ALORIS TOOL TECHNOLOGY CO., INC.

2017 CATALOG

The Originator of Quick Change Tooling

All Aloris products are proudly made in the USA.

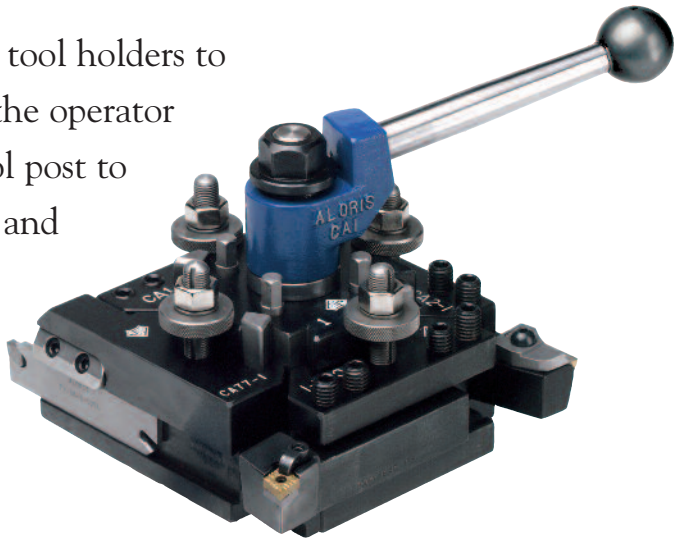
INTRODUCING

ALORIS INDEXABLE TOOL POSTS & SETS

New Product Built By The Originator of "The Quick Change Tool Post"

For Manual and CNC Lathes

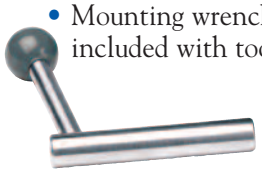
The **Aloris Indexable Tool Post** allows 4 independent tool holders to be locked to the tool post simultaneously. This allows the operator to do multiple operations by means of indexing the tool post to any of the 24 locking positions. The index positioning and locking is accomplished by the same means 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.

PATENT PENDING

The originator of quick change tooling

REV 1/12

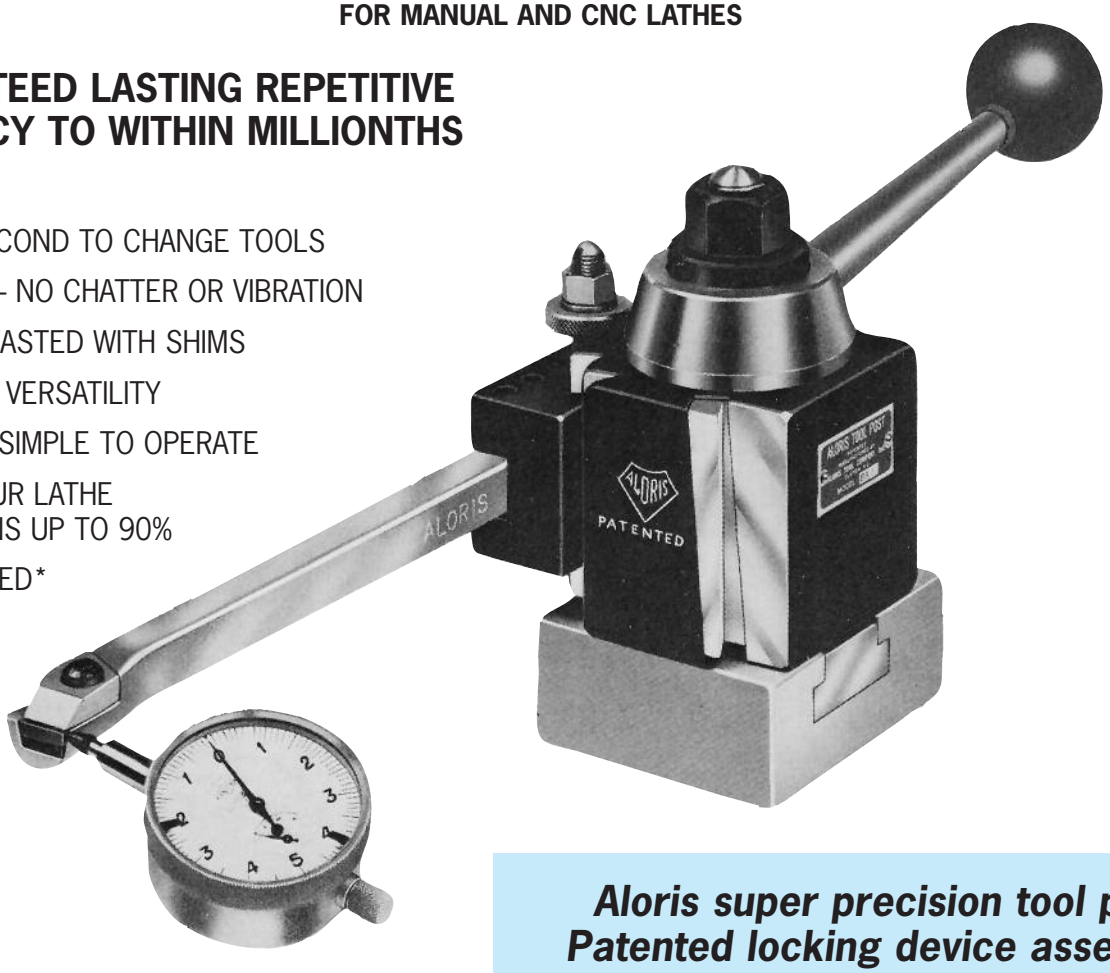
ALORIS SUPER PRECISION QUICK CHANGE TOOL POSTS

FOR MANUAL AND CNC LATHES

GUARANTEED LASTING REPETITIVE ACCURACY TO WITHIN MILLIONTHS

FEATURES:

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

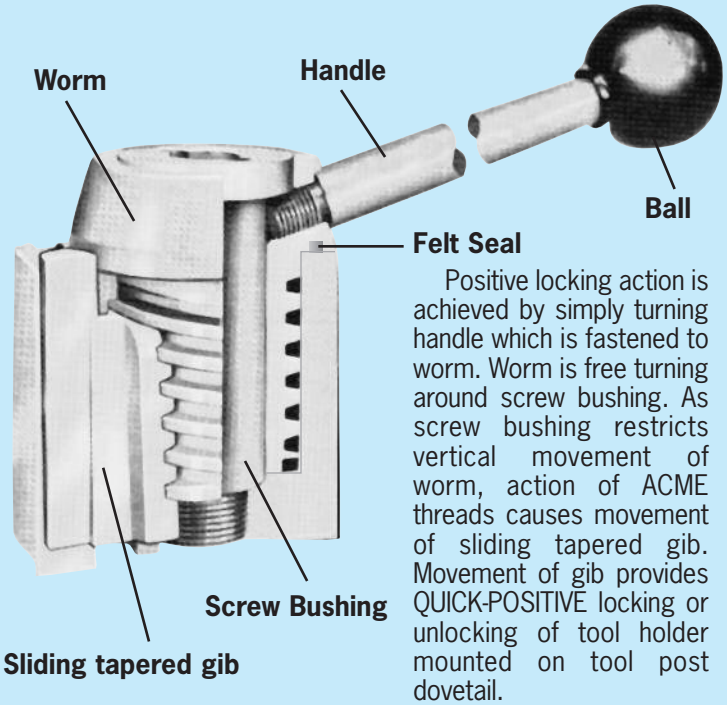


The ALORIS Super Precision tool post provides built-in quick tool changing versatility and flexibility combined with wide range, positive control and repetitive accuracy to meet the most exacting working tolerances. Whether for tool room or production work, the Aloris line of tool posts and holders will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

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

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

Aloris super precision tool post Patented locking device assembly



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

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

ALORIS QUICK CHANGE TOOL POSTS

Aloris Miniature (MA) Tool Post

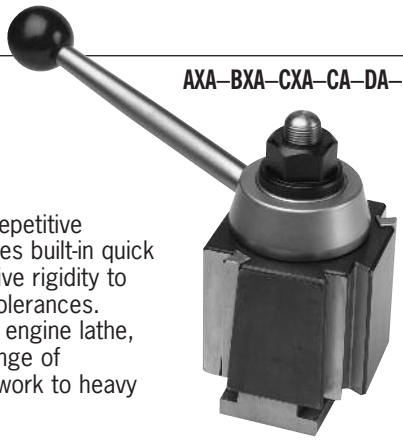
Also on Page 26

Super precision single dovetail tool post designed for jewelers and miniature lathes. Three holders can hold six tools for various operations. Height adjustment is provided for each tool.
Tool holder capacity: 1/8" – 3/8".
Tool post dimensions: 1 1/2" x 1 1/2" x 1 1/4".
See page 26 for toolholders.

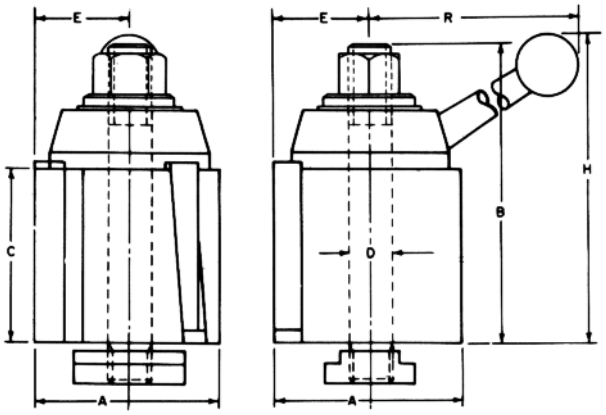
ORDER #: MA

Aloris Super-Precision Tool Post

AXA–BXA–CXA–CA–DA–EA



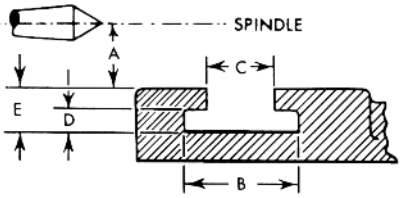
Precision engineered to assure repetitive accuracy. Advanced design provides built-in quick tool changing versatility with positive rigidity to meet the most exacting working tolerances. Quickly and easily installed on any engine lathe, bench or CNC lathe, for a wide range of operations — from fine precision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



ORDERING INFORMATION

AXA SERIES								BXA SERIES								CXA SERIES							
ORDER #: AXA								ORDER #: BXA								ORDER #: CXA							
DIMENSIONS								DIMENSIONS								DIMENSIONS							
A	B	C	D	E	H	R	SWING UP TO	A	B	C	D	E	H	R	SWING UP TO	A	B	C	D	E	H	R	SWING UP TO
2 1/2	3 7/8	2 1/4	9/16	1 3/8	4 11/16	5 3/4	10"	3	4 5/8	2 3/4	5/8	1 5/8	5 9/16	7 5/16	12–15"	3 1/2	5 1/8	3	3/4	1 7/8	6 1/8	7 7/8	13–18"

CA SERIES								DA SERIES								EA SERIES								
ORDER #: CA								ORDER #: DA								ORDER #: EA								
DIMENSIONS								DIMENSIONS								DIMENSIONS								SWING 25" HVY DUTY & LARGER LATHES
A	B	C	D	E	H	R	SWING UP TO	A	B	C	D	E	H	R	SWING UP TO	A	B	C	D	E	H	R		
4	6 1/4	3 5/8	7/8	2 1/8	7	9	14–20"	5	7 5/8	4 5/8	1"	2 11/16	8 3/4	10 7/8	17–48"	6	8 1/2	5	1 1/4	3 1/8	10	13 3/4		



MAKE OF LATHE	SWING	A	B	C	D	E

*To order tool holders see page 4 thru 25. *To order sets see pages 26 and 27.
*All Aloris Super Precision Quick Change Tool Posts are furnished with a BLANK T-Nut. Aloris can **machine the T-Nut** at ***NO ADDITIONAL CHARGE*** if "dimensions" are provided **at time of purchase,** otherwise the **T-Nut will ship blank.**
Please fill out chart and fax to 973-772-8606. *(Please reference your Purchase Order on your T-Nut ordering sheet.)*

POSTS: REPLACEMENT PARTS

Not Interchangeable with Indexable Tool Post Parts.

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

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

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

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

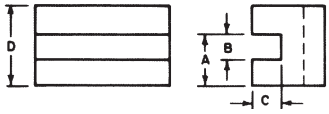
QUICK CHANGE SHANK TOOL HOLDERS

AXA SERIES

#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.



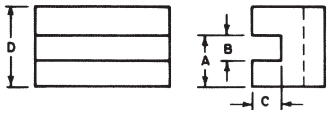
ORDER # AXA-1

A	B	C	D	Tool Bit
15/16	1/2	7/16	1 1/2	3/16–1/2

#1S

OVERSIZE TURNING AND FACING HOLDER

Takes large sizes of bits. Turning and facing tools can be locked in together. Saves time and labor when changing operations.
B dimension is oversize which allows larger tools to be used.



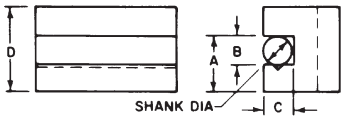
ORDER # AXA-1S

A	B	C	D	Tool Bit
1"	5/8	7/16	1 1/2	5/8 max

#2

BORING, TURNING AND FACING HOLDER

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



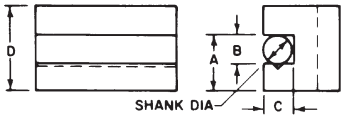
ORDER # AXA-2

A	B	C	D	Tool Bit	Shank
15/16	1/2	7/16	1 1/2	3/16–1/2	7/16

#2S

OVERSIZE BORING, TURNING AND FACING HOLDER

"V" groove holds round shank boring bars and tools as well as square tool bits.
B dimension is oversize which allows larger tools to be used.



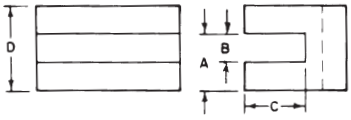
ORDER # AXA-2S

A	B	C	D	Tool Bit	Shank
1"	5/8	7/16	1 1/2	5/8 max	1/2

#6

MULTIPLE TOOL HOLDER

Versatile, ideal for repetitive work: for gang set-ups or form tool.



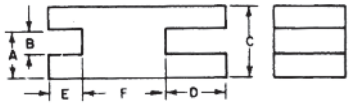
ORDER # AXA-6

A	B	C	D	Tool Bit
1"	1/2	1 1/8	1 9/16	1/4–1/2

#9

MULTI-PURPOSE HOLDER

Ideal for multiple operations. Left or right turning and facing, working close to tail stock, form tool gang set-ups, etc. Extremely useful for short heavy duty boring or CNC gang tooling.



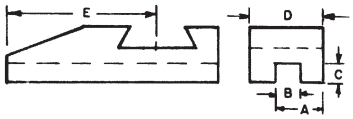
ORDER # AXA-9
SPECIAL ORDER

A	B	C	D	E	F	Tool Bit
15/16	3/8	1 1/2	1 7/8	1"	2 1/8	3/16–3/8

#13
#13L

EXTENSION TOOL HOLDER #13 & 13L

A new addition to the versatile Aloris dovetail mounted quick-change tool holder series. The #13 provides an extremely rugged extended open slot featuring maximum rigidity for deep turning or facing operation. 13L – opposite hand.



ORDER # AXA-13				ORDER # AXA-13L	
A	B	C	D	E	Tool Bit
15/16	1/2	7/16	1 1/2	2 1/2	3/16–1/2

HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-HA*

TOOL HOLDER SET SCREWS (SET OF 4)

ORDER # AXA-SS*

BXA SERIES

ORDER # BXA-1				
A	B	C	D	Tool Bit
1 1/8	5/8	1/2	1 3/4	1/4–5/8

ORDER # BXA-1S				
A	B	C	D	Tool Bit
1 3/16	3/4	1/2	1 3/4	3/4 max

ORDER # BXA-2					
A	B	C	D	Tool Bit	Shank
1 1/8	5/8	1/2	1 3/4	1/4–5/8	1/2

ORDER # BXA-2S					
A	B	C	D	Tool Bit	Shank
1 3/16	3/4	1/2	1 3/4	3/4 max	5/8

ORDER # BXA-6				
A	B	C	D	Tool Bit
1 1/16	1/2	1 9/16	1 3/4	1/4–1/2

ORDER # BXA-9 SPECIAL ORDER						
A	B	C	D	E	F	Tool Bit
1 1/8	1/2	1 3/4	2 11/16	1 3/16	2 5/8	1/4–1/2

ORDER # BXA-13				ORDER # BXA-13L	
A	B	C	D	E	Tool Bit
1 1/8	5/8	1/2	1 3/4	2 1/4	1/4–5/8

ORDER # BXA-HA*

ORDER # BXA-SS*

CXA SERIES

ORDER # CXA-1				
A	B	C	D	Tool Bit
1 7/16	3/4	5/8	2 1/8	1/2–3/4

ORDER # CXA-1S				
A	B	C	D	Tool Bit
1 9/16	1"	5/8	2 1/8	1" max

ORDER # CXA-2					
A	B	C	D	Tool Bit	Shank
1 7/16	3/4	5/8	2 1/8	1/2–3/4	3/4

ORDER # CXA-2S					
A	B	C	D	Tool Bit	Shank
1 9/16	1"	5/8	2 1/8	1" max	3/4

ORDER # CXA-6				
A	B	C	D	Tool Bit
1 5/16	5/8	1 7/16	2 1/8	3/8–5/8

ORDER # CXA-9 SPECIAL ORDER						
A	B	C	D	E	F	Tool Bit
1 5/16	5/8	2"	3"	1 5/8	3 3/8	3/8–5/8

ORDER # CXA-13				ORDER # CXA-13L	
A	B	C	D	E	Tool Bit
1 7/16	3/4	5/8	2 1/8	3 3/8	1/2–3/4

ORDER # CXA-HA*

ORDER # CXA-SS*

CA SERIES

ORDER # CA-1				
A	B	C	D	Tool Bit
1 11/16	1"	3/4	2 1/2	1/2–1"

ORDER # CA-1S				
A	B	C	D	Tool Bit
2"	1 1/4	3/4	2 1/2	1 1/4 max

ORDER # CA-2					
A	B	C	D	Tool Bit	Shank
1 11/16	1"	3/4	2 1/2	1/2–1"	13/16

ORDER # CA-2S					
A	B	C	D	Tool Bit	Shank
2"	1 1/4	3/4	2 1/2	1 1/4 max	1"

ORDER # CA-6				
A	B	C	D	Tool Bit
1 9/16	3/4	1 7/8	2 1/2	1/2–3/4

ORDER # CA-9 SPECIAL ORDER						
A	B	C	D	E	F	Tool Bit
1 1/2	3/4	2 1/2	3 3/8	1 3/4	3 7/8	3/8–3/4

ORDER # CA-13				ORDER # CA-13L	
A	B	C	D	E	Tool Bit
1 11/16	1"	3/4	2 1/2	3 3/4	1/2–1"

ORDER # CA-HA*

ORDER # CA-SS*

DA SERIES

ORDER # DA-1				
A	B	C	D	Tool Bit
2 3/16	1 1/4	1"	3 1/8	1/2–1 1/4

ORDER # DA-1S				
A	B	C	D	Tool Bit
2 5/16	1 1/2	1"	3 1/8	1 1/2 max

ORDER # DA-2					
A	B	C	D	Tool Bit	Shank
2 3/16	1 1/4	1"	3 1/8	1/2–1 1/4	1"

ORDER # DA-2S					
A	B	C	D	Tool Bit	Shank
2 7/16	1 1/2	1"	3 1/8	1 1/2 max	1 1/4

ORDER # DA-6				
A	B	C	D	Tool Bit
2 1/8	1"	2 1/8	3 1/4	1/2–1"

ORDER # DA-9 SPECIAL ORDER						
A	B	C	D	E	F	Tool Bit
2"	1"	3"	4"	2 1/8	4 7/8	1/2–1"

ORDER # DA-13				ORDER # DA-13L	
A	B	C	D	E	Tool Bit
2 1/8	1 1/4	1"	3 1/8	5"	1/2–1 1/4

ORDER # DA-HA*

ORDER # DA-SS*

EA SERIES

ORDER # EA-1				
A	B	C	D	Tool Bit
2 11/16	1 1/2	1 1/4	4"	3/4–1 1/2

ORDER # EA-2					
A	B	C	D	Tool Bit	Shank
2 11/16	1 1/2	1 1/4	4"	3/4–1 1/2	1 1/4

ORDER # EA-6				
A	B	C	D	Tool Bit
2 5/8	1 1/4	2 5/8	4"	3/4–1 1/2

ORDER # EA-13				ORDER # EA-13L	
A	B	C	D	E	Tool Bit
2 11/16	1 1/2	1 1/4	4"	6 1/2	3/4–1 1/2

ORDER # EA-HA*

ORDER # EA-SS*

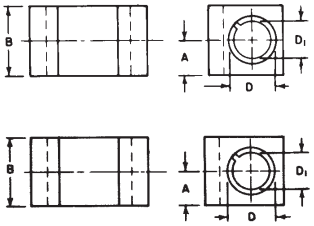
QUICK CHANGE BORING BAR TOOL HOLDERS

AXA SERIES

#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.



ORDER # AXA-4

A	B	D	D_1
3/4	1 1/2	3/4	5/8

ORDER # AXA-41

A	B	D	D_1
7/8	1 3/4	1"	3/4

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

ORDER # AXA-PINS*

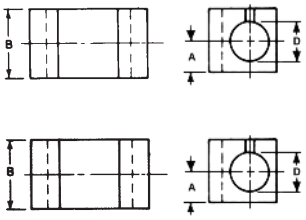
JAM SCREWS
For Holders #4* – #41* (Set of 2)

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	

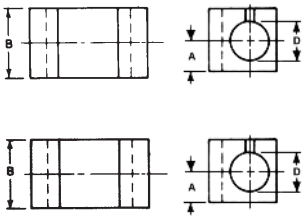
ORDER # AXA-41D

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

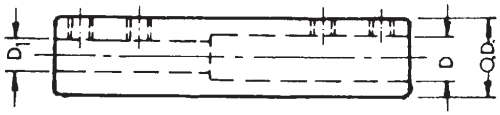
ORDER # AXA-STD*

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.

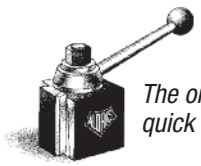


ORDERING INFORMATION	SIZES		
ORDER #	O.D.	D	D_1
RB-31*	3/4	1/2	1/4
RB-32*	3/4	3/8	3/16
RB-41*	1"	5/8	5/16
RB-42*	1"	1/2	1/4
RB-51*	1 1/4	3/4	3/8
RB-52*	1 1/4	5/8	5/16

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_1	A	B	D	D_1	A	B	D	D_1	A	B	D	D_1	A	B	D	D_1
1"	2"	1"	¾	1"	2"	1"	¾	1⅜	2¾	1¼	1"	1⅝	3¼	1½	1¼	2¼	4½	2½	2"
ORDER # BXA-41				ORDER # CXA-41				ORDER # CA-41				ORDER # DA-41							
A	B	D	D_1	A	B	D	D_1	A	B	D	D_1	A	B	D	D_1				
1"	2"	1¼	1"	1⅛	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		1⅛	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		1⅛	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.
397-407 GETTY AVENUE • P.O. BOX 1529 • CLIFTON, NJ 07015-1529
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

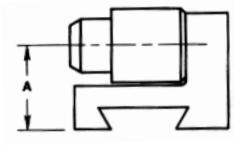
QUICK CHANGE DRILLING HOLDERS

AXA SERIES

#35

DOVETAIL CHUCK HOLDER

The uniquely designed dovetail chuck holder permits quick and accurate mounting of drills, reamers, taps, boring bars, etc., and feed by means of your lathe's carriage power drive–it eliminates tailstock mounting and tailstock drive. The Aloris chuck holder offers all of the quick-change, repeat positioning accuracy and high-rigidity features found in all Aloris precision dovetail holders. The chuck is mounted in a recessed position for minimum overhang, permitting use of the entire usable length of the tool. Available in capacities up to ¾-in. Dovetail holder supplied complete with chuck and key.



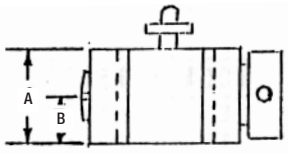
ORDER # AXA-35

A	CHUCK CAPACITY
2	0 – ½

#5C

5C COLLET HOLDER

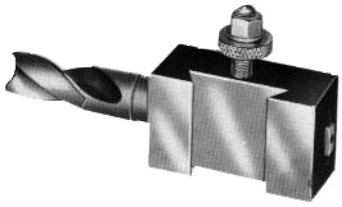
Can be used with a variety of shank tools: drills, reamers, C. bores, taps, end mills, boring bars and other tools. Collet not included.



ORDER # AXA-5C

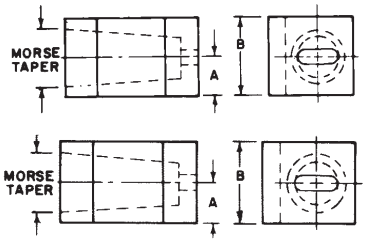
A	B	COLLET SIZE
1⅞	15/16	5C

#5, #53, #54, #55



MORSE TAPER HOLDER

Drills with carriage by using power feed instead of tail stock. Easily centered.



ORDER # AXA-5

A	B	TAPER HOLE SIZE
¾	1½	#2 M.T.

ORDER # AXA-53

A	B	TAPER HOLE SIZE
¾	1½	#3 M.T.

HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-HA*

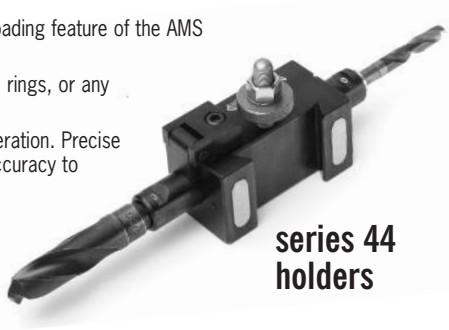
#44 BREECH-LOADING TAPER SOCKETS AND HOLDERS

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

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

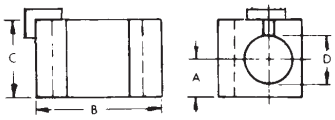
The latch does not interfere with the holder's ability to accept Aloris series BB__ boring bars, with or without keyed lock stop rings, or any round shank tools.

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



NOT FOR PISTON TYPE TOOL POST

SPECIAL ORDER # CXA-44				SPECIAL ORDER # CA-44			
A	B	C	D	A	B	C	D
1"	3¾	2"	1"	1⅛	4¼	2¼	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	15/16	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

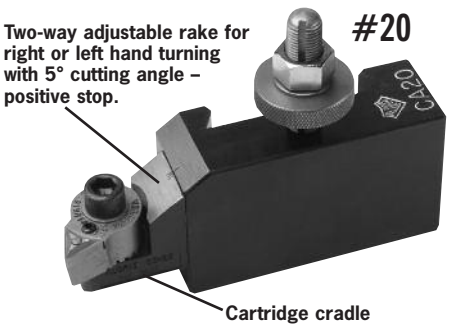
UNIVERSAL TOOL HOLDERS #20, #30, #22

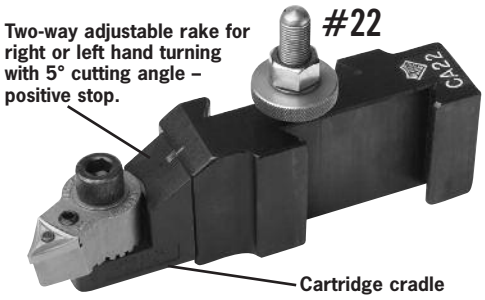
FOR RIGHT OR LEFT HAND TURNING, FACING, CHAMFERING AND BORING (#22)

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.

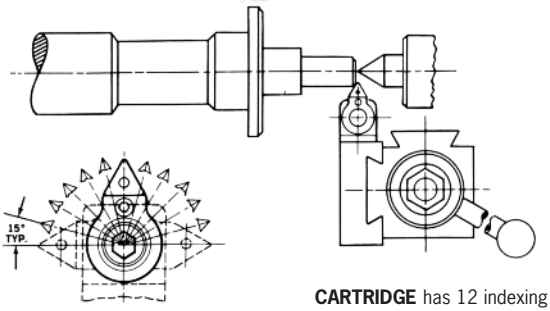
All holders assure proper cutting edge and clearance angles at all indexing points.





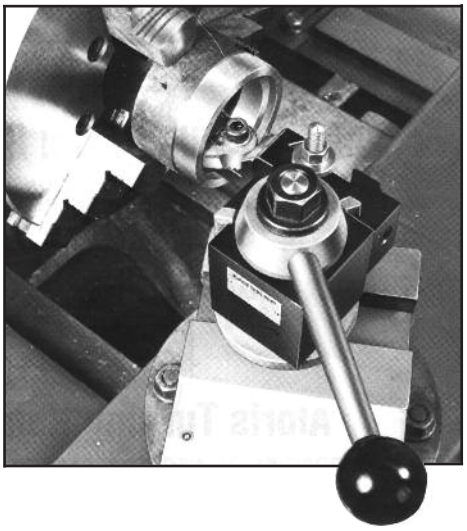
Tool Steel Cartridge adjusts every 15° for right or left hand turning, facing or chamfering. 12 positive lock positions. Exclusive positive lock with 2-way force holding insert down and tight against shoulder. Standard triangular carbide insert has 6 cutting edges.

ILLUSTRATIONS SHOW WHAT ONE SINGLE TOOL CAN ACCOMPLISH

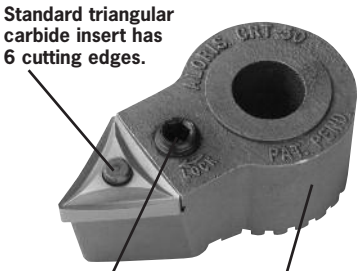


PICTORIAL DIAGRAM OF CARTRIDGE

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



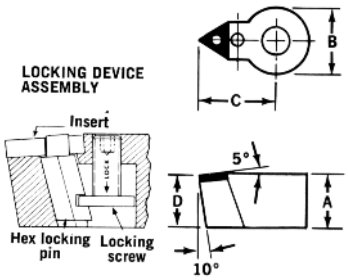
CARTRIDGE CRT-20, CRT-30, CRT-40 UNITS



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.



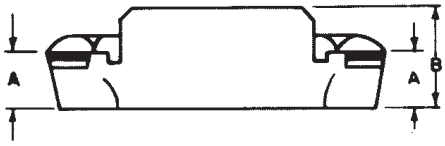
ORDERING INFORMATION FOR #20, #30, #22

	AXA SERIES	BXA SERIES	CXA SERIES	CA SERIES	DA SERIES	EA SERIES
UNIVERSAL TOOL HOLDER #20 Holder supplied as shown less insert.	ORDER # AXA-20	ORDER # BXA-20	ORDER # CXA-20	ORDER # CA-20		
	"A" DIM. = $1\frac{1}{2}$	"A" DIM. = $1\frac{3}{4}$	"A" DIM. = 2"	"A" DIM. = $2\frac{1}{2}$		
	"E" DIM. = $1\frac{1}{8}$	"E" DIM. = $1\frac{3}{16}$	"E" DIM. = $1\frac{3}{8}$	"E" DIM. = $1\frac{3}{4}$		
	REPLACEMENT PARTS					
CARTRIDGES	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*		
CRADLE	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*		
LOCK SCREW	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*		
HEX LOCKING PIN	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*		
HEIGHT ADJUSTMENT ASSEMBLY	ORDER # AXA-HA*	ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*		
UNIVERSAL TOOL HOLDER #30				ORDER # CA-30	ORDER # DA-30	ORDER # EA-30
				"A" DIM. = $2\frac{1}{2}$	"A" DIM. = $2\frac{3}{4}$	"A" DIM. = 3
				"E" DIM. = $1\frac{7}{8}$	"E" DIM. = $1\frac{15}{16}$	"E" DIM. = $2\frac{3}{16}$
	REPLACEMENT PARTS					
CARTRIDGES				ORDER # CRT-30*	ORDER # CRT-30*	ORDER # CRT-40*
LOCK SCREW				ORDER # LS-30*	ORDER # LS-30*	ORDER # LS-40*
HEX LOCKING PIN				ORDER # LP-30*	ORDER # LP-30*	ORDER # LP-40*
HEIGHT ADJUSTMENT ASSEMBLY				ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*
UNIVERSAL TURNING & BORING HOLDER #22	ORDER # AXA-22	ORDER # BXA-22	ORDER # CXA-22	ORDER # CA-22	ORDER # DA-22	ORDER # EA-22
	"A" DIM. = $1\frac{1}{2}$	"A" DIM. = $1\frac{3}{4}$	"A" DIM. = 2	"A" DIM. = $2\frac{1}{2}$	"A" DIM. = $2\frac{3}{4}$	"A" DIM. = 3
	"E" DIM. = $1\frac{1}{8}$	"E" DIM. = $1\frac{3}{16}$	"E" DIM. = $1\frac{3}{8}$	"E" DIM. = $1\frac{3}{4}$	"E" DIM. = 2	"E" DIM. = $2\frac{1}{8}$
	MIN BORE DIM. = $2\frac{1}{4}$	MIN BORE DIM. = $2\frac{1}{2}$	MIN BORE DIM. = 3	MIN BORE DIM. = $3\frac{1}{2}$	MIN BORE DIM. = $4\frac{1}{4}$	MIN BORE DIM. = 5
	MAX BORE LENGTH = $2\frac{1}{4}$	MAX BORE LENGTH = $2\frac{1}{4}$	MAX BORE LENGTH = $2\frac{1}{2}$	MAX BORE LENGTH = $2\frac{7}{8}$	MAX BORE LENGTH = $3\frac{1}{2}$	MAX BORE LENGTH = 4
	REPLACEMENT PARTS					
CARTRIDGES	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-20*	ORDER # CRT-30*	ORDER # CRT-30*	ORDER # CRT-40*
CRADLE	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-20*	ORDER # CC-30*	ORDER # CC-30*	
LOCK SCREW	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-20*	ORDER # LS-30*	ORDER # LS-30*	ORDER # LS-40*
HEX LOCKING PIN	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-20*	ORDER # LP-30*	ORDER # LP-30*	ORDER # LP-40*
HEIGHT ADJUSTMENT ASSEMBLY	ORDER # AXA-HA*	ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*

QUICK CHANGE COMBINATION CARBIDE INSERT CUTTING TOOLS WITH ADJUSTABLE CHIPBREAKER

AXA SERIES

#16

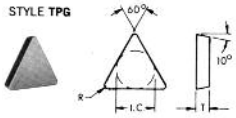


ORDER # AXA-16

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

REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER — **ORDER # 1-R* ORDER # 1-L***

REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT — **ORDER # SM-41***



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

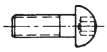
Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 – 54.

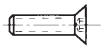
ORDER # TPG-322†

GRADE	
A2/A6	
767	

BUTTON HEAD CHIPBREAKER/CLAMP SCREW 2 REQ'D/HOLDER — **ORDER # SCR-12***



SHIM CLAMP SCREW (SET OF 5) — **ORDER # SM-41SS***

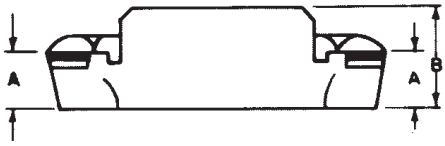


HEIGHT ADJUSTMENT ASSEMBLY — **ORDER # AXA-HA***

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.

#16N

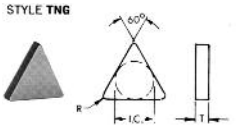


ORDER # AXA-16N

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

REPLACEMENT ADJUSTABLE CARBIDE CHIPBREAKER — **ORDER # 1-R*. ORDER # 1-L***

REPLACEMENT CARBIDE SHIM USED UNDER CARBIDE INSERT — **ORDER # SM-42***



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

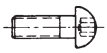
Inserts are priced individually however, they must be purchased in packages of 10.

See full selection of inserts on pages 49 – 54.

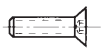
ORDER # TNG-321†

GRADE	
A2/A6	
767	

BUTTON HEAD CHIPBREAKER/CLAMP SCREW — **ORDER # SCR-12***



SHIM CLAMP SCREW (SET OF 5) — **ORDER # SM-42SS***



HEIGHT ADJUSTMENT ASSEMBLY — **ORDER # AXA-HA***

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.

†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			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE
1"	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†					**ORDER # TPG-322†**					**ORDER # TPG-432†**					**ORDER # TPG-432†**					**ORDER # TPG-432†**				
GRADE					GRADE					GRADE					GRADE					GRADE				
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6				
767			1		767					767					767					767				
ORDER # SCR-12*					**ORDER #: SCR-12***					**ORDER #: SCR-12***					**ORDER #: SCR-12***					**ORDER #: SCR-12***				
ORDER # SM-41SS*					**ORDER # SM-41SS***					**ORDER # SM-37SS***					**ORDER # SM-37SS***					**ORDER # SM-37SS***				
ORDER # BXA-HA*					**ORDER # CXA-HA***					**ORDER # CA-HA***					**ORDER # DA-HA***					**ORDER # EA-HA***				
ORDER # BXA-16N					**ORDER # CXA-16N**					**ORDER # CA-16N**					**ORDER # DA-16N**					**ORDER # EA-16N**				
A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT			A	B	TRIANGULAR INSERT		
		I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE			I.C.	THICK	RAKE
1"	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	5/8	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†					**ORDER # TNG-321†**					**ORDER # TNG-432†**					**ORDER # TNG-432†**					**ORDER # TNG-544†**				
GRADE					GRADE					GRADE					GRADE					GRADE				
A2/A6					A2/A6					A2/A6					A2/A6					A2/A6				
767					767					767					767					767				
ORDER # SCR-12*					**ORDER #: SCR-12***					**ORDER #: SCR-12***					**ORDER #: SCR-12***					**ORDER #: SCR-12***				
ORDER # SM-42SS*					**ORDER # SM-42SS***					**ORDER # SM-26SS***					**ORDER # SM-26SS***					**ORDER # SM-72SS***				
ORDER # BXA-HA*					**ORDER # CXA-HA***					**ORDER # CA-HA***					**ORDER # DA-HA***					**ORDER # EA-HA***				

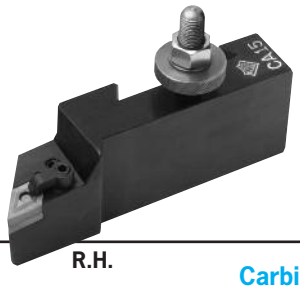
†Sold in package of 10 pcs. ††100 & up call for price.

See full selection of inserts on pages 49 – 54.

QUICK CHANGE PROFILING TOOL HOLDERS

#115 & #115L

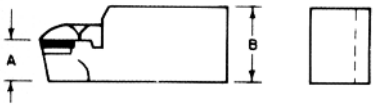
L.H.



R.H.

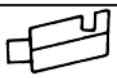
PROFILING TOOL HOLDERS

Available with right or left hand design for front or rear turning, profiling and contouring operations. Design features include: Unique, positive locking of insert is accomplished by the two-way force exerted by locking pin and the locking screw. Insert is held down and tight against the shoulders. Clamp lock insures extra rigidity of insert and holds chip-breaker, when used, securely in place. Choice of various diamond shaped inserts provides adaptation to positive or negative rake profiling. Available in Model #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
A	B	PROFILING INSERT		
		I.C.	THICK	RAKE
1"	1½	⅝	3/16–¼	POS. or NEG.

HEX LOCKING PINS		**ORDER # LP-65***
CLAMPS		**ORDER # ACK-12***
CLAMP SCREW		**ORDER # ASTC-4***
CARBIDE SHIMS (SEATS)		**ORDER # SM-307***
HEIGHT ADJUSTMENT ASSEMBLY		**ORDER # AXA-HA***

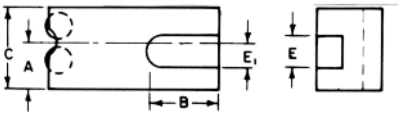
Carbide inserts listed at bottom of this page, and full selection on pages 49 – 54.

QUICK CHANGE KNURLING TOOL HOLDERS

#10

KNURLING, FACING AND TURNING HOLDER

For turning and facing as well as knurling. Supplied with a set of high speed precision ground and lapped medium diamond knurls. Easily replaceable.
Holder supplied with 2 knurls.

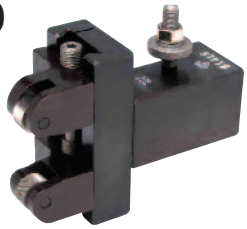


AXA SERIES

ORDER # AXA-10					
A	B	C	E	E_1	TOOL BIT
⅞	2½	1 9/16	½	⅜	3/16 – ½

HEIGHT ADJUSTMENT ASSEMBLY		**ORDER # AXA-HA***

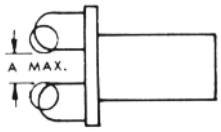
#19



ADJUSTABLE KNURLING HOLDER

...excellent knurling, with approach adjustability, is provided with the newly designed #19 knurling holder. The #19 is self-centering and is adjusted by means of a 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 availalbe with dovetail mounting (series 19) to fit Aloris tool posts. Precision ground, ¾" O.D. x ⅜" wide, high-speed medium diamond knurls are supplied unless otherwise specified.

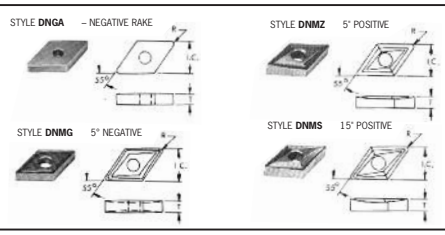


AXA SERIES

ORDER # AXA-19	
A	KNURL SIZE
2"	¾ x ¼ x ⅜

HEIGHT ADJUSTMENT ASSEMBLY		**ORDER # AXA-HA***

CARBIDE PROFILING INSERTS FOR 115 & 115L PROFILE TOOLS†



DIMENSIONS I.C.	T	R	INSERT ORDER #	GRADE A2/A6	767
⅝	3/16	1/32	DNGA-532*		
⅝	3/16	1/32	DNMG-532* DNMS-532		
⅝	¼	1/32	DNMZ-542* DNMS-542		

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

See full selection of inserts on pages 49 – 54.

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*					

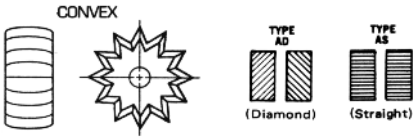
TECHNICAL DATA:
DIMENSIONS – CAPACITIES – MODELS

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_1	TOOL BIT	A	B	C	E	E_1	TOOL BIT	A	B	C	E	E_1	TOOL BIT	A	B	C	E	E_1	TOOL BIT	
1"	2 5/8	1 3/4	5/8	1/2	1/4 – 5/8	1 3/16	3 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

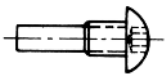
HIGH SPEED KNURLS

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

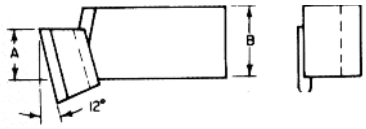
AXA SERIES

#8

THREADING HOLDER #8

This universal threading holder comes with an interchangeable high speed threading blade which has two cutting edges. You may now reverse your spindle and cut a thread without fear of hitting shoulders. Speeds your threading. Also available with carbide insert blade.

Holders supplied with blade as follows: AXA-P10, BXA-CXA-P6, CA-DA-EA-P4, or up to request.



HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-8

A	B	USED WITH
13/16	1 5/8	ANY THREADING BLADE SHOWN BELOW

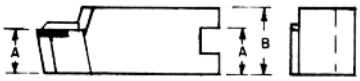
ORDER # AXA-HA*

#81

THREADING AND GROOVING TOOL HOLDER #81

Holder provides accurate threading and grooving. It is equipped with a threading insert holder (Aloris AT86) at the front – and an open slot for a grooving tool at the rear. Cutting tools are not included. Also available with high-speed blade.

Holder supplied with AT86 insert holder less threading insert. Also available with high-speed blade.



HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-81

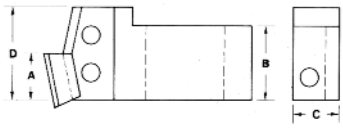
A	B	USED WITH
13/16	1 5/8	ANY THREADING BLADE SHOWN BELOW

ORDER # AXA-HA*

#88

ADJUSTABLE THREADING HOLDERS WITH H.S. BLADE & AT88 HEAD

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.



HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-88

A	B	C	D	USED WITH
1 1/8	1 5/8	1 1/2	2 1/4	ANY THREADING BLADE SHOWN BELOW

ORDER # AXA-HA*

ORDER #	AT-88

Use with any #88 series holder.

BLADES & INSERTS

HIGH SPEED THREADING BLADES – 60°

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

ORDER #	P-4	P-6	P-10
CAPACITY	4 or more T.P.I	6 or more T.P.I	10 or more T.P.I

HIGH SPEED THREADING BLADES – ACME 29°

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

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

THREADING BLADE GAUGE

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

ORDER #	GA #8

THREADING INSERT HOLDER AND INSERT – 60°

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

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

THREADING CARBIDE INSERT FOR HOLDER # AT-86

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

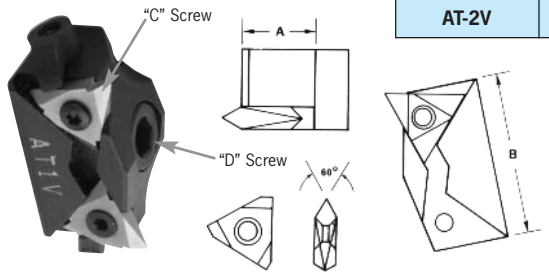
See full selection of inserts on pages 49 – 54.

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"	1¾	ANY THREADING BLADE SHOWN BELOW	1⅛	2"	ANY THREADING BLADE SHOWN BELOW	1¼	2¼	ANY THREADING BLADE SHOWN BELOW	1½	2¾	ANY THREADING BLADE SHOWN BELOW	1¾	3¼	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"	1¾	ANY THREADING BLADE SHOWN BELOW	1⅛	2"	ANY THREADING BLADE SHOWN BELOW	1¼	2¼	ANY THREADING BLADE SHOWN BELOW	1½	2¾	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	A	B	C	D	USED WITH					
1"	1¾	1½	2¼	ANY THREADING BLADE SHOWN BELOW	1⅛	2"	1⅝	2¼	ANY THREADING BLADE SHOWN BELOW	1⅛	2¼	1⅝	2¼	ANY THREADING BLADE SHOWN BELOW	1¼	2¾	2"	2⅝	ANY THREADING BLADE SHOWN BELOW					
ORDER # BXA-HA*			ORDER # CXA-HA*			ORDER # CA-HA*			ORDER # DA-HA*					

INSERT CARTRIDGES

STAND UP INSERT CARTRIDGE

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



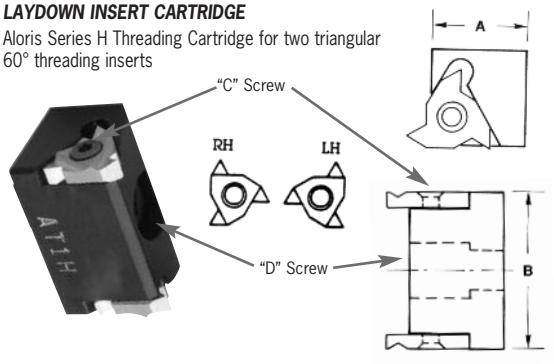
CARTRIDGE ORDER #	"A" Dim.	"B" Dim.	"C" Replacement Screw #	"D" Replacement Screw #	CLAMP #	CLAMP SCREW #	INSERT IC	KEY #
AT-1V	3/4 sq.	1 5/16	AGTS-1*	5/16 – 18 x ¾ shcs	ACK-19*	ASTC-9*	3/8	T-10*
AT-2V	7/8 sq.	1⅝	AGTS-2*	5/16 – 18 x ¾ shcs	ACK-19*	ASTC-9*	1/2	T-20*

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.	1¼	ASA-3T*	5/16 – 24 x ¾ lg shcs	3/8	T-10*
AT-2H	7/8 sq.	1 7/16	ASA-4T*	5/16 – 24 x ¾ 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*		

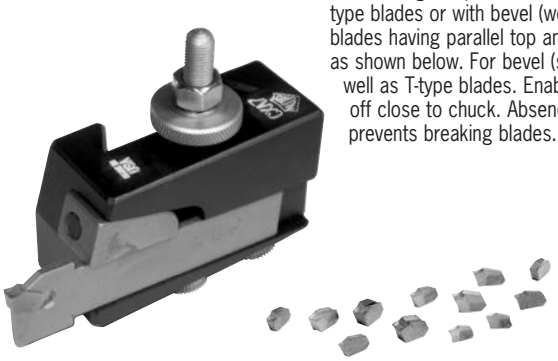
†Sold in package of 10 pcs. ††100 & up call for price.

See full selection of inserts on pages 49 – 54.

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

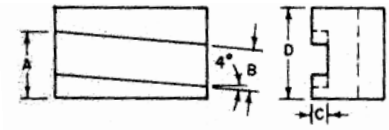
AXA SERIES

#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.



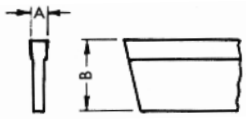
ORDER # AXA-7

A	B	C	D	BLADE HEIGHT
13/16	1/2	3/16	1 1/2	1/2

ALORIS WEDGE GRIP CARBIDE INSERT BLADES

ORDER # SGIH 19-3C-A7

PARTING BLADES



ORDER # P-2*

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

WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7

ORDER # WSA-1*

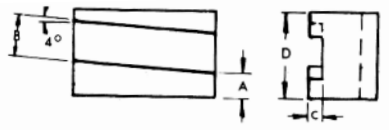
HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-HA*

#7R

UNIVERSAL PARTING BLADE TOOL HOLDER – REVERSIBLE

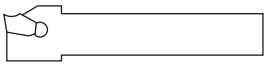
Has the same features as #7 with the advantage of rear cut-off use.



ORDER # AXA-7R

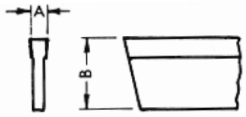
A	B	C	D	BLADE HEIGHT
11/16	1/2	3/16	1 1/2	1/2

ALORIS WEDGE GRIP CARBIDE INSERT BLADES



ORDER # SGIH 19-3C-A7

PARTING BLADES



ORDER # P-2*

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

WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7

ORDER # WSA-1*

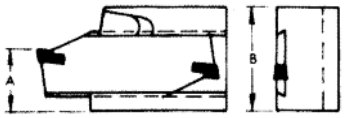
HEIGHT ADJUSTMENT ASSEMBLY

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.



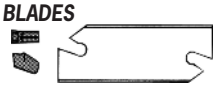
ORDER # AXA-71

A	B	USED WITH BLADE WIDTHS
15/16	1 13/16	1/8, 3/16 or 1/4

REVERSIBLE BLADES WITH BRAZED-IN CARBIDE TIPS

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

WEDGE GRIP THROWAWAY INSERT BLADES



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

EXTRACTOR
(For self-locking carbide insert removal)

ORDER # ESG-1*

WEDGE AND LOCK SCREW ASSEMBLY FOR HOLDERS #7

ORDER # WSA-6*

HEIGHT ADJUSTMENT ASSEMBLY

ORDER # AXA-HA*

Refer to Page 24 for Aloris GT style wedge lock carbide cut-off inserts.
See full selection of inserts on pages 49 – 54.

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: 1" / B: 11/16 / C: 3/16 / D: 1 3/4 / BLADE HEIGHT: 11/16	A: 1 3/16 / B: 3/4 / C: 3/16 / D: 2" / BLADE HEIGHT: 3/4	A: 1 7/16 / B: 7/8 / C: 1/4 / D: 2 1/2 / BLADE HEIGHT: 7/8	A: 1 3/4 / B: 1 1/8 / C: 1/4 / D: 2 3/4 / BLADE HEIGHT: 1 1/8	A: 1 7/8 / B: 1 1/8 / C: 1/4 / D: 3" / BLADE HEIGHT: 1 1/8
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": 1/8 HEIGHT "B": 11/16 / WIDTH "A": 5/32 HEIGHT "B": 11/16	WIDTH "A": 1/8 / HEIGHT "B": 3/4	WIDTH "A": 3/16 / HEIGHT "B": 7/8	WIDTH "A": 3/16 / HEIGHT "B": 1 1/8	WIDTH "A": 3/16 / HEIGHT "B": 1 1/8
ORDER # WSA-1*	ORDER # WSA-2*	ORDER # WSA-3*	ORDER # WSA-4*	ORDER # WSA-5*
ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*
ORDER # BXA-7R	ORDER # CXA-7R	ORDER # CA-7R	ORDER # DA-7R	ORDER # EA-7R
A: 3/4 / B: 11/16 / C: 3/16 / D: 1 3/4 / BLADE HEIGHT: 11/16	A: 1" / B: 1 1/8 / C: 13/16 / D: 2" / BLADE HEIGHT: 3/4	A: 1 1/16 / B: 7/8 / C: 1/4 / D: 2 1/2 / BLADE HEIGHT: 7/8	A: 1" / B: 1 1/8 / C: 1/4 / D: 2 3/4 / BLADE HEIGHT: 1 1/8	A: 1" / B: 1 1/8 / C: 1/4 / D: 3" / BLADE HEIGHT: 1 1/8
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": 1/8 HEIGHT "B": 11/16 / WIDTH "A": 5/32 HEIGHT "B": 11/16	WIDTH "A": 1/8 / HEIGHT "B": 3/4	WIDTH "A": 3/16 / HEIGHT "B": 7/8	WIDTH "A": 3/16 / HEIGHT "B": 1 1/8	WIDTH "A": 3/16 / HEIGHT "B": 1 1/8
ORDER # WSA-1*	ORDER # WSA-2*	ORDER # WSA-3*	ORDER # WSA-4*	ORDER # WSA-5*
ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*
ORDER # BXA-71	ORDER # CXA-71	CA-71 (2") / CA71-1 (1 1/2")	ORDER # DA-71	ORDER # EA-71
A: 15/16 / B: 2" / USED WITH BLADE WIDTHS: 1/8, 3/16 or 1/4	A: 1 15/16 / B: 2 3/8 / USED WITH BLADE WIDTHS: 1/8, 3/16 or 1/4	A: 1 1/8 / B: 3 1/4 / USED WITH BLADE WIDTH: 3/16, 1/4 / A: 1 5/16 / B: 2 1/2 / 71-125-1BSL 1/4 $46.00; 71-187-1BSL 7/16 $51.75; 71-250-1BSL 1/2 $55.20	A: 2" / B: 3 1/4 / USED WITH BLADE WIDTHS: 3/16 or 1/4	A: 2 1/16 / B: 3 3/8 / USED WITH BLADE WIDTHS: 3/16 or 1/4
71-125-1* / 71-187-1* / 71-250-1*	71-125-1* / 71-187-1* / 71-250-1*	71-187-2* / 71-250-2*	71-187-2* / 71-250-2*	71-187-2* / 71-250-2*
.120 x 1.50 / .187 x 1.50 / .250 x 1.50	.120 x 1.50 / .187 x 1.50 / .250 x 1.50	.187 x 2.00 / .250 x 2.00	.187 x 2.00 / .250 x 2.00	.187 x 2.00 / .250 x 2.00
71-125-1BSL* / 71-187-1BSL* / 71-250-1BSL*	71-125-1BSL* / 71-187-1BSL* / 71-250-1BSL*	71-187-2BSL* / 71-250-2BSL*	71-187-2BSL* / 71-250-2BSL*	71-187-2BSL* / 71-250-2BSL*
.120 x 1.50 / .187 x 1.50 / .250 x 1.50	.120 x 1.50 / .187 x 1.50 / .250 x 1.50	.187 x 2.00 / .250 x 2.00	.187 x 2.00 / .250 x 2.00	.187 x 2.00 / .250 x 2.00
ORDER # ESG-1*	ORDER # ESG-1*	ORDER # ESG-1*	ORDER # ESG-1*	ORDER # ESG-1*
ORDER # WSA-7*	ORDER # WSA-8*	ORDER # WSA-9* / ORDER # WSA-8*	ORDER # WSA-10*	ORDER # WSA-11*
ORDER # BXA-HA*	ORDER # CXA-HA*	ORDER # CA-HA*	ORDER # DA-HA*	ORDER # EA-HA*