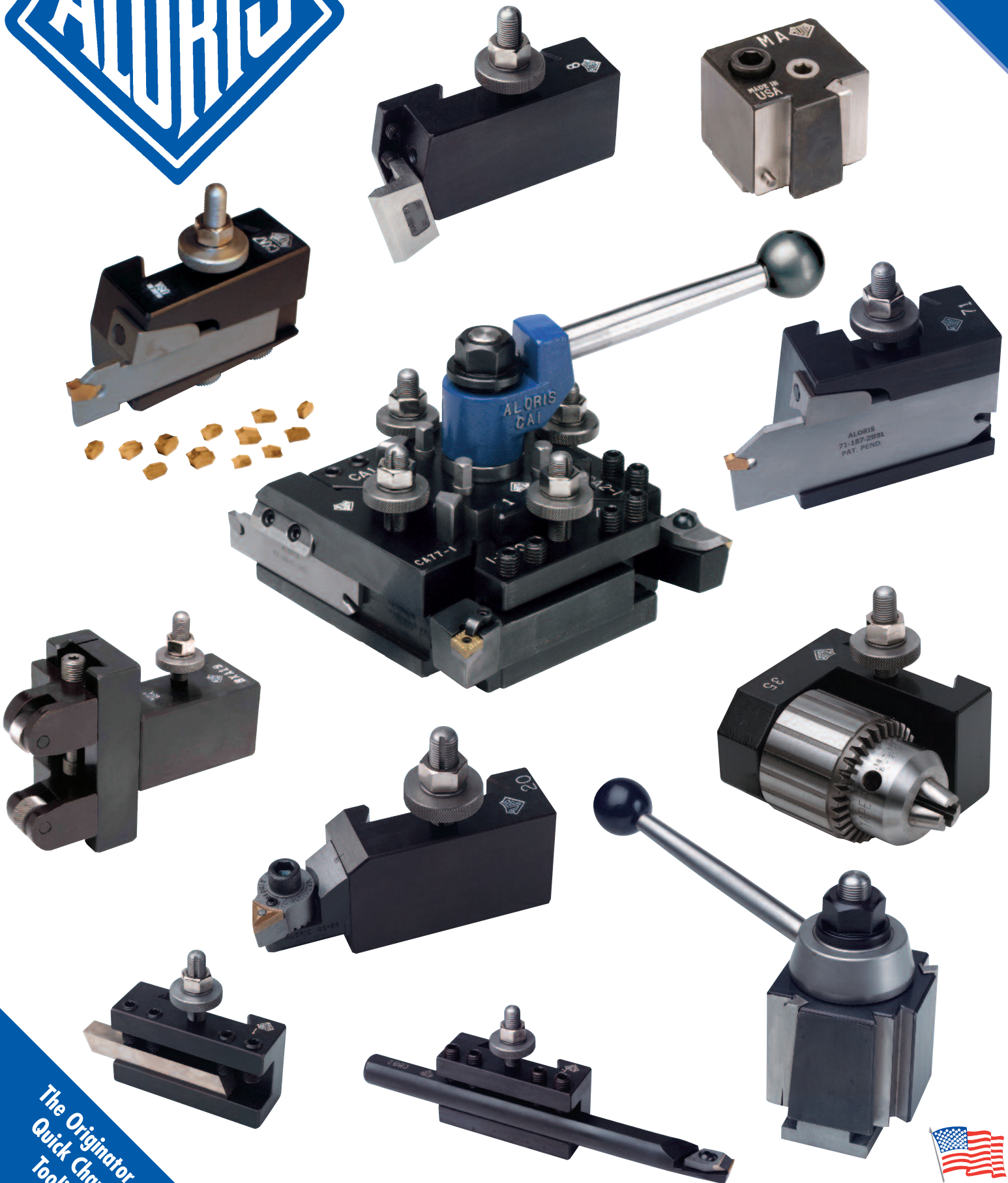




# ALORIS TOOL TECHNOLOGY CO., INC.

2017 CATALOG



The Originator of Quick Change Tooling



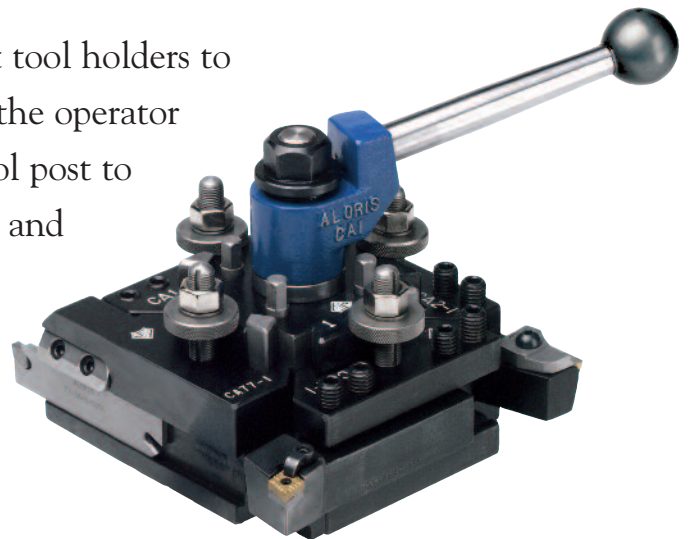
All Aloris products are proudly made in the USA.

# 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%**



All Aloris products are proudly made in the USA.

- 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



### ALORIS TOOL TECHNOLOGY CO., INC.

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REV 1/12

PATENT PENDING

The originator of quick change tooling

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# ALORIS SUPER PRECISION QUICK CHANGE TOOL POSTS

FOR MANUAL AND CNC LATHES

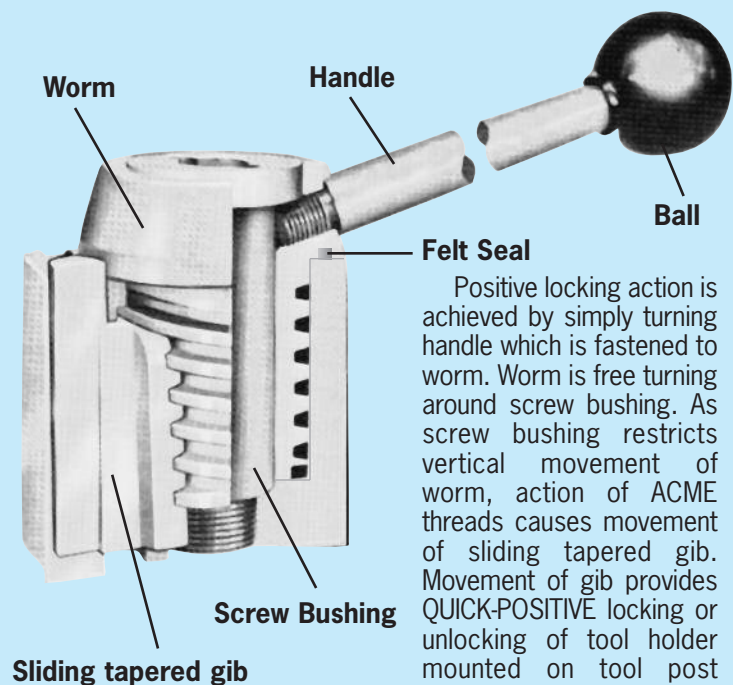
## GUARANTEED LASTING REPETITIVE ACCURACY TO WITHIN MILLIONTHS

### 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\*



### Aloris super precision tool post Patented locking device assembly



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.


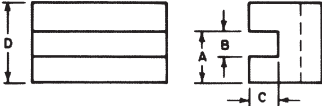

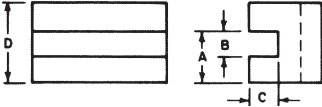

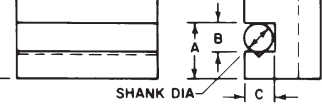

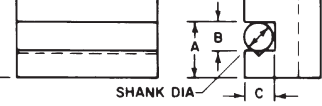

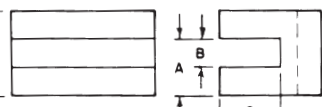

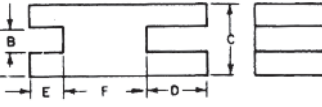

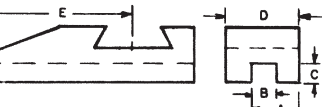

This new catalog includes the newest developments produced by Aloris design engineers in their constant search for new and better products that will increase productivity and reduce operating costs of all machine tool operations.

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.



# QUICK CHANGE SHANK TOOL HOLDERS

				<b>AXA SERIES</b>						
<b>#1</b>		<b>TURNING AND FACING HOLDER</b> Takes various sizes of bits. Turning and facing tools can be locked in together. Saves time and labor when changing operations.		<b>ORDER # AXA-1</b>						
				A	B	C	D	Tool Bit		
				$1\frac{5}{16}$	$\frac{1}{2}$	$\frac{7}{16}$	$1\frac{1}{2}$	$\frac{3}{16}-\frac{1}{2}$		
<b>#1S</b>		<b>OVERSIZE TURNING AND FACING HOLDER</b> 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.		<b>ORDER # AXA-1S</b>						
				A	B	C	D	Tool Bit		
				1"	$\frac{5}{8}$	$\frac{7}{16}$	$1\frac{1}{2}$	$\frac{5}{8}$ max		
<b>#2</b>		<b>BORING, TURNING AND FACING HOLDER</b> "V" groove holds round shank boring bars and tools as well as square tool bits.		<b>ORDER # AXA-2</b>						
				A	B	C	D	Tool Bit	Shank	
				$1\frac{5}{16}$	$\frac{1}{2}$	$\frac{7}{16}$	$1\frac{1}{2}$	$\frac{3}{16}-\frac{1}{2}$	$\frac{7}{16}$	
<b>#2S</b>		<b>OVERSIZE BORING, TURNING AND FACING HOLDER</b> "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.		<b>ORDER # AXA-2S</b>						
				A	B	C	D	Tool Bit	Shank	
				1"	$\frac{5}{8}$	$\frac{7}{16}$	$1\frac{1}{2}$	$\frac{5}{8}$ max	$\frac{1}{2}$	
<b>#6</b>		<b>MULTIPLE TOOL HOLDER</b> Versatile, ideal for repetitive work: for gang set-ups or form tool.		<b>ORDER # AXA-6</b>						
				A	B	C	D	Tool Bit		
				1"	$\frac{1}{2}$	$1\frac{1}{8}$	$1\frac{9}{16}$	$\frac{1}{4}-\frac{1}{2}$		
<b>#9</b>		<b>MULTI-PURPOSE HOLDER</b> 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.		<b>ORDER # AXA-9 SPECIAL ORDER</b>						
				A	B	C	D	E	F	Tool Bit
				$1\frac{5}{16}$	$\frac{3}{8}$	$1\frac{1}{2}$	$1\frac{7}{8}$	1"	$2\frac{1}{8}$	$\frac{3}{16}-\frac{3}{8}$
<b>#13</b> <b>#13L</b>		<b>EXTENSION TOOL HOLDER #13 &amp; 13L</b> 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.		<b>ORDER # AXA-13</b>	<b>ORDER # AXA-13L</b>					
				A	B	C	D	E	Tool Bit	
				$1\frac{5}{16}$	$\frac{1}{2}$	$\frac{7}{16}$	$1\frac{1}{2}$	$2\frac{1}{2}$	$\frac{3}{16}-\frac{1}{2}$	
<b>HEIGHT ADJUSTMENT ASSEMBLY</b>				<b>ORDER # AXA-HA*</b>						
<b>TOOL HOLDER SET SCREWS (SET OF 4)</b>			<b>ORDER # AXA-SS*</b>							



BXA SERIES						CXA 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 <sup>1</sup> / <sub>8</sub>	<sup>5</sup> / <sub>8</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	1/4– <sup>5</sup> / <sub>8</sub>		1 <sup>7</sup> / <sub>16</sub>	<sup>3</sup> / <sub>4</sub>	<sup>5</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>8</sub>	1/2– <sup>3</sup> / <sub>4</sub>		1 <sup>11</sup> / <sub>16</sub>	1"	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1/2–1"		2 <sup>3</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>4</sub>	1"	3 <sup>1</sup> / <sub>8</sub>	1/2–1 <sup>1</sup> / <sub>4</sub>		2 <sup>11</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	4"	3/4–1 <sup>1</sup> / <sub>2</sub>							
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 <sup>3</sup> / <sub>16</sub>	<sup>3</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	3/4 max		1 <sup>9</sup> / <sub>16</sub>	1"	<sup>5</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>8</sub>	1" max		2"	1 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub> max		2 <sup>5</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	1"	3 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub> 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	A	B	C	D	Tool Bit	Shank
1 <sup>1</sup> / <sub>8</sub>	<sup>5</sup> / <sub>8</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	1/4– <sup>5</sup> / <sub>8</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>7</sup> / <sub>16</sub>	<sup>3</sup> / <sub>4</sub>	<sup>5</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>8</sub>	1/2– <sup>3</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	1 <sup>11</sup> / <sub>16</sub>	1"	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1/2–1"	<sup>13</sup> / <sub>16</sub>	2 <sup>3</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>4</sub>	1"	3 <sup>1</sup> / <sub>8</sub>	1/2–1 <sup>1</sup> / <sub>4</sub>	1"	2 <sup>11</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	4"	3/4–1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>						
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 <sup>3</sup> / <sub>16</sub>	<sup>3</sup> / <sub>4</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	3/4 max	<sup>5</sup> / <sub>8</sub>	1 <sup>9</sup> / <sub>16</sub>	1"	<sup>5</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>8</sub>	1" max	<sup>3</sup> / <sub>4</sub>	2"	1 <sup>1</sup> / <sub>4</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub> max	1"	2 <sup>7</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	1"	3 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub> max	1 <sup>1</sup> / <sub>4</sub>												
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							
1 <sup>1</sup> / <sub>16</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>9</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	1/4– <sup>1</sup> / <sub>2</sub>		1 <sup>5</sup> / <sub>16</sub>	<sup>5</sup> / <sub>8</sub>	1 <sup>7</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>8</sub>	3/8– <sup>5</sup> / <sub>8</sub>		1 <sup>9</sup> / <sub>16</sub>	<sup>3</sup> / <sub>4</sub>	1 <sup>7</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>	1/2– <sup>3</sup> / <sub>4</sub>		2 <sup>1</sup> / <sub>8</sub>	1"	2 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>4</sub>	1/2–1"		2 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>5</sup> / <sub>8</sub>	4"	3/4–1 <sup>1</sup> / <sub>2</sub>							
ORDER # BXA-9 SPECIAL ORDER						ORDER # CXA-9 SPECIAL ORDER						ORDER # CA-9 SPECIAL ORDER						ORDER # DA-9 SPECIAL ORDER																	
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 <sup>1</sup> / <sub>8</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	2 <sup>11</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>16</sub>	2 <sup>5</sup> / <sub>8</sub>	1/4– <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>16</sub>	<sup>5</sup> / <sub>8</sub>	2"	3"	1 <sup>5</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>8</sub>	3/8– <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>4</sub>	3 <sup>7</sup> / <sub>8</sub>	3/8– <sup>3</sup> / <sub>4</sub>	2"	1"	3"	4"	2 <sup>1</sup> / <sub>8</sub>	4 <sup>7</sup> / <sub>8</sub>	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 <sup>1</sup> / <sub>8</sub>	<sup>5</sup> / <sub>8</sub>	<sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	1/4– <sup>5</sup> / <sub>8</sub>		1 <sup>7</sup> / <sub>16</sub>	<sup>3</sup> / <sub>4</sub>	<sup>5</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>8</sub>	1/2– <sup>3</sup> / <sub>4</sub>		1 <sup>11</sup> / <sub>16</sub>	1"	<sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>4</sub>	1/2–1"		2 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	1"	3 <sup>1</sup> / <sub>8</sub>	5"	1/2–1 <sup>1</sup> / <sub>4</sub>		2 <sup>11</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	4"	6 <sup>1</sup> / <sub>2</sub>	3/4–1 <sup>1</sup> / <sub>2</sub>		
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*											

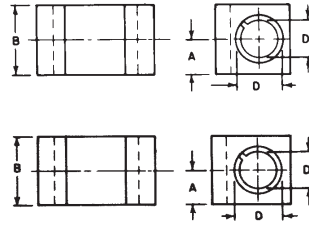
# QUICK CHANGE BORING BAR TOOL HOLDERS

## #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 SERIES

### ORDER # AXA-4

A	B	D	D <sub>1</sub>
3/4	1 1/2	3/4	5/8

### ORDER # AXA-41

A	B	D	D <sub>1</sub>
7/8	1 3/4	1"	3/4

### ORDER # AXA-PINS\*

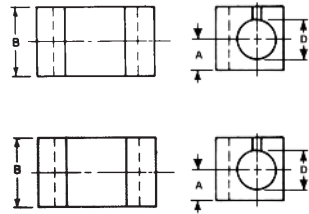
### ORDER # AXA-JS\*

## #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

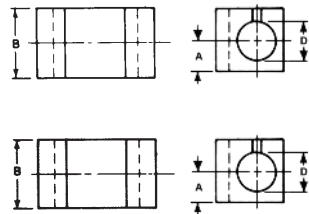
A	B	D	
7/8	1 3/4	1"	

## #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 3/4	1"	

### STOP RINGS



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

### HEIGHT ADJUSTMENT ASSEMBLY



### ORDER # AXA-HA\*

### BUSHINGS/STANDARD

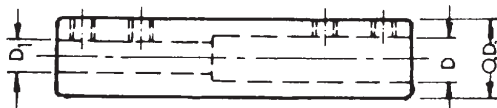
### ORDER # AXA-STD\*

### 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
RB-31*	3/4	1/2	1/4
RB-32*	3/4	3/8	3/16
RB-41*	1"	5/8	5/16
RB-42*	1"	1/2	1/4
RB-51*	1 1/4	3/4	3/8
RB-52*	1 1/4	5/8	5/16





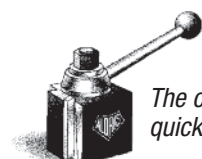
BXA SERIES				CXA SERIES				CA SERIES				DA SERIES				EA SERIES			
ORDER # BXA-4				ORDER # CXA-4				ORDER # CA-4				ORDER # DA-4				ORDER # EA-4			
A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>
1"	2"	1"	¾"	1"	2"	1"	¾"	1⅜"	2¾"	1¼"	1"	1⅝"	3¼"	1½"	1¼"	2¼"	4½"	2½"	2"
ORDER # BXA-41				ORDER # CXA-41				ORDER # CA-41				ORDER # DA-41							
A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>	A	B	D	D <sub>1</sub>				
1"	2"	1¼"	1"	1⅞"	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"		1⅞"	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"		1⅞"	2¼"	1¼"		1⅜"	2¾"	1½"		1¾"	3½"	2"		2¼"	4½"	3"	
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*			

Larger holders available for CA, DA Series on page 28.



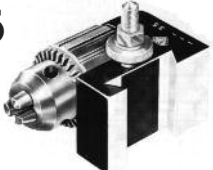
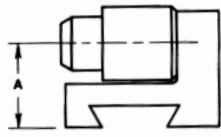

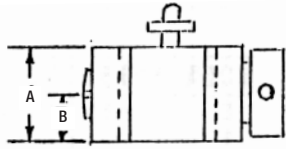

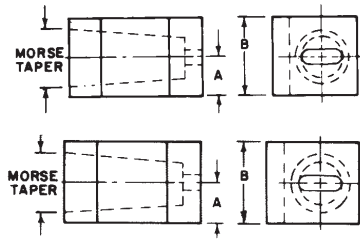

**ALORIS TOOL TECHNOLOGY CO., INC.**

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 TEL: 973.772.1201 • FAX: 973.772.8606 • TOLL FREE: 877.772.1733  
 E-MAIL: aloris@aloris.com • WEBSITE: <http://www.aloris.com>



*The originator of  
quick change tooling*

# QUICK CHANGE DRILLING HOLDERS

			<b>AXA SERIES</b>		
<b>#35</b>		<b>DOVETAIL CHUCK HOLDER</b> 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.			
			<b>ORDER # AXA-35</b>	A	CHUCK CAPACITY
		2	0 - 1/2		
<b>#5C</b>		<b>5C COLLET HOLDER</b> Can be used with a variety of shank tools: drills, reamers, C. bores, taps, end mills, boring bars and other tools. Collet not included.			
			<b>ORDER # AXA-5C</b>	A	B
		1 7/8	1 5/16	5C	
<b>#5, #53, #54, #55</b>		<b>MORSE TAPER HOLDER</b> Drills with carriage by using power feed instead of tail stock. Easily centered.			
			<b>ORDER # AXA-5</b>	A	B
		3/4	1 1/2	#2 M.T.	
			<b>ORDER # AXA-53</b>		
			A	B	TAPER HOLE SIZE
			3/4	1 1/2	#3 M.T.
<b>HEIGHT ADJUSTMENT ASSEMBLY</b>					
			<b>ORDER # AXA-HA*</b>		

## #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.

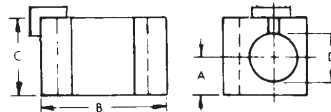
The latch provides positioning accuracy, prevents turning of the taper socket, and assures rigidity. The breech or back-end loading feature of the AMS Morse taper socket, reduces tool changeover time because the cross-slide remains fixed, eliminating re-centering.

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**

SPECIAL ORDER # CXA-44				SPECIAL 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"





BXA SERIES			CXA 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 7/8	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 9/16	3 1/8	#4 M.T.	1 5/8	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 1/16	2 1/8	#4 M.T.	1 1/4	2 1/2	#4 M.T.	1 5/8	3 1/4	#5 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

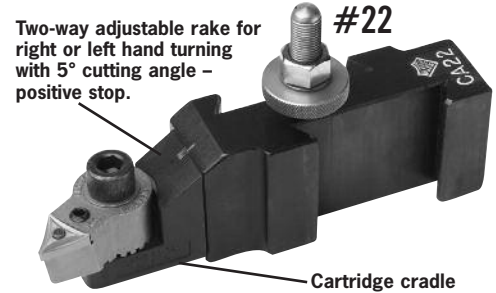
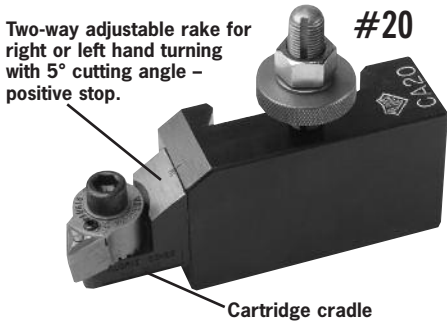
# UNIVERSAL TOOL HOLDERS #20, #30, #22

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.

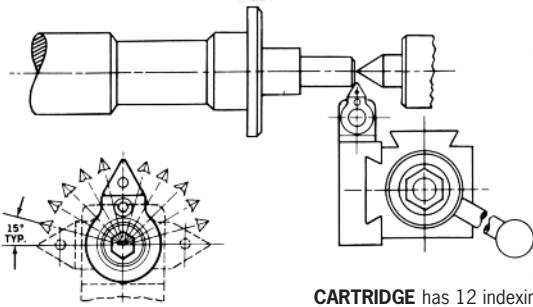
The model #22 with its two dovetail design leads to a wide range of applications by permitting front and rear turning, contouring, boring and facing operations.

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



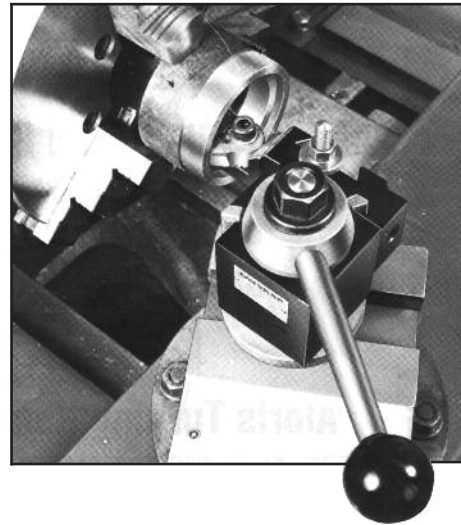
Tool Steel Cartridge adjusts every 15° for right or left hand turning, facing or chamfering. 12 positive lock positions. Exclusive positive lock with 2-way force holding insert down and tight against shoulder. Standard triangular carbide insert has 6 cutting edges.

## ILLUSTRATIONS SHOW WHAT ONE SINGLE TOOL CAN ACCOMPLISH



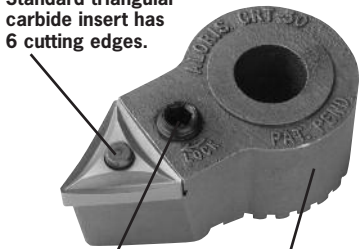
PICTORIAL DIAGRAM OF CARTRIDGE

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.



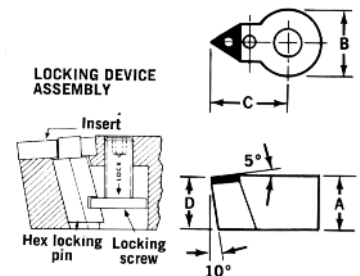
Exclusive positive lock with 2-way force holding insert down and tight against shoulder.

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 SERIES	BXA SERIES	CXA SERIES	CA SERIES	DA SERIES	EA SERIES
<b>UNIVERSAL TOOL HOLDER #20</b> 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. = 1⅝	"E" DIM. = 1⅞	"E" DIM. = 1⅞	"E" DIM. = 1¾		
	REPLACEMENT PARTS					
	<b>CARTRIDGES</b> 	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	
<b>CRADLE</b> 	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*		
<b>LOCK SCREW</b> 	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*		
<b>HEX LOCKING PIN</b> 	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*		
<b>HEIGHT ADJUSTMENT ASSEMBLY</b> 	ORDER # AXA-HA*	ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*		
<b>UNIVERSAL TOOL HOLDER #30</b> 				ORDER # CA-30	ORDER # DA-30	ORDER # EA-30
				"A" DIM. = 2½	"A" DIM. = 2¾	"A" DIM. = 3
				"E" DIM. = 1⅝	"E" DIM. = 1⅞	"E" DIM. = 2⅞
	REPLACEMENT PARTS					
	<b>CARTRIDGES</b> 				ORDER # CRT-30*	ORDER # CRT-30*
<b>LOCK SCREW</b> 				ORDER # LS-30*	ORDER # LS-30*	ORDER # LS-40*
<b>HEX LOCKING PIN</b> 				ORDER # LP-30*	ORDER # LP-30*	ORDER # LP-40*
<b>HEIGHT ADJUSTMENT ASSEMBLY</b> 				ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*
<b>UNIVERSAL TURNING &amp; BORING HOLDER #22</b> 	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. = 1⅝	"E" DIM. = 1⅞	"E" DIM. = 1⅞	"E" DIM. = 1¾	"E" DIM. = 2	"E" DIM. = 2⅝
	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 = 2⅞	MAX BORE LENGTH = 3½	MAX BORE LENGTH = 4
REPLACEMENT PARTS						
<b>CARTRIDGES</b> 	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-30*	ORDER # CRT-30*	ORDER # CRT-40*
<b>CRADLE</b> 	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-30*	ORDER # CC-30*	
<b>LOCK SCREW</b> 	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-30*	ORDER # LS-30*	ORDER # LS-40*
<b>HEX LOCKING PIN</b> 	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-30*	ORDER # LP-30*	ORDER # LP-40*
<b>HEIGHT ADJUSTMENT ASSEMBLY</b> 	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.

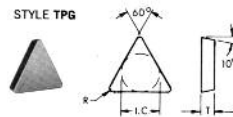


REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER

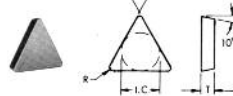


R

REPLACEMENT CARBIDE SHIM



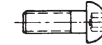
STYLE TPG



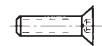
ORDER #	DIMENSIONS		
	I.C.	T	R
TPG-322*	3/8	1/8	1/32
TPG-432*	1/2	3/16	1/32

Inserts are priced individually however, they must be purchased in packages of 10. *See full selection of inserts on pages 49 - 54.*

CLAMP SCREW FOR CHIPBREAKER



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



## AXA 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.

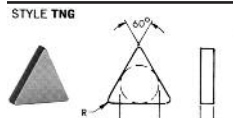


REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER

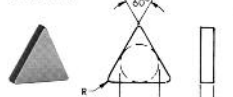


R

REPLACEMENT CARBIDE SHIM



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.*

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. \*\*100 & up call for price.

[See full selection of inserts on pages 49 - 54.](#)

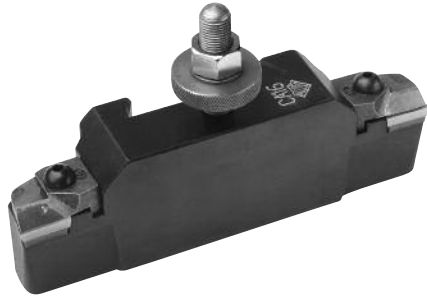


BXA SERIES					CXA SERIES					CA SERIES					DA SERIES					EA SERIES				
ORDER # BXA-12					ORDER # CXA-12					ORDER # CA-12					ORDER # DA-12					ORDER # EA-12				
A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	
		I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE		
1"	1 3/4"	3/8"	1/8"	POS.	1 3/16"	2"	3/8"	1/8"	POS.	1 1/2"	2 1/4"	1/2"	3/16"	POS.	1 3/4"	2 7/8"	1/2"	3/16"	POS.	2 7/16"	3 1/2"	1/2"	3/16"	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 <sup>†</sup>					ORDER # TPG-322 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>				
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			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	
		I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE		
1"	1 3/4"	3/8"	1/8"	NEG.	1 3/16"	2"	3/8"	1/8"	NEG.	1 1/2"	2 1/4"	1/2"	3/16"	NEG.	1 3/4"	2 7/8"	1/2"	3/16"	NEG.	2 7/16"	3 1/2"	3/8"	1/4"	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 <sup>†</sup>					ORDER # TNG-321 <sup>†</sup>					ORDER # TNG-432 <sup>†</sup>					ORDER # TNG-432 <sup>†</sup>					ORDER # TNG-544 <sup>†</sup>				
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. \*\*100 & up call for price.

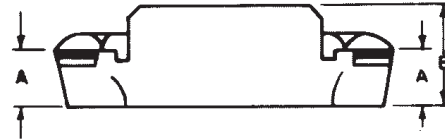
# QUICK CHANGE COMBINATION CARBIDE INSERT CUTTING TOOLS WITH ADJUSTABLE CHIPBREAKER

#16



## COMBINATION TURNING AND FACING HOLDER FOR CARBIDE TRIANGULAR INSERTS

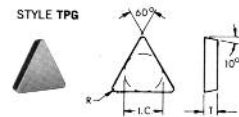
Accommodates standard triangular **positive** rake carbide inserts. Unique design permits both right hand and left hand turning and facing. Supplied with fully adjustable carbide chipbreakers and carbide shims to protect the holder.



REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT

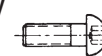


ORDER #	DIMENSIONS		
	I.C.	T	R
TPG-322*	3/8	1/8	1/32
TPG-432*	1/2	3/16	1/32

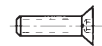
See full selection of inserts on pages 49 - 54.

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

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



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



## AXA 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\*

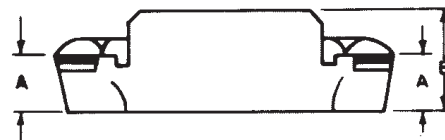
ORDER # AXA-HA\*

#16N



## COMBINATION TURNING AND FACING HOLDER FOR CARBIDE TRIANGULAR INSERTS

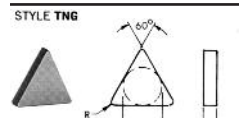
Accommodates standard triangular **negative** rake carbide inserts. Unique design permits both right hand and left hand turning and facing. Supplied with fully adjustable carbide chipbreakers and carbide shims to protect the holder.



REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT



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

See full selection of inserts on pages 49 - 54.

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

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. \*\*100 & up call for price.

See full selection of inserts on pages 49 - 54.





BXA SERIES					CXA 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			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	
		I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE		
1"	1 3/4"	3/8"	1/8"	POS.	1 3/16"	2"	3/8"	1/8"	POS.	1 1/2"	2 1/4"	1/2"	3/16"	POS.	1 3/4"	2 7/8"	1/2"	3/16"	POS.	2 7/16"	3 1/2"	1/2"	3/16"	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 <sup>†</sup>					ORDER # TPG-322 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>				
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			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	A	B	TRIANGULAR INSERT			RAKE	
		I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE				I.C.	THICK	RAKE		
1"	1 3/4"	3/8"	1/8"	NEG.	1 3/16"	2"	3/8"	1/8"	NEG.	1 1/2"	2 1/4"	1/2"	3/16"	NEG.	1 3/4"	2 7/8"	1/2"	3/16"	NEG.	2 7/16"	3 1/2"	3/8"	1/4"	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 <sup>†</sup>					ORDER # TNG-321 <sup>†</sup>					ORDER # TNG-432 <sup>†</sup>					ORDER # TNG-432 <sup>†</sup>					ORDER # TNG-544 <sup>†</sup>				
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. \*\*100 & up call for price.

See full selection of inserts on pages 49 – 54.

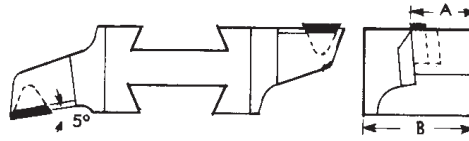
# QUICK CHANGE CARBIDE INSERT CUTTING TOOLS

## #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.

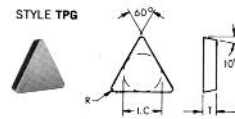


REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER



R

REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT

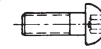


ORDER #	DIMENSIONS		
	I.C.	T	R
TPG-322*	3/8	1/8	1/32
TPG-432*	1/2	3/16	1/32

See full selection of inserts on pages 49 – 54.

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

BUTTON HEAD CHIPBREAKER/CLAMP SCREW



SHIM CLAMP SCREW (SET OF 5)



HEIGHT ADJUSTMENT ASSEMBLY



## AXA SERIES

ORDER # AXA-23  
SPECIAL ORDER

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

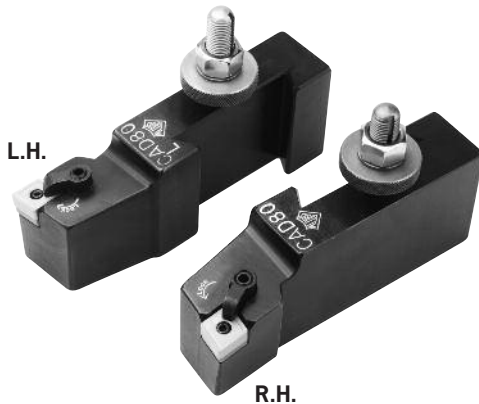
767

ORDER # SCR-12\*

ORDER # SM-41SS\*

ORDER # AXA-HA\*

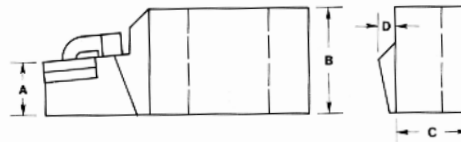
## #80 & #80L



### 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.

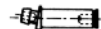
They are designed for use with Aloris quick change tool posts and allow turning and facing operations without removing the holder from the tool post. Repeat positioning accuracy within millionths is assured when used with Aloris tool posts.



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\*

\*\*100 & up call for price.


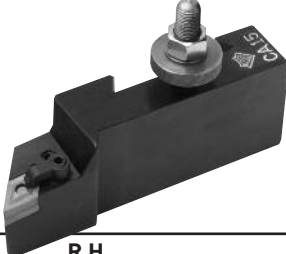
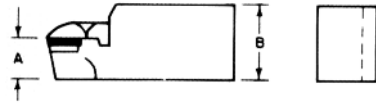





See full selection of inserts on pages 49 – 54.



BXA SERIES					CXA SERIES					CA SERIES					DA SERIES					EA SERIES				
ORDER # BXA-23 SPECIAL ORDER					ORDER # CXA-23 SPECIAL ORDER					ORDER # CA-23 SPECIAL ORDER														
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								
1"	1 3/4	3/8	1/8		1 1/16	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 <sup>†</sup>					ORDER # TPG-322 <sup>†</sup>					ORDER # TPG-432 <sup>†</sup>														
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-303*					ORDER # SM-390*					ORDER # SM-304*				
ORDER # LP-56*					ORDER # LP-57*					ORDER # LP-67*					ORDER # LP-67*					ORDER # LP-72*				
ORDER # CNMG-432 <sup>†</sup>					ORDER # CNMG-432 <sup>†</sup>					ORDER # CNMG-432 <sup>†</sup>					ORDER # CNMG-543 <sup>†</sup>					ORDER # CNMG-643 <sup>†</sup>				
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*				


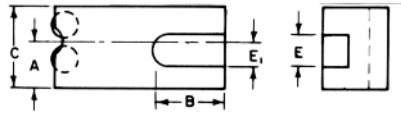

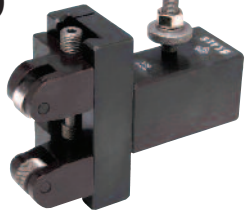

\*Sold in package of 10 pcs. \*\*100 & up call for price.

# QUICK CHANGE PROFILING TOOL HOLDERS

#115 & #115L		<b>PROFILING TOOL HOLDERS</b> 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 #115 (right hand) or #115L (left hand), dovetail mounting design assures maximum repeating accuracy when used with standard Aloris Tool Post. Holder supplied with shim and clamp.	AXA SERIES													
			ORDER # AXA-115	ORDER # AXA-115L												
 L.H.	 R.H.		<table border="1"> <thead> <tr> <th rowspan="2">A</th> <th rowspan="2">B</th> <th colspan="2">PROFILING INSERT</th> <th rowspan="2">POS. or NEG.</th> </tr> <tr> <th>I.C.</th> <th>THICK</th> </tr> </thead> <tbody> <tr> <td>1"</td> <td>1 1/2"</td> <td>3/8"</td> <td>3/16" - 1/4"</td> <td></td> </tr> </tbody> </table>		A	B	PROFILING INSERT		POS. or NEG.	I.C.	THICK	1"	1 1/2"	3/8"	3/16" - 1/4"	
			A	B			PROFILING INSERT			POS. or NEG.						
I.C.	THICK															
1"	1 1/2"	3/8"	3/16" - 1/4"													
		<b>HEX LOCKING PINS</b> 	ORDER # LP-65*													
		<b>CLAMPS</b> 	ORDER # ACK-12*													
		<b>CLAMP SCREW</b> 	ORDER # ASTC-4*													
		<b>CARBIDE SHIMS (SEATS)</b> 	ORDER # SM-307*													
		<b>HEIGHT ADJUSTMENT ASSEMBLY</b> 	ORDER # AXA-HA*													

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

# QUICK CHANGE KNURLING TOOL HOLDERS

#10		<b>KNURLING, FACING AND TURNING HOLDER</b> For turning and facing as well as knurling. Supplied with a set of high speed precision ground and lapped medium diamond knurls. Easily replaceable. <b>Holder supplied with 2 knurls.</b>	AXA SERIES													
			ORDER # AXA-10													
		<table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>E</th> <th>E<sub>1</sub></th> <th>TOOL BIT</th> </tr> </thead> <tbody> <tr> <td>7/8"</td> <td>2 1/2"</td> <td>1 9/16"</td> <td>1/2"</td> <td>3/8"</td> <td>3/16" - 1/2"</td> </tr> </tbody> </table>			A	B	C	E	E <sub>1</sub>	TOOL BIT	7/8"	2 1/2"	1 9/16"	1/2"	3/8"	3/16" - 1/2"
		A	B	C	E	E <sub>1</sub>	TOOL BIT									
7/8"	2 1/2"	1 9/16"	1/2"	3/8"	3/16" - 1/2"											
<b>HEIGHT ADJUSTMENT ASSEMBLY</b> 		ORDER # AXA-HA*														
	<b>ADJUSTABLE KNURLING HOLDER</b> ...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 threaded spindle with left and right hand threads, 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 3/8" wide, high-speed medium diamond knurls are supplied unless otherwise specified.	<table border="1"> <thead> <tr> <th>A</th> <th>KNURL SIZE</th> </tr> </thead> <tbody> <tr> <td>2"</td> <td>3/4" x 1/4" x 3/8"</td> </tr> </tbody> </table>			A	KNURL SIZE	2"	3/4" x 1/4" x 3/8"								
		A	KNURL SIZE													
2"	3/4" x 1/4" x 3/8"															
<b>HEIGHT ADJUSTMENT ASSEMBLY</b> 		ORDER # AXA-HA*														

## CARBIDE PROFILING INSERTS FOR 115 & 115L PROFILE TOOLS†

STYLE	RAKE	DIMENSIONS			INSERT ORDER #	GRADE	
		I.C.	T	R		A2/A6	767
STYLE DNMG	- NEGATIVE	3/8"	3/16"	1/32"	DNMG-532*		
STYLE DNMG	5° NEGATIVE	3/8"	3/16"	1/32"	DNMG-532* DNMS-532		
STYLE DNMZ	5° POSITIVE	3/8"	1/4"	1/32"	DNMZ-542* DNMS-542		
STYLE DNMS	15° POSITIVE	3/8"	1/4"	1/32"	DNMZ-542* DNMS-542		

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



TECHNICAL DATA:  
DIMENSIONS – CAPACITIES – MODELS

BXA SERIES						CXA SERIES					CA SERIES					DA SERIES					EA SERIES				
ORDER # BXA-115			ORDER # BXA-115L			ORDER # CXA-115			ORDER # CXA-115L		ORDER # CA-115			ORDER # CA-115L		ORDER # DA-115			ORDER # DA-115L						
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 5/8"	5/8"	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"	5/8"	3/16-1/4"	POS. or NEG.		1 3/4"	2 7/8"	5/8"	3/16-1/4"	POS. or NEG.			
ORDER # LP-65*						ORDER # LP-67*					ORDER # LP-67*					ORDER # LP-67*									
ORDER # ACK-12*						ORDER # ACK-12*					ORDER # ACK-12*					ORDER # ACK-12*									
ORDER # ASTC-4*						ORDER # ASTC-4*					ORDER # ASTC-4*					ORDER # ASTC-4*									
ORDER # SM-307*						ORDER # SM-307*					ORDER # SM-307*					ORDER # SM-307*									
ORDER # BXA-HA*						ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*									



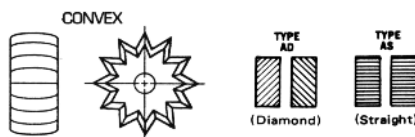
TECHNICAL DATA:  
DIMENSIONS – CAPACITIES – MODELS

BXA SERIES							CXA SERIES						CA SERIES						DA SERIES						EA SERIES								
ORDER # BXA-10							ORDER # CXA-10						ORDER # CA-10						ORDER # DA-10														
A	B	C	E	E <sub>1</sub>	TOOL BIT		A	B	C	E	E <sub>1</sub>	TOOL BIT		A	B	C	E	E <sub>1</sub>	TOOL BIT		A	B	C	E	E <sub>1</sub>	TOOL BIT							
1"	2 5/8"	1 3/4"	5/8"	1/2"	1/4 - 5/8"		1 1/16"	3 1/8"	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

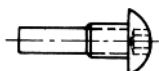
### HIGH SPEED KNURLS

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




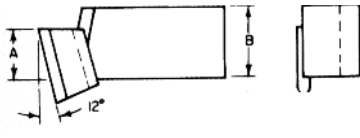


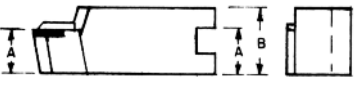


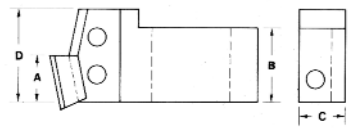

KNURL ORDER #	AD16R/AD16L/AS16* ACD16R/ACD16L/ACS16*	AD20R/AD20L/AS20/AD25R* AD25L/AS25/ACD20R/ACD20L* ACS20/ACD25R/ACD25L/ACS25*	AD50R/AD50L/AS50* ACD50R/ACD50L/ACS50*
	COARSE	MEDIUM	FINE
(NEW) TiN COATED			

### KNURL-LOCK SCREW



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


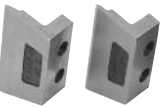



# QUICK CHANGE THREADING HOLDERS, BLADES & INSERTS

						<b>AXA SERIES</b>		
<b>#8</b>		<b>THREADING HOLDER #8</b> 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. <b>Holders supplied with blade as follows: AXA-P10, BXA-CXA-P6, CA-DA-EA-P4, or up to request.</b>				<b>ORDER # AXA-8</b>		
				A	B	USED WITH		
				13/16	1 5/8	ANY THREADING BLADE SHOWN BELOW		
				<b>HEIGHT ADJUSTMENT ASSEMBLY</b>				
						<b>ORDER # AXA-HA*</b>		
<b>#81</b>		<b>THREADING AND GROOVING TOOL HOLDER #81</b> 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. <b>Holder supplied with AT86 insert holder less threading insert. Also available with high-speed blade.</b>				<b>ORDER # AXA-81</b>		
				A	B	USED WITH		
				13/16	1 5/8	ANY THREADING BLADE SHOWN BELOW		
				<b>HEIGHT ADJUSTMENT ASSEMBLY</b>				
						<b>ORDER # AXA-HA*</b>		
<b>#88</b>		<b>ADJUSTABLE THREADING HOLDERS WITH H.S. BLADE &amp; AT88 HEAD</b> The new Aloris Series 88 Adjustable Threading Holder for right and left-hand 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.				<b>ORDER # AXA-88</b>		
				A	B	C	D	USED WITH
				1 1/4	1 5/8	1 1/2	2 1/4	ANY THREADING BLADE SHOWN BELOW
				<b>HEIGHT ADJUSTMENT ASSEMBLY</b>				
						<b>ORDER # AXA-HA*</b>		

<b>ORDER #</b>	<b>AT-88</b>

Use with any #88 series holder.

## BLADES & INSERTS

	<b>HIGH SPEED THREADING BLADES – 60°</b>												
	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.	<b>ORDER #</b>	<b>P-4</b>	<b>P-6</b>	<b>P-10</b>								
		<b>CAPACITY</b>	4 or more T.P.I.	6 or more T.P.I.	10 or more T.P.I.								
	<b>HIGH SPEED THREADING BLADES – ACME 29°</b>												
	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.	<b>ORDER #</b>	<b>AC-3</b>	<b>AC-4</b>	<b>AC-5</b>	<b>AC-6</b>	<b>AC-7</b>	<b>AC-8</b>	<b>AC-9</b>	<b>AC-10</b>	<b>AC-12</b>	<b>AC-14</b>	<b>AC-16</b>
		<b>CAPACITY</b>	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.
	<b>THREADING BLADE GAUGE</b>												
	Gauge is used for quick and accurate checking of re-ground high speed parting and/or threading blades to maintain proper angle for accurate thread cutting.	<b>ORDER #</b>	<b>GA #8</b>										
	<b>THREADING INSERT HOLDER AND INSERT – 60°</b>												
	Blade is reversible and has an adjustable insert for resharpening 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.	<b>HOLDER ORDER #</b>	<b>CAPACITY</b>										
		<b>AT-86</b>	6 TO 48 T.P.I.										
	<b>THREADING CARBIDE INSERT FOR HOLDER # AT-86</b>												
		<b>STYLE</b>	<b>TPI</b>	<b>INSERT ORDER #*</b>									
		60°V	6 – 48	<b>AT-4R*</b>									
		<b>GRADE</b>											
		A2/A6	767										

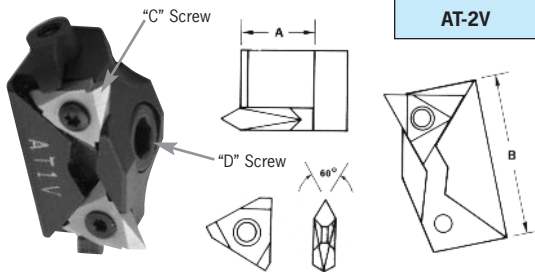


BXA SERIES				CXA SERIES				CA SERIES				DA SERIES				EA SERIES			
ORDER # BXA-8				ORDER # CXA-8				ORDER # CA-8				ORDER # DA-8				ORDER # EA-8			
A	B	USED WITH		A	B	USED WITH		A	B	USED WITH		A	B	USED WITH		A	B	USED WITH	
1"	1 3/4"	ANY THREADING BLADE SHOWN BELOW		1 1/8"	2"	ANY THREADING BLADE SHOWN 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			
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



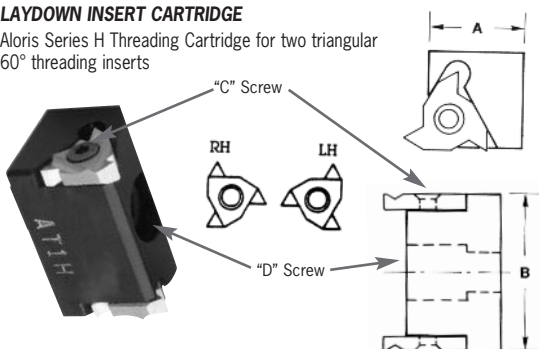
CARTRIDGE ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw #	"D" Replacement Screw #	CLAMP #	CLAMP SCREW #	INSERT IC	KEY #
AT-1V	3/4 sq.	1 1/16	AGTS-1*	5/16 – 18 x 3/4 shcs	ACK-19*	ASTC-9*	3/8	T-10*
AT-2V	7/8 sq.	1 1/8	AGTS-2*	5/16 – 18 x 3/4 shcs	ACK-19*	ASTC-9*	1/2	T-20*

### INSERTS: EXTERNAL VERTICAL 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #*	GRADE	
						A2/A6††	767††
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 – 24 x 3/4 lg shcs	3/8	T-10*
AT-2H	7/8 sq.	1 1/8	ASA-4T*	5/16 – 24 x 3/4 lg shcs	1/2	T-20*

### INSERTS: PARTIAL PROFILE 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #*	GRADE	
						A2/A6††	767††
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. ††100 & up call for price.

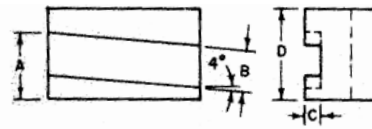
See full selection of inserts on pages 49 – 54.

# QUICK CHANGE PARTING & INSERT BLADE HOLDERS CUT-OFF & GROOVING HOLDERS

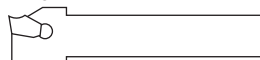
**#7**

**UNIVERSAL PARTING BLADE HOLDER**

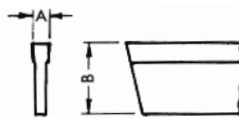
#7 and #7R Holders are only for use with the Aloris Wedge Grip Carbide Insert blades, T-type blades or with bevel (wedge-shape) blades having parallel top and bottom edges, as shown below. For bevel (see drawing) as well as T-type blades. Enables you to cut-off close to chuck. Absence of vibration prevents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



**ALORIS WEDGE GRIP CARBIDE INSERT BLADES**



**PARTING BLADES**



**WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7**



**HEIGHT ADJUSTMENT ASSEMBLY**



**AXA SERIES**

**ORDER # AXA-7**

A	B	C	D	BLADE HEIGHT
1 <sup>15</sup> / <sub>16</sub>	1/2	3/16	1 1/2	1/2

**ORDER # SGIH 19-3C-A7**

**ORDER # P-2\***

WIDTH "A": 3/32	HEIGHT "B": 1/2
-----------------	-----------------

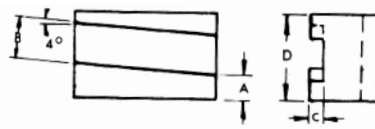
**ORDER # WSA-1\***

**ORDER # AXA-HA\***

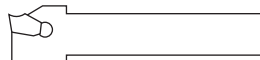
**#7R**

**UNIVERSAL PARTING BLADE TOOL HOLDER - REVERSIBLE**

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



**ALORIS WEDGE GRIP CARBIDE INSERT BLADES**



**PARTING BLADES**



**WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7**



**HEIGHT ADJUSTMENT ASSEMBLY**



**ORDER # AXA-7R**

A	B	C	D	BLADE HEIGHT
1 <sup>15</sup> / <sub>16</sub>	1/2	3/16	1 1/2	1/2

**ORDER # SGIH 19-3C-A7**

**ORDER # P-2\***

WIDTH "A": 3/32	HEIGHT "B": 1/2
-----------------	-----------------

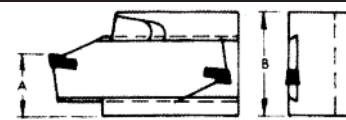
**ORDER # WSA-1\***

**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: wedge grip 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**



**WEDGE GRIP THROWAWAY INSERT BLADES**



**EXTRACTOR (For self-locking carbide insert removal)**

**WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7**



**HEIGHT ADJUSTMENT ASSEMBLY**



**ORDER # AXA-71**

A	B	USED WITH BLADE WIDTHS
1 <sup>15</sup> / <sub>16</sub>	1 13/16	1/8, 3/16 OR 1/4

**ORDER NUMBER** 71-125-1\* 71-187-1\* 71-250-1\*

**WIDTH x HEIGHT** .120 x 1.50 .187 x 1.50 .250 x 1.50

**ORDER NUMBER** 71-125-1BSL\* 71-187-1BSL\* 71-250-1BSL\*

**WIDTH x HEIGHT** .120 x 1.50 .187 x 1.50 .250 x 1.50

**ORDER # ESG-1\***

**ORDER # WSA-6\***

**ORDER # AXA-HA\***





**TECHNICAL DATA:  
DIMENSIONS – CAPACITIES – MODELS**

BXA SERIES					CXA 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 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	2"	3 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>16</sub>	7 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	7 <sup>7</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	3"	1 <sup>1</sup> / <sub>8</sub>			
ORDER # SGIH 26-4C-B7					ORDER # SGIH 26-4C-CX7					ORDER # SGIH 32-4.8C-C7					ORDER # SGIH 32-4.8C-D7					ORDER # SGIH 32-4.8C-E7							
ORDER # P-3*		ORDER # P-4C*			ORDER # P-3W*					ORDER # P-5*					ORDER # P-8*					ORDER # P-8*							
WIDTH "A": 3 <sup>3</sup> / <sub>8</sub> HEIGHT "B": 1 <sup>1</sup> / <sub>16</sub>		WIDTH "A": 5 <sup>5</sup> / <sub>32</sub> HEIGHT "B": 1 <sup>1</sup> / <sub>16</sub>			WIDTH "A": 1 <sup>1</sup> / <sub>8</sub>		HEIGHT "B": 3 <sup>3</sup> / <sub>4</sub>			WIDTH "A": 3 <sup>3</sup> / <sub>16</sub>		HEIGHT "B": 7 <sup>7</sup> / <sub>8</sub>			WIDTH "A": 3 <sup>3</sup> / <sub>16</sub>		HEIGHT "B": 1 <sup>1</sup> / <sub>8</sub>			WIDTH "A": 3 <sup>3</sup> / <sub>16</sub>		HEIGHT "B": 1 <sup>1</sup> / <sub>8</sub>					
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 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>16</sub>	1"	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>16</sub>	2"	3 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>16</sub>	7 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	7 <sup>7</sup> / <sub>8</sub>	1"	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub>	1"	1 <sup>1</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>	3"	1 <sup>1</sup> / <sub>8</sub>			
ORDER # SGIH 26-4C-B7					ORDER # SGIH 26-4C-CX7					ORDER # SGIH 32-4.8C-C7					ORDER # SGIH 32-4.8C-D7					ORDER # SGIH 32-4.8C-E7							
ORDER # P-3*		ORDER # P-4C*			ORDER # P-3W*					ORDER # P-5*					ORDER # P-8*					ORDER # P-8*							
WIDTH "A": 3 <sup>3</sup> / <sub>8</sub> HEIGHT "B": 1 <sup>1</sup> / <sub>16</sub>		WIDTH "A": 5 <sup>5</sup> / <sub>32</sub> HEIGHT "B": 1 <sup>1</sup> / <sub>16</sub>			WIDTH "A": 1 <sup>1</sup> / <sub>8</sub>		HEIGHT "B": 3 <sup>3</sup> / <sub>4</sub>			WIDTH "A": 3 <sup>3</sup> / <sub>16</sub>		HEIGHT "B": 7 <sup>7</sup> / <sub>8</sub>			WIDTH "A": 3 <sup>3</sup> / <sub>16</sub>		HEIGHT "B": 1 <sup>1</sup> / <sub>8</sub>			WIDTH "A": 3 <sup>3</sup> / <sub>16</sub>		HEIGHT "B": 1 <sup>1</sup> / <sub>8</sub>					
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 <sup>1</sup> / <sub>2</sub> )			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 <sup>5</sup> / <sub>16</sub>	2"	7 <sup>7</sup> / <sub>8</sub> , 3 <sup>3</sup> / <sub>16</sub> or 1 <sup>1</sup> / <sub>4</sub>			1 <sup>5</sup> / <sub>16</sub>	2 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub> , 3 <sup>3</sup> / <sub>16</sub> or 1 <sup>1</sup> / <sub>4</sub>			1 <sup>1</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>16</sub> , 1 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>2</sub>	71-125-1BSL 7 <sup>7</sup> / <sub>8</sub> \$46.00 71-187-1BSL 7 <sup>7</sup> / <sub>8</sub> \$51.75 71-250-1BSL 7 <sup>7</sup> / <sub>8</sub> \$55.20			2"	3 <sup>3</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>16</sub> or 1 <sup>1</sup> / <sub>4</sub>			2 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>16</sub> or 1 <sup>1</sup> / <sub>4</sub>		
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*	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	.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*	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	.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-8*			ORDER # WSA-10*					ORDER # WSA-11*							
ORDER # BXA-HA*					ORDER # CXA-HA*					ORDER # CA-HA*					ORDER # DA-HA*					ORDER # EA-HA*							

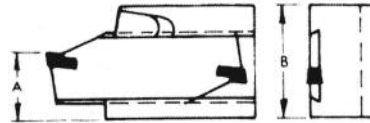
# QUICK CHANGE CUT-OFF & GROOVING HOLDERS BLADES & INSERTS

#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: wedge grip 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.



## WEDGE GRIP BLADES FOR CARBIDE INSERTS



ORDER NUMBER		<b>SGIH 19-2/-2PS*</b>
WIDTH OF CUT x HEIGHT		.087 or .093 x .750
REGULAR	POSITIVE STOP	

ORDER NUMBER		<b>SGIH 19-3*</b>
WIDTH OF CUT x HEIGHT		.120 x .750
REGULAR		

ORDER NUMBER		
WIDTH OF CUT x HEIGHT		

## WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #77



ORDER # WSA-6

## HEIGHT ADJUSTMENT ASSEMBLY



ORDER # AXA-HA\*

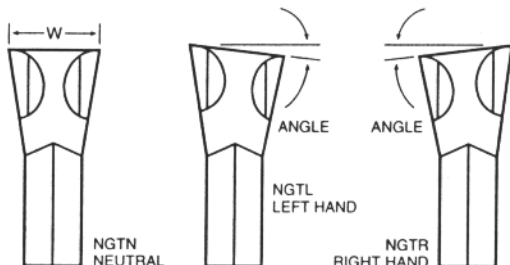
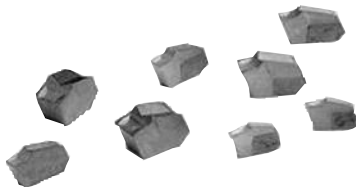
## AXA SERIES

ORDER # AXA-77

A	B	USED WITH BLADE WIDTHS
$\frac{31}{32}$	$1\frac{5}{8}$	.087 & .093 x .750

## GT STYLE ALORIS WEDGE GRIP CARBIDE CUT-OFF INSERTS

FOR WEDGE GRIP BLADES, POSITIVE RAKE SHARP  
EDGE FOR MANUAL & CNC LATHES.  
SEE PAGE 54 FOR DESCRIPTION OF  
CARBIDE GRADES.



## Aloris GT Cut-Off Insert

	Catalog Number	Cutting Edge Geometry	Cutting Width	Lead Angle	Grade A2 or A6	Grade 767
	GTN 2*	P	.087	0		
††	GT L/R 2*	P	.087	8		
	GTN 2.4*	P	.093	0		
††	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. †††Call for price over 100 quantity.

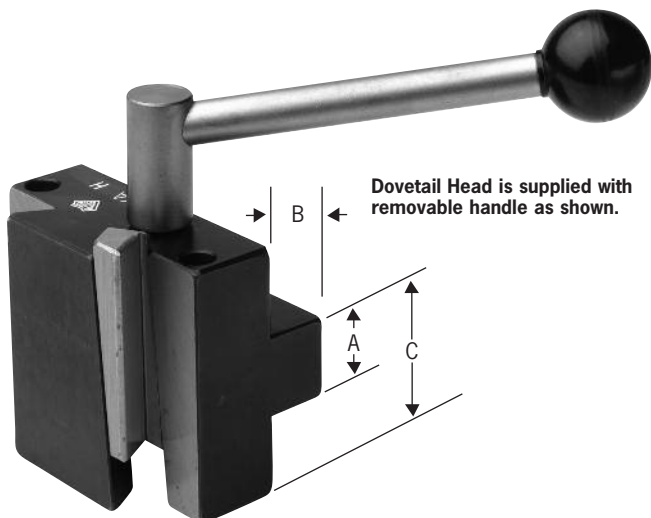
Inserts are priced individually, however, they must be purchased in packages of 10.

For blades see page 46.



BXA SERIES			CXA 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 <sup>7</sup> / <sub>32</sub>	2	.093 – .120 – .187	1 <sup>9</sup> / <sub>32</sub>	2	.120 – .160 – .187	1 <sup>1</sup> / <sub>16</sub>	2 <sup>1</sup> / <sub>2</sub>	.120 – .187 – .250	1 <sup>17</sup> / <sub>32</sub>	2 <sup>5</sup> / <sub>8</sub>	.120 – .187 – .250			
<b>SGIH 26-2/-2PS*</b>			<b>SGIH 26-3/-3PS*</b>			<b>SGIH 32-3/-3PS*</b>			<b>SGIH 32-3/-3PS*</b>					
.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			
<b>SGIH 26-3/-3PS*</b>			<b>SGIH 26-4/-4PS*</b>			<b>SGIH 32-5/-5PS*</b>			<b>SGIH 32-5/-5PS*</b>					
.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			
1 Each		1 Each	1 Each		1 Each	1 Each		1 Each	1 Each		1 Each			
<b>SGIH 26-5/-5PS*</b>			<b>SGIH 26-5/-5PS*</b>			<b>SGIH 32-6/-6PS*</b>			<b>SGIH 32-6/-6PS*</b>					
.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
<b>BXA-H</b>	7/8	3/4	1 <sup>11</sup> / <sub>16</sub>
<b>CXA-H</b>	1"	3/4	1 <sup>15</sup> / <sub>16</sub>
<b>CA-H</b>	1 <sup>1</sup> / <sub>4</sub>	1"	2 <sup>5</sup> / <sub>16</sub>
<b>DA-H</b>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>

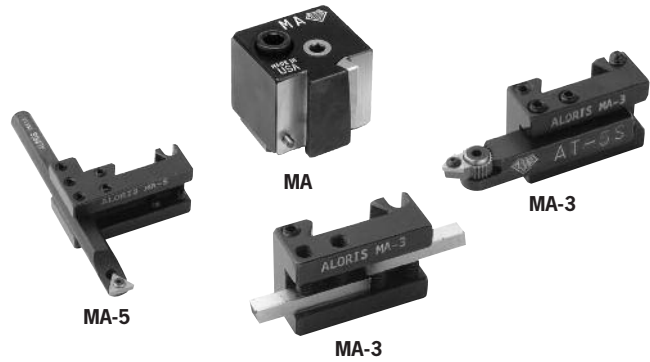
## Miniature (MA) Tool Post and Tool Holders

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

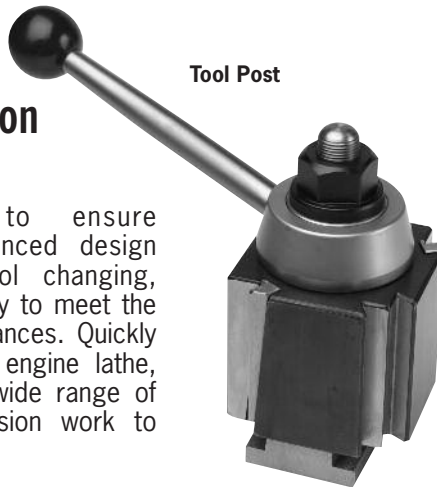
Set is supplied with "T" and screw wrenches, less cutting tools.



## SAVE 5% OVER COMPONENTS PURCHASED SEPARATELY

### Aloris Super-Precision Intro-Pro Sets

Precision-engineered to ensure 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.



#### #1 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.

#### #2 BORING, TURNING AND FACING HOLDER

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

Intro-Pro Set includes: Super-Precision Tool Post, #1 Tool Holder, #2 Tool Holder						
SERIES	AXA	BXA	CXA	CA	DA	EA
ORDER #	#1-IP	#2-IP	#3-IP	#4-IP	#5-IP	#6-IP

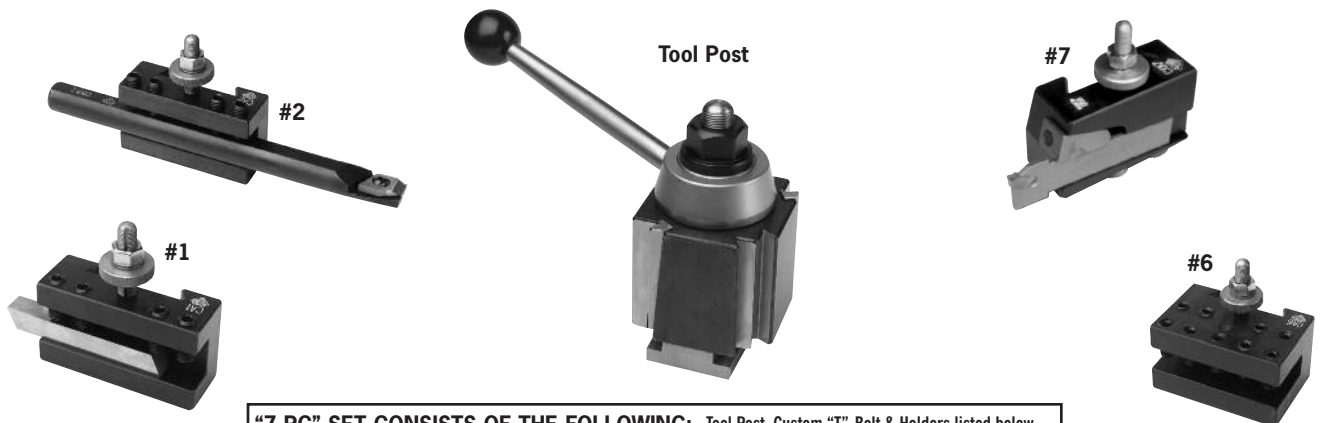
## 5-PIECE STARTER SET

### 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



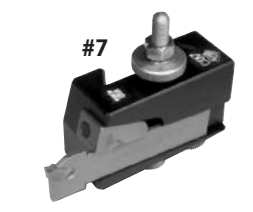
Pictures do not represent actual sets.

## ★ SAVE 10% ON "AS" SETS ONLY ★



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

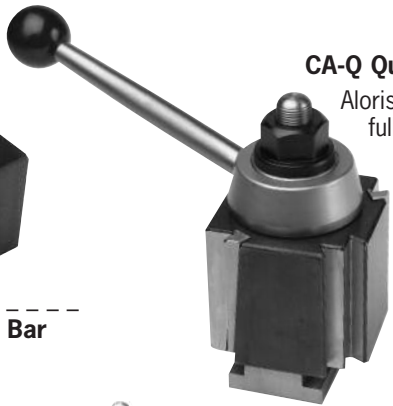
SERIES	AXA	BXA	CXA	CA	DA	EA
ORDER #	#1-AS	#2-AS	#3-AS	#4-AS	#5-AS	#6-AS
HOLDERS INCLUDED	AXA-1	BXA-1	CXA-1	CA-1	DA-1	EA-1
	AXA-2	BXA-2	CXA-2	CA-2	DA-2	EA-2
	AXA-4D	BXA-4D	CXA-4D	CA-4D	DA-4D	EA-4D
	AXA-53	BXA-53	CXA-41D	CA-41D	DA-41D	EA-6
	AXA-6	BXA-6	CXA-6	CA-54	DA-6	EA-7
	AXA-7	BXA-7	CXA-7	CA-6	DA-7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



Pictures do not represent actual sets.

# QUALIFIED TOOL POSTS AND HOLDERS

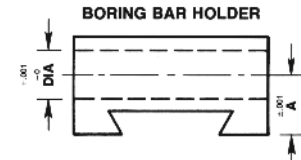
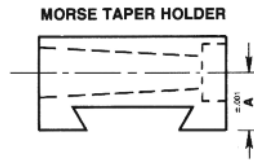
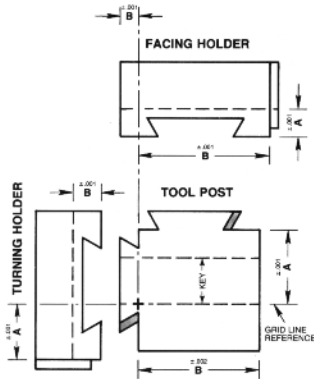
...a full range of qualified tooling to meet the rigorous repeat accuracy demands of C.N.C. Lathe operation, combined with the advantages and convenience of quick-change versatility, high-precision and superb workmanship – time and job proven qualities which have made Aloris products the tools preferred 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.



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	"T" BOLT	SET SCREW	
	A	B		ORDER #	ORDER #	ORDER #	ORDER #
CA-Q	2.400	3.525	19" SWING		CA-TB*		
<b>TURNING HOLDER</b>							
CA-1Q	1.460	.915	1"	CA-HA*			
<b>FACING HOLDER</b>							
CA-1LQ	.915	3.860	1"	CA-HA*			
<b>*MORSE TAPER HOLDERS</b>							
CA-52Q	1.375	—	#2 M.T.	CA-HA*			
CA-53Q			#3 M.T.	CA-HA*			
CA-54Q			#4 M.T.	CA-HA*			
<b>**BORING BAR HOLDERS</b>							
CA-4Q-750	1.375	.625	½"	CA-HA*		CAQ-SS*	
CA-4Q-1000			1"	CA-HA*		CAQ-SS*	
CA-4Q-1250			1½"	CA-HA*		CAQ-SS*	
CA-4Q-1500			1½"	CA-HA*		CAQ-SS*	
CA-4Q-1750			1½"	CA-HA*		CAQ-SS*	
CA-4Q-2000	1.750	.625	2"	CA-HA*		CAQ-SS*	

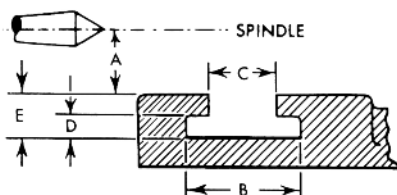
DA _____ SERIES				REPLACEMENT PARTS			
ORDER #	DIMENSIONS		CAPACITY	HEIGHT ADJUSTMENT	"T" BOLT	SET SCREW	
	A	B		ORDER #	ORDER #	ORDER #	ORDER #
DA-Q	3.100	4.400	24" SWING		DA-TB*		
<b>TURNING HOLDER</b>							
DA-1Q	1.450	1.500	1½"	DA-HA*			
<b>FACING HOLDER</b>							
DA-1LQ	1.500	4.550	1½"	DA-HA*			
<b>*MORSE TAPER HOLDERS</b>							
DA-53Q	2.000	—	#3 M.T.	DA-HA*			
DA-54Q			#4 M.T.	DA-HA*			
DA-55Q			#5 M.T.	DA-HA*			
<b>**BORING BAR HOLDERS</b>							
DA-4Q-1000	2.000	.625	1"	DA-HA*		DAQ-SS*	
DA-4Q-1250			1½"	DA-HA*		DAQ-SS*	
DA-4Q-1500			1½"	DA-HA*		DAQ-SS*	
DA-4Q-1750			1½"	DA-HA*		DAQ-SS*	
DA-4Q-2000			2"	DA-HA*		DAQ-SS*	
DA-4Q-2500	2.250	.935	2½"	DA-HA*		DAQ-SS*	
DA-4Q-3000	2.500		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	5/8"	1 1/4"	GRAZIANO SAG	12" 14" 20"	BXA CXA CA	3/4"	1 1/4"	NARDINI	TT1000 TT1200 MS1400 MS1600 ND1500 ND1700 IN2000 IN2500 SZ2000 SZ2500 AM25 32 40	AXA AXA BXA CXA CXA CA CA DA DA DA EA	5/8"	1 1/4"		
			3/4"	1 1/4"				HARDINGE	AXA						1/2"	1"
			1"	1 1/2"												
1 1/4"	2"	HENDEY	9" 12" & 1GP 2GP, 4C, 14" & 16" 18", 20" & 24"	AXA BXA CXA CA	1/2"	1"										
1"	1 1/2"						HERCULES	40	DA or EA				1/2"	2 1/2"		
1 1/2"	2 1/2"	HERCULES AJAX	14" 18" 24"	CXA CA DA	3/4"	1 1/4"										
1 1/2"	2 1/2"						IKEGAI	20"	CA				1"	1 1/2"		
1 1/2"	2 1/2"	KERRY	11" & 13"	AXA	1/2"	1"										
1 1/2"	2 1/2"						LANSING	16"	CXA				3/4"	1 1/4"		
1 1/2"	2 1/2"	LEBLOND DUAL DRIVE	15"	CXA	3/4"	1 1/4"										
1 1/2"	2 1/2"						LEBLOND HEAVY DUTY	1610, NE-2013 & 2516 NF-2516 & 3220 NI-3220 & 4025 NK-4025 & 5032	CXA CA DA EA				3/4"	1 1/4"		
1 1/2"	2 1/2"	LEBLOND REGAL	13" 15" 17", 19", 21" & 24"	BXA CXA CA	5/8"	1 1/4"										
1 1/2"	2 1/2"						LEHMANN BRANDES	16", 18" & 20" 22", 25", 32" & 36"	CA EA	1 1/2"	1 1/2"					
1 1/2"	2 1/2"	LODGE AND SHIPLEY	1307 1610, 2013, 2013-17 & 2013-27 2516 & 2516-27 3220, 2516 & 2516-21	CXA CA CA DA EA EA	3/4"	1 1/4"										
1 1/2"	2 1/2"						LOGAN	9", 10", 11" & 12" 14"	AXA BXA	1/2"	1"					
1 1/2"	2 1/2"	MAZAK	14" 17" 18-21-860 24" 30"	CXA CA CA DA EA	3/4"	1 1/4"										
1 1/2"	2 1/2"						MISAL	K12 & K13 K14 & K16	AXA BXA	1/2"	1"					
1 1/2"	2 1/2"	MONARCH	10" 13 (60 & 61) K-15 COMPACT 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 EA EA	1/2"	1"										
1 1/2"	2 1/2"						MORRI SEIKI	16 1/8" 17 1/8" & 18 3/4" 20 1/2"	CXA CA DA	3/4"	1 1/4"					
1 1/2"	2 1/2"	SIGMA	14" 17" 18-21-860 24" 30"	CXA CA CA DA EA	3/4"	1 1/4"										
1 1/2"	2 1/2"						SOUTH BEND	K12 & K13 K14 & K16	AXA BXA	1/2"	1"					
1 1/2"	2 1/2"	SOUTH IND	10" 13 (60 & 61) K-15 COMPACT 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 EA EA	1/2"	1"										
1 1/2"	2 1/2"						SPRINGFIELD	10" 13 (60 & 61) K-15 COMPACT 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 EA EA	1/2"	1"					
1 1/2"	2 1/2"	STANDARD MODERN	10" 12" 14" & 16" 17"	BXA CXA CXA or CA CA	5/8"	1 1/4"										
1 1/2"	2 1/2"						VDF	42DSL, 18RO, 21RO & 48DSL M530 & V630 E560, M670 & V800	CXA CXA CA DA	3/4"	1 1/4"					
1 1/2"	2 1/2"	VOEST	17" & 20"	CXA	3/4"	1 1/4"										

## "T" NUT ORDERING INFORMATION



MAKE OF LATHE	SWING	A	B	C	D	E

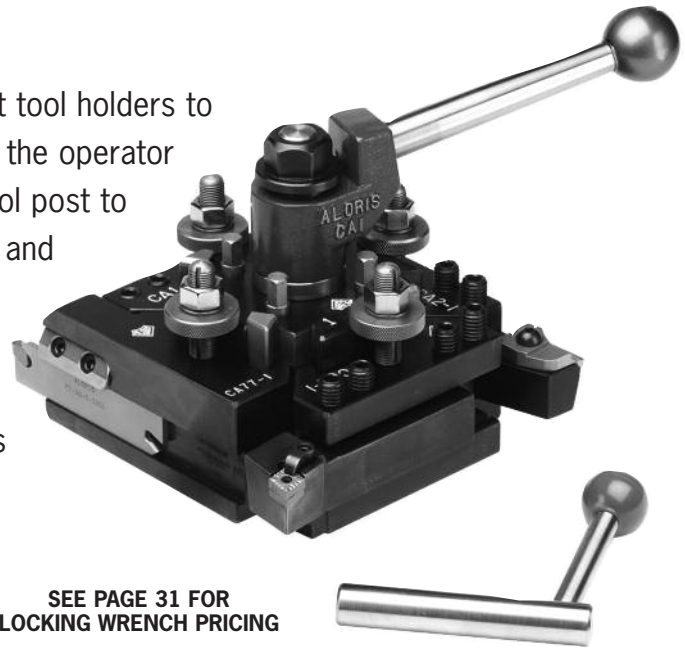
When ordering, please give name and swing of lathe or specified dimensions. Please fax the above chart with your order. Without this information "T" nut will be supplied blank. There is an extra charge for riser-blocks.

# 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.



- 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



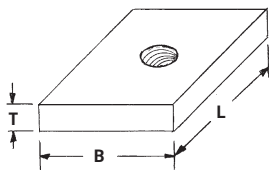
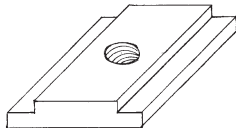
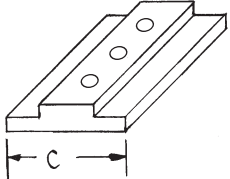
Face Gear for Indexable Tool Posts

## ORDERING INFORMATION

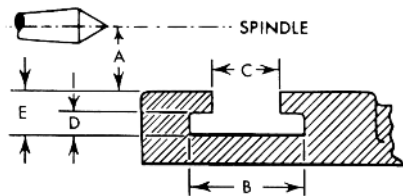
SERIES				SERIES				SERIES			
SWING		UP-15"		SWING		15"-22"		SWING		22"-36"	
ORDER #		BXA-I		ORDER #		CA-I		ORDER #		DA-I	
A	B	C	D	A	B	C	D	A	B	C	D
3"	2¾"	5"	9/16"	4"	37/16"	67/16"	¾"	5"	45/8"	83/16"	7/8"



# ALORIS INDEXABLE TOOL POST OPTIONS

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

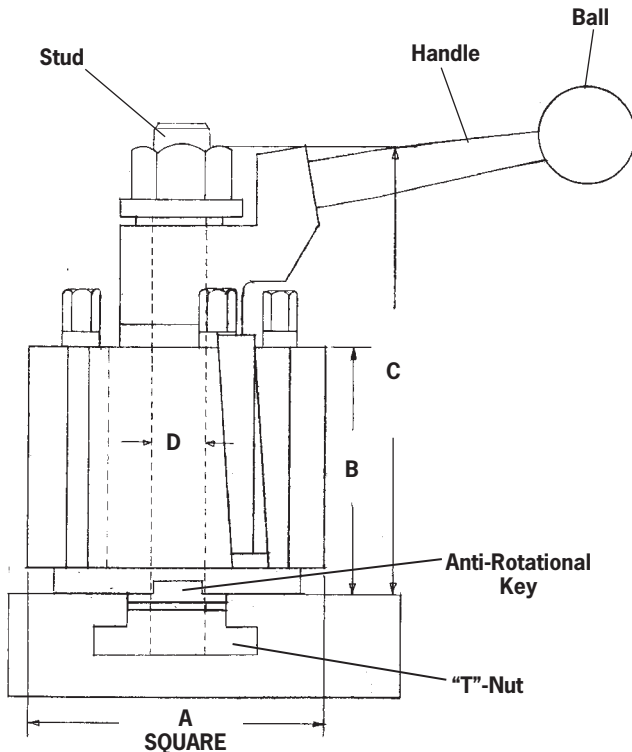
## "T" NUT ORDERING INFORMATION



(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. Please fax the above chart with your order. Without this information "T" nut will be blank. There is an extra charge for riser-blocks.












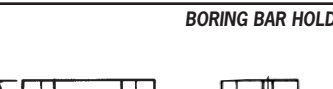



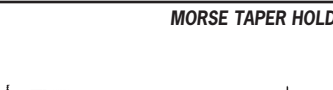


## INDEXABLE TOOL POST REPLACEMENT PARTS

Not interchangeable with standard tool post parts.

<b>"T" BOLT ASSY = "T"-NUT AND STUD (INDEXABLE)</b>			
ORDER #	BXA-I-TB*	CA-I-TB*	DA-I-TB*
<b>HANDLES (INDEXABLE)</b>			
ORDER #	BXA-I-HANDLE*	CA-I-HANDLE*	DA-I-HANDLE*
<b>BALLS (INDEXABLE)</b>			
ORDER #	BXA-I-BALL*	CA-I-BALL*	DA-I-BALL*
<b>FLANGE NUTS (INDEXABLE)</b>			
ORDER #	BXA-I-FN*	CA-I-FN*	DA-I-FN*
<b>LOCKING WRENCH</b>			
ORDER #	BXA-I-LW*	CA-I-LW*	DA-I-LW*

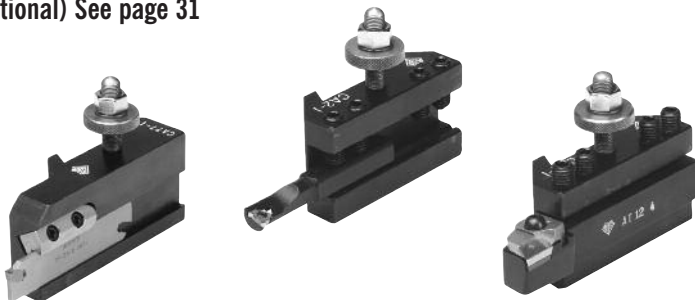
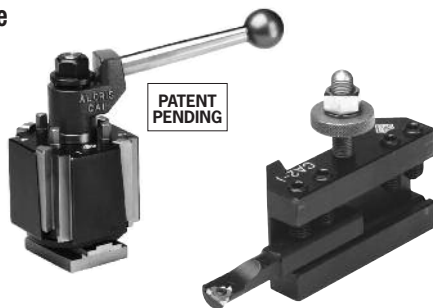
# ALORIS INDEXABLE TOOL HOLDERS

<b>#1-I</b>  <b>TURNING &amp; FACING HOLDER</b> 	<b>ORDER # BXA-1-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>1<sup>3</sup>/<sub>16</sub></td> <td>1<sup>1</sup>/<sub>16</sub></td> <td>1<sup>3</sup>/<sub>4</sub></td> <td>5/8</td> </tr> </tbody> </table>	A	B	C	Tool Cap	1 <sup>3</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	5/8	<b>ORDER # CA-1-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>1<sup>13</sup>/<sub>16</sub></td> <td>1"</td> <td>2<sup>1</sup>/<sub>2</sub></td> <td>1"</td> </tr> </tbody> </table>	A	B	C	Tool Cap	1 <sup>13</sup> / <sub>16</sub>	1"	2 <sup>1</sup> / <sub>2</sub>	1"	<b>ORDER # DA-1-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>C</th> <th>Tool Cap</th> </tr> </thead> <tbody> <tr> <td>2<sup>1</sup>/<sub>4</sub></td> <td>1<sup>1</sup>/<sub>4</sub></td> <td>3<sup>3</sup>/<sub>8</sub></td> <td>1<sup>1</sup>/<sub>4</sub></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 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>4</sub>
A	B	C	Tool Cap																								
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A	B	C	Tool Cap																								
2 <sup>5</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>																								
<b>#100-I</b>  <b>BORING BAR HOLDER</b> 	<b>ORDER # BXA-100-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>7/8</td> <td>1<sup>3</sup>/<sub>4</sub></td> <td>3/4</td> </tr> </tbody> </table>	A	B	D	7/8	1 <sup>3</sup> / <sub>4</sub>	3/4	<b>ORDER # CA-100-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1<sup>1</sup>/<sub>8</sub></td> <td>2<sup>1</sup>/<sub>4</sub></td> <td>1"</td> </tr> </tbody> </table>	A	B	D	1 <sup>1</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>4</sub>	1"	<b>ORDER # DA-100-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1<sup>1</sup>/<sub>8</sub></td> <td>2<sup>3</sup>/<sub>4</sub></td> <td>1<sup>1</sup>/<sub>4</sub></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 <sup>1</sup> / <sub>8</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>						
A	B	D																									
7/8	1 <sup>3</sup> / <sub>4</sub>	3/4																									
A	B	D																									
1 <sup>1</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>4</sub>	1"																									
A	B	D																									
1 <sup>1</sup> / <sub>8</sub>	2 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>																									
<b>#104-I</b>  <b>BORING BAR HOLDER</b> 	<b>ORDER # BXA-104-I</b> <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"	<b>ORDER # CA-104-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1<sup>1</sup>/<sub>4</sub></td> <td>2<sup>1</sup>/<sub>2</sub></td> <td>1<sup>1</sup>/<sub>4</sub></td> </tr> </tbody> </table>	A	B	D	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	<b>ORDER # DA-104-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>D</th> </tr> </thead> <tbody> <tr> <td>1<sup>5</sup>/<sub>8</sub></td> <td>3<sup>3</sup>/<sub>4</sub></td> <td>1<sup>1</sup>/<sub>2</sub></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 <sup>5</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>						
A	B	D																									
1"	2"	1"																									
A	B	D																									
1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>																									
A	B	D																									
1 <sup>5</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>																									
<b>#77-I</b>  <b>CUTOFF HOLDER (CARBIDE)</b> 	<b>ORDER # BXA-77-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>1<sup>5</sup>/<sub>16</sub></td> <td>1<sup>3</sup>/<sub>4</sub></td> </tr> </tbody> </table>	A	B	1 <sup>5</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	<b>ORDER # CA-77-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>1<sup>1</sup>/<sub>4</sub></td> <td>2<sup>1</sup>/<sub>2</sub></td> </tr> </tbody> </table>	A	B	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	<b>ORDER # DA-77-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> </tr> </thead> <tbody> <tr> <td>1<sup>9</sup>/<sub>16</sub></td> <td>3</td> </tr> </tbody> </table> <p>Cut-off &amp; Grooving Holders – Designed for extreme rigidity under heavy cutting conditions. See page 33 for blades and inserts. →</p>	A	B	1 <sup>9</sup> / <sub>16</sub>	3												
A	B																										
1 <sup>5</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>																										
A	B																										
1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>																										
A	B																										
1 <sup>9</sup> / <sub>16</sub>	3																										
<b>#77-I</b> <b>WEDGE &amp; LOCK SCREW</b>	<b>WSA-BXA-77-I</b> Clamp & Screws	<b>WSA-CA-77-I</b> Clamp & Screws	<b>WSA-DA-77-I</b> Clamp & Screws																								
<b>#53-I #54-I #55-I</b>  <b>MORSE TAPER HOLDER</b> 	<b>ORDER # BXA-53-I</b> <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>1<sup>3</sup>/<sub>4</sub></td> <td>#3 MT</td> </tr> </tbody> </table>	A	B	Taper Hole Size	7/8	1 <sup>3</sup> / <sub>4</sub>	#3 MT	<b>ORDER # CA-54-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>Taper Hole Size</th> </tr> </thead> <tbody> <tr> <td>1<sup>1</sup>/<sub>4</sub></td> <td>2<sup>1</sup>/<sub>2</sub></td> <td>#4 MT</td> </tr> </tbody> </table>	A	B	Taper Hole Size	1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	#4 MT	<b>ORDER # DA-55-I</b> <table border="1"> <thead> <tr> <th>A</th> <th>B</th> <th>Taper Hole Size</th> </tr> </thead> <tbody> <tr> <td>1<sup>5</sup>/<sub>8</sub></td> <td>3<sup>3</sup>/<sub>4</sub></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 <sup>5</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	#5 MT						
A	B	Taper Hole Size																									
7/8	1 <sup>3</sup> / <sub>4</sub>	#3 MT																									
A	B	Taper Hole Size																									
1 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	#4 MT																									
A	B	Taper Hole Size																									
1 <sup>5</sup> / <sub>8</sub>	3 <sup>3</sup> / <sub>4</sub>	#5 MT																									

# 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



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.

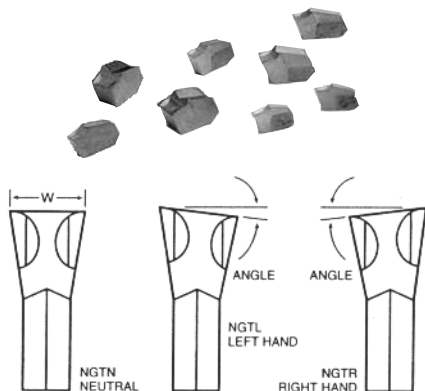
**SAVE 5% ON INDEXABLE STARTER SETS**

SERIES	BXA-I	CA-I	DA-I
ORDER #	BXA-I-SET	CA-I-SET	DA-I-SET

## GT STYLE WEDGE GRIP CARBIDE CUT-OFF INSERTS

FOR WEDGE GRIP BLADES, POSITIVE RAKE SHARP EDGE FOR MANUAL & CNC LATHES.

SEE PAGE 54 FOR DESCRIPTION OF CARBIDE GRADES



### Aloris GT Cut-Off Insert

Catalog Number	Cutting Edge Geometry	Cutting Width	Lead Angle	Grade A2 or A6	Grade 767
GTN 2*	P	.087	0		
** GT L/R 2*	P	.087	8		
GTN 2.4*	P	.093	0		
** 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. \*\*\*Call for price over 100 quantity.  
Inserts are priced individually, however, they must be purchased in packages of 10.  
For blades see page 46.

## WEDGE GRIP BLADES FOR #77-I HOLDERS



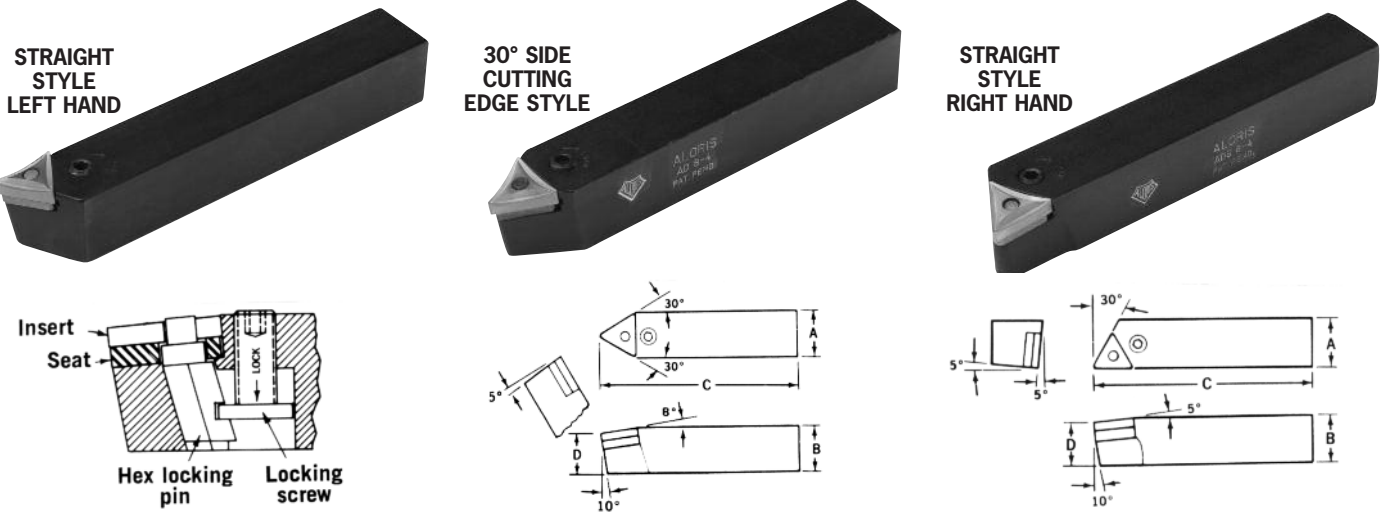
	BXA-I	CA-I	DA-I
ORDER #	SGIH 19-2*	SGIH 26-2*	SGIH 32-3*
WIDTH OF CUT x HEIGHT	.093 x .750	.093 x 1.00	.120 x 1.25
ORDER #	SGIH 19-3*	SGIH 26-3*	SGIH 32-5*
WIDTH OF CUT x HEIGHT	.120 x .750	.120 x 1.00	.187 x 1.25
ORDER #		SGIH 26-4*	SGIH 32-6*
WIDTH OF CUT x HEIGHT		.160 x 1.00	.250 x 1.25
ORDER #		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 #*	GRADE	
		I.C.	T	R		A2/A6	767
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*		

\*Inserts are priced individually, however, they must be purchased in packages of 10. \*\*100 & up call for price.

See full selection of inserts on pages 49 – 54.

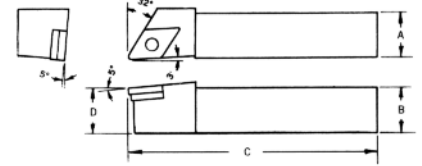
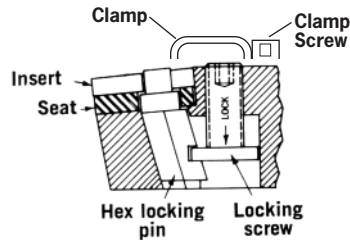
# ALORIS PROFILING TOOL HOLDERS AT15 & AT15L

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 OR 1/4	SM-117*	LP-15*	LS-15*	ACK-12*	ASTC-4*
AT15-8	AT15-8L	1"	1"	6"	1 1/8							

## CARBIDE INSERTS FOR PROFILING TOOL HOLDERS

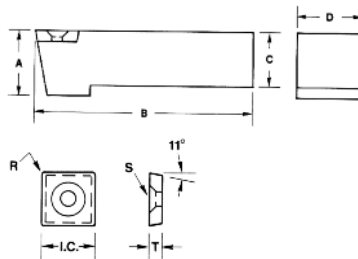
ALL INSERTS BELOW FIT ANY 15 OR 15L TOOL HOLDERS

STYLE	RAKE	DIMENSIONS	INSERT ORDER #*	GRADE	
				A2/A6	767
STYLE DNGA	- NEGATIVE	I.C., T, R	DNGA-532*		
STYLE DNMG	5° NEGATIVE	I.C., T, R	DNMG-532*		
STYLE DNMS	15° POSITIVE	I.C., T, R	DNMS-532*		
STYLE DNMZ	5° POSITIVE	I.C., T, R	DNMZ-542*		
		I.C., T, R	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 #*	A2/A6	767	SCREW		SIZE
	A	B	C	D	I.C.	T	R				ORDER #		
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 5/8
ASIH-5	7/8	4 3/4	7/8	7/8	3/4	3/16	3/64	ASD-12P*			ASD-12PSCR*		10-24 x 5/8

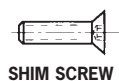
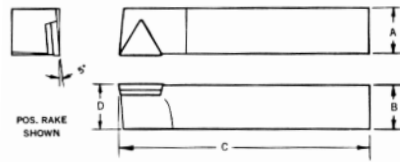
\*Sold in package of 10 pcs. \*\*100 & up call for price.

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 #	DIMENSIONS				INSERT SIZE		CARBIDE SHIM		SHIM SCREW		CARBIDE CHIPBREAKER		CHIPBREAKER CLAMP SCREW		
POS.	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 #†	GRADE	
		I.C.	T	R		A2/A6	767
	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 #†	GRADE	
		I.C.	T	R		A2/A6	767
	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.

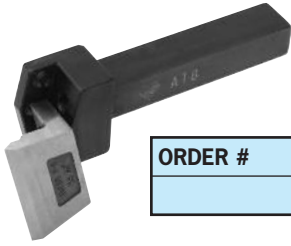
## ALORIS SOCKET SCREW "T" – WRENCHES

- 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 SET* (1 OF EACH)
TW-1*	1/16	5	
TW-2*	5/64	5	
TW-3*	3/32	5	
TW-4*	1/8	5	
TW-5*	5/32	5	
TW-6*	3/16	5	
TW-7*	7/32	5 1/4	
TW-8*	1/4	5 1/4	

# ALORIS THREADING TOOL HOLDER MODEL AT-8



<b>ORDER #</b>	<b>AT-8</b>

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.

<b>ORDER #</b>	<b>P-4</b>	<b>P-6</b>	<b>P-10</b>
<b>CAPACITY</b>	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.

<b>ORDER #</b>	<b>AC-3</b>	<b>AC-4</b>	<b>AC-5</b>	<b>AC-6</b>	<b>AC-7</b>	<b>AC-8</b>	<b>AC-9</b>	<b>AC-10</b>	<b>AC-12</b>	<b>AC-14</b>	<b>AC-16</b>
<b>CAPACITY</b>	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.

<b>ORDER #</b>	<b>GA #8</b>



## 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.

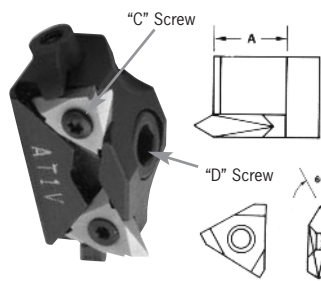
<b>HOLDER ORDER #</b>	<b>CAPACITY</b>
<b>AT-86</b>	6 TO 48 T.P.I.

## THREADING CARBIDE INSERT FOR HOLDER # AT-86

STYLE	TPI	INSERT ORDER #*	GRADE	
			A2/A6	767
60°V	6 – 48	AT-4R*		

## STAND UP INSERT CARTRIDGE

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



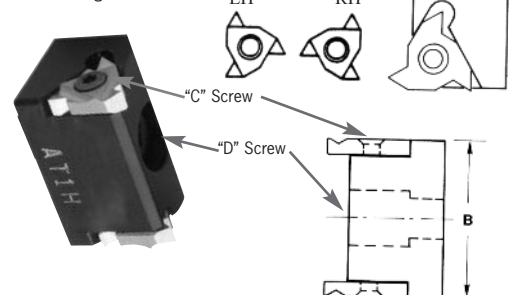
CARTRIDGE ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw #	"D" Replacement Screw #	CLAMP #	CLAMP SCREW #	INSERT IC	KEY #
AT-1V	3/4 sq.	1 1/16	AGTS-1*	5/16 – 18 x 3/4 shcs	ACK-19*	ASTC-9*	3/8	T-10
AT-2V	7/8 sq.	1 1/8	AGTS-2*	5/16 – 18 x 3/4 shcs	ACK-19*	ASTC-9*	1/2	T-20*

## INSERTS: EXTERNAL VERTICAL 60° TRIANGULAR THREADING INSERTS

STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #	GRADE	
						A2/A6	767
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	7/8 sq.	1 1/8	ASA-4T	5/16 – 18 x 3/4 lg shcs	1/2	T-20*

## INSERTS: PARTIAL PROFILE 60° TRIANGULAR THREADING INSERTS

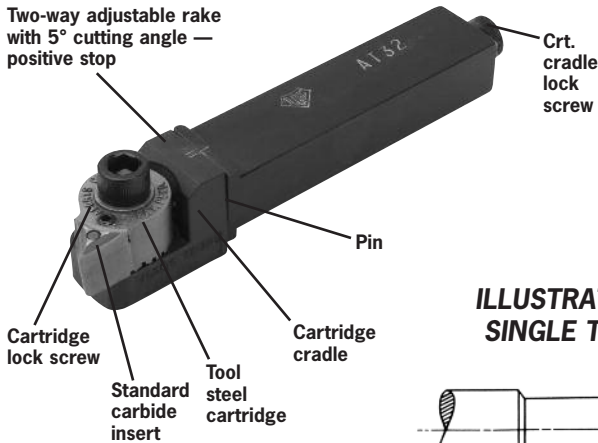
STYLE	TPI	IC	L	USED WITH CARTRIDGE	INSERT ORDER #	GRADE	
						A2/A6	767
60°V-RH	8 – 48	3/8	Pos	AT-1H	16ER-LAG60-RH*		
60°V-LH	8 – 48	3/8	Pos	AT-1H	16ER-LAG60-LH*		
60°V-RH	5 – 7	1/2	Pos	AT-2H	22ER-LN60-RH*		
60°V-LH	5 – 7	1/2	Pos	AT-2H	22ER-LN60-LH*		

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

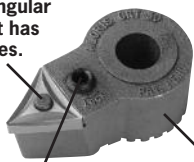
# ALORIS ADJUSTABLE-SHANK TOOL HOLDERS

FOR LEFT OR RIGHT HAND TURNING, FACING OR CHAMFERING.

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



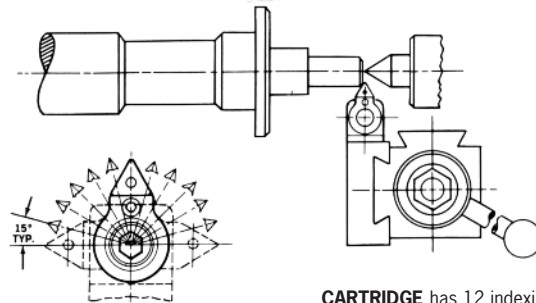
Standard triangular carbide insert has 6 cutting edges.



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

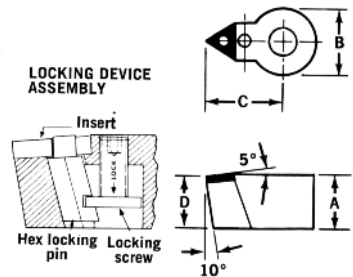
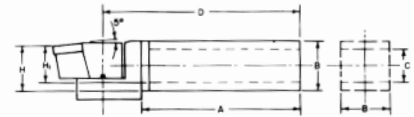


PICTORIAL DIAGRAM OF CARTRIDGE

The adjustable shank feature introduces added flexibility — turning the shank 90° permits choice of shank and cutting tool alignment. The cartridge, with its 12 indexing positions at 15° intervals, provides for many angular turning operations. See page 10 for cartridge details.

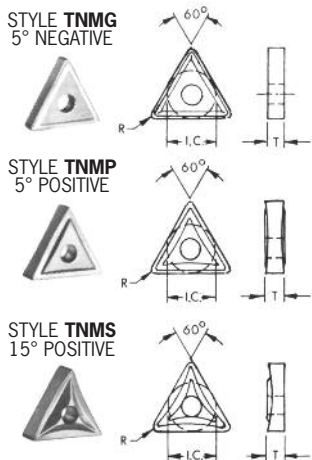
The two-way adjustable rake provides for right or left hand turning, facing and chamfering. Rake has 5° cutting angle with positive stop. Adjustment is made by loosening cradle lock screw and selecting desired setting.

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 <sub>1</sub>	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†



HOLDER #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #	GRADE	
		I.C.	T	R		A2/A6	767
AT-32	CRT-20	3/8	3/16	1/32	TNMG-332†		
					TNMP-332†		
					TNMS-332†		

HOLDER #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #	GRADE	
		I.C.	T	R		A2/A6	767
AT-40	CRT-30	1/2	3/16	1/32	TNMG-432†		
					TNMP-432†		
					TNMS-432†		

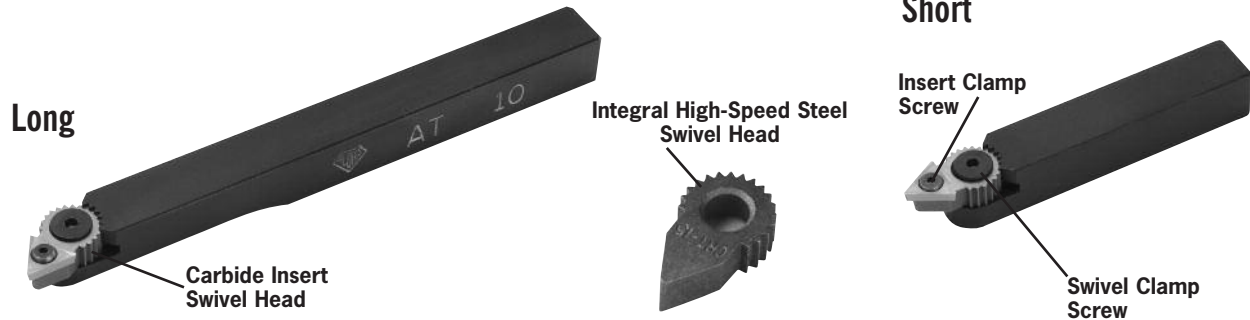
†Inserts are priced individually, however, they must be purchased in packages of 10. ††100 & up call for price.

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 #	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 #	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 #*	GRADE	
					I.C.	T	R		A2/A6	767
			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	5/16	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.



Cartridge cradle

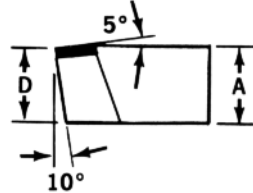
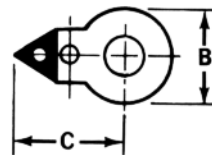
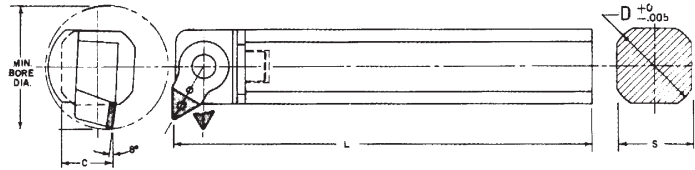
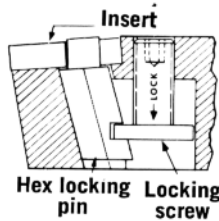
Standard triangular carbide insert has 6 cutting edges.



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

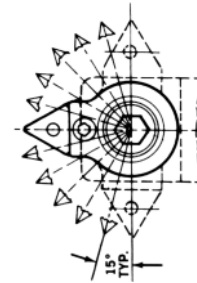
Tool Steel Cartridge adjuster every 15° for right or left hand turning facing or chamfering. 12 positive lock positions.

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.

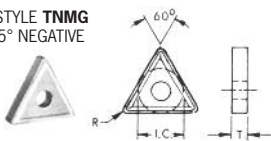


ORDERING INFORMATION						REPLACEMENT PARTS							
BORING BAR ORDER #		MIN. BORE DIA.	TOTAL LENGTH L	S	D	C	CARTRIDGE		CARTRIDGE CRADLE	HEX LOCKING PIN		LOCKING SCREW	
							ORDER #		ORDER #	ORDER #	ORDER #	ORDER #	
CBB4-20		2 3/8	16"	1 1/4	1 1/2	1"	CRT-20*		CC-4*	LP-20*	LS-20*		
CBB5-20		2 3/8	18"	1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

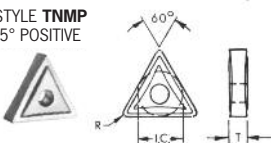
STYLE TNMG

5° NEGATIVE



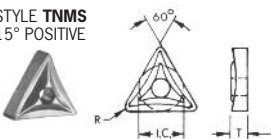
STYLE TNMP

5° POSITIVE



STYLE TNMS

15° POSITIVE



BORING BAR #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #	GRADE	
		I.C.	T	R		A2/A6	767
CBB4-20	CRT20	3/8	3/16	1/32	TNMG-332*		
CBB5-20					TNMP-332*		
					TNMS-332*		

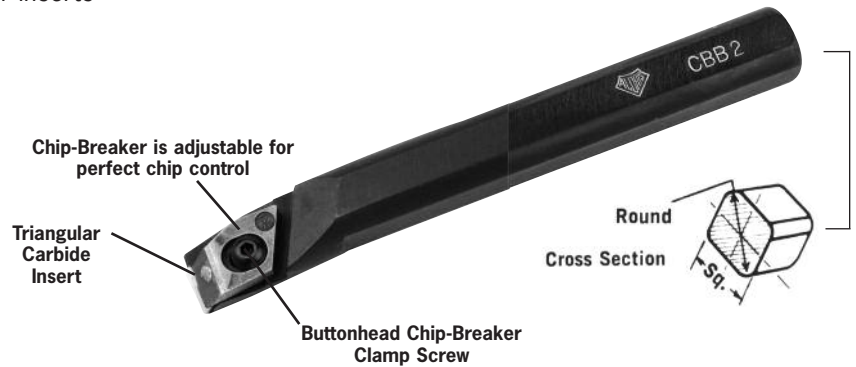
\*Inserts are priced individually however, they must be purchased in packages of 10. \*\*100 & up call for price.

BORING BAR #	CARTRIDGE #	DIMENSIONS			INSERT ORDER #	GRADE	
		I.C.	T	R		A2/A6	767
CBB6-30	CRT30	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. \*\*100 & up call for price.

# 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 #		ORDER #		ORDER #		ORDER #	
CBB-1	5/8	3/4	8"	1/8	3/8	1/8	CB-13*		SCR-1*		SM-41*		SM-41SS*	
CBB-2	7/8	1"	12"	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 5/8	1/2	3/16	CB-46*		SCR-12*		SM-37*		SM-37SS*	

## INSERTS FOR ADJUSTABLE CHIPBREAKER BORING BARS<sup>†</sup>

STYLE TPG	DIMENSIONS			INSERT ORDER #*	GRADE	
	I.C.	T	R		A2/A6	767
		3/8	1/8	1/32	TPG-322*	
	1/2	3/16	1/32	TPG-432*		

<sup>†</sup>Inserts are priced individually, however, they must be purchased in packages of 10. <sup>\*\*</sup>100 & up call for price. See full selection of inserts on pages 49 – 54.

## 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.



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

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

## 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

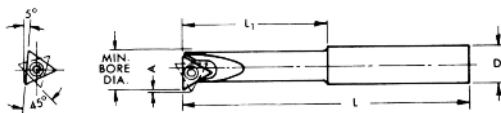
An adjustable “throw-away insert”, boring bar designed especially for through boring, facing, or boring to a square shoulder or any lead angle.

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.



**7% SAVING ON SET OF 4 BORING BARS**



**BS** set consists of BS1 – BS2 – BS3 – BS4

**BL** set consists of BL1 – BL2 – BL3 – BL4

## SUPPLIED WITH A-6 CARBIDE INSERT

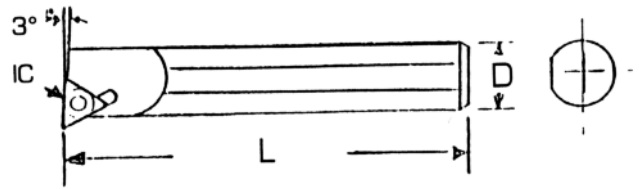
ORDERING INFORMATION (SHORT)							REPLACEMENT PARTS				
ORDER #	SAVE 7% ON SET OF 4 ORDER #	MIN. BORE DIA.	ADJUSTMENT A	DIMENSIONS			INSERT SIZE	LEAD ANGLE ADJUSTMENT SCREW		INSERT CLAMP SCREW	
				D	L	L <sub>1</sub>		ORDER #		ORDER #	
BS-1	BS-SET	1/2	1/32	3/4	3 3/4	1 3/4	1/4 I.C.	SAS-10*		LS-4*	
BS-2		9/16	1/32		3 3/8	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		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 #	SAVE 7% ON SET OF 4 ORDER #	MIN. BORE DIA.	ADJUSTMENT A	DIMENSIONS			INSERT SIZE	LEAD ANGLE ADJUSTMENT SCREW		INSERT CLAMP SCREW		
				D	L	L <sub>1</sub>		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		5/8	7"	3 1/4	5/16 I.C.	SAS-10*		LS-6*	
BL-4		11/16	1/32		3/4	8"	3 3/4	3/8 I.C.	SAS-250*		LS-8*	
BL-5		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	DIMENSIONS			STYLE	GRADE	
	I.C.	T	R		A2/A6	767
STYLE ATPG	$\frac{1}{4}$	$\frac{3}{32}$	$\frac{1}{64}$	ATPG-431*		
STYLE ATPGHL	$\frac{1}{4}$	$\frac{3}{32}$	$\frac{1}{64}$	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*		

\*Inserts are priced individually, however, they must be purchased in packages of 10. \*\*100 & up call for price.

See full selection of inserts on pages 49 – 54.

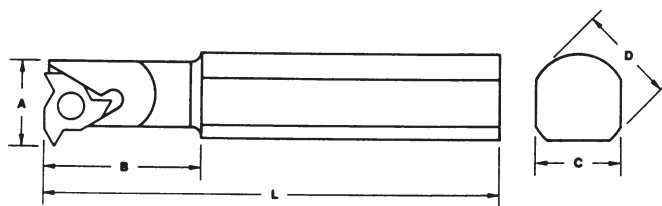
# ALORIS SERIES ATB INTERNAL THREADING BARS



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 1/16	2 3/4	1 1/16	1 1/4	12"	3/8	ASA3T*		T10*			—	
ATB-5R	ATB-5L	1 1/16	3 3/8	1 1/4	1 1/2	14"	1/2	ASA4T*		T20*		YI4(RH)*		
												YE4(LH)*		

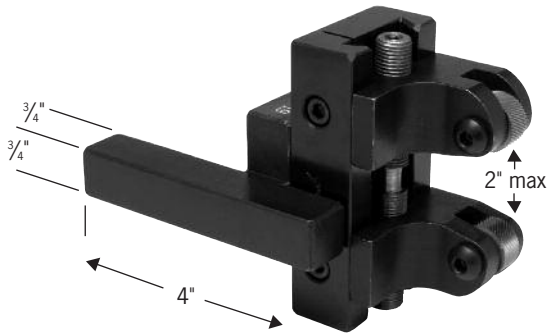


## 60° PARTIAL PROFILE INTERNAL CARBIDE THREADING INSERTS†

RH	LH	USE WITH BORING BAR #	ORDER # RIGHT HAND†	ORDER # LEFT HAND†	I.C.	THREADS (TPI)	GRADE	
							A2/A6	767
		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		

†Inserts are priced individually, however, they must be purchased in packages of 10. \*\*100 & up call for price.

# ALORIS AT-19 ADJUSTABLE KNURLING HOLDER

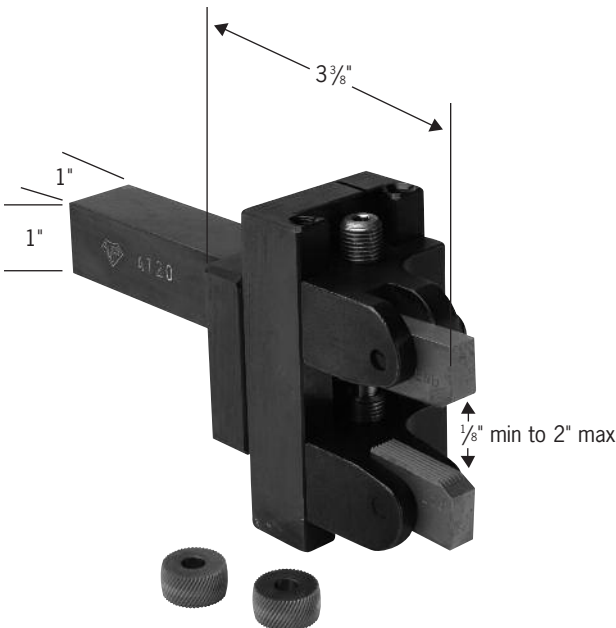


...excellent knurling, with approach adjustability, is provided with the newly designed AT-19 knurling holder. The AT-19 is self-centering and is adjusted by means of a conveniently located knurled knob, providing the ideal near-vertical-axis approach angle for a wide range of stock diameters. Spindle 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

# 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 lockscrew, 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

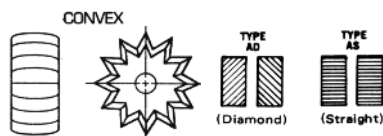
## BAR GRIPPERS



GRIPPER ORDER # (pair)	AT-20G*

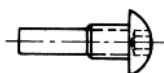
## HIGH SPEED KNURLS

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
(NEW) TiN COATED			

## KNURL-LOCK SCREW

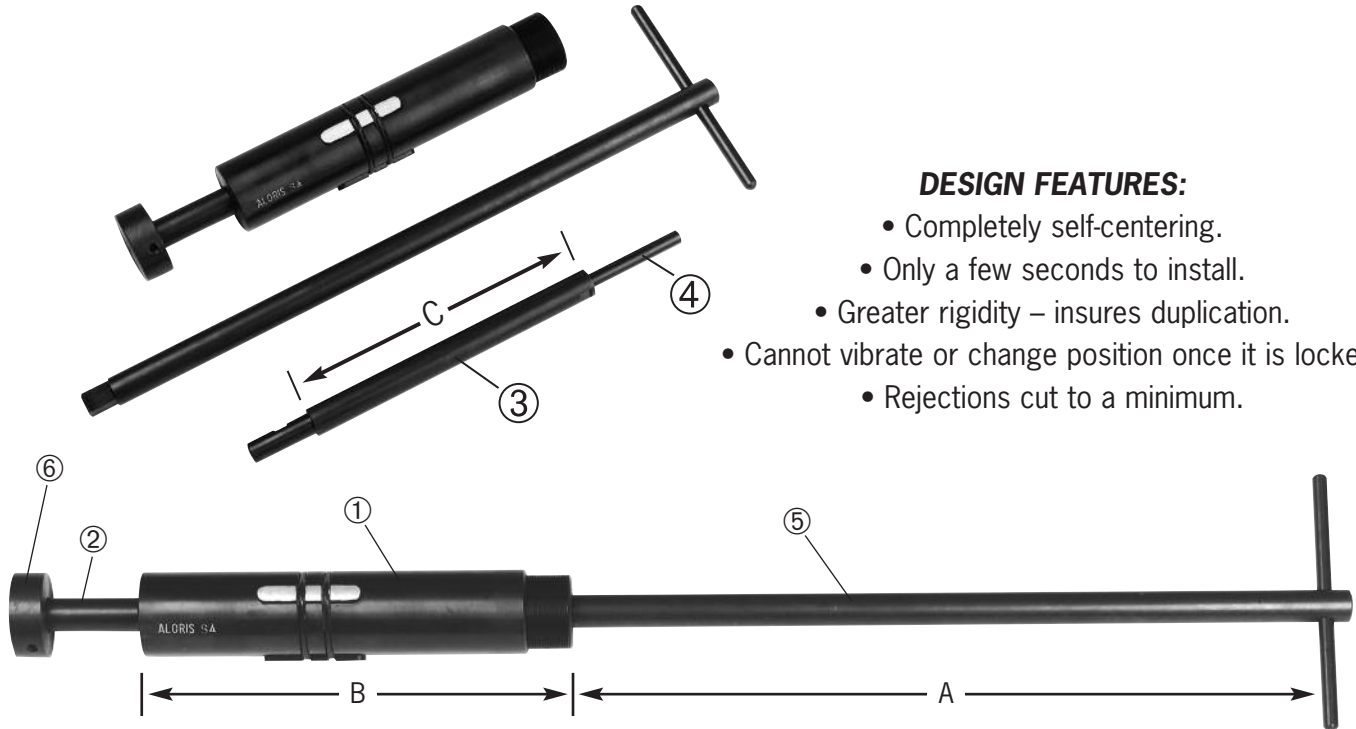


ORDER #	SCR-10*	Used with any #10, #19 and #20 holder

# 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	45/16	45/16	3/4" to 15/16"
S-1	12¼	4½	6	1" to 1¼"
S-2	19	67/16	6½	15/16" to 11/16"
S-3	21½	77/8	10½	1¾" to 27/16"
S-4	22¾	9¼	10½	2½" to 3½"
S-5	22¾	12	10½	35/8" to 4½"

Spindle stop is supplied with screw wrenches.

### SPINDLE STOP – REPLACEMENT PARTS

	S-00	S-0	S-1	S-2	S-3	S-4	S-5
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

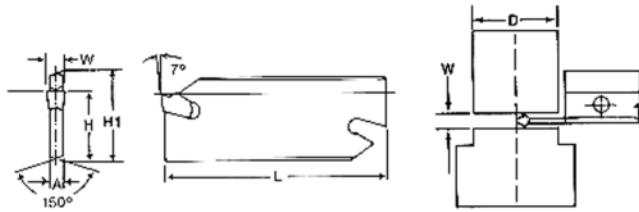


## Regular Style

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

## Positive Stop Style

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



ORDERING INFORMATION				DIMENSIONS						
Designation	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	3/8	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	13/64	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	3/8	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	13/64	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

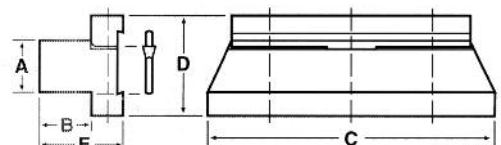
Simple block design accommodates Wedge Grip and competitive blade systems. Unique wedge clamp provides firm seating for light and heavy duty cut-off and grooving operations. Two piece design provides stability, strength and correct alignment of blade for maximum performance.



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 SGIH 26-6
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 SGIH 32-4
SGTBN 25-6*		1.0	25/32	4 5/16	1 7/8	1 15/32	SGIH 32-5 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 32-6 SGIH 32-8 SGIH 32-9

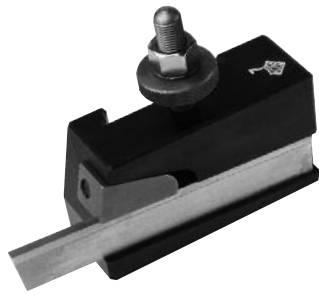
\*For large quantities, call for price.



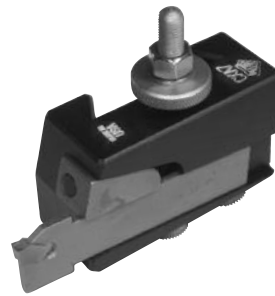
# ALORIS #7 CUT-OFF SYSTEM



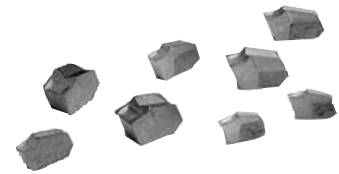
#7 Holder without blade.



#7 Holder with original high-speed cut-off blade.

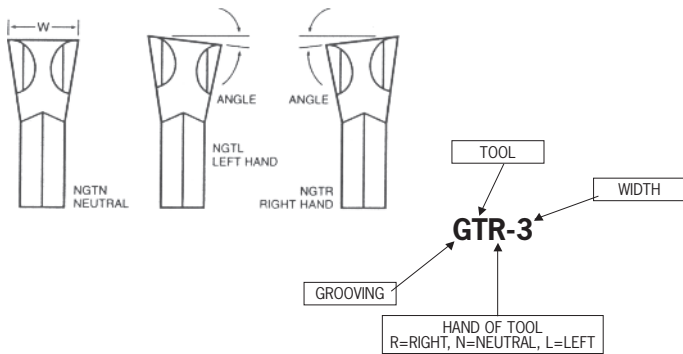


#7 Holder with **NEW** wedge lock carbide insert blade.



Aloris GT Inserts.

#7 Holder		High Speed Cut-Off Blade	Wedge Grip Carbide Insert Blade	Carbide Inserts
Series Ordering #		Ordering #	Ordering #	Ordering #
AXA-7 AXA-7R		P-2 width 3/32"	SGIH 19-3C-A7	GTL 3, GTN 3, GTR 3 width .120
BXA-7 BXA-7R		P-3 width 0.125"	SGIH 26-4C-B7	GTL 4, GTN 4, GTR 4 width .160
CXA-7 CXA-7R		P-3W width 0.125"	SGIH 26-4C-CX7	GTL 4, GTN 4, GTR 4 width .160
CA-7 CA-7R		P-5 width 0.187"	SGIH 32-4.8C-C7	GTL 4.8, GTN 4.8, GTR 4.8 width .187
DA-7 DA-7R		P-8 width 0.187"	SGIH 32-4.8C-D7	GTL 4.8, GTN 4.8, GTR 4.8 width .187
EA-7 EA-7R		P-8 width 0.187"	SGIH 32-4.8C-E7	GTL 4.8, GTN 4.8, GTR 4.8 width .187



### 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.

### Aloris GT Cut-Off Insert

Catalog Number	Cutting Edge Geometry	Cutting Width	Lead Angle	Grade A2 or A6	Grade 767
GTN 2*	P	.087	0		
GT L/R 2*	P	.087	8		
GTN 2.4*	P	.093	0		
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		






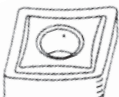
Inserts are priced individually, however, they must be purchased in packages of 10.

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

Insert Information on Pages 49 to 54.

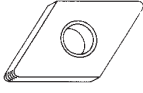





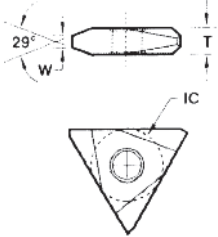
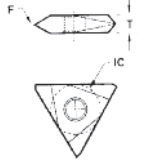
# ALORIS CARBIDE INSERTS

- 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				GRADES	
		I.C.	THICK- NESS	RADIUS	HOLE	GRADE A2/A6†	GRADE 767†
<b>ATPG</b>   <b>ATPGHL</b>   <b>ATPGHR</b> 	<b>ASD-8P*</b>	1/2	1/8	1/32			
	<b>ASD-12P*</b>	3/4	3/16	3/64			
	<b>AT-4R*</b>						
	<b>ATD-8P*</b>	1/2	3/16	1/32	.7188		
	<b>ATDHL-8P*</b>	1/2	3/16	1/32	.7188		
	<b>ATPG-321*</b>	5/32	1/16	1/64	.2188		
	<b>ATPG-431*</b>	1/4	3/32	1/64	.3594		
	<b>ATPG-541*</b>	5/16	1/8	1/64	.5469		
	<b>ATPG-642*</b>	3/8	1/8	1/32	.5312		
	<b>ATPGHL-431*</b>	1/4	3/32	1/64	.3594		
	<b>ATPGHL-541*</b>	5/16	1/8	1/64	.5469		
	<b>ATPGHL-642*</b>	3/8	1/8	1/32	.5312		
<b>ATPGHR-431*</b>	1/4	3/32	1/64	.3594			
<b>ATPGHR-541*</b>	5/16	1/8	1/64	.5469			
<b>CHIPBREAK MN</b> 	<b>CNMG-431 MN*</b>	1/2	3/16	1/64	.203		
	<b>CNMG-432 MN*</b>	1/2	3/16	1/32	.203		
	<b>CNMG-433 MN*</b>	1/2	3/16	3/64	.203		
<b>CHIPBREAK RN</b> 	<b>CNMG-434 RN*</b>	1/2	3/16	1/16	.203		
	<b>CNMG-542 RN*</b>	5/8	1/4	1/32	.250		
	<b>CNMG-543 RN*</b>	5/8	1/4	3/64	.250		
<b>CHIPBREAK MN</b>	<b>CNMG-642 RN*</b>	3/4	1/4	1/32	.312		
<b>CHIPBREAK MN</b>	<b>CNMG-643 MN*</b>	3/4	1/4	3/64	.312		
<b>CHIPBREAK RN</b>	<b>CNMG-644 RN*</b>	3/4	1/4	1/16	.312		
<b>CNMZ</b> 	<b>CNMZ-432 MP*</b>	1/2	3/16	1/32	.203		
	<b>CNMZ-543 MP*</b>	5/8	1/4	3/64	.250		
	<b>CNMZ-642 MP*</b>	3/4	1/4	1/32	.312		
	<b>CNMZ-643 MP*</b>	3/4	1/4	3/64	.312		

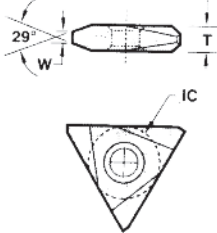
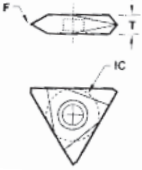
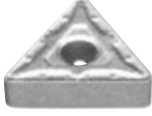



†Quantities of 100 and over, call for price. Inserts sold in packages of 10.

# ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS				GRADES	
		I.C.	THICKNESS	RADIUS	HOLE	GRADE A2/A6†	GRADE 767†
<b>DNGA</b> 	<b>DNGA-532*</b>	5/8	3/16	1/32	.250		
	<b>DNGA-542*</b>	5/8	1/4	1/32	.250		
	<b>DNGA-543*</b>	5/8	1/4	3/64	.250		
<b>DNMG</b> 	<b>DNMG-331 LR-11*</b>	3/8	3/16	1/64	.750		
	<b>DNMG-332 LR-11*</b>	3/8	3/16	1/32	.150		
<b>CHIPBREAK MN</b> <b>DNMG-333 MN*</b>		3/8	3/16	3/64	.150		
<b>DNMG</b> 	<b>DNMG-431 LR-13*</b>	1/2	3/16	1/64	.203		
	<b>DNMG-432 LR-13*</b>	1/2	3/16	1/32	.203		
<b>10° POSITIVE</b> <b>DNMS-542*</b>		5/8	1/4	1/32	.250		
<b>CHIPBREAK MN</b> <b>DNMZ-432 MP*</b>		1/2	3/16	1/32	.203		
<b>CHIPBREAK MN</b> <b>DNMZ-532 MP*</b>		5/8	3/16	1/32	.250		
<b>CHIPBREAK MN</b> <b>DNMZ-542 MP*</b>		5/8	1/4	1/32	.250		
<b>NT</b> 	<b>NT-2 R &amp; L HND*</b>						
	<b>NT-3 R &amp; L HND*</b>						
	<b>NT-4 R &amp; L HND*</b>						
<b>NT</b> 	<b>NT-2 POS R &amp; L HND*</b>						
	<b>NT-3 POS R &amp; L HND*</b>						
	<b>NT-4 POS R &amp; L HND*</b>						
<b>TNG</b> 	<b>TNG 321*</b>	3/8	1/8	1/64			
	<b>TNG 322*</b>	3/8	1/8	1/32			
	<b>TNG 323*</b>	3/8	1/8	3/64			
	<b>TNG 431*</b>	1/2	3/16	1/64			
	<b>TNG 432*</b>	1/2	3/16	1/32			
	<b>TNG 544*</b>	5/8	1/4	1/16			
<b>TNMA</b> 	<b>TNMA 32 NT 6*</b>	3/8	.127		.150		
	<b>TNMA 32 NT 8*</b>	3/8	.127		.150		
	<b>TNMA 32 NT 10*</b>	3/8	.127		.150		
	<b>TNMA 32 NT 12*</b>	3/8	.127		.150		
	<b>TNMA 43 NT 4*</b>	1/4	.189		.203		
	<b>TNMA 43 NT 5*</b>	1/4	.189		.203		
	<b>TNMA 43 NT 6*</b>	1/4	.189		.203		
	<b>TNMA 43 NT 8*</b>	1/4	.189		.203		
	<b>TNMA 43 NT 10*</b>	1/4	.189		.203		
<b>TNMA</b> 	<b>TNMA 32 NV*</b>	3/8	.127	8-36	.150		
	<b>TNMA 43 NV*</b>	1/2	.189	5-24	.203		
	<b>TNMA 54 NV*</b>	5/8	.252	4-20	.250		
	<b>TNMA 64 NV*</b>	3/4	.250	4-20	.312		
	<b>TNMA 66 NV*</b>	3/4	.375	3-12	.312		

†Quantities of 100 and over, call for price. Inserts sold in packages of 10.

# ALORIS CARBIDE INSERTS

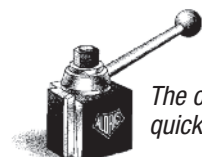
SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS				GRADE	
		I.C.	THICK- NESS	RADIUS	HOLE	GRADE A2/A6†	GRADE 767†
 TNMC	TNMC 32 NT 6 *	3/8	.127		.150		
	TNMC 32 NT 8 *	3/8	.127		.150		
	TNMC 32 NT 10 *	3/8	.127		.150		
	TNMC 32 NT 12 *	3/8	.127		.150		
	TNMC 43 NT 4 *	1/4	.189		.203		
	TNMC 43 NT 5 *	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		

†Quantities of 100 and over, call for price. Inserts sold in packages of 10.




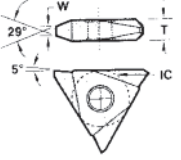
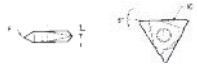
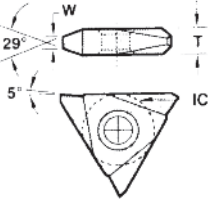


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*The originator of  
quick change tooling*

# ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS				GRADES	
		I.C.	THICKNESS	RADIUS	HOLE	GRADE A2/A6†	GRADE 767†
	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			
	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 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 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			

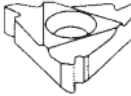
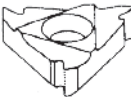
†Quantities of 100 and over, call for price. Inserts sold in packages of 10.

# ALORIS CARBIDE INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS				GRADES	
		I.C.	THICKNESS	RADIUS	HOLE	GRADE A2/A6†	GRADE 767†
 <b>WNUMG</b>	<b>WNUMG-331 MN*</b>	3/8	3/16	1/64	.150		
	<b>WNUMG-332 MN*</b>	3/8	3/16	1/32	.150		
	<b>WNUMG-333 MN*</b>	3/8	3/16	3/64	.150		
	<b>WNUMG-431 MN*</b>	1/2	3/16	1/64	.203		
	<b>WNUMG-432 MN*</b>	1/2	3/16	1/32	.203		
	<b>WNUMG-433 MN*</b>	1/2	3/16	3/64	.203		

†Quantities of 100 and over, call for price.

# LAY DOWN THREADING INSERTS

SHAPE OR CHIPBREAKER DEPICTED	ORDER #	DIMENSIONS				GRADES →			GRADES	
		I.C.	THICKNESS	RADIUS	HOLE	X	Y	TPI	A2/A6	767
 <b>AIT-R/L60</b>	<b>1/4 AIT-R60*</b>	1/4	.126	.0018	.128	.031	.035	16-48		
	<b>1/4 AIT-L60*</b>	1/4	.126	.0018	.128	.031	.035	16-48		
	<b>3/8 AIT-R60*</b>	3/8	.143	.002	.155	.047	.067	8-48		
	<b>3/8 AIT-L60*</b>	3/8	.143	.002	.155	.047	.067	8-48		
	<b>1/2 AIT-R60*</b>	1/2	.188	.008	.192	.067	.098	5-7		
	<b>1/2 AIT-L60*</b>	1/2	.188	.008	.192	.067	.098	5-7		
 <b>ER/L60</b>	<b>16ER LAG 60-RH*</b>	3/8	.143	.002	.155	.047	.067	8-48		
	<b>16ER LAG 60-LH*</b>	3/8	.143	.002	.155	.047	.067	8-48		
	<b>22ER LN 60-RH*</b>	1/2	.188	.0132	.192	.067	.098	5-7		
	<b>22ER LN 60-LH*</b>	1/2	.188	.0132	.192	.067	.098	5-7		

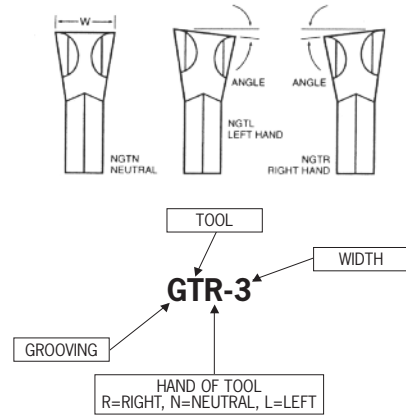
Inserts sold in packages of 10.

## 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	Grade A2 or A6	Grade 767
	GTN 2*	P	.087	0		
††	GT L/R 2*	P	.087	8		
	GTN 2.4*	P	.093	0		
††	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. †††Call for price over 100 quantity.

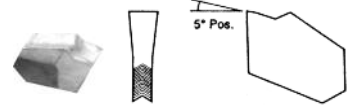
Inserts are priced individually, however, they must be purchased in packages of 10.

For blades see page 46.

## 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.



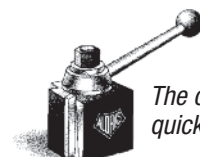
### Pick the grade to fit your application.

- 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*



# FAX ORDER FORM FOR ITEMS MARKED WITH AN \*(ASTERISK)



Fax: 973.772.8606

## We make it easy! Call, fax or mail...

Use this form as a handy worksheet and then **call** us at 973.772.1201 or toll free at 877.722.1733 (between 8am and 4:30 pm EST) with your credit card information (we accept all major credit cards: American Express, MasterCard, VISA and Discover).

### OR...

Complete the order form and **fax** it to us at 973.772.8606 (24 hours a day).

### OR...

Complete the order form and **mail** it to us at Aloris Tool Technology, P.O. Box 1529, Clifton, NJ 07015-1529.

### For fax or mail orders, please check one:

- Check or Money Order Enclosed
- Please ship C.O.D.

Purchase Order No. \_\_\_\_\_

Contact Name \_\_\_\_\_

Title \_\_\_\_\_

Telephone Number (\_\_\_\_) \_\_\_\_\_

### Bill To: (Please print)

Company Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

### Ship To: (if different from information above)

Company Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

Contact Name \_\_\_\_\_

Purchase Order No. (if necessary) \_\_\_\_\_

Shipping Instructions \_\_\_\_\_

ORDER #	DESCRIPTION	PRICE EACH	QUANTITY	TOTAL PRICE

NOTE: Tax and freight charges will be automatically added to your order.

SUBTOTAL	
TAX	
FREIGHT	
<b>TOTAL</b>	



Conditions, terms, and prices are subject to change without notice.

**FAX ORDER TO: 973.772.8606**

# POLICY AND PROCEDURES

1. **MINIMUM ORDERS:**

All orders will be a minimum of \$50.00 net. Any orders less than minimum will be charged at the \$50.00 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.

Drop Ship Fee 10% effective January 1st, 2015.

This Charge will be added directly to the invoice. This will not affect shipments made to the Distributors warehouse but solely to orders shipped to the end user.

3. **DELIVERY:**

All merchandise will be shipped FOB, Aloris Factory, Clifton, N.J., 07011. 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 35%. If the goods require refurbishing, an additional 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. This Catalog supercedes any pricing, policies and procedures from any previous catalog.

8. **REPAIRS/SPECIALS:**

Repairs and parts are quoted as soon as possible. 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:**

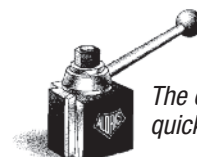
All items marked with an \* (**asterisk**) after the order number, specials, and repairs are available directly from the manufacturer, and may be purchased at list price with any major credit card, or COD.

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

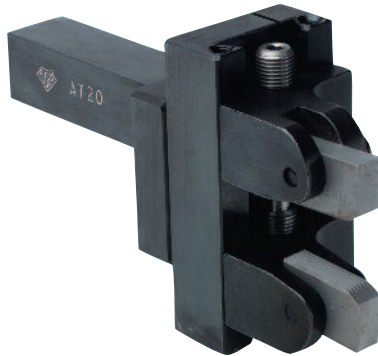


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