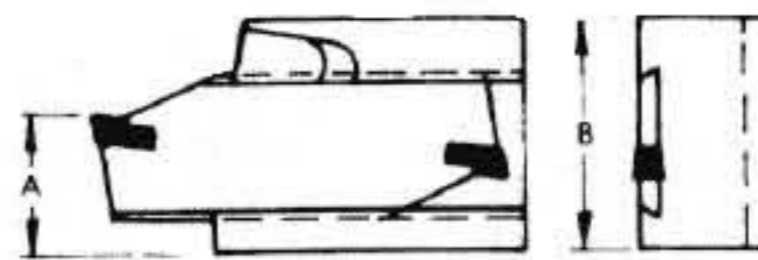
QUICK CHANGE CUT-OFF & GROOVING HOLDERS BLADES & INSERTS

#77



CUT-OFF AND GROOVING HOLDER

Designed for extremely high rigidity under heavy duty conditions, and cool chatter-free operation at higher speeds. Two different blades can be used with this holder: self-locking throwaway insert blade, or reversible blade with brazed-in carbide tips, shown. The chip breaker is an integral part of the blade and cannot be lifted by broken chips. Simplicity is but one of the major advantages of the Series 77. Adjustment of the blade position is simple, the locking is accomplished by one screw instead of the usual number of adjusting and clamping screws. The versatility of this tool is further increased by the availability of a wide range of cutting edge widths. Holder supplied less blade. Blades are interchangeable with Iscar and Sandvik.



SELF-LOCKING BLADES FOR CARBIDE INSERTS

ORDER NUMBER

WIDTH OF CUT x HEIGHT



ORDER NUMBER

WIDTH OF CUT x HEIGHT

ORDER NUMBER

WIDTH OF CUT x HEIGHT

WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #77



HEIGHT ADJUSTMENT ASSEMBLY



AXA-AX SERIES

ORDER # AXA-77

A	B	USED WITH BLADE WIDTHS
3 1/32	1 5/8	.087 & .093 x .750

SGIH 19-2/-2PS*

.087 or .093 x .750

SGIH 19-3*

.120 x .750

ORDER # WSA-6

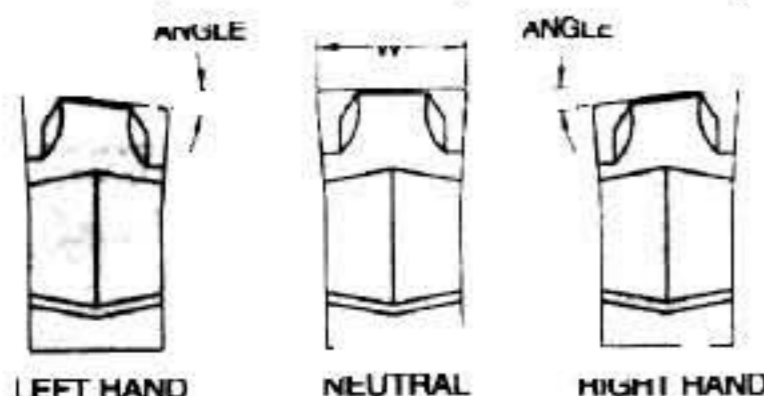
ORDER # AXA-HA*

GT STYLE SELF GRIP CARBIDE CUT-OFF INSERTS

FOR SELF-LOCKING BLADES, POSITIVE RAKE SHARP EDGE FOR MANUAL & CNC LATHES.
SEE PAGE 54 FOR DESCRIPTION OF CARBIDE GRADES



Left Hand - 8° Lead Angle Neutral - 0° Lead Angle Right Hand - 8° Lead Angle



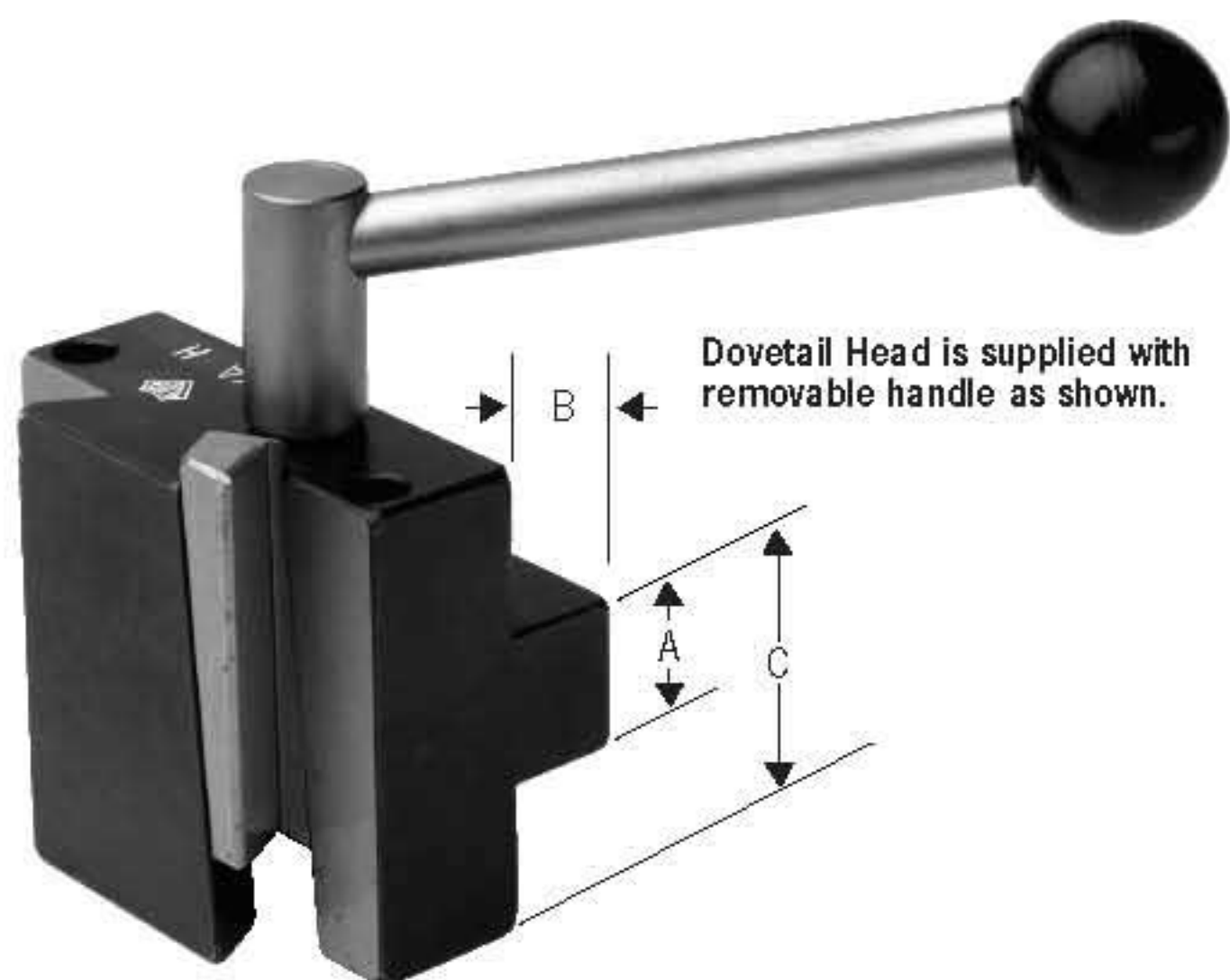
	Catalog Number	Cutting Edge Geometry	Cutting Width	Lead Angle
	GTN 2*	P	.087	0
++	GT L/R 2*	P	.087	8
++	GT L/R 2.4*	P	.093	8
	GTN 3*	P	.120	0
++	GT L/R 3*	P	.120	8
	GTN 4*	P	.160	0
++	GT L/R 4*	P	.160	8
	GTN 4.8*	P	.187	0
++	GT L/R 4.8*	P	.187	8
	GTN 5*	P	.200	0
++	GT L/R 5*	P	.200	8
	GTN 6*	P	.250	0
++	GT L/R 6*	P	.250	8
	GTN 8*	P	.315	0
++	GT L/R 8*	P	.315	4
	GTN 9*	P	.375	0
++	GT L/R 9*	P	.375	4

++Specify left or right hand.



BXA-BX SERIES			CXA-CX SERIES			CA SERIES			DA SERIES			EA SERIES
ORDER # BXA-77			ORDER # CXA-77			ORDER # CA-77			ORDER # DA-77			
A	B	USED WITH BLADE WIDTHS	A	B	USED WITH BLADE WIDTHS	A	B	USED WITH BLADE WIDTHS	A	B	USED WITH BLADE WIDTHS	
1 $\frac{1}{32}$	2	.093 – .120 – .187	1 $\frac{1}{32}$	2	.120 – .160 – .187	1 $\frac{1}{16}$	2 $\frac{1}{2}$.120 – .187 – .250	1 $\frac{1}{32}$	2 $\frac{1}{8}$.120 – .187 – .250	
SGIH 26-2/-2PS*			SGIH 26-3/-3PS*			SGIH 32-3/-3PS*			SGIH 32-3/-3PS*			
.087 or .093 x 1.0			.120 x 1.0			.120 x 1.25			.120 x 1.25			
REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	
SGIH 26-3/-3PS*			SGIH 26-4/-4PS*			SGIH 32-5/-5PS*			SGIH 32-5/-5PS*			
.120 x 1.0			.160 x 1.0			.187 x 1.25			.187 x 1.25			
REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	
SGIH 26-5/-5PS*			SGIH 26-5/-5PS*			SGIH 32-6/-6PS*			SGIH 32-6/-6PS*			
.187 x 1.0			.187 x 1.0			.250 x 1.25			.250 x 1.25			
REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	REGULAR		POSITIVE STOP	
ORDER # WSA-7			ORDER # WSA-8			ORDER # WSA-9			ORDER # WSA-10			
ORDER # BXA-HA*			ORDER # CXA-HA*			ORDER # CA-HA*			ORDER # DA-HA*			

Universal Mounting Aloris Super-Precision Single-Dovetail Heads

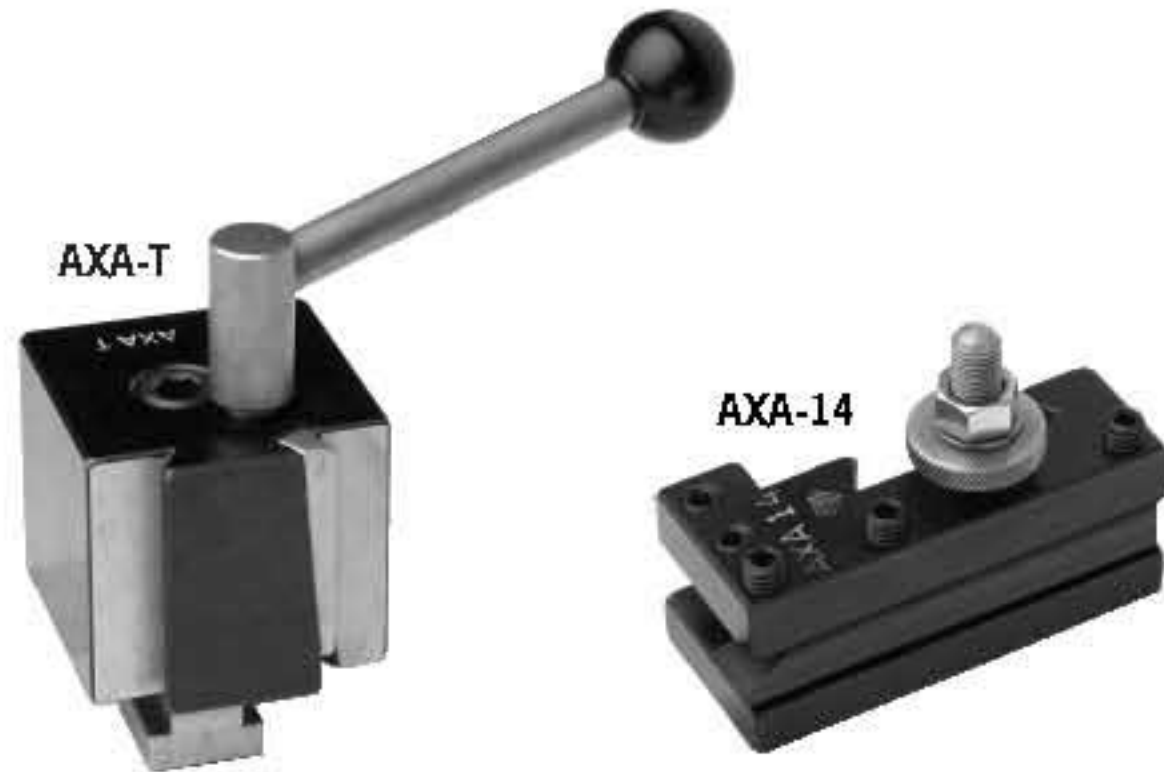


The rapid tool-changing versatility and accuracy synonymous with the name Aloris, is now available to users of lathes with turret tool posts or any open slot mounting arrangement. The head is also drilled for mounting on other types of tool carriages. The newly designed models of super-precision single-dovetail heads, accepts any of the wide range of tool holders in the same series, providing quick tool changing flexibility and repeat accuracy at the flick of a handle-one quarter turn locks holder in working position within .0001 inches of preset position everytime. Costly time loss due to repetitive realignment is eliminated. The socket wrench handle, included in the basic head price, is removable for possible clearance requirements when used on CNC lathes.

ORDER #	DIMENSIONS		
	A	B	C
BXA-H	$\frac{7}{8}$	$\frac{3}{4}$	1 $\frac{11}{16}$
CXA-H	1"	$\frac{3}{4}$	1 $\frac{15}{16}$
CA-H	1 $\frac{1}{4}$	1"	2 $\frac{5}{16}$
DA-H	1 $\frac{1}{2}$	1 $\frac{1}{4}$	3 $\frac{1}{4}$

SETS OF TOOL POSTS AND HOLDERS

Model AXA-T Tool Post & AXA-14 Tool Holder



The super precision one dovetail tool post and tool holder are especially designed for the tracer attachments. The knurled nut on the holder provides exact height adjustment, entirely eliminating the use of shims.

The maximum tool capacity for turning and boring is $\frac{1}{2}$ ".
Dovetail dimensions of this unit are the same as the AXA. For additional tool holders see AXA series.

ORDER #	AXA-T	AXA-14	AXA-T SET 5% Saving
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Tool Post is supplied with removeable handle.
Holder is supplied with screw wrench.

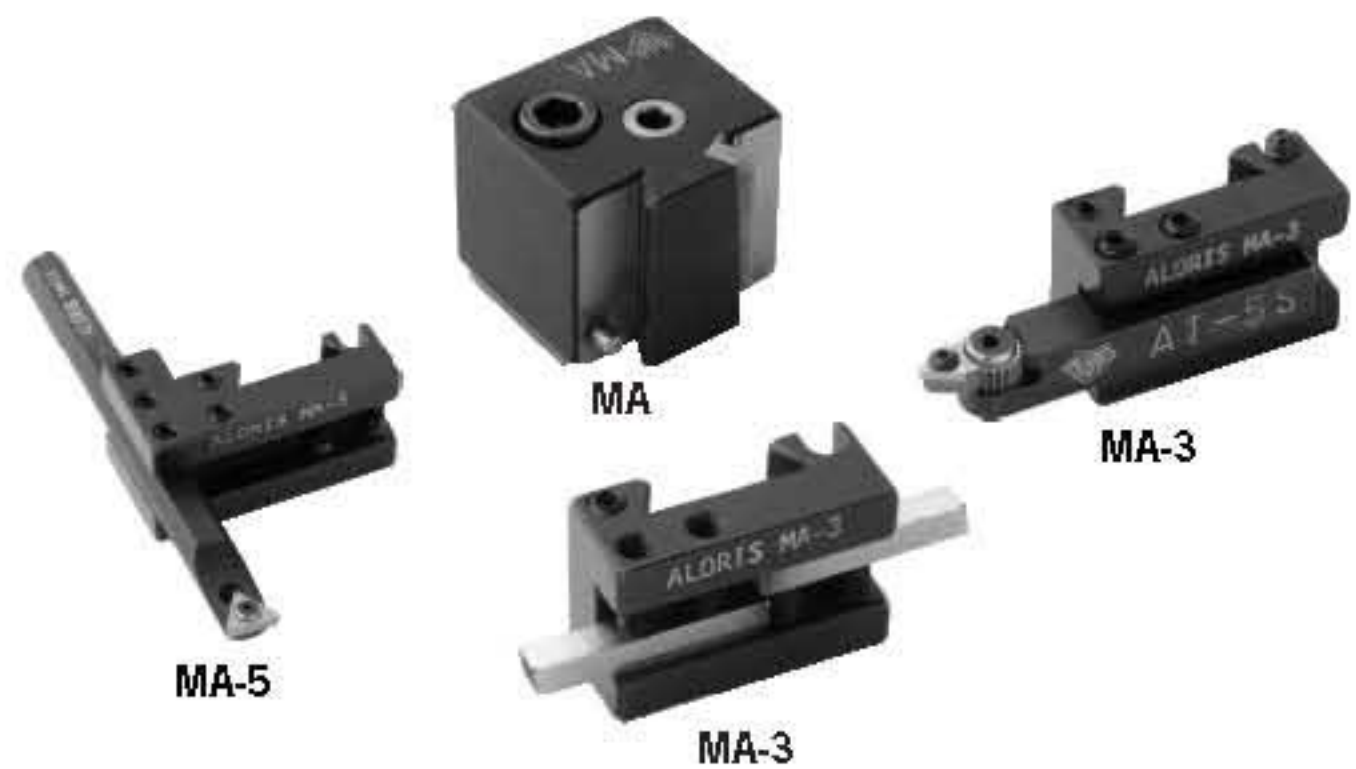
Model MA Tool Post and Tool Holders

Super precision one dovetail tool post and tool holders are especially designed for bench lathes and jewelry lathes. Three holders hold 6 different tools, are quickly interchangeable for 6 different operations. Height adjustment for each tool bit is provided on all holders. Tool holder capacity for turning or boring is $\frac{1}{8}$ to $\frac{3}{8}$ ".

Tool post dimensions are $1\frac{1}{2} \times 1\frac{1}{2} \times 1\frac{1}{4}$ ".

ORDER #	MA	MA-3	MA-3	MA-5	MA-SET 5% Saving
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Set is supplied with "T" and screw wrenches, less cutting tools.



Model A2 Tool Post and Tool Holders

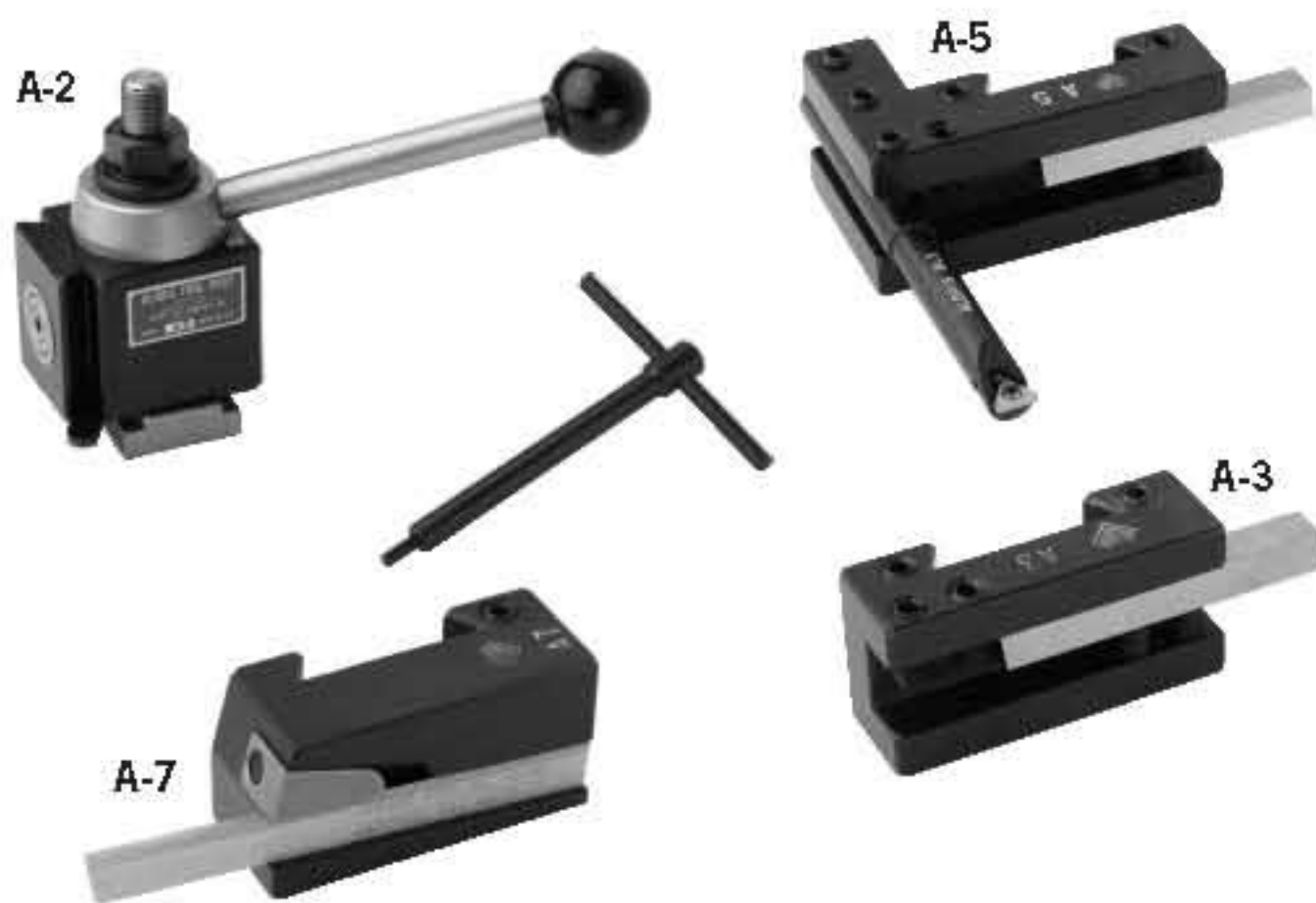
ECONOMY UNIT FOR SMALL LATHES

A one dovetail economy unit especially designed for small lathes, screw machines and turret lathes. Reversible holders have their own height adjustment, which is made by a set screw for each tool. Simple to grind tools without removing them from the holder.

Maximum tool capacity for turning holder is $\frac{1}{2}$ ".

Maximum tool capacity for boring is $\frac{5}{8}$ ".

Dovetail dimensions of this unit are the same as AXA. For additional tool holders see AXA series.



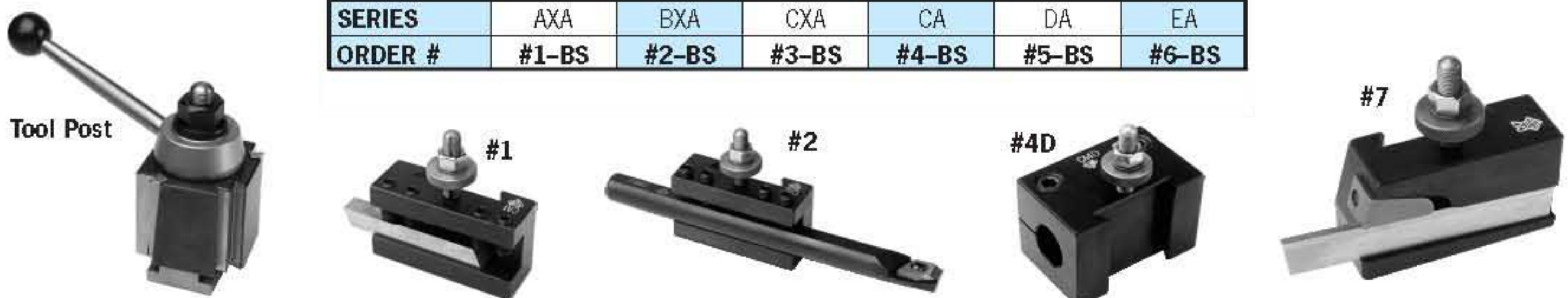
ORDER #	A-2	A-3	A-5	A-7	A-2 SET 5% Savings
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Order # A2 T-Bolt

5 PIECE STARTER SET SAVE 5% OVER COMPONENTS PURCHASED SEPARATELY

"5 PC" SET CONSISTS OF THE FOLLOWING: Tool Post, Custom "T"-Bolt & Holders listed below

SERIES	AXA	BXA	CXA	CA	DA	EA
ORDER #	#1-BS	#2-BS	#3-BS	#4-BS	#5-BS	#6-BS



SAVE 5% ON 7 PIECE SETS OF TOOL POSTS AND HOLDERS



"7 PC" SET CONSISTS OF THE FOLLOWING: Tool Post, Custom "T"-Bolt & Holders listed below

SERIES	AXA	BXA	CXA	CA	DA	EA
ORDER #	#1-SET	#2-SET	#3-SET	#4-SET	#5-SET	#6-SET
HOLDERS INCLUDED	AXA-1	BXA-1	CXA-1	CA-1	DA-1	EA-1
	AXA-2	BXA-2	CXA-2	CA-2	DA-2	EA-2
	AXA-4D	BXA-4D	CXA-4D	CA-4D	DA-41D	EA-4D
	AXA-6	BXA-6	CXA-6	CA-6	DA-6	EA-6
	AXA-7	BXA-7	CXA-7	CA-7	DA-8	EA-8
	AXA-8	BXA-8	CXA-8	CA-8	DA-16N	EA-16N



★ SAVE 10% ON "AS" SETS ONLY ★



"AS" SET CONSISTS OF THE FOLLOWING: Tool Post, Custom "T"-Bolt & Holders listed below

SERIES	AXA	BXA	CXA	CA	DA	EA
ORDER #	#1-AS	#2-AS	#3-AS	#4-AS	#5-AS	#6-AS
HOLDERS INCLUDED	AXA-1	BXA-1	CXA-1	CA-1	DA-1	EA-1
	AXA-2	BXA-2	CXA-2	CA-2	DA-2	EA-2
	AXA-4D	BXA-4D	CXA-4D	CA-4D	DA-4D	EA-4D
	AXA-53	BXA-53	CXA-41D	CA-41D	DA-41D	EA-6
	AXA-6	BXA-6	CXA-6	CA-54	DA-6	EA-7
	AXA-7	BXA-7	CXA-7	CA-6	DA-7	EA-8
	AXA-8	BXA-8	CXA-8	CA-7	DA-8	EA-16N
	AXA-10	BXA-10	CXA-10	CA-8	DA-16N	EA-30
	AXA-16	BXA-16	CXA-16	CA-16	DA-30	
	AXA-20	BXA-20	CXA-20	CA-30		



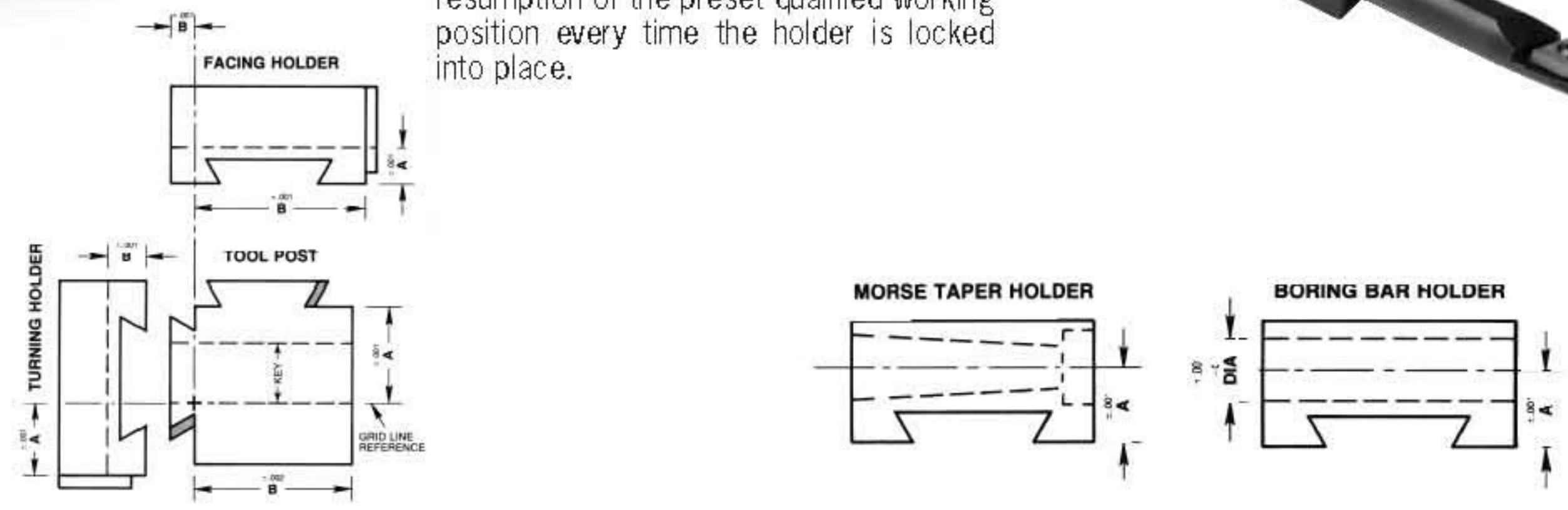
QUALIFIED TOOL POSTS AND HOLDERS

...a full range of qualified tooling to meet the rigorous repeat accuracy demands of C.N.C. Lathe operation, combined with the advantages and convenience of quick-change versatility, high-precision and superb workmanship – time and job proven qualities which have made Aloris products the tools preferred by lathe craftsmen for over 40 years. The Aloris Q System provides simplicity in set-up, programming and operation of C.N.C. lathes. The point of origin (grid line), custom located for your particular lathe, is a fixed reference for setting up all tools used in the system. The Aloris Q System can also be used on conventional lathes, with superior results.



CA-Q Qualified Tool Post
 Aloris Q System Tool Posts have fully qualified working surfaces. Perpendiculars are accurately parallel and square to the base. For point of origin location, qualified surface data and other dimensions see below.

Qualified Tool Holders
 Aloris Qualified Tool Holders are designed for use with all manually or C.N.C. Lathes. All are available in CA __ Q and DA __ Q sizes. They feature parallel and square working surfaces to assure automatic resumption of the preset qualified working position every time the holder is locked into place.



TECHNICAL DATA: MODELS — DIMENSIONS — CAPACITIES

CA _____ SERIES			REPLACEMENT PARTS			
ORDER #	DIMENSIONS		CAPACITY	HEIGHT ADJUSTMENT		SET SCREW
	A	B		ORDER #	PRICE EA.	
CA-Q	2.400	3.525	19" SWING		CA-TB*	
TURNING HOLDER						
CA-1Q	1.460	.915	1"	CA-HA*		
FACING HOLDER						
CA-1LQ	.915	3.860	1"	CA-HA*		
*MORSE TAPER HOLDERS						
CA-52Q	1.375	—	#2 M.T.	CA-HA*		
CA-53Q			#3 M.T.	CA-HA*		
CA-54Q			#4 M.T.	CA-HA*		
**BORING BAR HOLDERS						
CA-4Q-750	1.375	.625	¾"	CA-HA*		CAQ-SS*
CA-4Q-1000			1"	CA-HA*		CAQ-SS*
CA-4Q-1250			1½"	CA-HA*		CAQ-SS*
CA-4Q-1500			1¾"	CA-HA*		CAQ-SS*
CA-4Q-1750	1.750	.625	1¾"	CA-HA*		CAQ-SS*
CA-4Q-2000			2"	CA-HA*		CAQ-SS*

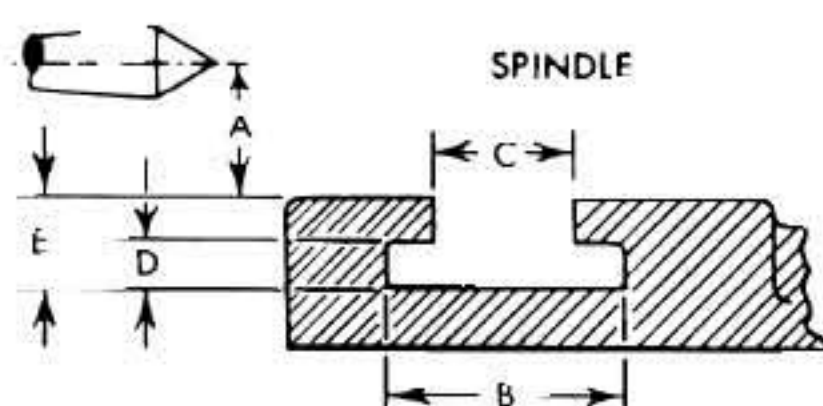
DA _____ SERIES					REPLACEMENT PARTS		
ORDER #	PRICE EA.	DIMENSIONS		CAPACITY	HEIGHT ADJUSTMENT		SET SCREW
		A	B		ORDER #	PRICE EA.	
DA-Q		3.100	4.400	24" SWING		DA-TB*	
TURNING HOLDER							
DA-1Q		1.450	1.500	1½"	DA-HA*		
FACING HOLDER							
DA-1LQ		1.500	4.550	1½"	DA-HA*		
*MORSE TAPER HOLDERS							
DA-53Q	2.000	—	—	#3 M.T.	DA-HA*		
DA-54Q				#4 M.T.	DA-HA*		
DA-55Q				#5 M.T.	DA-HA*		
**BORING BAR HOLDERS							
DA-4Q-1000	2.000	.625	—	1"	DA-HA*		DAQ-SS*
DA-4Q-1250				1½"	DA-HA*		DAQ-SS*
DA-4Q-1500				1¾"	DA-HA*		DAQ-SS*
DA-4Q-1750				2"	DA-HA*		DAQ-SS*
DA-4Q-2000				2½"	DA-HA*		DAQ-SS*
DA-4Q-2500				2.250	.935	—	2½"
DA-4Q-3000	2.500	.935	—	3"	DA-HA*		DAQ-SS*

When ordering replacement set screws please provide dimensions.

RECOMMENDATIONS FOR BENCH, CNC AND ENGINE LATHES

MAKE OF LATHE	SWING	ALORIS TOOL POST	CAPACITY		MAKE OF LATHE	SWING	ALORIS TOOL POST	CAPACITY		MAKE OF LATHE	SWING	ALORIS TOOL POST	CAPACITY				
			MAX TOOL BIT	MAX BOR. TOOL				MAX TOOL BIT	MAX BOR. TOOL				MAX TOOL BIT	MAX BOR. TOOL			
ACER	1340G 1440E & G 1740G 2080G	BXA CXA CA DA	3/8"	1 1/4"	GRAZIANO SAG	12" 14" 20"	BXA CXA CA	3/8"	1 1/4"	NARDINI	TT1000 TT1200 MS1400 MS1600 ND1500 ND1700 IN2000 IN2500 SZ2000 SZ2500 AM25 32 40	AXA AXA BXA BXA CXA CXA CA DA DA DA EA EA	3/8"	1 1/4"			
			1"	1 1/2"				1"	1 1/2"				1"	1 1/2"			
ALPHA	A330 A400 A460 A550	BXA CXA CA DA	3/8"	1 1/4"	HARDINGE		AXA	1/2"	1"				HARRISON	11", 12" & 13" 17"	BXA CA	3/8"	1 1/4"
			1"	1 1/2"				1"	1 1/2"							1"	1 1/2"
AMERICAN	14"B, 16"C & 20"D 20"E & 25"F 25"G, 32"H, 32"I & 40"J	CA DA EA	1"	1 1/2"	HENDEY	9" 12" & 1GP 2GP, 4C, 14" & 16" 18", 20" & 24"	AXA BXA CXA CA	1/2"	1"				HERCULES	40	DA or EA	1 1/2"	2 1/2"
			1 1/4"	2"				1 1/4"	2"							1 1/4"	2"
ATLAS	6", 10" & 12"	AXA	1/2"	1"	HERCULES AJAX	14" 18" 24"	CXA CA DA	3/8" 1" 1 1/4"	1 1/4" 1 1/2" 2"				NEBEL	1307, 2013 & 2516 SB-2516-20 & HXB26/45	CXA CA or DA CA or DA	3/8"	1 1/4"
AXELSON	14" & 16"B 20"W, 20"D, 25"E 2516 & 3419 32F	CA DA DA EA	1"	1 1/2"	IKEGAI	20"	CA	1"	1 1/2"							OKUMA	LS14"LK 18"LS & 21"LS
			1 1/4"	2"				1 1/4"	2"				1"	1 1/2"			
BARER MEUSER	MOL16", MIL18" MIL18", 20" & 22" MIL18", 24", MIV24", 28" & 32"	CXA CXA CA or DA CA or DA	3/8"	1 1/4"	KERRY	11" & 13"	AXA	1/2"	1"				REED PRENTICE	14" & 16" 20"	CA DA	1"	1 1/2"
			1 1/4"	2"				1 1/4"	2"	1"	1 1/2"						
BOYE & EMMES	14" & 16" 18", 20" & 22" 25" & 32"	CA DA EA	1"	1 1/2"	LEBLOND DUAL DRIVE	15"	CXA	3/8"	1 1/4"	RIVETT	608, 715R & 9185 1020A	AXA BXA	1/2"	1"			
			1 1/4"	2"				1 1/4"	2"				1/2"	1"			
BRIDGEPORT ROMI	13-5 16-8 20-10	BXA CXA CA	3/8"	1 1/4"	LEBLOND HEAVY DUTY	1610, NE-2013 & 2516 NF-2516 & 3220 NI-3220 & 4025 NK-4025 & 5032	CXA CA DA EA	3/8"	1 1/4"	ROCKWELL	10" & 11" 14"	AXA BXA	1/2"	1"			
			1"	1 1/2"				1"	1 1/2"				1"	1 1/2"			
CARROL & JAMIESON	15", 16" & 18"	CXA	3/8"	1 1/4"	LEBLOND REGAL	13" 15" 17", 19", 21" & 24"	BXA CXA CA	3/8"	1 1/4"	SHARP		AXA BXA CXA CA	3/8"	1 1/4"			
			1"	1 1/2"				1"	1 1/2"				1"	1 1/2"			
CINCINNATI HYDRASHIFT	10" & 12 1/2" 15" & 18" 21" 26"	BXA CXA CA DA	3/8"	1 1/4"	LEHMANN BRANDES	16", 18" & 20" 22", 25", 32" & 36"	CA EA	1"	1 1/2"	SHELDON	10" 11" & 13" 15" & 17"	AXA BXA CXA or CA	1/2"	1"			
			1 1/4"	2"				1 1/4"	2"				1"	1 1/2"			
CINCINNATI TRAY LATHES	15" 18"	BXA CXA	3/8"	1 1/4"	LOGAN	9", 10", 11" & 12" 14"	AXA BXA	1/2"	1"	SHELDON SEBASTIAN	13" 15"	BXA CXA or CA	3/8"	1 1/4"			
			1"	1 1/2"				1"	1 1/2"				1"	1 1/2"			
CINCINNATI HEAVY DUTY LATHES	14" 16" 18" & 20" 22" & 24"	BXA CXA CA DA	3/8"	1 1/4"	MAZAK	14" 17" 18-21-860 24" 30"	CXA CA CA DA EA	3/8"	1 1/4"	SIGMA	SN20A SV18R-15 SN4016, 4518 & 5020 SN55-22, 6325 & 71-28	BXA CXA CA CA or DA	3/8"	1 1/4"			
			1"	1 1/2"				1"	1 1/2"				1"	1 1/2"			
CLAUSING	10 1300 Series 1400 & 15" Series	AXA BXA CXA	1/2"	1"	MISAL	K12 & K13 K14 & K16	AXA BXA	1/2"	1"	SOUTH BEND	9 & 10 1307, 13 & 14 16" 17"	AXA BXA BXA or CXA CA	1/2"	1"			
			3/8"	1 1/4"				3/8"	1 1/4"				3/8"	1 1/4"			
CLAUSING COLCHESTER	13" 15" 17" & 21"	BXA CXA CA	3/8"	1 1/4"	MONARCH	10" 13 (60 & 61) K-15 KOMPACT 1000EE & 16 (60 & 61) 62 SERIES 1610 20" (60 & 61) 62 SERIES 2013 MODEL M & 62 SER. 2516 MODEL N & 80 SER. 2516 80 SER. 3220 MODEL NN 90 SER. 4025	AXA BXA CXA CA CA DA DA DA DA EA EA	1/2"	1"	SOUTH IND	15"	CXA	3/8"	1 1/4"			
			1"	1 1/2"				1"	1 1/2"				1"	1 1/2"			
CRAFTSMAN	12"	AXA	1/2"	1"	MORRI SEIKI	16 1/8" 17 1/8" & 18 3/4" 20 1/2"	CXA CA DA	3/8"	1 1/4"	SPRINGFIELD	14" & 16" 18", 20", 22" & 24" 30"	CA DA EA	1"	1 1/2"			
DELTA	10" & 11" 14"	AXA BXA	1/2"	1"				1 1/4"	1 1/2"				1 1/2"	1"	1 1/2"	1"	1 1/2"
ELGIN		AXA	1/2"	1"	STANDARD MODERN	10" 12" 14" & 16" 17"	BXA CXA CXA or CA CA	3/8"	1 1/4"	VDF	42DSL, 18RO 21RO & 48DSL M530 & V630 E560, M670 & V800	CXA CXA CA DA	3/8"	1 1/4"			
ELLIOTT	15 & 16	CXA	3/8"	1 1/4"				1 1/4"	2"				1 1/4"	2"	1"	1 1/2"	1"
ELLIOTT CONCORD	18 & 21	CA	1"	1 1/2"	VOEST	17" & 20"	CXA	3/8"	1 1/4"								
EMCO MAIER	SUPER II ELNOMAT13S ELNOMAT15D	AXA BXA CXA	1/2" 3/8" 3/8"	1" 1 1/4" 1 1/4"													
GALLIC	14" & 16"	BXA	3/8"	1 1/4"													

"T" NUT ORDERING INFORMATION



MAKE OF LATHE	SWING	A	B	C	D	E

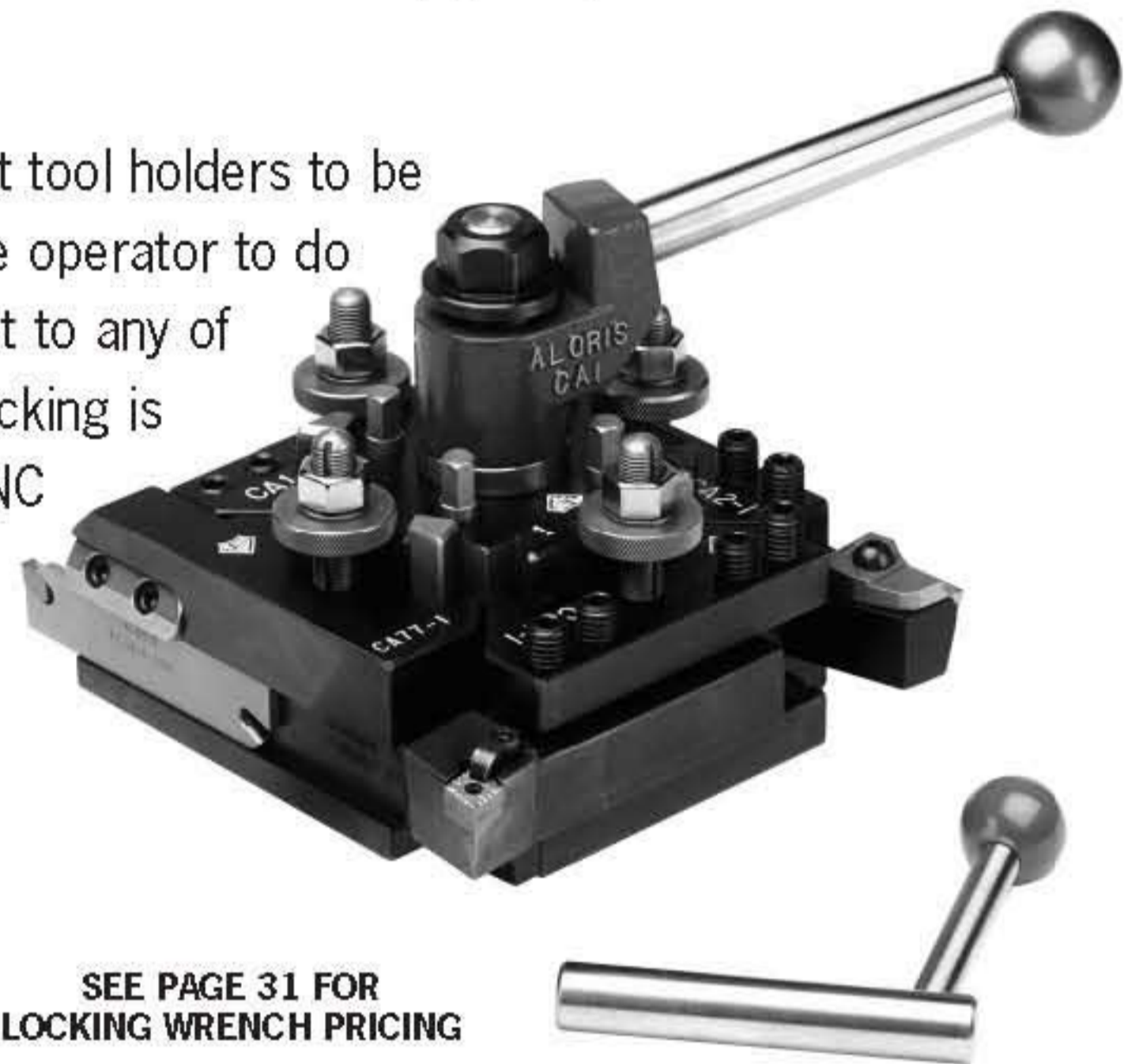
When ordering, please give name and swing of lathe or specified dimensions. Without this information "T" nut will be supplied to fit most popular lathes. There is an extra charge for special "T" nuts and riser-blocks. Please fax the above chart with your order.

ALORIS INDEXABLE TOOL POSTS

FOR MANUAL AND CNC LATHES

- Precision Engineered to Assure Repetitive Accuracy
- Accuracy Within Millionths!
- CNC Applications
- Super Rigidity
- No Shims Required
- Available with Anti-rotation Key (Optional)
- Furnished with Blank "T" Nut or Machined "T" Nut (Optional)

The Aloris Indexable Tool Post allows 4 independent tool holders to be locked to the tool post simultaneously. This allows the operator to do multiple operations by means of indexing the tool post to any of the 24 locking positions. The index positioning and locking is accomplished by the same means as a turret on a CNC Lathe. This is the ultimate in productivity on Manual and CNC Lathes without indexing capabilities. Two standard Aloris Tool Holders can be mounted with no modification or you can modify some existing Aloris holders to fit the indexable tool post.



SEE PAGE 31 FOR LOCKING WRENCH PRICING

- Industry Standard
- Repeatability of .00005
- Some standard Aloris Tool Holders will fit if slightly modified
- All components heat treated and ground
- 24 positions, 15° precision indexing through heat treated precision ground face gears
- Precision engineered to assure repetitive accuracy
- Full length wedge lock as featured on the traditional Aloris Tool Post for ultimate rigidity
- Optionally furnished with anti-rotation key precision fit to lathe compound (*eliminates rotation and movement of tool post under extreme cutting conditions*)
- The highest quality lathe tool accessories available
- Only 3 sizes required for up to 36 inch swing
- Over forty five years of machine tool manufacturing experience
- Mounting wrench included with tool post

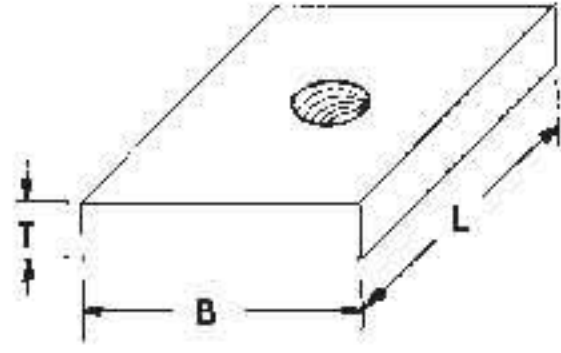
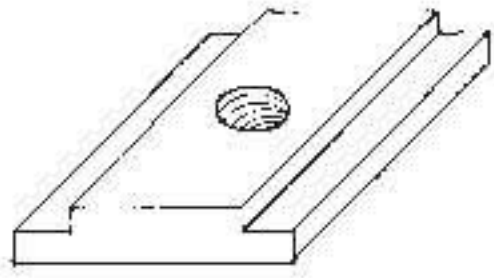
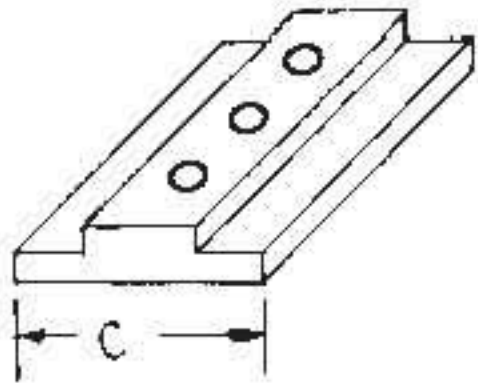


Face Gear for Indexable Tool Posts

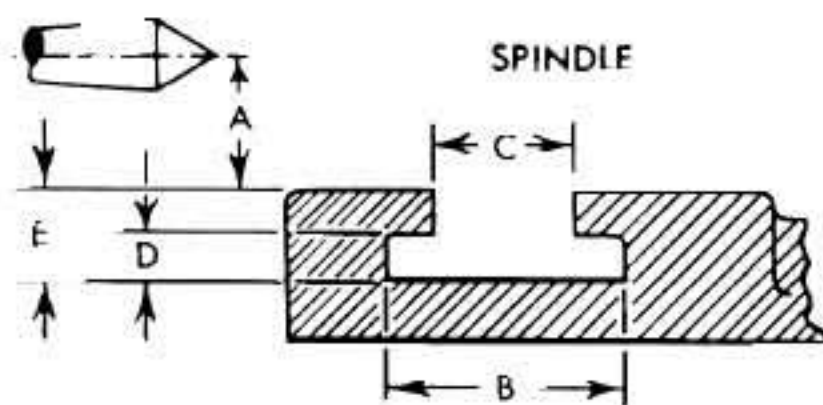
ORDERING INFORMATION

SERIES				SERIES				SERIES			
SWING		UP-15"		SWING		15"-22"		SWING		22"-36"	
ORDER #		BXA-I		ORDER #		CA-I		ORDER #		DA-I	
A	B	C	D	A	B	C	D	A	B	C	D
3"	2¾"	5"	9/16"	4"	3¾"	6¾"	¾"	5"	4½"	8¾"	7/8"

ALORIS INDEXABLE TOOL POST OPTIONS

	"T" NUT BLANK	ORDER # BXA-I-TB*	ORDER # CA-I-TB*	ORDER # DA-I-TB*
	"T" DIM	1/2"	3/4"	7/8"
	"B" DIM	2 1/4"	2 1/2"	3"
	"L" DIM	2 1/2"	3 1/2"	4 1/2"
Nut and stud included. Customer to machine. Furnished with tapped hole only.				
	OPTIONAL "T" NUT MACHINED (FILL OUT CHART BELOW)	ORDER # BXA-I-TM*	ORDER # CA-I-TM*	ORDER # DA-I-TM*
	Machined by Aloris. Ready for installation.			
	OPTIONAL ANTI-ROTATION KEY (CUSTOMER TO FINISH "C" DIMENSION IN THE CHART BELOW)	ORDER # BXA-I-ARS*	ORDER # CA-I-ARS*	ORDER # DA-I-ARS*
	Semi-finished.			
	OPTIONAL "C" DIM. ANTI-ROTATION KEY (ALORIS TO FINISH "C" DIMENSION IN THE CHART BELOW)	ORDER # BXA-I-ARF*	ORDER # CA-I-ARF*	ORDER # DA-I-ARF*
	Finished and assembled by Aloris. (Precision Ground.)			

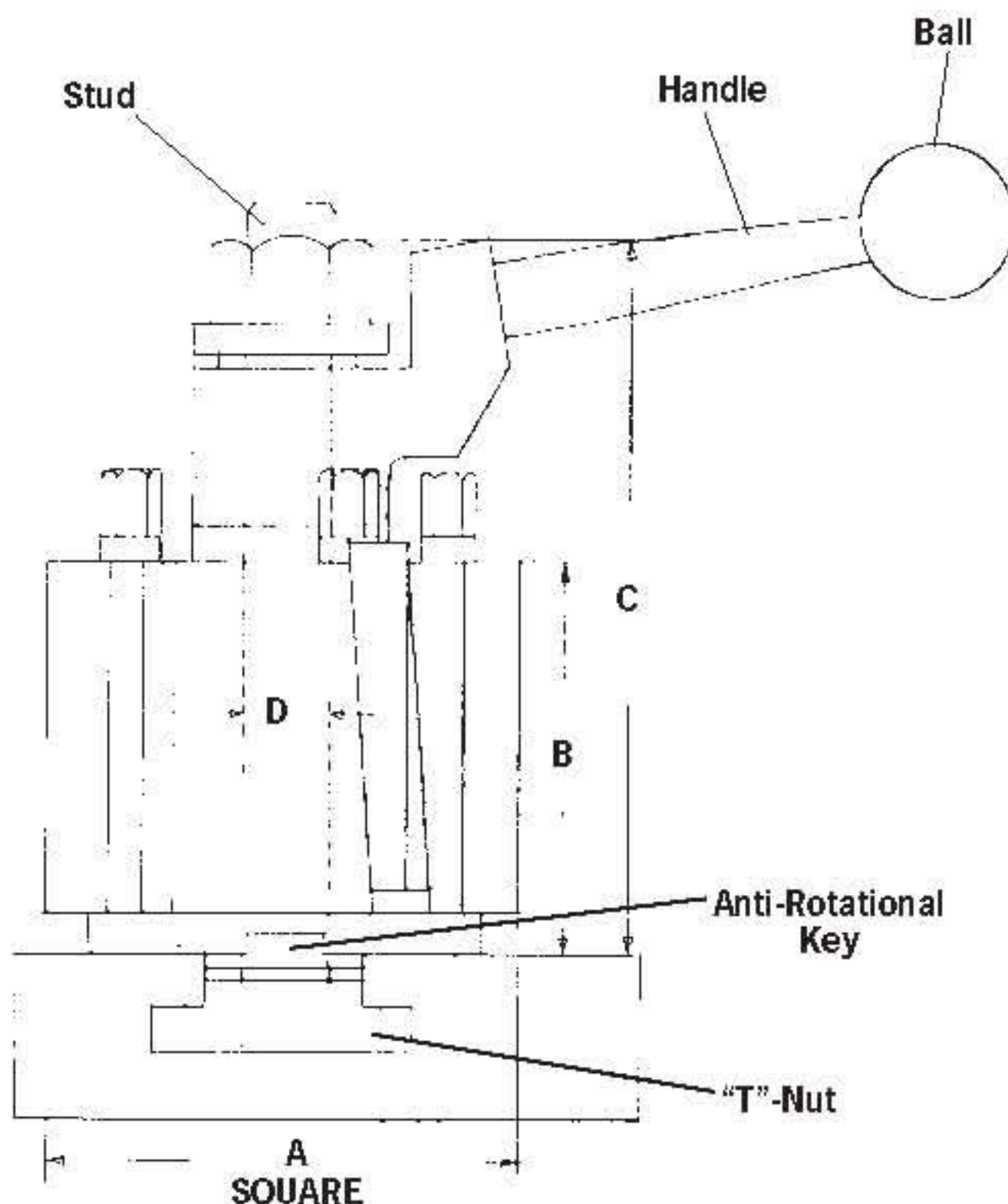
"T" NUT ORDERING INFORMATION



(Please Complete Chart and Fax)

MAKE OF LATHE	SWING	A	B	C	D	E

When ordering, please give name and swing of lathe or specified dimensions. Without this information "T" nut will be supplied to fit most popular lathes. There is an extra charge for special "T" nuts and riser-blocks. Please fax the above chart with your order.



INDEXABLE TOOL POST REPLACEMENT PARTS

Not interchangeable with standard tool post parts.

"T" BOLT ASSY = "T"-NUT AND STUD (INDEXABLE)			
ORDER #	BXA-I-TB*	CA-I-TB*	DA-I-TB*




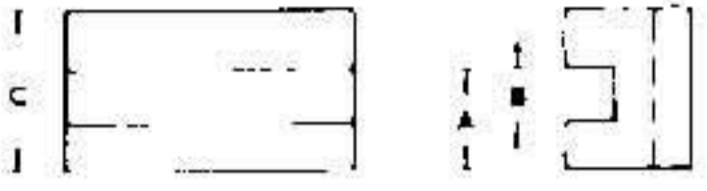



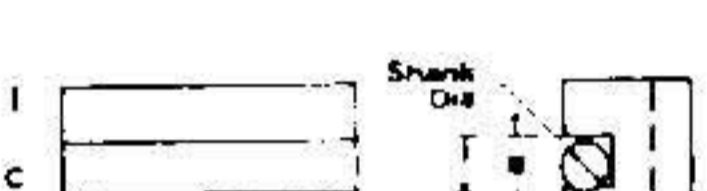

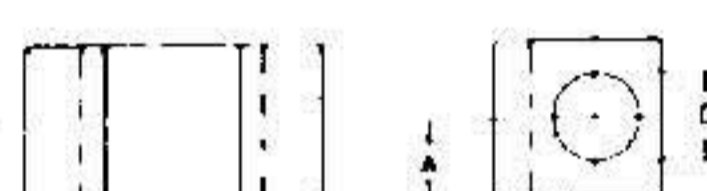

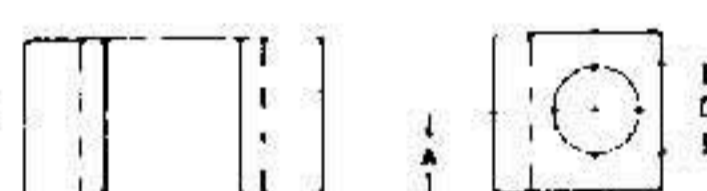

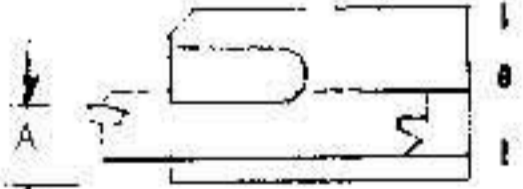


HANDLES (INDEXABLE)			
ORDER #	BXA-I-HANDLE*	CA-I-HANDLE*	DA-I-HANDLE*

BALLS (INDEXABLE)			
ORDER #	BXA-I-BALL*	CA-I-BALL*	DA-I-BALL*

FLANGE NUTS (INDEXABLE)			
ORDER #	BXA-I-FN*	CA-I-FN*	DA-I-FN*

LOCKING WRENCH			
ORDER #	BXA-I-LW*	CA-I-LW*	DA-I-LW*

ALORIS INDEXABLE TOOL HOLDERS

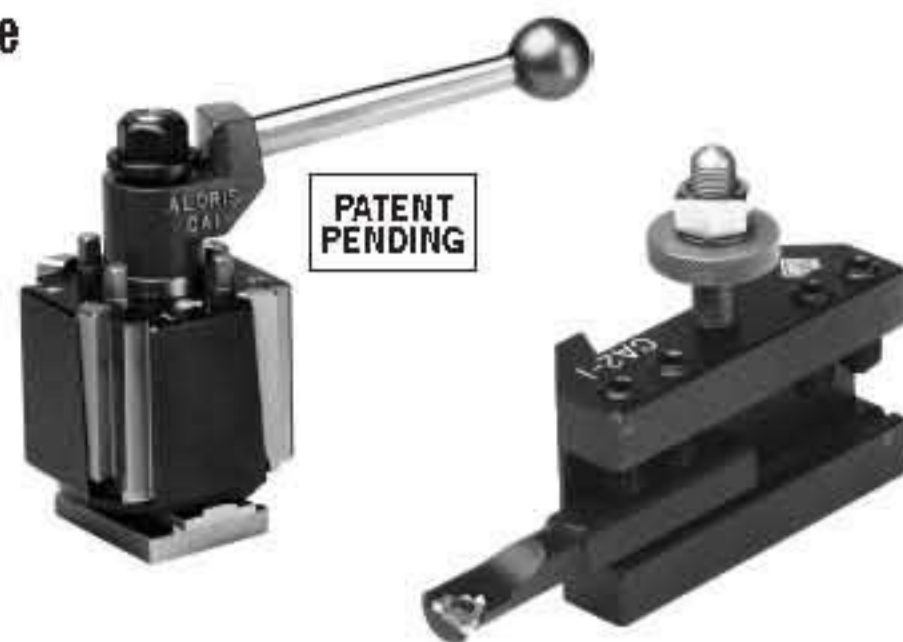
#1-I 	TURNING & FACING HOLDER 	ORDER # BXA-1-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>1³/₁₆</td> <td>1¹/₁₆</td> <td>1³/₄</td> <td>5/8</td> </tr> </tbody> </table>	A	B	C	Tool Cap	1 ³ / ₁₆	1 ¹ / ₁₆	1 ³ / ₄	5/8	ORDER # CA-1-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>1¹³/₁₆</td> <td>1"</td> <td>2¹/₂</td> <td>1"</td> </tr> </tbody> </table>	A	B	C	Tool Cap	1 ¹³ / ₁₆	1"	2 ¹ / ₂	1"	ORDER # DA-1-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>2¹/₄</td> <td>1¹/₄</td> <td>3¹/₈</td> <td>1¹/₄</td> </tr> </tbody> </table> <p>Turning and facing accommodates a variety of turning or facing tools. Capacity listed in chart.</p>	A	B	C	Tool Cap	2 ¹ / ₄	1 ¹ / ₄	3 ¹ / ₈	1 ¹ / ₄
A	B	C	Tool Cap																									
1 ³ / ₁₆	1 ¹ / ₁₆	1 ³ / ₄	5/8																									
A	B	C	Tool Cap																									
1 ¹³ / ₁₆	1"	2 ¹ / ₂	1"																									
A	B	C	Tool Cap																									
2 ¹ / ₄	1 ¹ / ₄	3 ¹ / ₈	1 ¹ / ₄																									
#1-IX 	OVERSIZE TURNING & FACING HOLDER 	ORDER # BXA-1-IX <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>1³/₁₆</td> <td>3/4</td> <td>1³/₄</td> <td>3/4</td> </tr> </tbody> </table>	A	B	C	Tool Cap	1 ³ / ₁₆	3/4	1 ³ / ₄	3/4	ORDER # CA-1-IX <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>1¹³/₁₆</td> <td>1¹/₄</td> <td>2¹/₂</td> <td>1¹/₄</td> </tr> </tbody> </table>	A	B	C	Tool Cap	1 ¹³ / ₁₆	1 ¹ / ₄	2 ¹ / ₂	1 ¹ / ₄	ORDER # DA-1-IX <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>2⁵/₁₆</td> <td>1¹/₂</td> <td>3¹/₈</td> <td>1¹/₂</td> </tr> </tbody> </table> <p>Turning and facing accommodates a variety of turning or facing tools. Capacity listed in chart. Larger tool capacity.</p>	A	B	C	Tool Cap	2 ⁵ / ₁₆	1 ¹ / ₂	3 ¹ / ₈	1 ¹ / ₂
A	B	C	Tool Cap																									
1 ³ / ₁₆	3/4	1 ³ / ₄	3/4																									
A	B	C	Tool Cap																									
1 ¹³ / ₁₆	1 ¹ / ₄	2 ¹ / ₂	1 ¹ / ₄																									
A	B	C	Tool Cap																									
2 ⁵ / ₁₆	1 ¹ / ₂	3 ¹ / ₈	1 ¹ / ₂																									
#2-I 	TURNING, FACING & BORING HOLDER 	ORDER # BXA-2-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Sq Shank</th> </tr> </thead> <tbody> <tr> <td>1³/₁₆</td> <td>1¹/₁₆</td> <td>1³/₄</td> <td>5/8 1/2</td> </tr> </tbody> </table>	A	B	C	Sq Shank	1 ³ / ₁₆	1 ¹ / ₁₆	1 ³ / ₄	5/8 1/2	ORDER # CA-2-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Sq Shank</th> </tr> </thead> <tbody> <tr> <td>1¹³/₁₆</td> <td>1"</td> <td>2¹/₂</td> <td>1" 1³/₁₆</td> </tr> </tbody> </table>	A	B	C	Sq Shank	1 ¹³ / ₁₆	1"	2 ¹ / ₂	1" 1 ³ / ₁₆	ORDER # DA-2-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Sq Shank</th> </tr> </thead> <tbody> <tr> <td>2¹/₄</td> <td>1¹/₄</td> <td>3¹/₈</td> <td>1¹/₄ 1"</td> </tr> </tbody> </table> <p>Boring, turning and facing holder accommodates round shank tools in "V" groove as well as turning and facing tools as the #1 holder. Capacity listed in chart.</p>	A	B	C	Sq Shank	2 ¹ / ₄	1 ¹ / ₄	3 ¹ / ₈	1 ¹ / ₄ 1"
A	B	C	Sq Shank																									
1 ³ / ₁₆	1 ¹ / ₁₆	1 ³ / ₄	5/8 1/2																									
A	B	C	Sq Shank																									
1 ¹³ / ₁₆	1"	2 ¹ / ₂	1" 1 ³ / ₁₆																									
A	B	C	Sq Shank																									
2 ¹ / ₄	1 ¹ / ₄	3 ¹ / ₈	1 ¹ / ₄ 1"																									
#2-IX 	OVERSIZE TURNING, FACING & BORING HOLDER 	ORDER # BXA-2-IX <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Sq Shank</th> </tr> </thead> <tbody> <tr> <td>1³/₁₆</td> <td>3/4</td> <td>1³/₄</td> <td>3/4 1/2</td> </tr> </tbody> </table>	A	B	C	Sq Shank	1 ³ / ₁₆	3/4	1 ³ / ₄	3/4 1/2	ORDER # CA-2-IX <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Sq Shank</th> </tr> </thead> <tbody> <tr> <td>1¹³/₁₆</td> <td>1¹/₄</td> <td>2¹/₂</td> <td>1¹/₄ 1³/₁₆</td> </tr> </tbody> </table>	A	B	C	Sq Shank	1 ¹³ / ₁₆	1 ¹ / ₄	2 ¹ / ₂	1 ¹ / ₄ 1 ³ / ₁₆	ORDER # DA-2-IX <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>2⁵/₁₆</td> <td>1¹/₂</td> <td>3¹/₈</td> <td>1¹/₂</td> </tr> </tbody> </table> <p>Boring, turning and facing holder accommodates round shank tools in "V" groove as well as turning and facing tools as the #1 holder. Capacity listed in chart. Larger tool capacity.</p>	A	B	C	Tool Cap	2 ⁵ / ₁₆	1 ¹ / ₂	3 ¹ / ₈	1 ¹ / ₂
A	B	C	Sq Shank																									
1 ³ / ₁₆	3/4	1 ³ / ₄	3/4 1/2																									
A	B	C	Sq Shank																									
1 ¹³ / ₁₆	1 ¹ / ₄	2 ¹ / ₂	1 ¹ / ₄ 1 ³ / ₁₆																									
A	B	C	Tool Cap																									
2 ⁵ / ₁₆	1 ¹ / ₂	3 ¹ / ₈	1 ¹ / ₂																									
#100-I 	BORING BAR HOLDER 	ORDER # BXA-100-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>7/8</td> <td>1³/₄</td> <td>3/4</td> </tr> </tbody> </table>	A	B	D	7/8	1 ³ / ₄	3/4	ORDER # CA-100-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1¹/₈</td> <td>2¹/₄</td> <td>1"</td> </tr> </tbody> </table>	A	B	D	1 ¹ / ₈	2 ¹ / ₄	1"	ORDER # DA-100-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1³/₈</td> <td>2³/₄</td> <td>1¹/₄</td> </tr> </tbody> </table> <p>Heavy duty boring bar holder with precision ground bore and set screw clamping to provide maximum rigidity and alignment of boring bars. Capacities listed in chart. See the full line of boring bars on page 40-44.</p>	A	B	D	1 ³ / ₈	2 ³ / ₄	1 ¹ / ₄						
A	B	D																										
7/8	1 ³ / ₄	3/4																										
A	B	D																										
1 ¹ / ₈	2 ¹ / ₄	1"																										
A	B	D																										
1 ³ / ₈	2 ³ / ₄	1 ¹ / ₄																										
#104-I 	BORING BAR HOLDER 	ORDER # BXA-104-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1"</td> <td>2"</td> <td>1"</td> </tr> </tbody> </table>	A	B	D	1"	2"	1"	ORDER # CA-104-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1¹/₄</td> <td>2¹/₂</td> <td>1¹/₄</td> </tr> </tbody> </table>	A	B	D	1 ¹ / ₄	2 ¹ / ₂	1 ¹ / ₄	ORDER # DA-104-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1⁵/₈</td> <td>3¹/₄</td> <td>1¹/₂</td> </tr> </tbody> </table> <p>Heavy duty boring bar holder with precision ground bore and set screw clamping to provide maximum rigidity and alignment of boring bars. Capacities listed in chart. See the full line of boring bars on page 40-44.</p>	A	B	D	1 ⁵ / ₈	3 ¹ / ₄	1 ¹ / ₂						
A	B	D																										
1"	2"	1"																										
A	B	D																										
1 ¹ / ₄	2 ¹ / ₂	1 ¹ / ₄																										
A	B	D																										
1 ⁵ / ₈	3 ¹ / ₄	1 ¹ / ₂																										
#77-I 	CUTOFF HOLDER (CARBIDE) 	ORDER # BXA-77-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>1⁵/₁₆</td> <td>1³/₄</td> </tr> </tbody> </table>	A	B	1 ⁵ / ₁₆	1 ³ / ₄	ORDER # CA-77-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>1¹/₄</td> <td>2¹/₂</td> </tr> </tbody> </table>	A	B	1 ¹ / ₄	2 ¹ / ₂	ORDER # DA-77-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>1⁵/₁₆</td> <td>3</td> </tr> </tbody> </table> <p>Cut-off & Grooving Holders – Designed for extreme rigidity under heavy cutting conditions. See page 33 for blades and inserts.</p>	A	B	1 ⁵ / ₁₆	3												
A	B																											
1 ⁵ / ₁₆	1 ³ / ₄																											
A	B																											
1 ¹ / ₄	2 ¹ / ₂																											
A	B																											
1 ⁵ / ₁₆	3																											
#77-I 	WEDGE & LOCK SCREW 	WSA-BXA-77-I Clamp & Screws	WSA-CA-77-I Clamp & Screws	WSA-DA-77-I Clamp & Screws																								
#53-I #54-I #55-I 	MORSE TAPER HOLDER 	ORDER # BXA-53-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>Taper Hole Size</th> </tr> </thead> <tbody> <tr> <td>7/8</td> <td>1³/₄</td> <td>#3 MT</td> </tr> </tbody> </table>	A	B	Taper Hole Size	7/8	1 ³ / ₄	#3 MT	ORDER # CA-54-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>Taper Hole Size</th> </tr> </thead> <tbody> <tr> <td>1¹/₄</td> <td>2¹/₂</td> <td>#4 MT</td> </tr> </tbody> </table>	A	B	Taper Hole Size	1 ¹ / ₄	2 ¹ / ₂	#4 MT	ORDER # DA-55-I <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>Taper Hole Size</th> </tr> </thead> <tbody> <tr> <td>1⁵/₈</td> <td>3¹/₄</td> <td>#5 MT</td> </tr> </tbody> </table> <p>Morse Taper Holder – Precision ground taper bore with tang locks. Morse Taper drills securely so operator can power feed drills with the carriage rather than manually with the conventional tailstock.</p>	A	B	Taper Hole Size	1 ⁵ / ₈	3 ¹ / ₄	#5 MT						
A	B	Taper Hole Size																										
7/8	1 ³ / ₄	#3 MT																										
A	B	Taper Hole Size																										
1 ¹ / ₄	2 ¹ / ₂	#4 MT																										
A	B	Taper Hole Size																										
1 ⁵ / ₈	3 ¹ / ₄	#5 MT																										

Spare parts available upon request. Standard Aloris holders that can be modified by mitering the corners to prevent interference when mounting onto tool post: #1, #2, #4, #4D, #100, #141, #104, #7, #35.

ALORIS INDEXABLE STARTER SETS

FOR MANUAL AND CNC LATHES

- Precision Engineered to Assure Repetitive Accuracy
- Accuracy Within Millionths!
- CNC Applications
- Super Rigidity
- No Shims Required
- Available with Anti-rotation Key (Optional)
- Furnished with Blank "T" Nut or Machined "T" Nut (Optional) See page 31



PATENT PENDING



This precision engineered tool post was designed by Aloris Tool Technology Co. Inc. to solve typical problems encountered by machinists. This tool post incorporates the full length Aloris wedge design for maximum rigidity, individual height adjustments—so shims are not required, and superior indexing which allows the machinist to select any of the tools which are mounted to accomplish multiple operations without removing tools from the holder absolutely reduces set-up time and cycle time, and enhances accuracy.

The basic set consists of one tool post, mounting wrench, "T" nut blank, and four holders: 1 pc. – #1-I turning and facing; 2 pcs. – #2-I facing, turning, and boring; 1 pc. – #77-I cutoff. Blades, inserts, and boring bars not included.

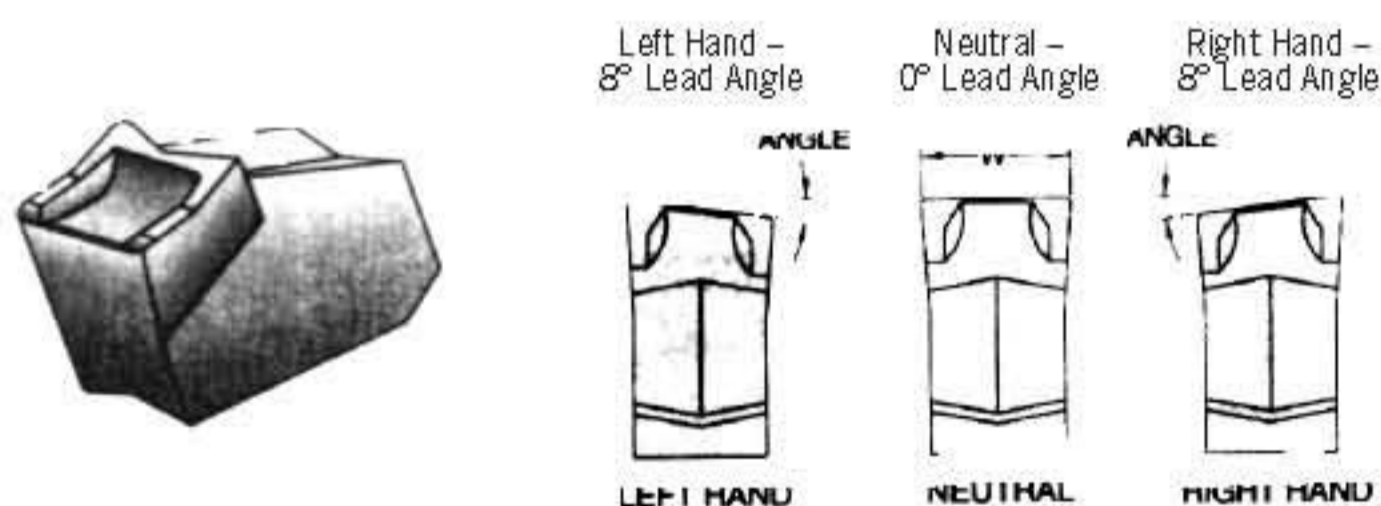
- Aloris recommends customers to order the indexable tool post with the optional Anti-rotation Key which avoids movement under extreme conditions.
- Spare parts pricing available upon request.

SERIES	BXA-I	CA-I	DA-I
ORDER #	BXA-I-SET	CA-I-SET	DA-I-SET
LIST PRICE FOR SET			
W/OVER 5% SAVINGS			

GT STYLE SELF GRIP CARBIDE CUT-OFF INSERTS

WITH POSITIVE RAKE SHARP EDGE FOR MANUAL & CNC LATHES

FOR DESCRIPTION OF CARBIDE GRADES & CUTTING EDGE GEOMETRY SEE PAGE 54



	Catalog Number	Cutting Edge Geometry	Cutting Width	Lead Angle
	GTN 2"	P	.087	0
††	GT L/R 2"	P	.087	8
††	GT L/R 2.4"	P	.093	8
	GTN 3"	P	.120	0
††	GT L/R 3"	P	.120	8
	GTN 4"	P	.160	0
††	GT L/R 4"	P	.160	8
	GTN 4.8"	P	.187	0
††	GT L/R 4.8"	P	.187	8
	GTN 5"	P	.200	0
††	GT L/R 5"	P	.200	8
	GTN 6"	P	.250	0
††	GT L/R 6"	P	.250	8
	GTN 8"	P	.315	0
††	GT L/R 8"	P	.315	4
	GTN 9"	P	.375	0
††	GT L/R 9"	P	.375	4

††Specify left or right hand.

Inserts are priced individually, however, they must be purchased in packages of 10. For blades see page 46.

SELF LOCKING BLADES FOR #77-I HOLDERS



	BXA-I	CA-I	DA-I
ORDER #	SGIH 19-2"	SGIH 26-2"	SGIH 32-3"
WIDTH OF CUT x HEIGHT	.093 x .750	.093 x 1.00	.120 x 1.25
ORDER #	SGIH 19-3"	SGIH 26-3"	SGIH 32-5"
WIDTH OF CUT x HEIGHT	.120 x .750	.120 x 1.00	.187 x 1.25
ORDER #		SGIH 26-4"	SGIH 32-6"
WIDTH OF CUT x HEIGHT		.160 x 1.00	.250 x 1.25
ORDER #		SGIH 26-5"	
WIDTH OF CUT x HEIGHT		.187 x 1.00	

See full selection of cutting tools on pages 49 – 54.

ALORIS DOUBLE-LOCK TOOL HOLDERS

AVAILABLE IN RIGHT OR LEFT HAND VERSIONS AND DESIGNED TO ACCEPT STANDARD INSERT.

A unique locking device exerts a two-way force on the carbide insert: downward and tight against shoulder to assure rigid, positive seating.



ORDERING INFORMATION							REPLACEMENT PARTS					
HOLDER ORDER #			DIMENSIONS				INSERT SIZE		CARBIDE SEAT	HEX LOCK PIN	LOCK SCREW	
30° SIDE CUT	RIGHT	LEFT	A	B	C	D	I.C.	THICK	ORDER #	ORDER #	ORDER #	
AD5-3	ADS5-3	ADS5-3L	5/8	5/8	4 1/2	9/16	3/8	1/8	ST-1*	LP-1*	LS-1*	
AD6-3	ADS6-3	ADS6-3L	3/4	3/4	4 1/2	11/16	3/8	1/8	ST-1*	LP-1*	LS-1*	
AD8-4	ADS8-4	ADS8-4L	1"	1"	6"	15/16	1/2	3/16	ST-2*	LP-2*	LS-2*	
AD10-4	ADS10-4	ADS10-4L	1"	1 1/4	6"	1 3/16	1/2	3/16	ST-2*	LP-2*	LS-2*	
AD10-5	ADS10-5	ADS10-5L	1 1/4	1 1/4	7"	1 5/32	5/8	1/4	ST-3*	LP-3*	LS-3*	
AD12-5	ADS12-5	ADS12-5L	1"	1 1/2	8"	1 13/32	5/8	1/4	ST-3*	LP-3*	LS-3*	

CARBIDE INSERTS FOR DOUBLE-LOCK TOOL HOLDERS*

	DOUBLE-LOCK HOLDER #	DIMENSIONS			INSERT ORDER #*
		I.C.	T	R	
STYLE TNMG 5° NEGATIVE 	AD5-3, ADS5-3, ADS5-3L, AD6-3, ADS6-3, ADS6-3L	3/8	3/16	1/32	TNMP-332*
	AD8-4, ADS8-4, ADS8-4L, AD10-4, ADS10-4, ADS10-4L	1/2	3/16	1/32	TNMG-432* TNMP-432*
STYLE TNMP 5° POSITIVE 	AD10-5, ADS10-5, ADS10-5L, AD12-5, ADS12-5, ADS12-5L	5/8	1/4	3/64	TNMG-543* TNMP-543*

See full selection of inserts on pages 49 – 54.

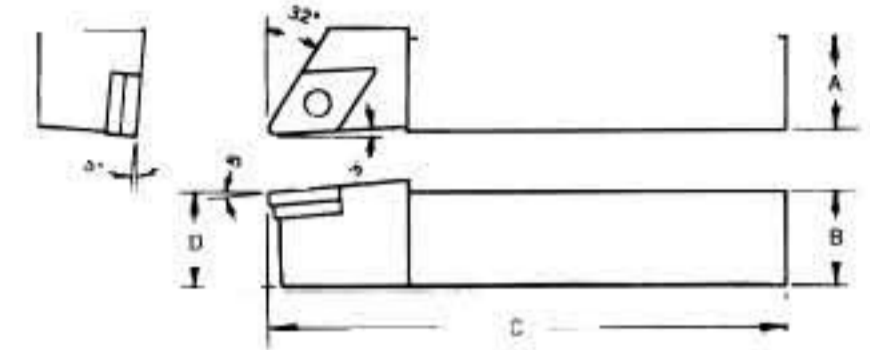
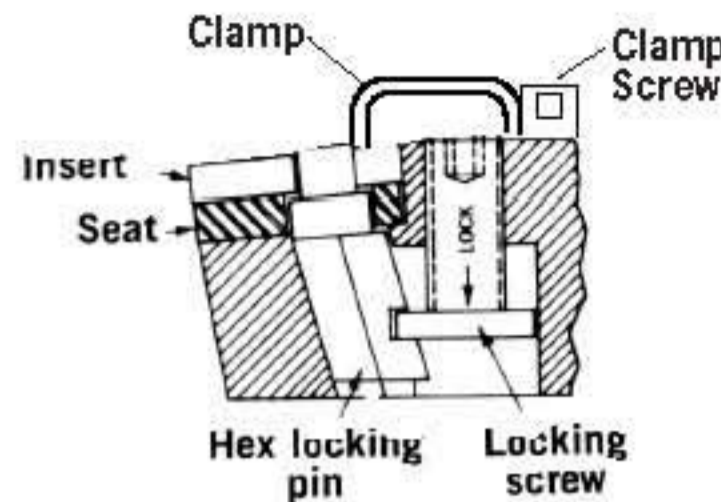
ALORIS PROFILING TOOL HOLDERS AT15 & AT15L

AVAILABLE IN RIGHT OR LEFT HAND VERSIONS FOR TURNING OR PROFILING.
THESE HOLDERS ACCOMMODATE STANDARD DIAMOND SHAPE INSERTS.

A unique locking device which exerts a two-way force on the insert: downward and tight against the shoulder to assure rigid, positive seating. Insert choice determines positive or negative rake turning. Holders supplied as shown less carbide inserts.



RIGHT HAND SHOWN



ORDERING INFORMATION						REPLACEMENT PARTS						
HOLDER ORDER #		DIMENSIONS				INSERT SIZE		CARBIDE SEAT	HEX LOCK PIN	LOCK SCREW	CLAMP	CLAMP SCREW
RIGHT	LEFT	A	B	C	D	I.C.	THICK					
AT15-6	AT15-6L	3/4	3/4	4 1/4	1 1/8	5/8	3/16	SM-117*	LP-15*	LS-15*	ACK-12*	ASTC-4*
AT15-8	AT15-8L	1"	1"	6"	1 1/8	5/8	OR 1/4					

CARBIDE INSERTS FOR PROFILING TOOL HOLDERS

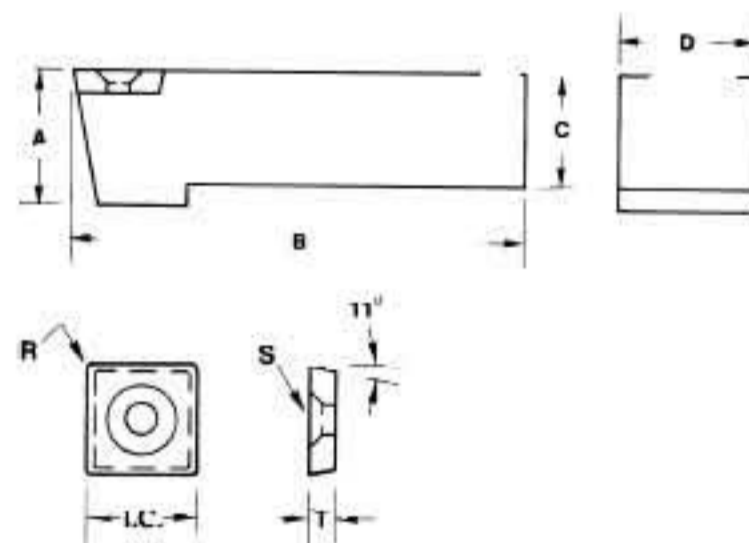
ALL INSERTS BELOW FIT ANY 15 OR 15L TOOL HOLDERS

STYLE	RAKE	DIMENSIONS			INSERT ORDER #*
		I.C.	T	R	
STYLE DNGA	- NEGATIVE RAKE	5/8	3/16	1/32	DNGA-532*
STYLE DNMG	5° NEGATIVE	5/8	3/16	1/32	DNMG-532* DNMS-532*
STYLE DNMZ	5° POSITIVE	5/8	1/4	1/32	DNMZ-542* DNMS-542*
STYLE DNMS	15° POSITIVE	5/8	1/4	1/32	DNMS-542*

*Sold in package of 10 pcs. **100 & up call for price.

See full selection of inserts on pages 49 - 54.

ALORIS SERIES ASIH CHAMFERING, FACING & TURNING HOLDERS



Aloris ASIH Series universal holders accommodate standard square carbide inserts and are designed for chamfering, facing and turning operations. ASIH Series holders are available in four shank sizes and are designed for use in Aloris #1, #2 and #13 quick-change dovetail tool holders or any square shank holder.

Aloris ASIH Series holders accommodate 1/2" I.C. and 3/4" I.C. carbide inserts. An insert holding screw is provided.

ORDERING INFORMATION					REPLACEMENT PARTS						
HOLDER ORDER #	DIMENSIONS				DIMENSIONS			GRADE INSERT #*	SCREW ORDER #	SIZE	
	A	B	C	D	I.C.	T	R				
ASIH-2	3/4	4 3/4	1/2	5/8	1/2	1/8	1/32	ASD-8P*	ASD-8PSCR*	8-32 x 1/2	
ASIH-3	3/4	4 3/4	3/4	5/8	1/2	1/8	1/32	ASD-8P*	ASD-8PSCR*	8-32 x 1/2	
ASIH-4	7/8	4 3/4	3/4	7/8	3/4	3/16	3/64	ASD-12P*	ASD-12PSCR*	10-24 x 3/8	
ASIH-5	7/8	4 3/4	7/8	7/8	3/4	3/16	3/64	ASD-12P*	ASD-12PSCR*	10-24 x 3/8	

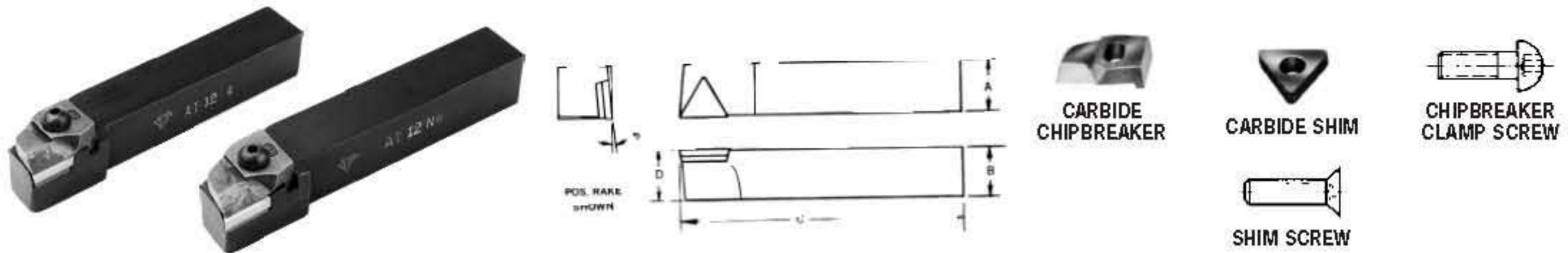
*Sold in package of 10 pcs.

See full selection of inserts on pages 49 - 54.

ALORIS TURNING HOLDERS AT12 & AT12N

AVAILABLE IN POSITIVE OR NEGATIVE RAKE VERSIONS AND DESIGNED TO ACCEPT STANDARD TRIANGULAR INSERTS.

Adjustable carbide chipbreaker provides excellent chip control. Holders supplied as shown less carbide inserts.



HOLDER ORDERING INFORMATION							REPLACEMENT PARTS			
ORDER # POS.	DIMENSIONS				INSERT SIZE		CARBIDE SHIM	SHIM SCREW	CARBIDE CHIPBREAKER	CHIPBREAKER CLAMP SCREW
	A	B	C	D	I.C.	THICK	ORDER #	ORDER #	ORDER #	ORDER #
AT12-2	3/4	1/2	4 1/2	13/16	3/8	1/8	SM-41*	SM-41SS*	1-R*	SCR-12*
AT12-3	3/4	3/4	4 1/2	13/16	3/8	1/8	SM-41*	SM-41SS*	1-R*	SCR-12*
AT12-4	1"	1"	6"	1"	1/2	3/16	SM-37*	SM-37SS*	2-R*	SCR-12*
AT12N-3	3/4	3/4	4 1/2	13/16	3/8	1/8	SM-42*	SM-42SS*	1-R*	SCR-12*
AT12N-4	1"	1"	6"	1"	1/2	3/16	SM-26*	SM-26SS*	2-R*	SCR-12*

CARBIDE INSERTS FOR AT12 AND AT12N

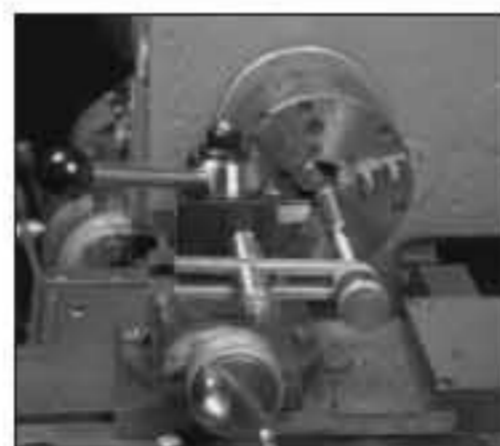
STYLE TPG	HOLDER #	DIMENSIONS			INSERT ORDER #†
		I.C.	T	R	
	AT12-2	3/8	1/8	1/32	TPG-322*
	AT12-3	3/8	1/8	1/32	TPG-322*
	AT12-4	1/2	3/16	1/32	TPG-432*
STYLE TNG	HOLDER #	DIMENSIONS			INSERT ORDER #†
		I.C.	T	R	
	AT12N-3	3/8	1/8	1/64	TNG-321*
	AT12N-4	1/2	3/16	1/32	TNG-432*

†Sold in package of 10 pcs. ††100 & up call for price.

See full selection of inserts on pages 49 – 54.

ALORIS GUIDE STOP

- Speed up multiple piece operations.
- Mounts instantly on any Aloris Tool Post.
- Adjusts 5 ways – non-marring bearings.
- Can mount to vise.



ORDER #

AGS

ALORIS CLASSIC WOOD ALL PURPOSE TOOL TRAY

ADDED CONVENIENCE...SPEEDS PRODUCTION • 11" X 16"

- Keep Lathe area organized – tools close at hand.
- Clamps to rear of Lathe bed without drilling holes.
- Universal mounting bracket included.
- Adjustable height.

ORDER #

ATT



ALORIS SOCKET SCREW "T" – WRENCHES

- These indispensable tools are essential in every Tool Room, Machine Shop, and to all other industrial users.
- Especially useful in hard-to-reach places. Speeds up all socket screw fastening. Greater torque pressure can be applied easily.
- Drivers are made of Special Alloy Steel, hardened for longer service.
- Each set of 8 comes in own plastic case.



ORDERING INFORMATION		
"T"-WRENCH ORDER #	WIDTH ACROSS FLATS	OVERALL LENGTH
TW-1*	1/16	5
TW-2*	1/16	5
TW-3*	1/16	5
TW-4*	1/8	5
TW-5*	1/8	5
TW-6*	1/8	5
TW-7*	1/8	5 1/4
TW-8*	1/4	5 1/4

ALORIS THREADING TOOL HOLDER MODEL AT-8



ORDER # AT-8

Especially designed to hold interchangeable high speed and carbide insert threading blades. When the cutting blade is mounted on the upper surface of the holder, and spindle direction reversed, thread cutting can be accomplished without danger of hitting shoulders, thereby speeding up threading operation. Lead angle adjustment is obtained through set screw changes.

Various pitches of precision ground high speed steel threading blades for cutting American standard 60°, and Acme 29°, threads are available.

Carbide inserts conveniently mount in place of the high speed blade when required. Please review the combination of high speed and carbide options listed below.



HIGH SPEED THREADING BLADES - 60°

Exclusive blade design with two cutting edges, precision ground, assures unusually long life. To resharpen, simply grind the top surface. All blades are uniformly designed to fit any Aloris threading holder.

ORDER #	P-4	P-6	P-10
PRICE		\$43.00	
CAPACITY	4 or more T.P.I.	6 or more T.P.I.	10 or more T.P.I.



HIGH SPEED THREADING BLADES - ACME 29°

Exclusive blade design with two cutting edges, precision ground, assures unusually long life. To resharpen, simply grind the top surface. All blades are uniformly designed to fit any Aloris threading holder.

ORDER #	AC-3	AC-4	AC-5	AC-6	AC-7	AC-8	AC-9	AC-10	AC-12	AC-14	AC-16
CAPACITY	3 T.P.I.	4 T.P.I.	5 T.P.I.	6 T.P.I.	7 T.P.I.	8 T.P.I.	9 T.P.I.	10 T.P.I.	12 T.P.I.	14 T.P.I.	16 T.P.I.



THREADING BLADE GAUGE

Gauge is used for quick and accurate checking of re-ground high speed parting or threading blades to maintain proper angle for accurate thread cutting.

ORDER #	GA #8
---------	-------



THREADING INSERT HOLDER AND INSERT - 60°

Blade is reversible and has an adjustable insert for resharpening purposes. Inserts are stocked in grade A2 and A6. When ordering specify grade desired, otherwise grade A6 will be supplied. Blade fits any Aloris threading holder.

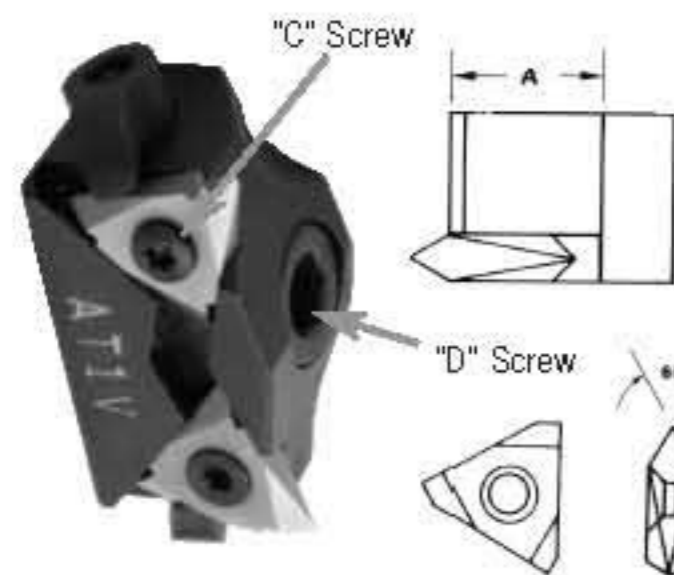
HOLDER ORDER #	CAPACITY
AT-86	6 TO 48 T.P.I.

THREADING CARBIDE INSERT FOR HOLDER # AT-86

STYLE	TPI	INSERT ORDER #*
60°V	6 - 48	AT-4R*

STAND UP INSERT CARTRIDGE

Aloris Series V Threading Cartridge for two triangular 60° threading inserts



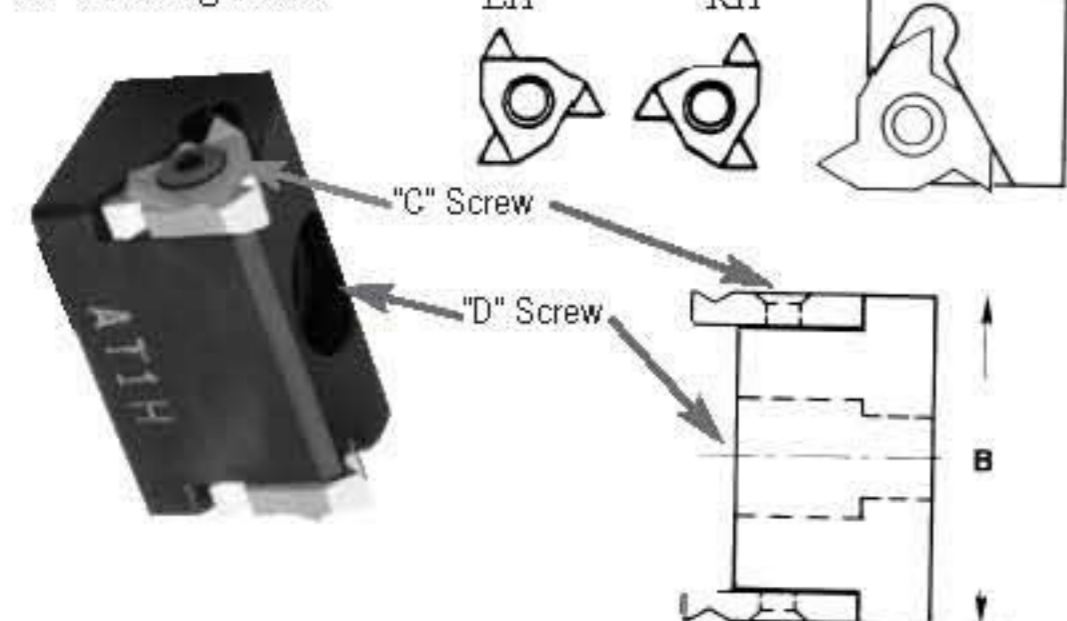
CARTRIDGE ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw #	"D" Replacement Screw #	CLAMP #	CLAMP SCREW #	INSERT IC	KEY #
AT-1V	3/4 sq.	1 1/16	AGTS-1*	5/16 - 18 x 3/4 shcs	ACK-19*	ASTC-9*	3/8	T-10*
AT-2V \$74.00	7/8 sq.	1 1/8	AGTS-2* \$4.00	5/16 - 18 x 3/4 shcs	ACK-19* \$11.00	ASTC-9* \$3.75	1/2	T-20* \$8.00

INSERTS: EXTERNAL VERTICAL 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #
60°	8+	3/8	Pos	AT-1V	TPMC-32NV*
60°	8+	3/8	Neg	AT-1V	TNMC-32NV*
60°	6+	1/2	Pos	AT-2V	TPMC-43NV*
60°	6+	1/2	Neg	AT-2V	TNMC-43NV*

LAYDOWN INSERT CARTRIDGE

Aloris Series H Threading Cartridge for two triangular 60° threading inserts



ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw	"D" Replacement Screw	INSERT IC	KEY #
AT-1H	3/4 sq.	1 1/4	ASA-3T	5/16 - 18 x 3/4 lg shcs	3/8	T-10*
AT-2H \$70.00	7/8 sq.	1 1/16	ASA-4T \$2.00	5/16 - 18 x 3/4 lg shcs	1/2	T-20* \$8.00

INSERTS: PARTIAL PROFILE 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #
60°V-RH	8 - 48	3/8	Pos	AT-1H	16ER-LAG60-RH*
60°V-LH	8 - 48	3/8	Pos	AT-1H	16ER-LAG60-LH*
60°V-RH	5 - 7	1/2	Pos	AT-2H	22ER-LN60-RH*
60°V-LH	5 - 7	1/2	Pos	AT-2H	22ER-LN60-LH*

*Sold in package of 10 pcs.

ALORIS ADJUSTABLE-SHANK TOOL HOLDERS

FOR LEFT OR RIGHT HAND TURNING, FACING OR CHAMFERING.

Two-way adjustable rake with 5° cutting angle — positive stop

Crt. cradle lock screw

Pin

Cartridge lock screw

Standard carbide insert

Tool steel cartridge

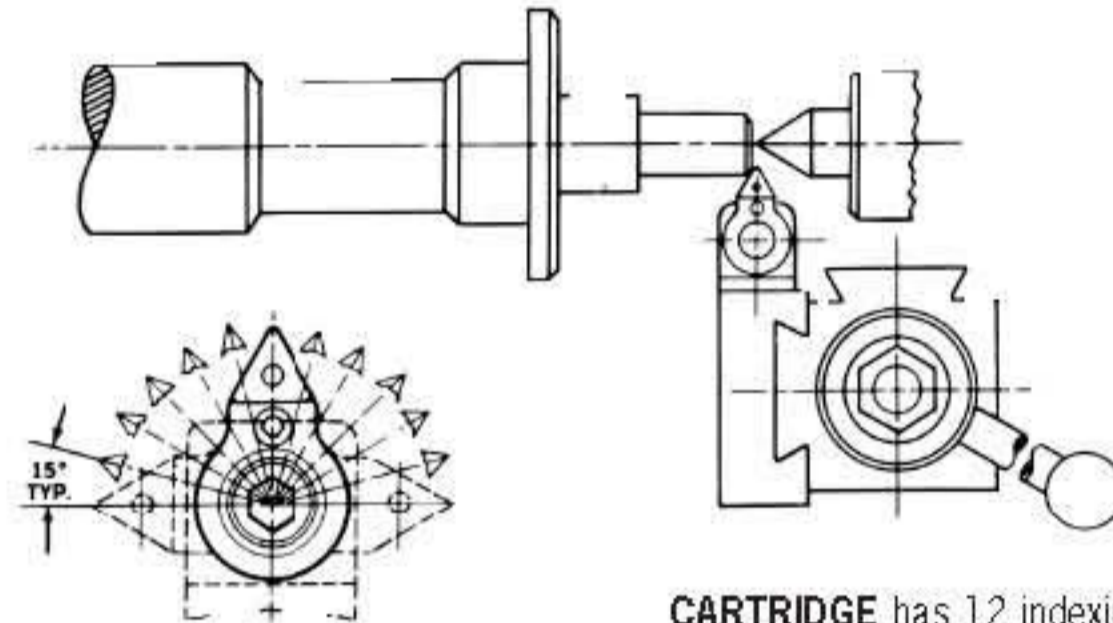
Cartridge cradle

Standard triangular carbide insert has 6 cutting edges.

Exclusive positive lock with 2-way force holding insert down and tight against shoulder.

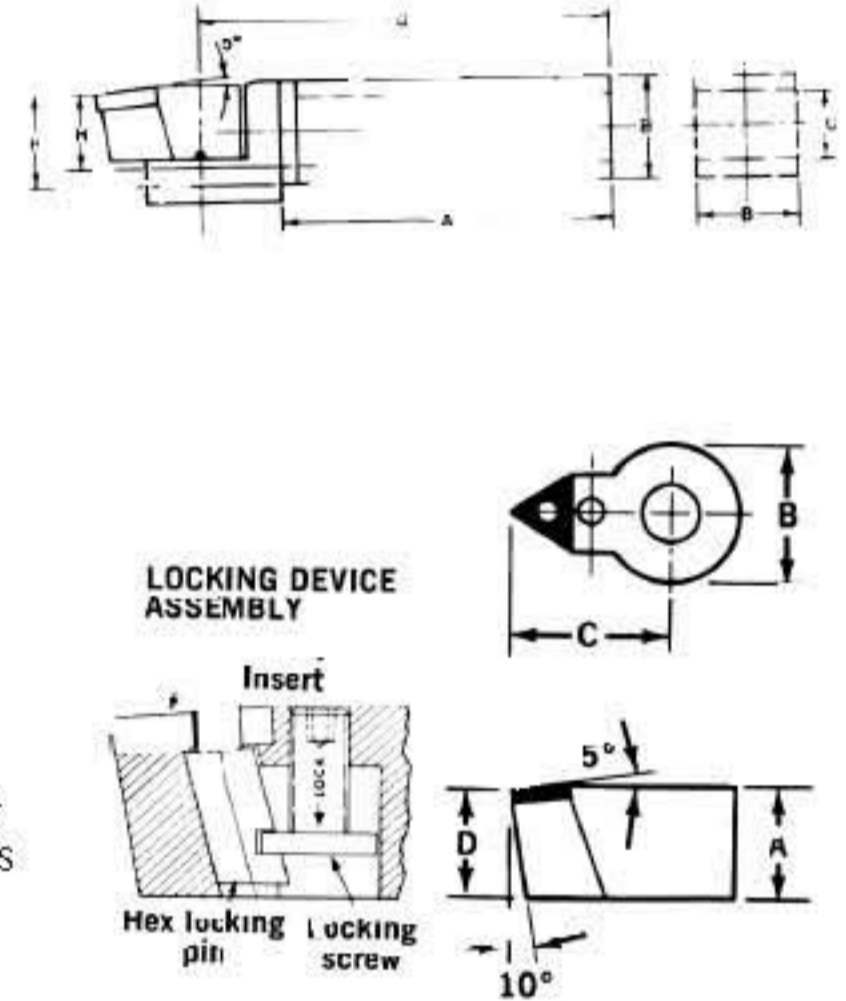
Tool Steel Cartridge adjuster every 15° for right or left hand turning facing or chamfering. 12 positive lock positions.

ILLUSTRATIONS SHOW WHAT ONE SINGLE TOOL CAN ACCOMPLISH



PICTORIAL DIAGRAM OF CARTRIDGE

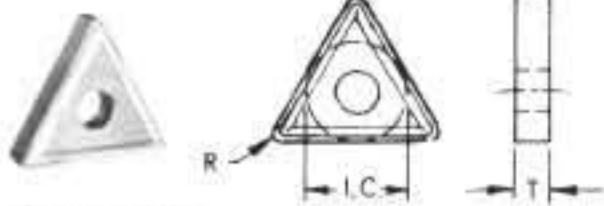
CARTRIDGE has 12 indexing positions at 15° intervals. This means many angular turning and chamfering jobs can be done faster and easier.



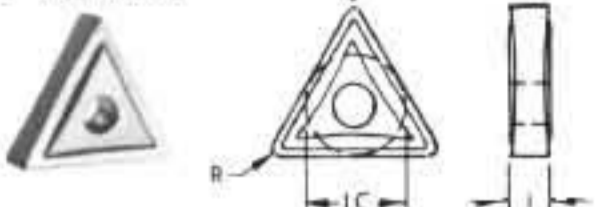
ORDERING INFORMATION							REPLACEMENT PARTS			
HOLDER	DIMENSIONS						CARTRIDGE	HEX LOCKING PIN	LOCKING SCREW	CRADLES
ORDER #	A	B	C	D	H	H ₁	ORDER #	ORDER #	ORDER #	ORDER #
AT-32	4"	1"	3/4"	4 7/8"	7/8"	3/4"	CRT-20*	LP-20*	LS-20*	CC-20S*
AT-40	4 1/2"	1 1/4"	1"	5 11/16"	1 1/16"	1 5/16"	CRT-30*	LP-30*	LS-30*	CC-30S*

CARBIDE INSERTS FOR ALORIS ADJUSTABLE-SHANK TOOL HOLDERS[†]

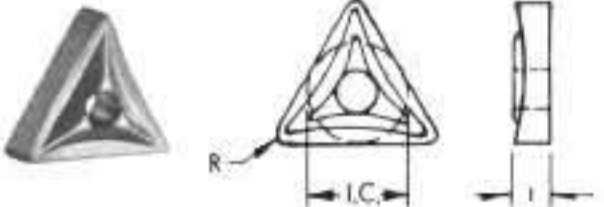
STYLE TNMG
5° NEGATIVE



STYLE TNMP
5° POSITIVE



STYLE TNMS
15° POSITIVE



HOLDER #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #
		I.C.	T	R	
AT-32	CRT-20	3/8"	3/16"	1/32"	TNMP-332 [†]
					TNMS-332 [†]
AT-40	CRT-30	1/2"	3/16"	1/32"	TNMG-432 [†]
					TNMS-432 [†]
					TNMP-432 [†]

[†]Inserts are priced individually, however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 - 54.

MINI SWIVEL-CARTRIDGE TOOL HOLDERS

FOR LEFT OR RIGHT HAND TURNING, BORING, FACING AND CHAMFERING.



...tool holder can be used with cartridge or high-speed steel swivel head. Indexing of every 15° permits many angular turning and boring operations. Adjustment is made by just one turn of the lock screw, and selecting desired setting — 12 positive lock positions.

The cartridge accommodates triangular carbide insert with “0” rake allowing internal and external threading. The high-speed steel swivel head has 60° included angle and can be ground to various job requirements.

...a short version with all of the desirable features of the holder described at left. Designed for mounting in boring bars, such as Aloris BB__ series for angular boring and threading. In addition, the short holder can be used in Aloris quick-change tool holders #6, #9 and #18 for multiple turning. For carbide insert and high-speed steel swivel heads, see table above.

ORDERING INFORMATION		REPLACEMENT PARTS				
TOOL HOLDER – SHORT		SAVE 20% ON SET OF 3 ORDER #	HIGH SPEED SWIVEL HEAD	SWIVEL CLAMP SCREW For Hi-Speed & Carbide Swivel Head	CARBIDE INSERT SWIVEL HEAD	INSERT CLAMP SCREW
ORDER #	SHANK SIZE		ORDER #	ORDER #	ORDER #	ORDER #
AT-5S	3/8 x 3/8 x 2	ATS-SET	CRT-5H*	LS-5C*	CRT-5*	LS-2L*
AT-10S	1/2 x 1/2 x 2 3/4		CRT-10H*	LS-10C*	CRT-10*	LS-4*
AT-15S	5/8 x 5/8 x 3 1/2		CRT-15H*	LS-15C*	CRT-15*	LS-6*

ORDERING INFORMATION			REPLACEMENT PARTS				
TOOL HOLDER – LONG			SAVE 20% ON SET OF 3 ORDER #	HIGH SPEED SWIVEL HEAD	SWIVEL CLAMP SCREW For Hi-Speed & Carbide Swivel Head	CARBIDE INSERT SWIVEL HEAD	INSERT CLAMP SCREW
ORDER #	SHANK SIZE	MIN. BORE DIA.		ORDER #	ORDER #	ORDER #	ORDER #
AT-5	3/8 x 3/8 x 4	3/4	ATL-SET	CRT-5H*	LS-5C*	CRT-5*	LS-2L*
AT-10	1/2 x 1/2 x 5	1"		CRT-10H*	LS-10C*	CRT-10*	LS-4*
AT-15	5/8 x 5/8 x 6	1 3/8		CRT-15H*	LS-15C*	CRT-15*	LS-6*

CARBIDE INSERTS FOR MINI SWIVEL-CARTRIDGE TOOL HOLDERS[†]

STYLE ATPG	STYLE ATPGHL	STYLE ATPGHR	HOLDER #	CARBIDE INSERT SWIVEL HEAD #	DIMENSIONS			INSERT ORDER #*
					I.C.	T	R	
			AT-5,5S	CRT-5	5/32	1/16	1/64	ATPG-321*
			AT-10, 10S	CRT-10	1/4	3/32	1/64	ATPG-431* ATPGHL-431* ATPGHR-431*
			AT-15, 15S	CRT-15	3/16	1/8	1/64	ATPG-541* ATPGHL-541* ATPGHR-541*

[†]Sold in package of 10 pcs. ^{**}100 & up call for price.

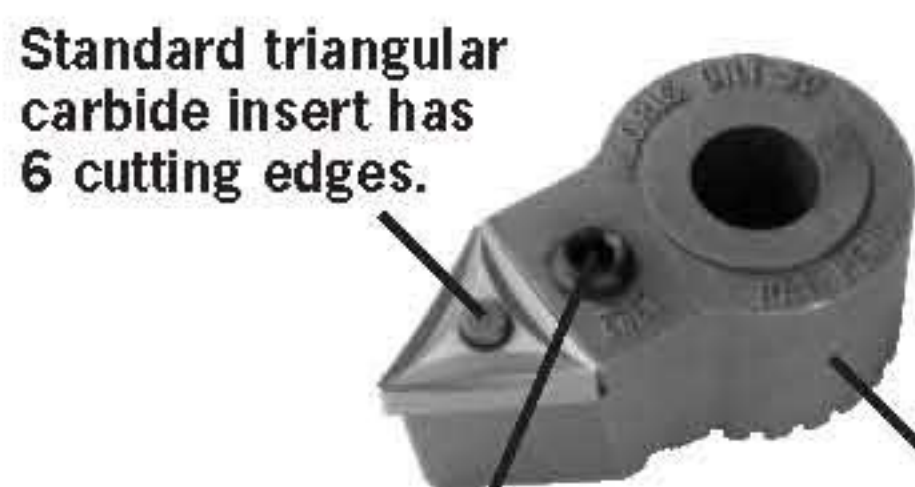
See full selection of inserts on pages 49 – 54.

ALORIS CARTRIDGE-HEAD BORING BAR

FOR DEEP HOLE BORING OPERATIONS

The Aloris boring bar/cartridge combination is designed for maximum rigidity, will not permit tool deflection. All parts are heat treated for maximum strength. The cartridge, with its 12 indexing positions at 15° intervals, provides for many

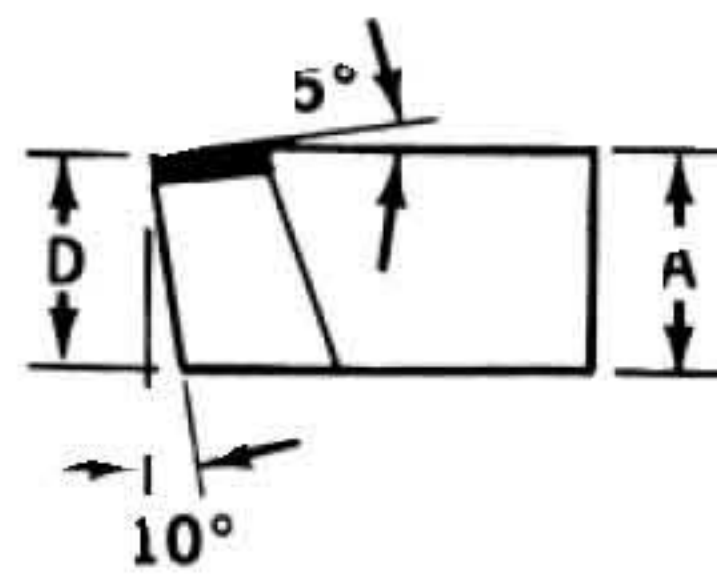
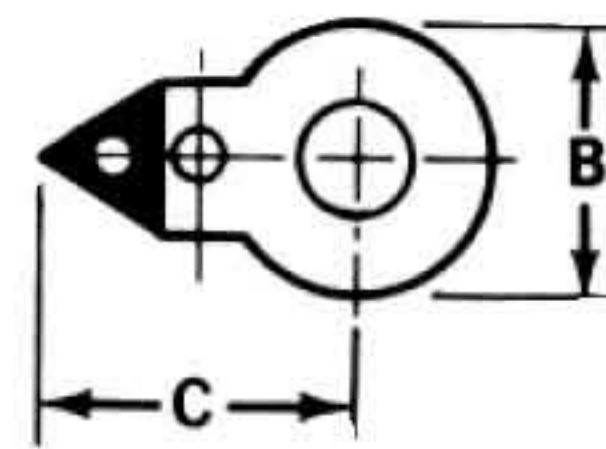
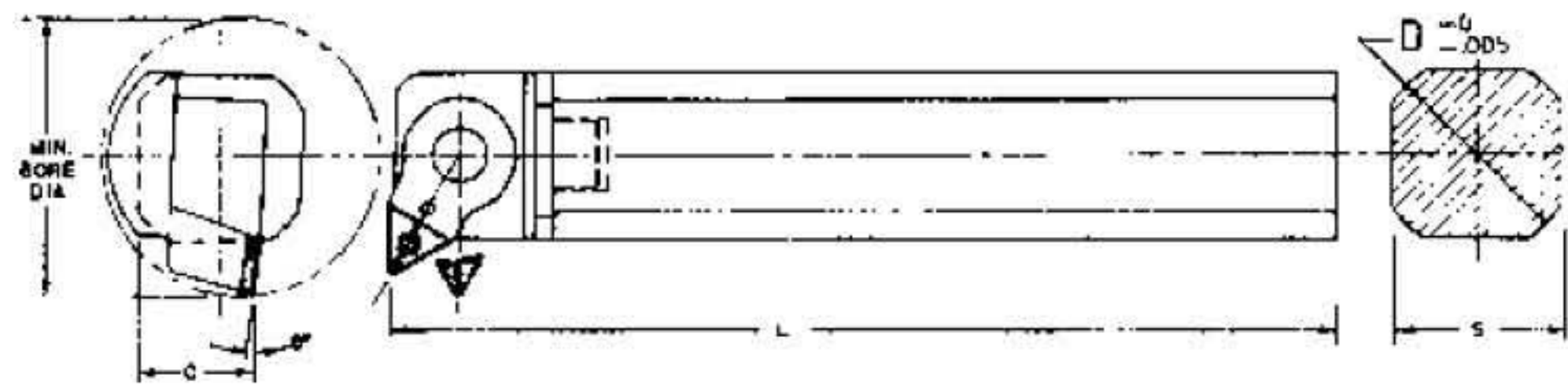
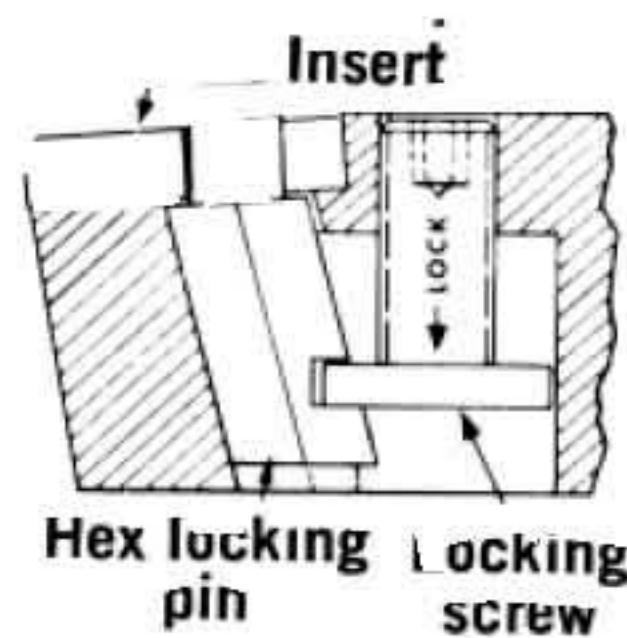
angular boring operations. Angular positions are illustrated below. The two-way adjustable rake provides 5° cutting angle with positive stop. Adjustment is made by loosening cradle lock screws and selecting desired setting.



Exclusive positive lock with 2-way force holding insert down and tight against shoulder.

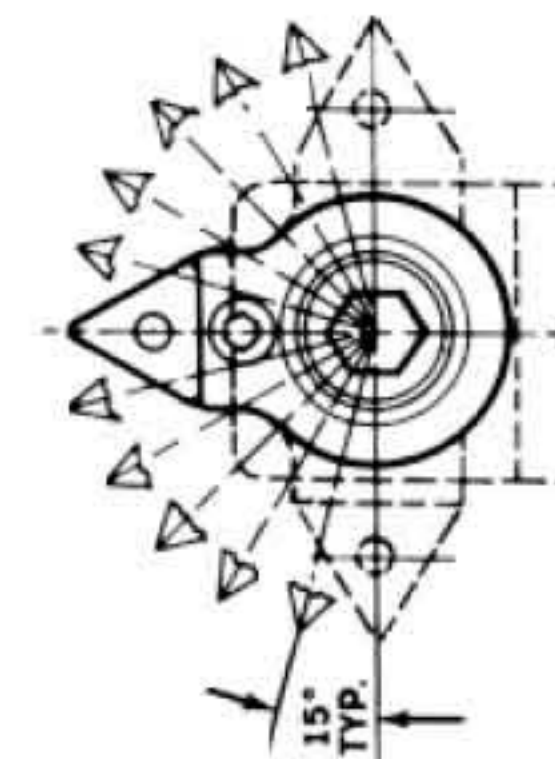
Tool Steel Cartridge adjuster every 15° for right or left hand turning facing or chamfering. 12 positive lock positions.

LOCKING DEVICE ASSEMBLY



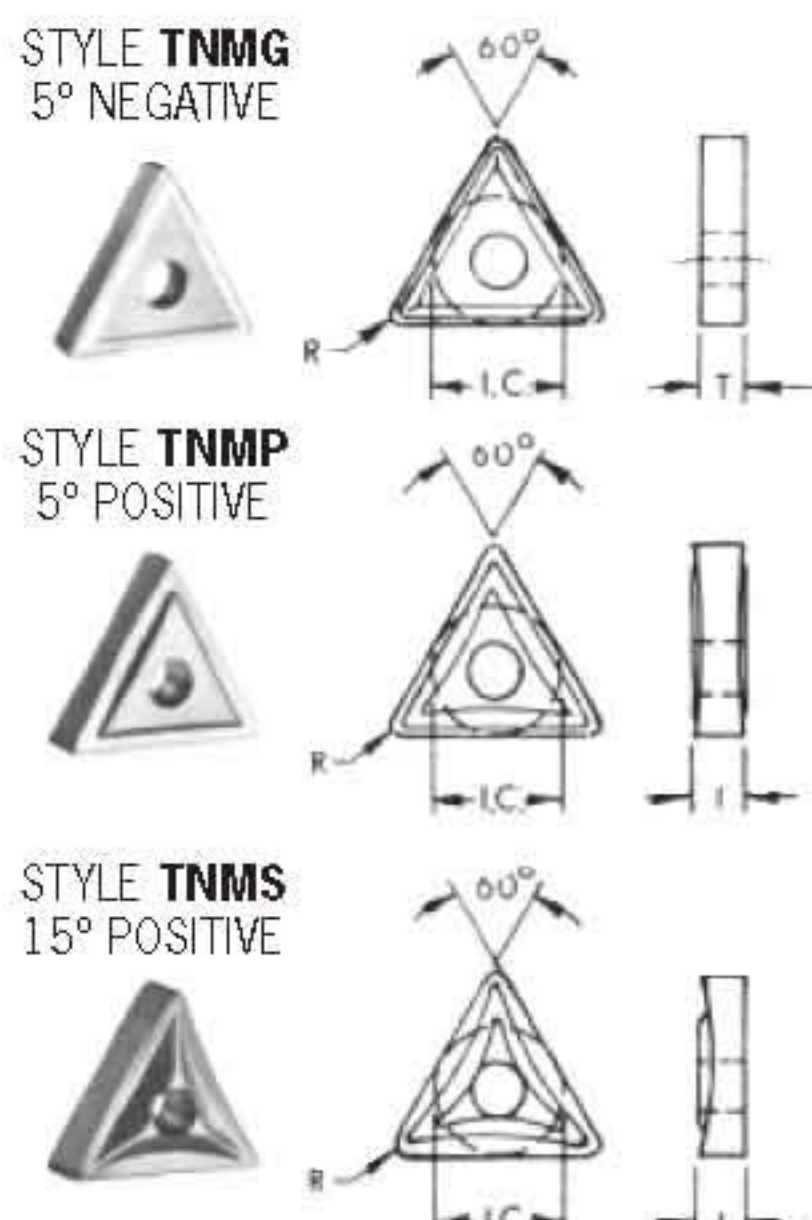
PICTORIAL DIAGRAM OF CARTRIDGE

CARTRIDGE has 12 indexing positions at 15° intervals. This means many angular turning and chamfering jobs can be done faster and easier.



ORDERING INFORMATION						REPLACEMENT PARTS			
BORING BAR ORDER #	MIN. BORE DIA.	TOTAL LENGTH L	S	D	C	CARTRIDGE	CARTRIDGE CRADLE	HEX LOCKING PIN	LOCKING SCREW
						ORDER #	ORDER #	ORDER #	ORDER #
CBB4-20	2 ³ / ₈	16"	1 ¹ / ₄	1 ¹ / ₂	1"	CRT-20*	CC-4*	LP-20*	LS-20*
CBB5-20	2 ³ / ₈	18"	1 ¹¹ / ₁₆	2"	1 ³ / ₁₆	CRT-20*	CC-5*	LP-20*	LS-20*
CBB6-30	3 ¹ / ₄	22"	2 ¹ / ₈	2 ¹ / ₂	1 ¹ / ₁₆	CRT-30*	CC-6*	LP-30*	LS-30*

CARBIDE INSERTS FOR ALORIS CARTRIDGE-HEAD BORING BARS[†]

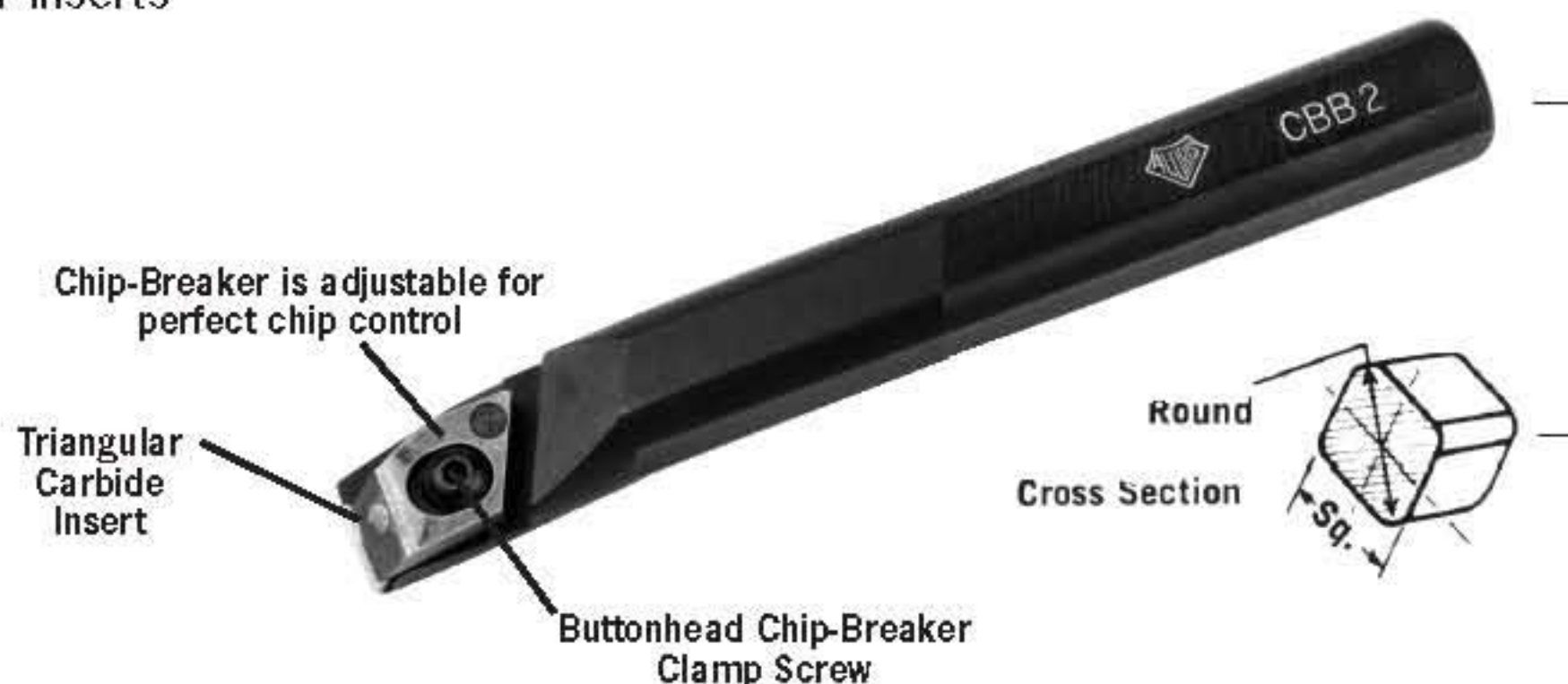


BORING BAR #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #
		I.C.	T	R	
CBB4-20 CBB5-20	CRT20	3/8	3/16	1/32	TNMG-332* TNMP-332* TNMS-332*

BORING BAR #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #
		I.C.	T	R	
CBB6-30	CRT30	1/2	3/16	1/32	TNMG-432* TNMS-432* TNMP-432*

ALORIS ADJUSTABLE CHIPBREAKER BORING BARS

- Heat-treated alloy steel
- Supplied with adjustable carbide chip-breaker and carbide shim to protect the boring bar
- Accommodates standard positive rake triangular inserts
- Used for boring to square shoulder
- Can be used with open slot holders #1 and #2, as well as heavy duty holders #4, #41, #4D, #41D, #100, #104, #141



ORDERING INFORMATION							REPLACEMENT PARTS				
BORING BAR ORDER #	BORING BAR SIZE			MIN. BORE DIA.	INSERT SIZE		ADJUSTABLE CHIPBREAKER		CHIPBREAKER CLAMP SCREW	CARBIDE SHIM	CARBIDE SHIM SCREW
	Square	Round	Length		I.C.	Thick	ORDER #	PRICE EA.	ORDER #	ORDER #	ORDER #
CBB-1	5/8	3/4	8"	1 1/8	3/8	1/8	CB-13*		SCR-1*	SM-41*	SM-41SS*
CBB-2	7/8	1"	12"	1 1/4	3/8	1/8	CB-13*		SCR-2*	SM-41*	SM-41SS*
CBB-3	1 1/16	1 1/4	14"	1 5/16	3/8	1/8	CB-13*		SCR-3*	SM-41*	SM-41SS*
CBB-4	1 1/4	1 1/2	16"	1 3/8	1/2	3/16	CB-46*		SCR-12*	SM-37*	SM-37SS*

INSERTS FOR ADJUSTABLE CHIPBREAKER BORING BARS*

STYLE TPG	DIMENSIONS			INSERT ORDER #*
	I.C.	T	R	
	3/8	1/8	1/32	TPG-322*
	1/2	3/16	1/32	TPG-432*

ALORIS REVERSIBLE BORING BARS FOR SQUARE TOOL BITS

The Aloris boring bars are designed for 45° and 90° cutting tool positions. Both ends of the boring bar are broached in the same plane, so that either end can be used after removing the bar from the holder.



NOTE: All boring bars are supplied with screw wrench and tool bits.

BORING BAR ORDER #	DIA.	LENGTH	SQUARE CUTTER
BB-1	5/8	10"	3/16
BB-2	3/4	12"	1/4
BB-3	1"	14"	5/16
BB-4	1 1/4	16"	3/8
BB-5	1 1/2	22"	1/2
BB-6	2"	24"	1/2
BB-7	2 1/2	30"	5/8

BORING BARS FOR SQ. TOOL BITS

DESIGNED IN TWO MODELS: ONE FOR 45°, OTHER FOR 90° CUTTING TOOL POSITION



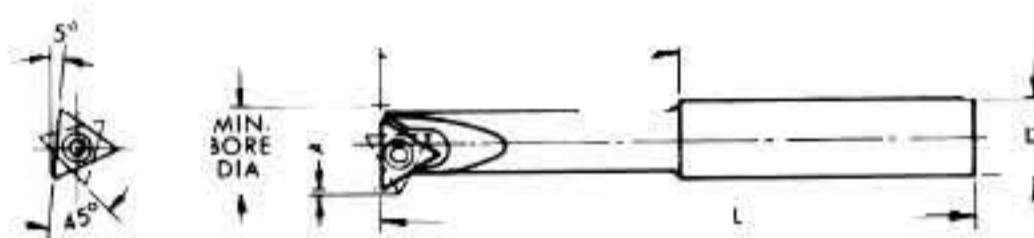
BORING BAR ORDER #	DIA.	LENGTH	TOOL BIT
FOR 90° CUTTING ANGLE			
BB-8	3/4	6"	1/4
BB-10	1"	9"	5/16
FOR 45° CUTTING ANGLE			
BB-9	3/4	6"	1/4
BB-11	1"	9"	5/16

ALORIS ADJUSTABLE – INSERT BORING BARS

An adjustable “throw-away insert”, boring bar designed especially for through boring, facing, or boring to a square shoulder or any lead angle.

Fast, accurate positioning of the replaceable insert is accomplished by the simple adjustment of the positioning socket set screw and the locking flat head socket cap screw while the bar is mounted on the machine.

For use with a lathe boring holder, milling machine, jig bore, CNC lathe, etc., the Aloris adjustable-insert boring bars are available in 4 popular sizes ranging from 1/2" to 1" shank diameters. They are offered as single units; or in a set, saving up to 7%. All boring bars are products from high quality heat treated steel.



BS set consists of
BS1 – BS2 – BS3 – BS4

BL set consists of
BL1 – BL2 – BL3 – BL4

SUPPLIED WITH A-6 CARBIDE INSERT

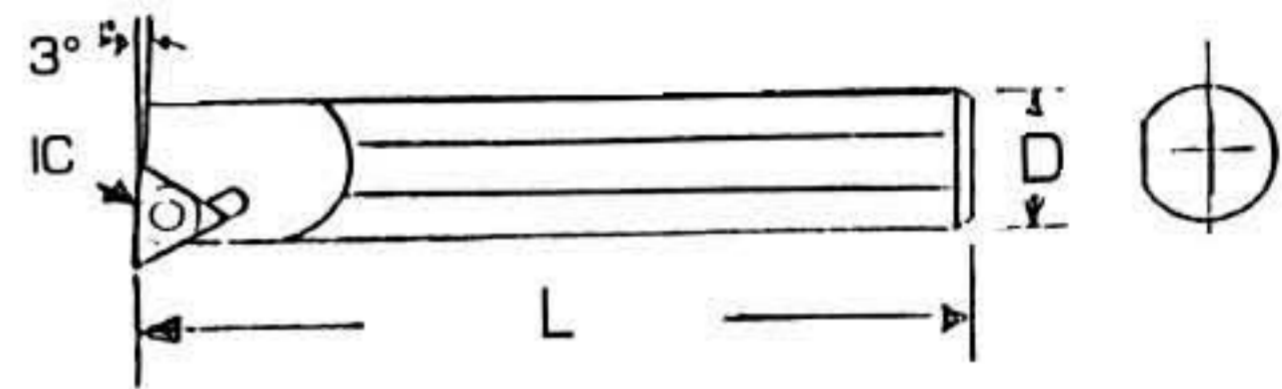
ORDERING INFORMATION (SHORT)						REPLACEMENT PARTS			
ORDER #	ON SET OF 4 ORDER #	MIN. BORE DIA.	ADJUSTMENT A	DIMENSIONS			INSERT SIZE	LEAD ANGLE ADJUSTMENT SCREW	INSERT CLAMP SCREW
				D	L	L ₁		ORDER #	ORDER #
BS-1	BS-SET	1/2	1/32	3/4	3 3/4	1 3/4	1/4 I.C.	SAS-10*	LS-4*
BS-2		9/16	1/32		3 7/8	1 7/8	1/4 I.C.	SAS-10*	LS-4*
BS-3		5/8	1/32		4 1/4	2 1/4	5/16 I.C.	SAS-10*	LS-6*
BS-4		11/16	1/32		4 3/8	2 3/8	3/8 I.C.	SAS-250*	LS-8*
BS-5	BL-SET	1/2	1/32	3/4	6"	1 3/4	1/4 I.C.	SAS-10*	LS-4*
BS-6		11/16	1/32		6"	2 1/2	3/8 I.C.	SAS-250*	LS-8*

ORDERING INFORMATION (LONG)						REPLACEMENT PARTS			
ORDER #	ON SET OF 4 ORDER #	MIN. BORE DIA.	ADJUSTMENT A	DIMENSIONS			INSERT SIZE	LEAD ANGLE ADJUSTMENT SCREW	INSERT CLAMP SCREW
				D	L	L ₁		ORDER #	ORDER #
BL-1	BL-SET	1/2	1/32	1/2	5"	1 3/8	1/4 I.C.	SAS-10*	LS-4*
BL-2		9/16	1/32		6"	—	1/4 I.C.	SAS-10*	LS-4*
BL-3		5/8	1/32		7"	3 1/4	5/16 I.C.	SAS-10*	LS-6*
BL-4		11/16	1/32		8"	3 3/4	3/8 I.C.	SAS-250*	LS-8*
BL-5	BL-SET	13/16	1/32	1"	9"	3"	3/8 I.C.	SAS-250*	LS-8*
BL-6		1 1/16	1/32		9"	3"	1/2 I.C.	SAS-312*	LS-8*

FOR INSERTS SEE OPPOSITE PAGE

ALORIS INDEXABLE CARBIDE INSERT BORING BARS




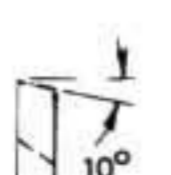
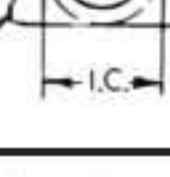
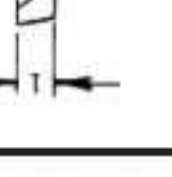


Bars are made of alloy steel and heat treated for maximum rigidity. Popular triangular positive rake inserts are held securely by a flat head screw. Available to bore holes with minimum size of $\frac{7}{16}$ in manual and CNC lathes, also excellent in boring heads. May be cut to length using an abrasive cut off wheel.



SUPPLIED WITH A-6 CARBIDE INSERT

BORING BAR ORDER #	MIN. BORE DIA.	DIMENSIONS		*INSERT SIZE	INSERT CLAMP SCREW
		D	L		
CBB-10	$\frac{7}{16}$	$\frac{3}{8}$	4"	$\frac{1}{4}$ I.C.	LS-4*
CBB-20	$\frac{1}{2}$	$\frac{7}{16}$	5"	$\frac{1}{4}$ I.C.	LS-4*
CBB-30	$\frac{9}{16}$	$\frac{1}{2}$	6"	$\frac{1}{4}$ I.C.	LS-4*
CBB-40	$\frac{5}{8}$	$\frac{9}{16}$	7"	$\frac{5}{16}$ I.C.	LS-6*
CBB-50	$\frac{11}{16}$	$\frac{5}{8}$	8"	$\frac{3}{8}$ I.C.	LS-8*
CBB-60	$\frac{13}{16}$	$\frac{3}{4}$	9"	$\frac{3}{8}$ I.C.	LS-8*
CBB-70	$1\frac{1}{16}$	1"	9"	$\frac{1}{2}$ I.C.	LS-8*
CBB-70S	$1\frac{1}{16}$	1"	12"	$\frac{1}{2}$ I.C.	LS-8*

INSERTS FOR ALORIS ADJUSTABLE AND CARBIDE INSERT BORING BARS†

STYLE	I.C.	T	R	STYLE
	$\frac{1}{4}$	$\frac{3}{32}$	$\frac{1}{64}$	ATPG-431*
	$\frac{1}{4}$	$\frac{3}{32}$	$\frac{1}{64}$	ATPGHL-431*
	$\frac{5}{16}$	$\frac{1}{8}$	$\frac{1}{64}$	ATPG-541*
	$\frac{5}{16}$	$\frac{7}{8}$	$\frac{1}{64}$	ATPGHL-541*
	$\frac{3}{8}$	$\frac{1}{8}$	$\frac{1}{32}$	ATPG-642*
	$\frac{3}{8}$	$\frac{1}{8}$	$\frac{1}{32}$	ATPGHL-642*
	$\frac{1}{2}$	$\frac{3}{16}$	$\frac{1}{32}$	ATD-8P*
	$\frac{1}{2}$	$\frac{3}{16}$	$\frac{1}{32}$	ATDHL-8P*

See full selection of inserts on pages 49 – 54.

ALORIS SERIES ATB INTERNAL THREADING BARS



Aloris ATB Series threading bars can be used for internal right or left-hand threading. Available in five sizes, these bars accommodate standard triangular-shaped throwaway threading inserts in a hardened seat.

The ATB Series shank has three flat sides specially designed for use in Aloris boring bar holders #1, #2, #13, #4 and # 41. They may also be used in any Aloris boring bar holder. Excellent for CNC machines.

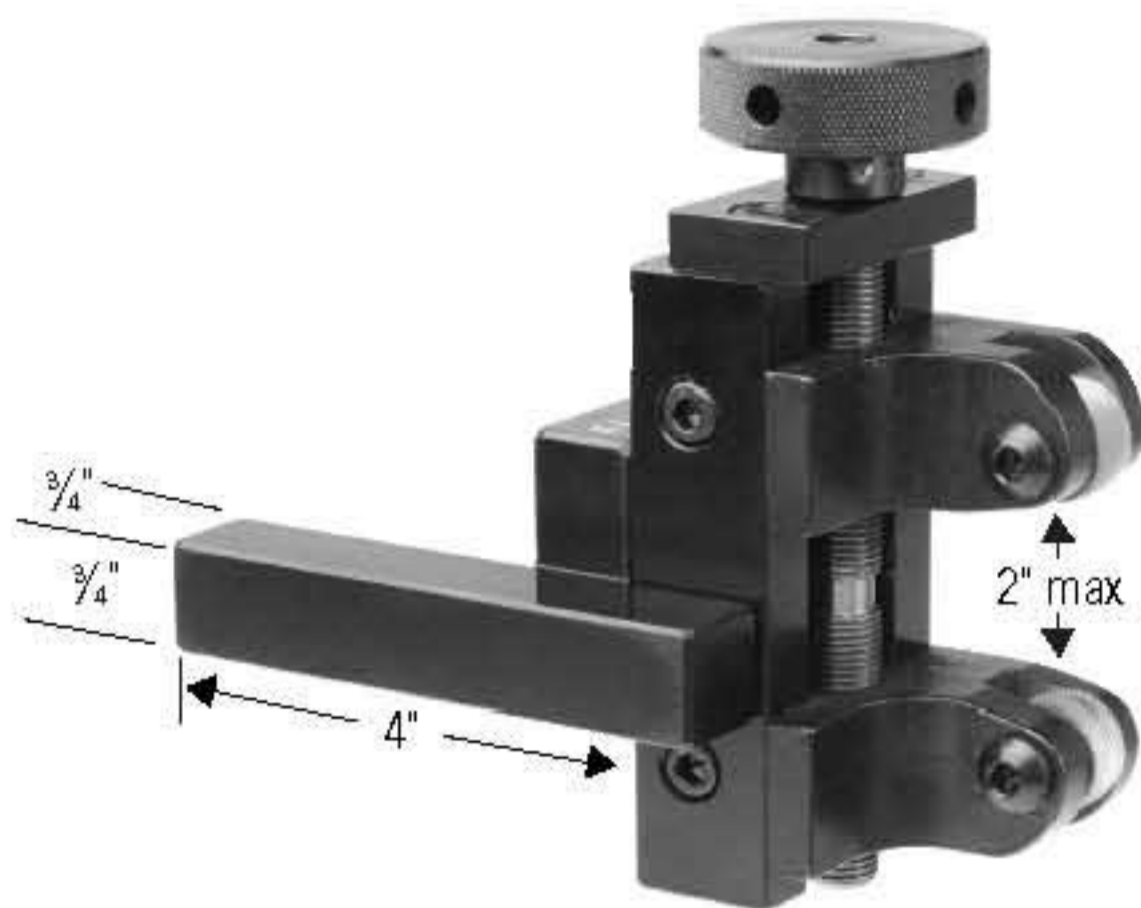
ORDERING INFORMATION									REPLACEMENT PARTS		
BORING BAR ORDER #		DIMENSIONS							INSERT SCREW	KEY	SHIM
RIGHT HAND	LEFT HAND	A	B	C	D	L	I.C.	ORDER #	ORDER #	ORDER #	
ATB-1R	ATB-1L	1/2	7/8	5/8	3/4	6 1/2	1/4	ASA2T*	T8*		
ATB-2R	ATB-2L	3/4	1 1/2	5/8	3/4	7"	3/8	ASA3T*	T10*		
ATB-3R	ATB-3L	1"	2 1/4	7/8	1"	10"	3/8	ASA3T*	T10*		
ATB-4R	ATB-4L	1 3/16	2 3/4	1 1/16	1 1/4	12"	3/8	ASA3T*	T10*		
ATB-5R	ATB-5L	1 7/16	3 1/8	1 1/4	1 1/2	14"	1/2	ASA4T*	T20*	YI4(RH)* YE4(LH)*	



60° PARTIAL PROFILE INTERNAL CARBIDE THREADING INSERTS*

RH	LH	USE WITH BORING BAR #	ORDER # RIGHT HAND†	ORDER # LEFT HAND†	I.C.	THREADS (TPI)
		ATB-1	1/4 AIT-R60*	1/4 AIT-L60*	1/4	16-48
		ATB-2-3-4	3/8 AIT-R60*	3/8 AIT-L60*	3/8	8-48
		ATB-5	1/2 AIT-R60*	1/2 AIT-L60*	1/2	5-7

ALORIS AT-19 ADJUSTABLE KNURLING HOLDER

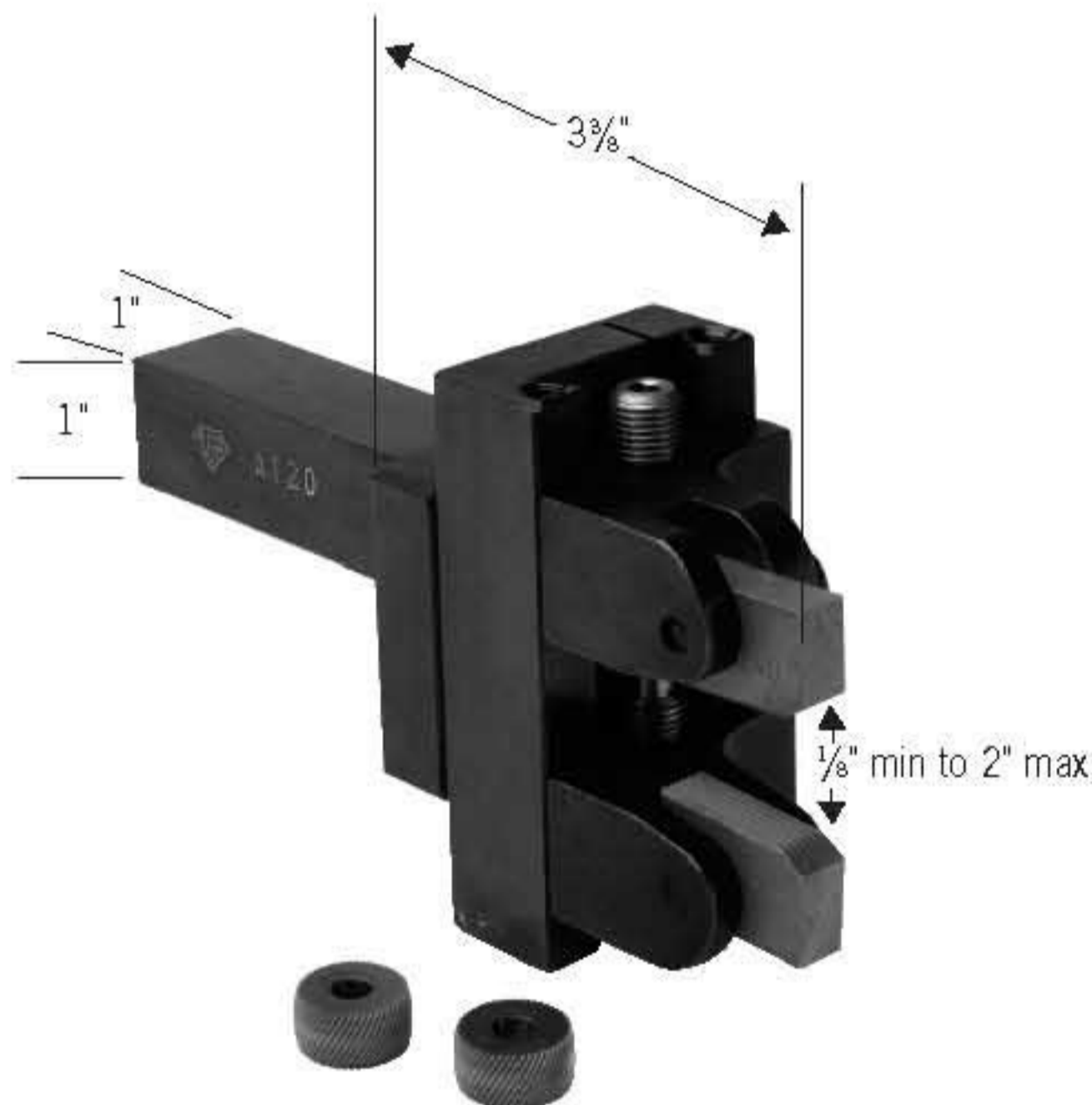


...excellent knurling, with approach adjustability, is provided with the newly designed AT-19 knurling holder. The AT-19 is self-centering and is adjusted by means of a conveniently located knurled knob, providing the ideal near-vertical-axis approach angle for a wide range of stock diameters. Spindle and cross-slide pressure are minimal, thus knurling of thin wall tubing is easily performed.

The Aloris AT-19, which is designed for use in any standard turret tool post or other open-slot holder, is also available with dovetail mounting (series 19) to fit Aloris tool posts. Precision ground, 3/4" O.D. x 3/8" wide, high-speed medium diamond knurls are supplied unless otherwise specified.

ORDER #	AT-19
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ALORIS AT-20 COMBO CNC BAR PULLER KNURLING TOOL



...mounts into tool slot on CNC turrets easily adjustable with knurls installed the range is 1/8"-2". Opposing forces on knurls create little or no force on the machine. Just remove the two knurl lock screws, replace with bar grippers and use as a heavy duty bar puller. There are **no** gripper springs to remove when changing bar diameters. Just loosen the lock screw, insert allen wrench and dial to the next size, preload approximately 1/8 rev., lock locking screw. Furnished with 1" shank without knurls or grippers. Minimum clearance required between turret and covers is 3 3/8".

ORDER #	AT-20
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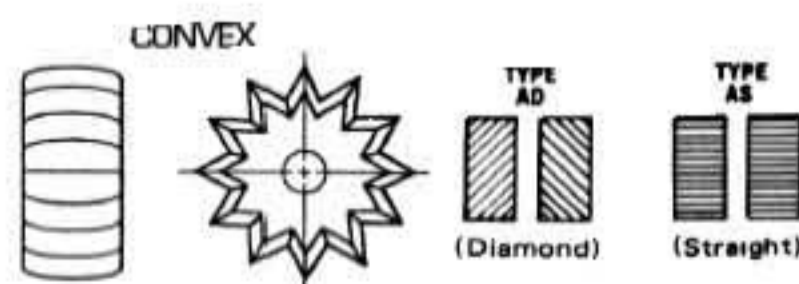
BAR GRIPPERS



GRIPPER ORDER # (pair)	AT-20G*
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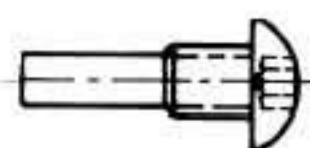
HIGH SPEED KNURLS

For #10, #19, #20 Holders:
AD-Diamond/AS-Straight/NEW - Convex
Hi-Cobalt (ACD-Spiral & ACS-Straight)



KNURL ORDER #	AD16R/AD16L/AS16* ACD16R/ACD16L/ACS16*	AD20R/AD20L/AS20/AD25R* AD25L/AS25/ACD20R/ACD20L* ACS20/ACD25R/ACD25L/ACS25*	AD50R/AD50L/AS50* ACD50R/ACD50L/ACS50*
	COARSE	MEDIUM	FINE

KNURL-LOCK SCREW

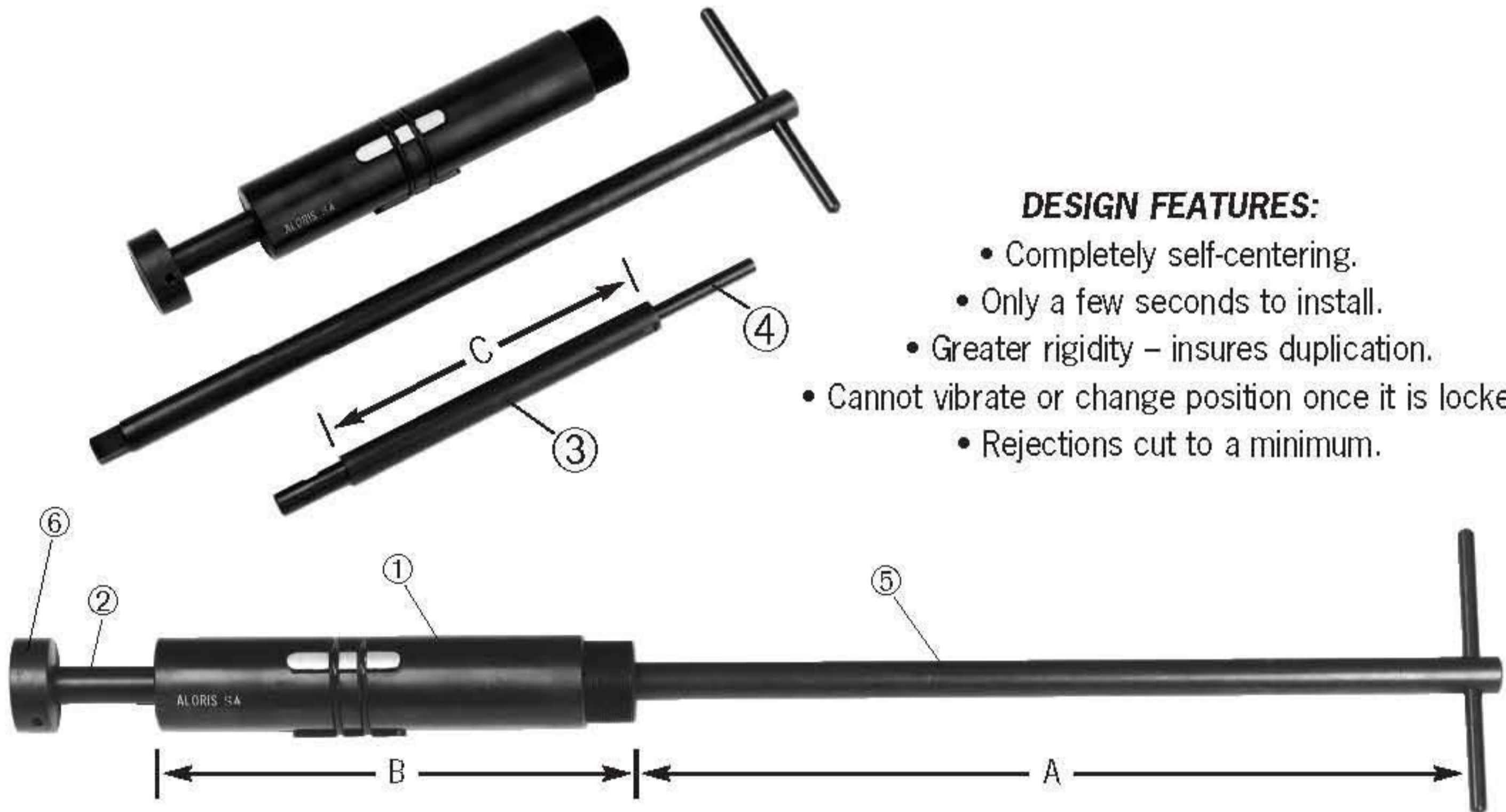


ORDER #	SCR-10*	Used with any #10, #19 and #20 holder
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ALORIS UNIVERSAL LATHE – SPINDLE AND COLLET STOPS

FOR USE IN CNC, MANUAL LATHES & INDEXING HEADS

Fully adjustable to fit a wide variety of applications (ranges listed in chart below). Cut time dramatically on jobs where the part must be registered in machine more than one time or where more than one part is to be machined. Just slide the body into the spindle of the machine, rotate the T-handle wrench which expands 3 keys which lock the body securely into position. When the chuck or collet is opened, and the next piece loaded into machine all distances from the stop will repeat exactly.



DESIGN FEATURES:

- Completely self-centering.
- Only a few seconds to install.
- Greater rigidity – insures duplication.
- Cannot vibrate or change position once it is locked.
- Rejections cut to a minimum.

COMPLETE SET CONSISTS OF:

- ① • Body, with adjustable locking jaws and threaded and tapered pin which has square end shank and spring loaded locking ball.
- ② • Short extension bar.
- ③ • Long extension bar.
- ④ • Bar for use with collets.
- ⑤ • Socket T-handle wrench.
- ⑥ • Removable cup, to fit short and long extension bars, for use when machining tubing.

ORDERING INFORMATION

ORDER #	DIMENSIONS			TO FIT SPINDLE SIZE
	A	B	C	
S-00	11¼	3¼		9/16" to 23/32"
S-0	107/8	43/16	47/16	3/4" to 15/16"
S-1	12¼	4½	6	1" to 1¼"
S-2	19	67/16	6½	17/16" to 111/16"
S-3	21½	77/8	10½	1¾" to 27/16"
S-4	22¼	9¼	10½	2½" to 3½"
S-5	22¼	12	10½	35/8" to 4½"

Spindle stop is supplied with screw wrenches.

SPINDLE STOP – REPLACEMENT PARTS

Body with Scr/Gibs/Rings*
Taper Screw*
Gibs (Set of 3)*
"O" Rings (Set of 2)*
Long - Extension*
Short - Extension*
T-Handle Wrench*

SGIH CUT-OFF & GROOVING BLADES

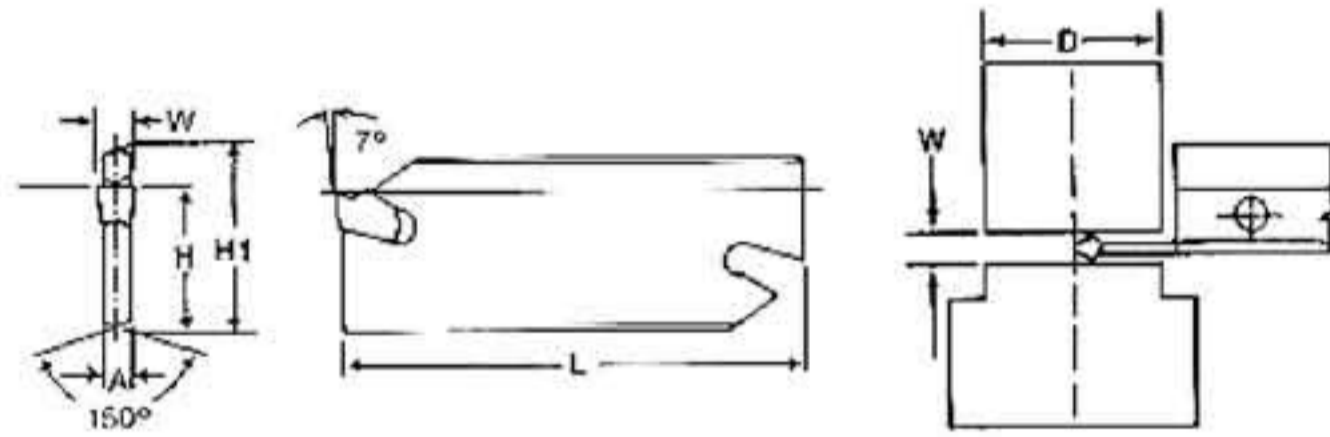


Regular Style

Inserts are securely held in Self Locking blades by a tapered locking system. No additional clamping devices are required. Extraction tool included.

Positive Stop Style

Inserts are securely held in Self Locking blades by a tapered locking system featuring a "Positive Stop" that prevents insert drift and the blade pocket from spreading once the insert is set firmly in place. No additional clamping devices are required. Self Locking Positive Stop blades are used with existing GTN inserts and tool blocks. Extraction tool included.



ORDERING INFORMATION				DIMENSIONS						
Designation	Regular	Positive Stop		Width=W ±.004"	D Max.	A	L	H	H1	See page 54 for price Insert Style
SGIH 19-2	-2PS*			.087/.093	1 1/2	1/16	3 3/8	39/64	3/4	GTN/R/L -2, 2.4
SGIH 19-3	—			.120	1 1/2	3/32	3 3/8	39/64	3/4	GTN/R/L -3
SGIH 26-2	-2PS*			.087/.093	3	1/16	4 5/16	53/64	1	GTN/R/L -2, 2.4
SGIH 26-3	-3PS*			.120	3	3/32	4 5/16	53/64	1	GTN/R/L -3
SGIH 26-4	-4PS*			.160	3	1/8	4 5/16	53/64	1	GTN/R/L -4
SGIH 26-5	-5PS*			.187/.200	3	5/32	4 5/16	53/64	1	GTN/R/L -4.8, 5
SGIH 26-6	-6PS*			.250	3	3/64	4 5/16	53/64	1	GTN/R/L -6
SGIH 32-3	-3PS*			.120	4	3/32	5 7/8	63/64	1 1/4	GTN/R/L -3
SGIH 32-4	-4PS*			.160	4	1/8	5 7/8	63/64	1 1/4	GTN/R/L -4
SGIH 32-5	-5PS*			.187/.200	5	5/32	5 7/8	63/64	1 1/4	GTN/R/L -4.8, 5
SGIH 32-6	-6PS*			.250	5	3/64	5 7/8	63/64	1 1/4	GTN/R/L -6
SGIH 32-8	-8PS*			.315	5	17/64	5 7/8	63/64	1 1/4	GTN/R/L -8
SGIH 32-9	-9PS*			.375	5	5/16	5 7/8	63/64	1 1/4	GTN/R/L -9

*Quantities over 10, call for price.

CNC Tool Blocks

SGTBN Series

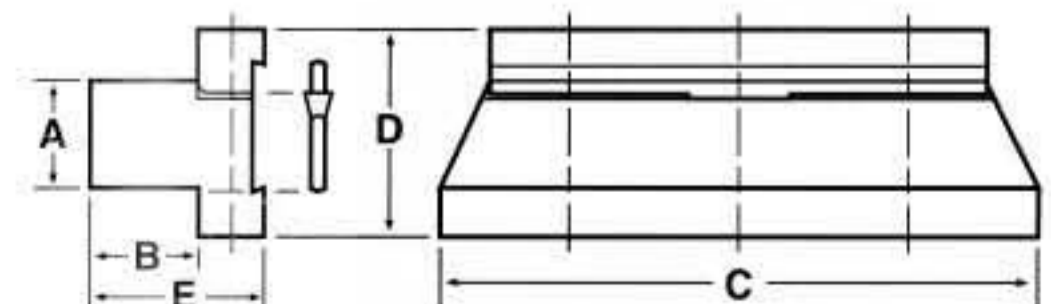
Simple block design accommodates Self Locking and competitive blade systems. Unique wedge clamp provides firm seating for light and heavy duty cut-off and grooving operations. Two piece design provides stability, strength and correct alignment of blade for maximum performance.



The two piece design facilitates easy installation to many CNC machining centers. Can be utilized for left or right hand operations.

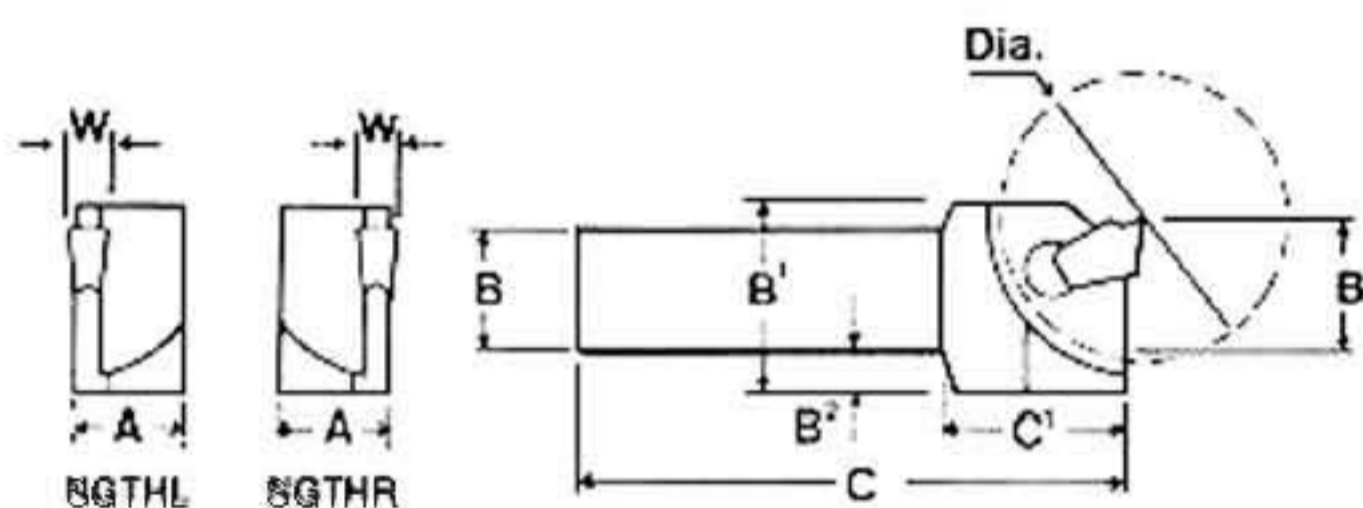
ORDERING INFORMATION	DIMENSIONS					Blade Styles Regular or Positive See above
Catalog Number	A	B	C	D	E	
SGTBN 16-2*	5/8	5/8	3 7/16	1 3/16	1 1/64	SGIH 19-2
SGTBN 16-5*	5/8	5/8	3 7/16	1 1/2	1 5/16	SGIH 26-2 SGIH 26-3
SGTBN 19-5*	3/4	3/4	3 7/16	1 1/2	1 7/16	SGIH 26-4 SGIH 26-5
SGTBN 25-5*	1.0	25/32	3 7/16	1 1/2	1 15/32	SGIH 26-6
SGTBN 19-6*	3/4	3/4	4 5/16	1 7/8	1 7/16	SGIH 32-3
SGTBN 25-6*	1.0	25/32	4 5/16	1 7/8	1 15/32	SGIH 32-4 SGIH 32-5
SGTBN 32-6*	1 1/4	1 1/8	4 5/16	1 7/8	1 13/16	SGIH 32-6
SGTBN 32-1-6*	1 1/4	1 1/8	4 5/16	1 7/8	1 59/64	SGIH 32-6
SGTBN 38.6*	1 1/2	1 5/8	4 5/16	1 7/8	2 27/64	SGIH 32-8 SGIH 32-9

*For large quantities, call for price.



INTEGRAL SHANK CUT-OFF TOOLHOLDERS

Inserts are securely held in Self Locking blades by a tapered locking system. No additional clamping devices are required. Positive* stop styles available.



ORDERING INFORMATION		DIMENSIONS								
Catalog Number [†]		Width	A	B	C	B1	B2	C1	Ø Dia Max.	Insert Style Used ⁺⁺⁺
Right Hand	Left Hand									
SGTHR 9.5-2*	SGTHL 9.5-2*	.087/.093	3/8	3/8	3 3/8	3/4	3/16	45/64	1 7/64	GTN/R/L -2, 2.4
SGTHR 9.5-3*	SGTHL 9.5-3*	.120	3/8	3/8	3 3/8	3/4	3/16	45/64	1 7/64	GTN/R/L -3
SGTHR 10-2*	SGTHL 10-2*	.087/.093	3/8	25/64	3 3/8	3/4	3/16	45/64	1 7/64	GTN/R/L -2, 2.4
SGTHR 10-3*	SGTHL 10-3*	.120	3/8	25/64	3 3/8	3/4	3/16	45/64	1 7/64	GTN/R/L -3
SGTHR 12-2*	SGTHL 12-2*	.087/.093	25/64	15/32	4 21/64	3/4	5/32	45/64	1 11/64	GTN/R/L -2, 2.4
SGTHR 12-3*	SGTHL 12-3*	.120	25/64	15/32	4 21/64	53/64	15/64	53/64	1 17/64	GTN/R/L -3
SGTHR 12.7-2*	SGTHL 12.7-2*	.087/.093	25/64	1/2	4 21/64	53/64	5/32	45/64	1 11/64	GTN/R/L -2, 2.4
SGTHR 12.7-3*	SGTHL 12.7-3*	.120	25/64	1/2	4 21/64	53/64	15/64	53/64	1 17/64	GTN/R/L -3
SGTHR 16-2*	SGTHL 16-2*	.087/.093	25/64	5/8	4 21/64	3/4	-	45/64	1 11/64	GTN/R/L -2, 2.4
SGTHR 16-3*	SGTHL 16-3*	.120	15/32	5/8	4 21/64	15/16	5/32	25/32	1 17/64	GTN/R/L -3
SGTHR 16-4*	SGTHL 16-4*	.160	15/32	5/8	4 21/64	15/16	5/32	53/64	1 21/64	GTN/R/L -4
SGTHR 19-2*	SGTHL 19-2*	.087/.093	15/32	3/4	4 21/64	15/16	-	25/32	1 17/64	GTN/R/L -2, 2.4
SGTHR 19-3*	SGTHL 19-3*	.120	15/32	3/4	4 21/64	15/16	-	53/64	1 13/32	GTN/R/L -3
SGTHR 19-4*	SGTHL 19-4*	.160	15/32	3/4	4 21/64	15/16	-	29/32	1 17/32	GTN/R/L -4
SGTHR 19-5*	SGTHL 19-5*	.187/.200	15/32	3/4	4 21/64	15/16	-	29/32	1 17/64	GTN/R/L -4.8, 5
SGTHR 20-2*	SGTHL 20-2*	.087/.093	15/32	25/32	4 21/64	15/16	-	25/32	1 17/64	GTN/R/L -2, 2.4
SGTHR 20-3*	SGTHL 20-3*	.120	15/32	25/32	4 21/64	15/16	-	53/64	1 13/32	GTN/R/L -3
SGTHR 20-4*	SGTHL 20-4*	.160	15/32	25/32	4 21/64	15/16	-	29/32	1 17/32	GTN/R/L -4
SGTHR 20-5*	SGTHL 20-5*	.187/.200	15/32	25/32	4 21/64	15/16	-	29/32	1 17/32	GTN/R/L -4.8, 5
SGTHR 25-3*	SGTHL 25-3*	.120	63/64	63/64	5 7/8	1 3/16	-	63/64	2 1/16	GTN/R/L -3
SGTHR 25-4*	SGTHL 25-4*	.160	63/64	63/64	5 7/8	1 3/16	-	1 3/16	2 1/2	GTN/R/L -4
SGTHR 25-5*	SGTHL 25-5*	.187/.200	63/64	63/64	5 7/8	1 3/16	-	1 21/64	3	GTN/R/L -4.8, 5
SGTHR 25.4-3*	SGTHL 25.4-3*	.120	63/64	1	5 7/8	1 3/16	-	63/64	2 1/16	GTN/R/L -3
SGTHR 25.4-4*	SGTHL 25.4-4*	.160	63/64	1	5 7/8	1 3/16	-	1 3/16	2 1/2	GTN/R/L -4
SGTHR 25.4-5*	SGTHL 25.4-5*	.187/.200	63/64	1	5 7/8	1 3/16	-	1 21/64	3	GTN/R/L -4.8, 5

**GT Cut-Off Inserts Available Positive, and High Positive
Available in Neutral, Left Hand, Right Hand, Coated & Uncoated**

Insert Information & Pricing on Pages 49 to 54.

ALORIS CARBIDE INSERTS

A-2 A specially formulated grade of tungsten carbide with a unique combination of high strength and abrasion resistance. The A-2 is an excellent choice for cast iron, high temperature alloys, and non-ferrous materials.




A-2 – An uncoated grade used for machining 200 + 300 series stainless steel; cast iron (gray), malleable irons, ductile irons, brass, bronze, carbon, plastic, fiberglass, high temp alloy, nickel and cobalt base. [i.e. rene 41, (inconel w, x, 702, 718) (m 252 – washpaloy) hastelloy, inconel 600, TD-2, HS21, HS 31, HS 36, L 605) titanium (i.e. (Ti 5 A1-2.5 SN) (Ti 6-2-4-2) (Ti 6A1-4V) (Ti 6 A1-6V-25n) (Ti 7 A1-4 Mo) (Ti 8 A1 Mo-1V) (Ti A 55) (Ti 5A) (Ti 140A) aluminum (i.e. 2017T, 2042T, 6061T)]

A-6 A specially formulated grade of tungsten carbide with an excellent combination of toughness and hardness for turning, boring, and grooving on steel and alloyed cast iron. The A-6 may be utilized at moderate cutting speeds with medium feeds.

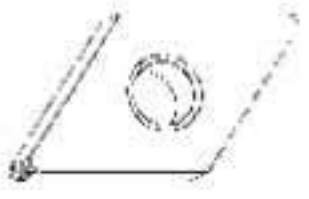



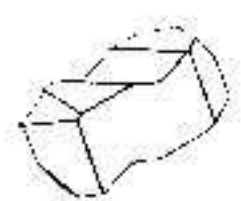
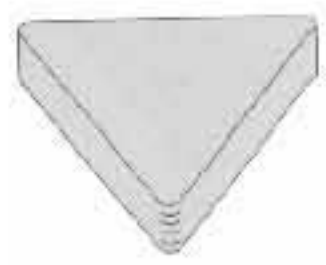
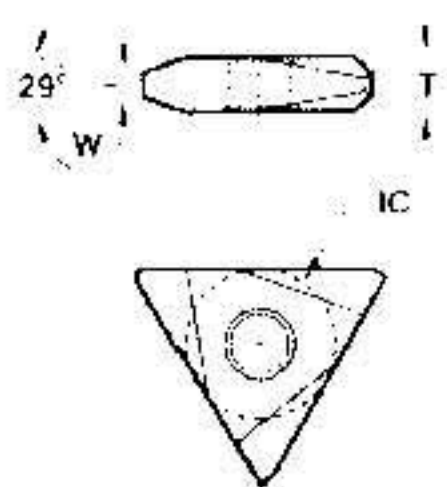
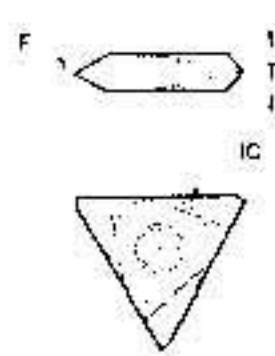
A-6 – An uncoated grade used for machining low, medium, and high carbon steel [i.e. 1000, 1100, 1200, 1500 series], alloy steel [i.e. 1300, 2000, 3000, 4000, 5000, 8000 series], cast steel [i.e. carbon and alloy], nodular iron.

767 A specially formulated substrate carbide grade with a (gold) multi-layer coating with a broad application range for turning, milling, grooving, and cut-off purposes. The 767 exhibits high hardness at elevated temperatures and it also works well in most large depths of cut. This grade accommodates moderate to high speed machining on low, medium, and high carbon steels as well as alloy and tool steels.

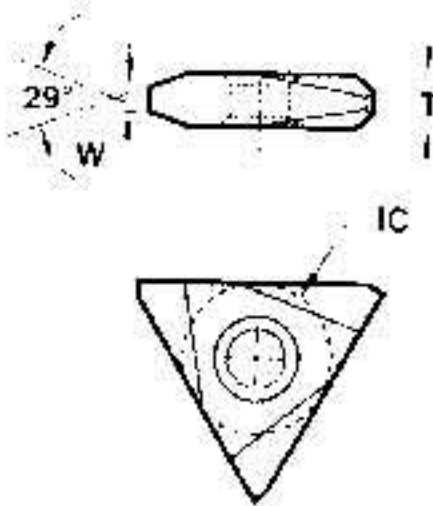
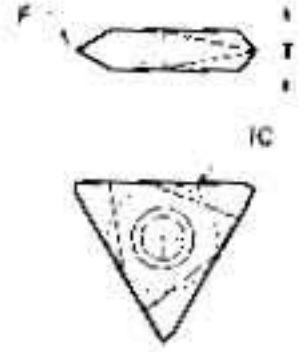




767 – A coated grade used for machining low, medium, and high carbon steel [i.e. 1000, 1100, 1200, 1500 series], alloy steel [i.e. 1300, 2000, 3000, 4000, 5000, 8000 series], cast steel [i.e. carbon and alloy], nodular iron.

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS			
		I.C.	THICKNESS	RADIUS	HOLE
ATPG  ATPGHL  ATPGHR 	ASD-8P*	1/2	1/8	1/32	
	ASD-12P*	3/4	3/16	3/64	
	AT-4R*				
	ATD-8P*	1/2	3/16	1/32	.7188
	ATDHL-8P*	1/2	3/16	1/32	.7188
	ATPG-321*	5/32	1/16	1/64	.2188
	ATPG-431*	1/4	3/32	1/64	.3594
	ATPG-541*	5/16	1/8	1/64	.5469
	ATPG-642*	3/8	1/8	1/32	.5312
	ATPGHL-431*	1/4	3/32	1/64	.3594
	ATPGHL-541*	5/16	1/8	1/64	.5469
	ATPGHL-642*	3/8	1/8	1/32	.5312
ATPGHR-431*	1/4	3/32	1/64	.3594	
ATPGHR-541*	5/16	1/8	1/64	.5469	
CHIPBREAK MN 	CNMG-431 MN*	1/2	3/16	1/64	.203
	CNMG-432 MN*	1/2	3/16	1/32	.203
	CNMG-433 MN*	1/2	3/16	3/64	.203
CHIPBREAK RN 	CNMG-434 RN*	1/2	3/16	1/16	.203
	CNMG-542 RN*	5/8	1/4	1/32	.250
	CNMG-543 RN*	5/8	1/4	3/64	.250
	CNMG-642 RN*	3/4	1/4	1/32	.312
CHIPBREAK MN	CNMG-643 MN*	3/4	1/4	3/64	.312
CHIPBREAK RN	CNMG-644 RN*	3/4	1/4	1/16	.312
CNMZ 	CNMZ-432 MP*	1/2	3/16	1/32	.203
	CNMZ-543 MP*	5/8	1/4	3/64	.250
	CNMZ-642 MP*	3/4	1/4	1/32	.312
	CNMZ-643 MP*	3/4	1/4	3/64	.312

ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS			
		I.C.	THICK- NESS	RADIUS	HOLE
DNGA 	DNGA-532*	5/8	3/16	1/32	.250
	DNGA-542*	5/8	1/4	1/32	.250
	DNGA-543*	5/8	1/4	3/64	.250
DNMG 	DNMG-331 LR-11*	3/8	3/16	1/64	.750
	DNMG-332 LR-11*	3/8	3/16	1/32	.150
CHIPBREAK MN	DNMG-333 MN*	3/8	3/16	3/64	.150
DNMG 	DNMG-431 LR-13*	1/2	3/16	1/64	.203
	DNMG-432 LR-13*	1/2	3/16	1/32	.203
10° POSITIVE	DNMS-542*	5/8	1/4	1/32	.250
CHIPBREAK MN	DNMZ-432 MP*	1/2	3/16	1/32	.203
CHIPBREAK MN	DNMZ-532 MP*	5/8	3/16	1/32	.250
CHIPBREAK MN	DNMZ-542 MP*	5/8	1/4	1/32	.250
NT 	NT-2 R & L HND*				
	NT-3 R & L HND*				
	NT-4 R & L HND*				
NT 	NT-2 POS R & L HND*				
	NT-3 POS R & L HND*				
	NT-4 POS R & L HND*				
TNG 	TNG 321*	3/8	1/8	1/64	
	TNG 322*	3/8	1/8	1/32	
	TNG 323*	3/8	1/8	3/64	
	TNG 431*	1/2	3/16	1/64	
	TNG 432*	1/2	3/16	1/32	
	TNG 544*	5/8	1/4	1/16	
TNMA 	TNMA 32 NT 6*	3/8	.127		.150
	TNMA 32 NT 8*	3/8	.127		.150
	TNMA 32 NT 10*	3/8	.127		.150
	TNMA 32 NT 12*	3/8	.127		.150
	TNMA 43 NT 4*	1/4	.189		.203
	TNMA 43 NT 5*	1/4	.189		.203
	TNMA 43 NT 6*	1/4	.189		.203
	TNMA 43 NT 8*	1/4	.189		.203
	TNMA 43 NT 10*	1/4	.189		.203
TNMA 	TNMA 32 NV*	3/8	.127	8-36	.150
	TNMA 43 NV*	1/2	.189	5-24	.203
	TNMA 54 NV*	5/8	.252	4-20	.250
	TNMA 64 NV*	3/4	.250	4-20	.312
	TNMA 66 NV*	3/4	.375	3-12	.312

ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS			
		I.C.	THICK- NESS	RADIUS	HOLE
 TNMC	TNMC 32 NT 6*	3/8	.127		.150
	TNMC 32 NT 8*	3/8	.127		.150
	TNMC 32 NT 10*	3/8	.127		.150
	TNMC 32 NT 12*	3/8	.127		.150
	TNMC 43 NT 4*	1/4	.189		.203
	TNMC 43 NT 5*	1/4	.189		.203
	TNMC 43 NT 6*	1/4	.189		.203
	TNMC 43 NT 8*	1/4	.189		.203
	TNMC 43 NT 10*	1/4	.189		.203
 TNMC	TNMC 32 NV*	3/8	.127	8-36	.150
	TNMC 43 NV*	1/2	.189	5-24	.203
	TNMC 54 NV*	5/8	.252	4-20	.250
	TNMC 64 NV*	3/4	.250	4-20	.312
	TNMC 66 NV*	3/4	.375	3-12	.312
 TNMG	TNMG-221 MN*	1/4	1/8	1/64	.093
	TNMG-222 MN*	1/4	1/8	1/32	.093
	TNMG-331 MN*	3/8	3/16	1/64	.150
	TNMG-332 MN*	3/8	3/16	1/32	.150
	TNMG-333 MN*	3/8	3/16	3/64	.150
	TNMG-431 MN*	1/2	3/16	1/64	.203
	TNMG-432 MN*	1/2	3/16	1/32	.203
CHIPBREAK RN	TNMG-433 RN*	1/2	3/16	3/64	.203
CHIPBREAK MN	TNMG-542 MN*	5/8	1/4	1/32	.250
 TNMG	TNMG-543*	5/8	1/4	3/64	.250
	TNMG-544*	5/8	1/4	1/16	.250
 TNMS	TNMS-331*	3/8	3/16	1/64	.150
	TNMS-332*	3/8	3/16	1/32	.150
	TNMS-431*	1/2	3/16	1/64	.203
	TNMS-432*	1/2	3/16	1/32	.203
 TNMP	TNMP-332*	3/8	3/16	1/32	.150
	TNMP-432*	1/2	3/16	1/32	.203
	TNMP-543*	5/8	1/4	3/64	.250



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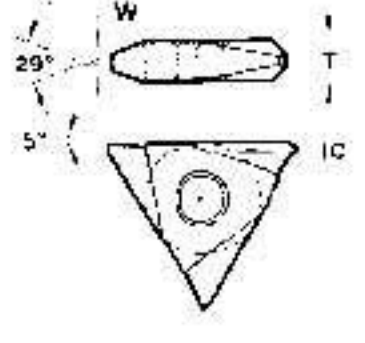

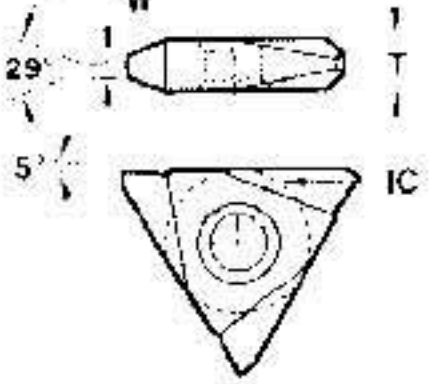
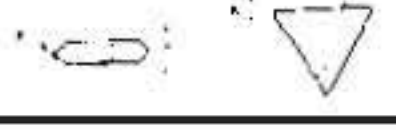

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*The originator of
quick change tooling*

ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS			
		I.C.	THICK- NESS	RADIUS	HOLE
	TPG-221*	1/4	1/8	1/64	
	TPG-222*	1/4	1/8	1/32	
	TPG-223*	1/4	1/8	3/64	
	TPG-224*	1/4	1/8	1/16	
	TPG-321*	3/8	1/8	1/64	
	TPG-322*	3/8	1/8	1/32	
	TPG-323*	3/8	1/8	3/64	
	TPG-324*	3/8	1/8	1/16	
	TPG-431*	1/2	3/16	1/32	
	TPG-432*	1/2	3/16	1/32	
	TPG-433*	1/2	3/16	3/64	
	TPG-434*	1/2	3/16	1/16	
	TPG				
	TPMA 32 NT 6*	3/8	.127		.150
	TPMA 32 NT 8*	3/8	.127		.150
	TPMA 32 NT 10*	3/8	.127		.150
	TPMA 32 NT 12*	3/8	.127		.150
	TPMA 43 NT 4*	1/4	.189		.203
	TPMA 43 NT 5*	1/4	.189		.203
	TPMA 43 NT 6*	1/4	.189		.203
	TPMA 43 NT 8*	1/4	.189		.203
	TPMA 43 NT 10*	1/4	.189		.203
TPMA					
	TPMA 32 NV*	3/8	.127	8-36	.150
	TPMA 43 NV*	1/2	.189	5-24	.203
	TPMC 32 NT 6*	3/8	.127		.150
	TPMC 32 NT 8*	3/8	.127		.150
	TPMC 32 NT 10*	3/8	.127		.150
	TPMC 32 NT 12*	3/8	.127		.150
	TPMC 43 NT 4*	1/4	.189		.203
	TPMC 43 NT 5*	1/4	.189		.203
	TPMC 43 NT 6*	1/4	.189		.203
	TPMC 43 NT 8*	1/4	.189		.203
	TPMC 43 NT 10*	1/4	.189		.203
TPMC					
	TPMC 32 NV*	3/8	.127	8-36	.150
	TPMC 43 NV*	1/2	.189	5-24	.203
	TPU-321*	3/8	1/8	1/64	
	TPU-322*	3/8	1/8	1/32	
	TPU-323*	3/8	1/8	3/64	
	TPU-324*	3/8	1/8	1/16	
TPU					

ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS			
		I.C.	THICK- NESS	RADIUS	HOLE
 WNUMG	WNUMG-331 MN*	3/8	3/16	1/64	.150
	WNUMG-332 MN*	3/8	3/16	1/32	.150
	WNUMG-333 MN*	3/8	3/16	3/64	.150
	WNUMG-431 MN*	1/2	3/16	1/64	.203
	WNUMG-432 MN*	1/2	3/16	1/32	.203
	WNUMG-433 MN*	1/2	3/16	3/64	.203

LAY DOWN THREADING INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS				GRADES →		
		I.C.	THICK- NESS	RADIUS	HOLE	X	Y	TPI
 AIT-R/L60	1/4 AIT-R60*	1/4	.126	.0018	.128	.031	.035	16-48
	1/4 AIT-L60*	1/4	.126	.0018	.128	.031	.035	16-48
	3/8 AIT-R60*	3/8	.143	.002	.155	.047	.067	8-48
	3/8 AIT-L60*	3/8	.143	.002	.155	.047	.067	8-48
	1/2 AIT-R60*	1/2	.188	.008	.192	.067	.098	5-7
	1/2 AIT-L60*	1/2	.188	.008	.192	.067	.098	5-7
 ER/L60	16ER LAG 60-RH*	3/8	.143	.002	.155	.047	.067	8-48
	16ER LAG 60-LH*	3/8	.143	.002	.155	.047	.067	8-48
	22ER LN 60-RH*	1/2	.188	.0132	.192	.067	.098	5-7
	22ER LN 60-LH*	1/2	.188	.0132	.192	.067	.098	5-7

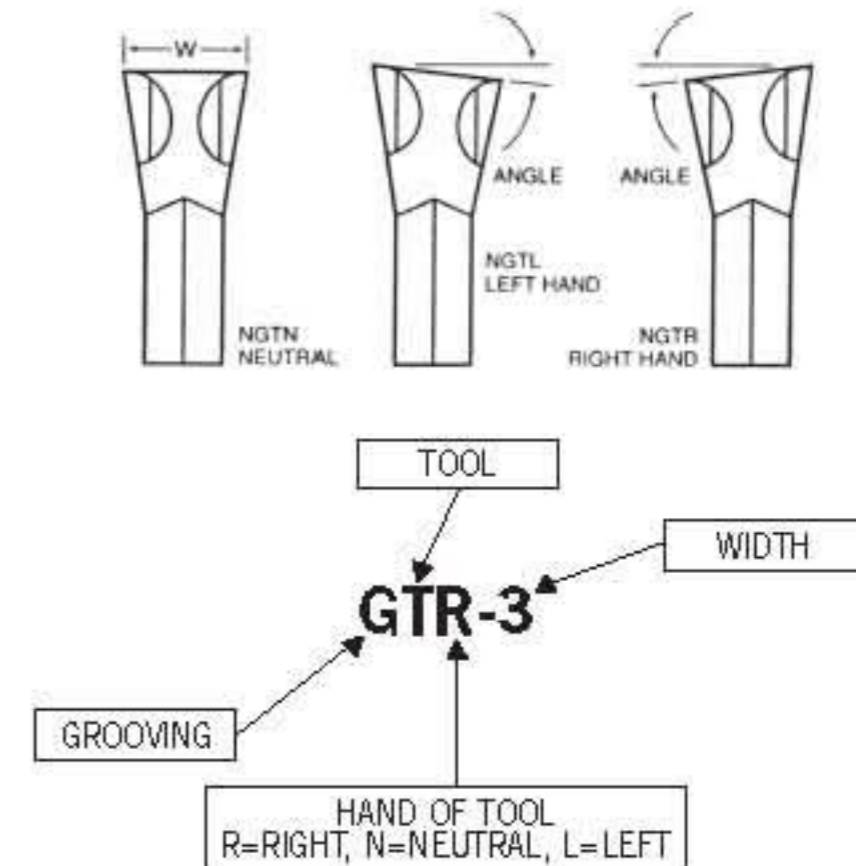
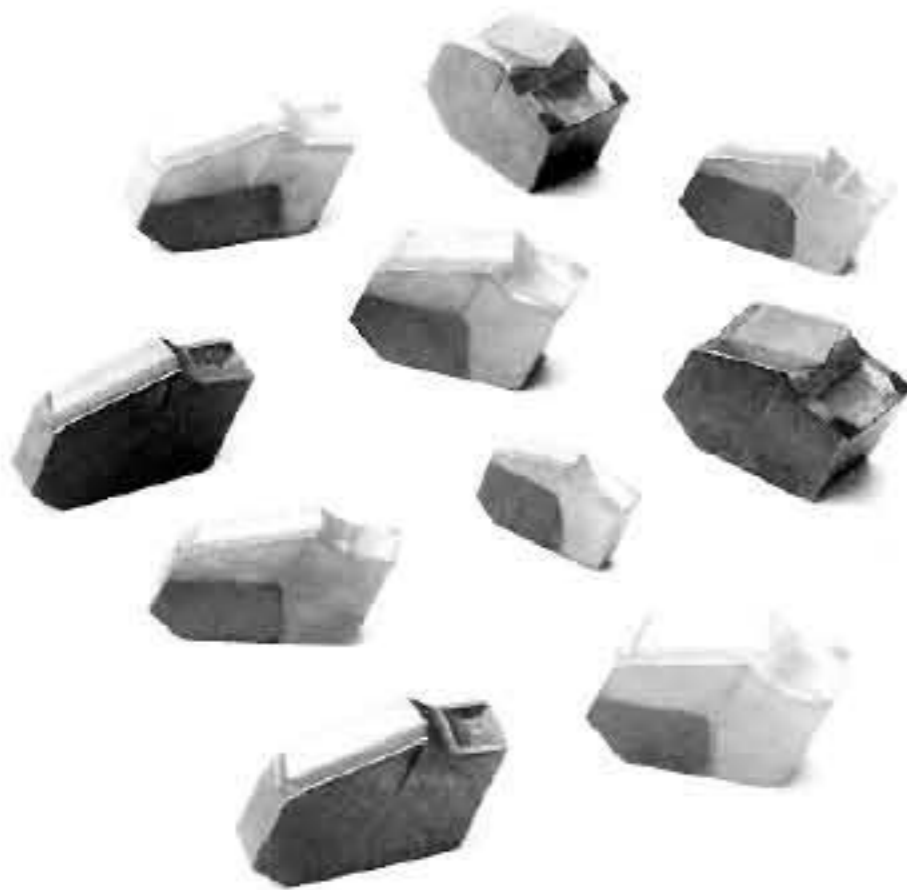
Inserts sold in packages of 10. Prices are per piece.

**NOW AVAILABLE FROM ALORIS
ALORIS/YES TOOL QUICKTIP DRILLS**



CALL FOR A COMPLETE CATALOG

ALORIS CUT-OFF AND GROOVING INSERTS



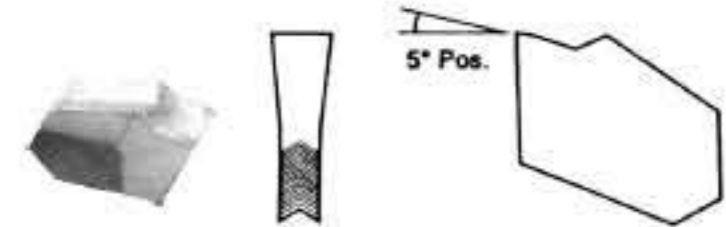
GT Cut-Off Insert

	Catalog Number	Cutting Edge Geometry	Cutting Width	Lead Angle
	GTN 2*	P	.087	0
++	GT L/R 2*	P	.087	8
++	GT L/R 2.4*	P	.093	8
	GTN 3*	P	.120	0
++	GT L/R 3*	P	.120	8
	GTN 4*	P	.160	0
++	GT L/R 4*	P	.160	8
	GTN 4.8*	P	.187	0
++	GT L/R 4.8*	P	.187	8
	GTN 5*	P	.200	0
++	GT L/R 5*	P	.200	8
	GTN 6*	P	.250	0
++	GT L/R 6*	P	.250	8
	GTN 8*	P	.315	0
++	GT L/R 8*	P	.315	4
	GTN 9*	P	.375	0
++	GT L/R 9*	P	.375	4

CUTTING EDGE GEOMETRY POSITIVE

Positive (P Style) for Positive Cutting Action
(Stock standard)

Aloris' P Style insert is ideal for 300 Series stainless steel, high-temperature alloys, cast iron, chrome and nickel based alloys.



Pick the grade to fit your application.

- 767** - A strong steel cutting grade ideal for cut-off and grooving applications, coated with Titanium Nitride (gold) for additional wear properties.
- A2** - Our best fine-grain uncoated grade for cast iron, nonferrous metals and high-temp alloys.
- A6** - A strong steel cutting grade, uncoated, for low to medium speed operations.



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The originator of quick change tooling

POLICY AND PROCEDURES

1. **MINIMUM ORDERS:**

All orders will be a minimum of \$25.00 net. Any orders less than minimum will be charged at the \$25.00 minimum rate.

2. **TERMS:**

1% 10 days – NET 30 days. Discounts are to be taken as per our terms and any extended discounts will be considered as partial payments in accordance with New Jersey UCC Code Section 1-207. Past due accounts, over 45 days, will be charged 1½% interest per month and all orders will be placed on CREDIT HOLD and not reissued into production until the account is up to date.

3. **DELIVERY:**

All merchandise will be shipped FOB, Aloris Factory, Clifton, N.J., 07015. We ship UPS, unless otherwise specified. All merchandise will be shipped in partial shipments, unless notified to the contrary. The majority of orders will be shipped within 48 hours.

4. **CLAIMS/SHORTAGES/SHORT SHIPMENTS:**

Claims, shortages, or short shipments must be reported within 5 days after receipt of merchandise. Packaging must be intact and all claims must be reported through delivering carrier. Packaging must be retained for damaged goods inspection. Please always refer to our order number.

5. **RETURNS/RESTOCKING CHARGES:**

All returns must be authorized and accompanied by an "RGA" number issued by Aloris and shipped prepaid. We will accept returns within a 30 day period as long as items have not been used. If the error was our responsibility, there will be NO restocking charge. All other returns will be subject to a restocking charge of 20%. If the goods require refurbishing, an additional 10% charge will be levied. Aloris reserves the right to inspect and approve all returns.

6. **GUARANTEE/SERVICE:**

The products are guaranteed to be free from defect in material and workmanship. Products will be repaired or replaced, at our option, at no charge unless items have been: misused, abused, accidentally damaged or normal wear and tear and also where alterations or modifications were or have been made by anyone other than Aloris. Repairs not covered by the foregoing guarantee will be made at net pricing and shall be payable pursuant to the foregoing terms.

7. **PRICES:**

Prices are guaranteed at time of order into production. Prices are subject to change without notice. The catalog 2006 supersedes any pricing policies & procedures of any previous catalog.

8. **REPAIRS/SPECIALS:**

Repairs and parts are quoted within 24 hours. Aloris Tool will manufacture these products. All special tooling products are on a quotation basis and are non-returnable and non-cancellable once order is received.

9. **REPLACEMENT PARTS:**

All items marked with an * (**asterisk**) after the order number, specials, and repairs are available directly from the manufacturer, and may be purchased at list price with any major credit card, or COD. Freight charges for these orders will be as follows:

**Conditions, terms, and prices are subject to change without notice.
Any typographical or other error in this catalog is subject to correction.**



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