

# J-SERIES

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Tungaloy Report No. 345S1-G

## New modular head turning toolholder system for swiss machines



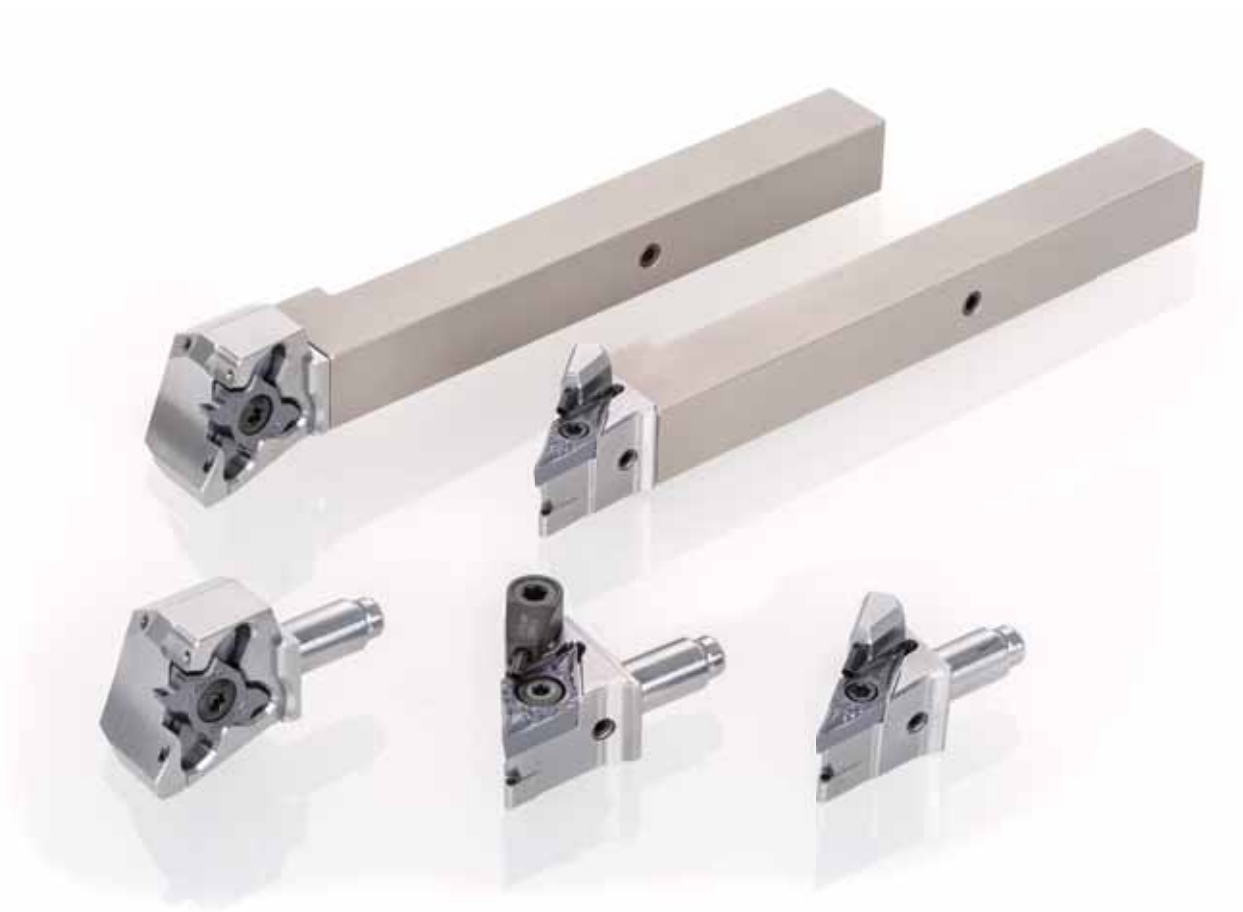


ACCELERATED MACHINING



TurnLine

**J-SERIES**  
TUNGALOY

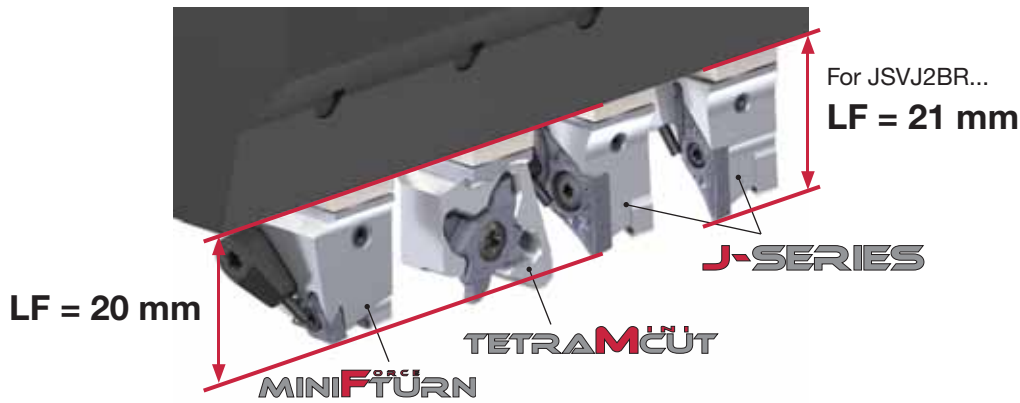


Significantly reduces machine downtime for changing tools and setups

# Modular style Swiss turning tool system with maximum flexibility and precision repeatability

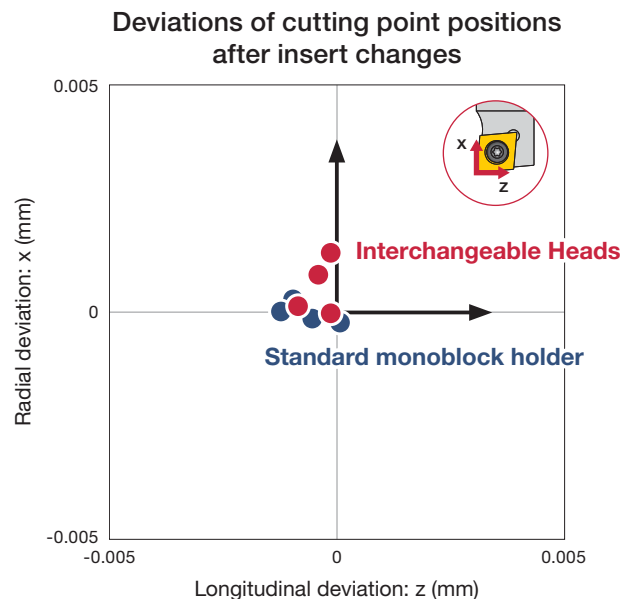
## Features

The heads are all designed with functional length (LF) to provide secure insert edge positions for good repeatability



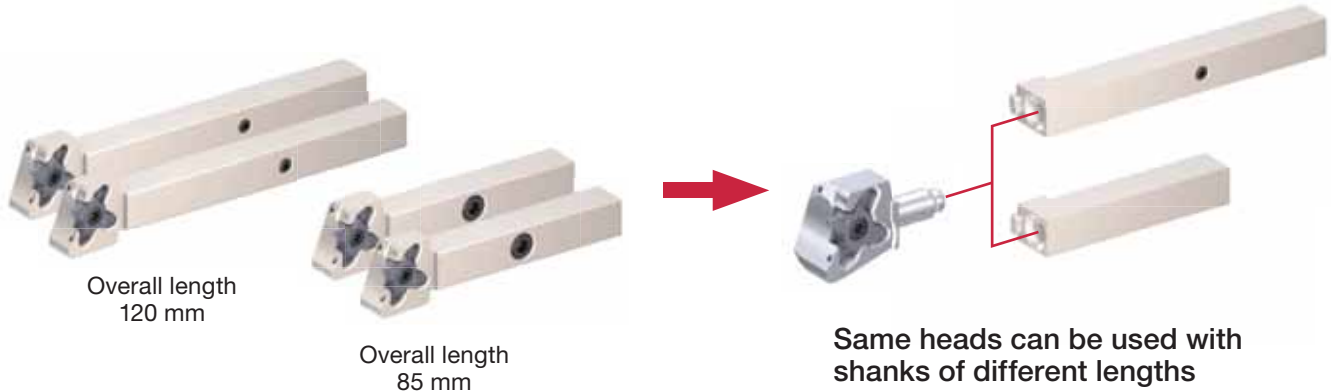
## High repeatability equivalent to mono-block tools

J-series Interchangeable Heads provides the cutting edge point position with high repeatability accuracy of 1  $\mu\text{m}$  or less for the x and z axis — which is the same high accuracy that monoblock turning holders can provide.



## Shank size flexibility

Applicable for many types of machines, due to the large variety of shank lengths. The same coupling shape allows shared heads to all types of shanks.

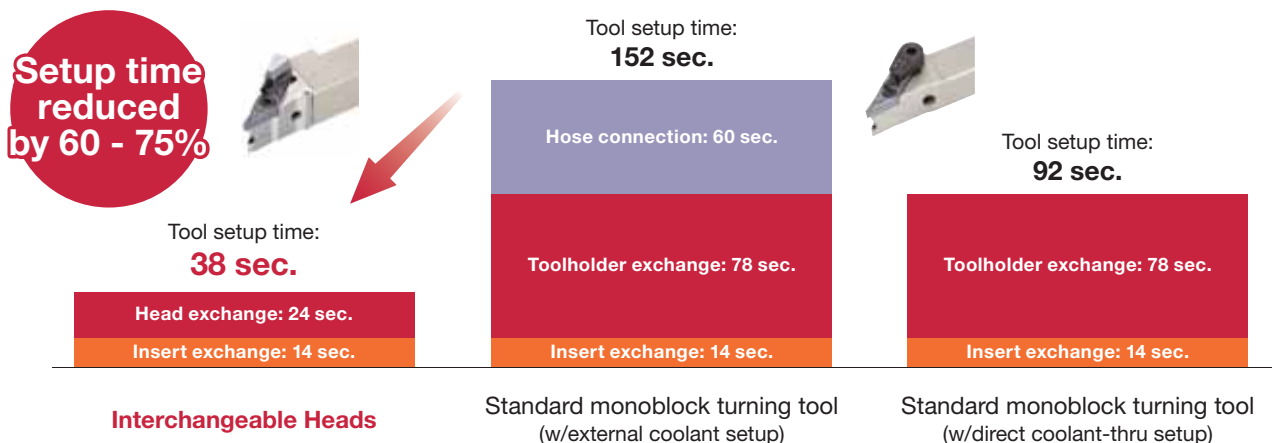


## Unique coupling design

Simply loosen the clamping screw for easy tool exchanges. Unique coupling design allows extremely high repeatability.



## Modular design simplifies tool change and set up, significantly reducing machine downtime












## Interchangeable Heads Lineup

Shanks (size: 12 mm x 12 mm)

Overall length* (mm)	Without coolant	With coolant	Page
85	✓	✓	15
120	✓	✓	15

\*With the head attached

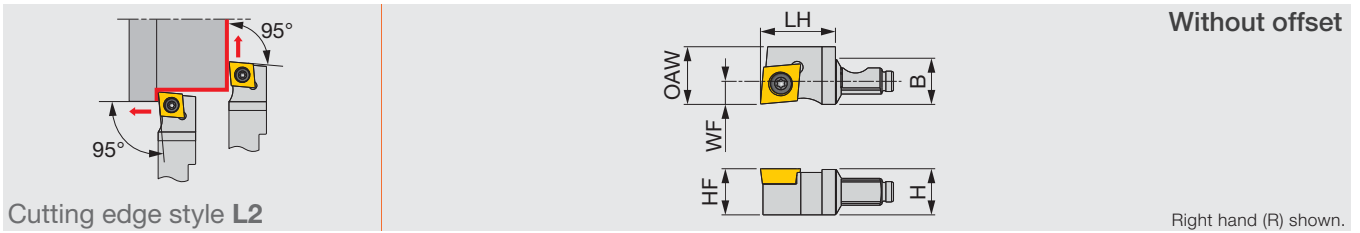
## Heads

Tool series	Insert shape	Without coolant	With coolant	Page
<b>J-SERIES</b>	<b>CC**09T3...</b> 	✓	✓	7
	<b>DC**0702...</b> 	✓	✓	8
	<b>DC**11T3...</b> 	✓	✓	8
	<b>VB**1103...</b> 	✓	✓	9
	<b>J10ER...</b> 	✓	-	9
	<b>MINIFURN</b>	<b>WXGU0403**L...</b> 	✓	✓
<b>DXGU0703**L...</b> 		✓	✓	11
<b>VXGU09T2**L...</b> 		✓	✓	12
<b>TETRAMCUT</b>	<b>TC*18R/L...</b> 	✓	✓	13, 14

## HEADS

### QC12-JSCL2CR

Screw-on head with 95° approach angle, for positive 80° rhombic inserts



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSCL2CR09	12	12	19.5	12	6	15	0.2	CC**09T3...	1.2

\*Torque: Recommended clamping torque (N-m)

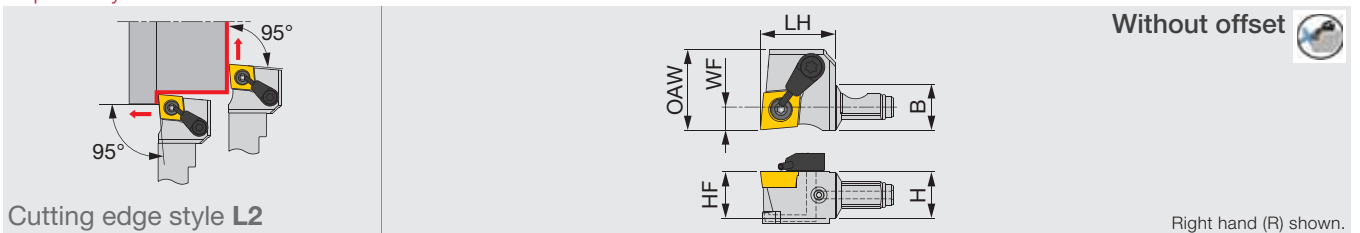
\*\*RE: Standard corner radius

#### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSCL2CR09	CSTB-4SD	T-8F

### QC12-JSCL2CR-CHP

Screw-on head with 95° approach angle, for positive 80° rhombic inserts, with high pressure coolant capability



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSCL2CR09-CHP	12	12	19.5	12	6	21	0.2	CC**09T3...	1.2

Through-coolant head

\*Torque: Recommended clamping torque (N-m)

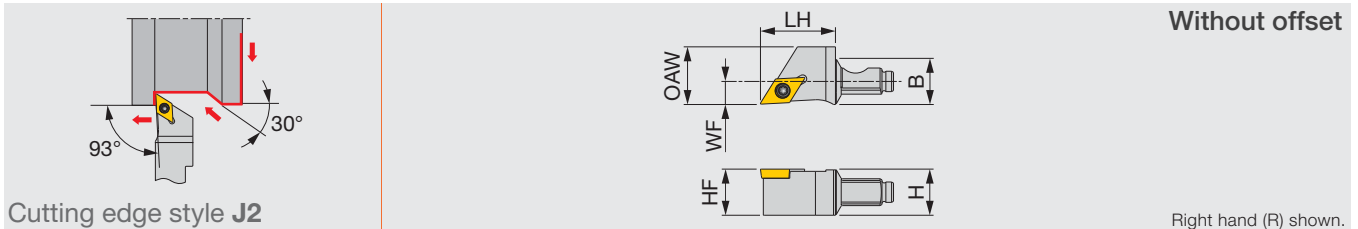
\*\*RE: Standard corner radius

#### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	O-ring
QC12-JSCL2CR09-CHP	CSTB-4SD	S-CU-CHP	T-8F	ORSS-0454.5X1.0NBR70

## QC12-JSDJ2CR

Screw-on head with 93° approach angle, for positive 55° rhombic inserts



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSDJ2CR07	12	12	19.5	12	6	15	0.2	DC**0702...	1.2
QC12-JSDJ2CR11	12	12	19.5	12	6	15	0.2	DC**11T3...	1.2

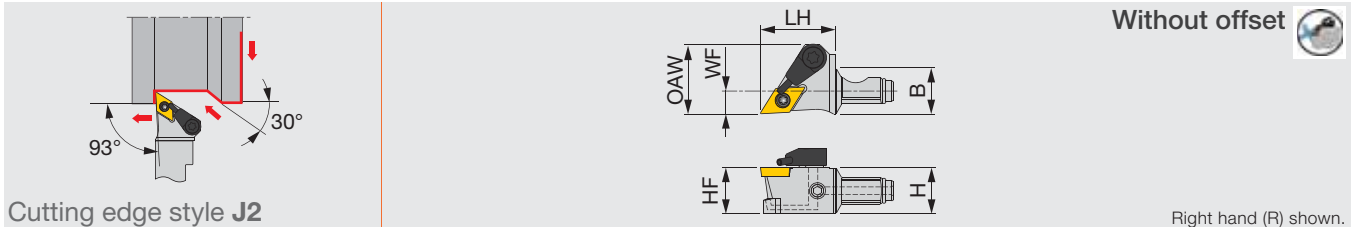
\*Torque: Recommended clamping torque (N·m)  
 \*\*RE: Standard corner radius

### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSDJ2CR07	CSTB-2.5	T-8F
QC12-JSDJ2CR11	CSTB-4SD	T-8F

## QC12-JSDJ2CR-CHP

Screw-on head with 93° approach angle, for positive 55° rhombic inserts, with high pressure coolant capability



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSDJ2CR07-CHP	12	12	19.5	12	6	18	0.2	DC**0702...	1.2
QC12-JSDJ2CR11-CHP	12	12	19.5	12	6	21	0.2	DC**11T3...	1.2

Through-coolant head  
 \*Torque: Recommended clamping torque (N·m)  
 \*\*RE: Standard corner radius

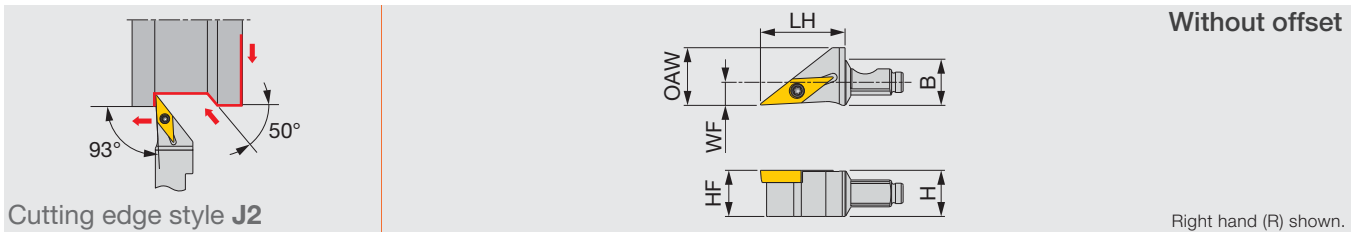
### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	O-ring
QC12-JSDJ2CR07-CHP	CSTB-2.5	S-CU-CHP	T-8F	ORSS-0454.5X1.0NBR70
QC12-JSDJ2CR11-CHP	CSTB-4SD	S-CU-CHP	T-8F	ORSS-0454.5X1.0NBR70



## QC12-JSVJ2BR

Screw-on head with 93° approach angle, for positive 35° rhombic inserts



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSVJ2BR11	12	12	22	12	6	15	0.2	VB**1103...	1.2

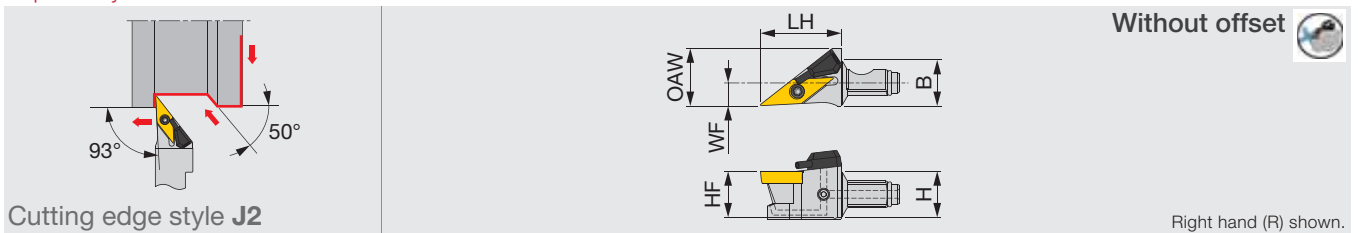
\*Torque: Recommended clamping torque (N-m) \*\*RE: Standard corner radius

### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSVJ2BR11	CSTB-2.5	T-8F

## QC12-JSVJ2BR-CHP

Screw-on head with 93° approach angle, for positive 35° rhombic inserts, with high pressure coolant capability



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSVJ2BR11-CHP	12	12	21	12	6	15	0.2	VB**1103...	1.2

Through-coolant head

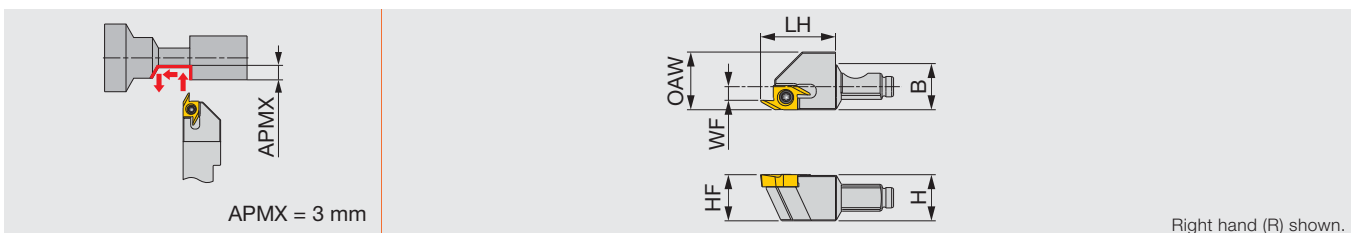
\*Torque: Recommended clamping torque (N-m) \*\*RE: Standard corner radius

### SPARE PARTS

Designation	Clamping screw	Wrench 1	O-ring	Coolant nozzle	Screw	Wrench 2
QC12-JSVJ2BR11-CHP	CSTB-2.5	T-8F	ORSS-0454.5X1.0NBR70	NZ-1.10-7-CHP	SSHM4-4-TB	P-2

## QC12-JSEGR

Screw-on head for back turning



Designation	H	B	LH	HF	WF	OAW	Insert	Torque*
QC12-JSEGR10	12	12	19.5	12	3.5	15	J10ER...	1.2

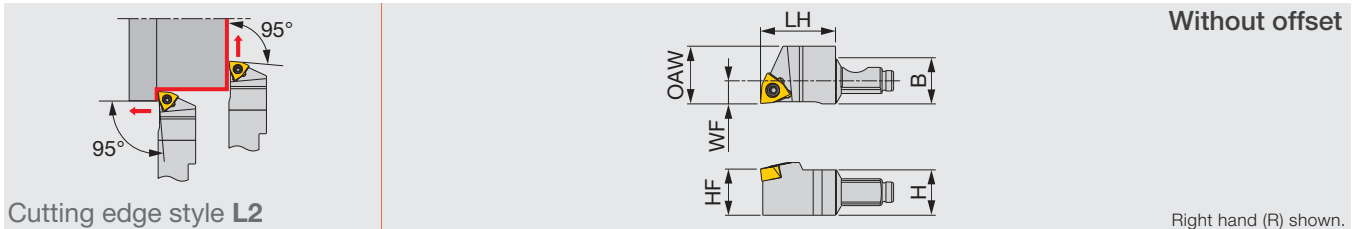
\*Torque: Recommended clamping torque (N-m)

### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSEGR10	CSTB-2.5	T-8F

### QC12-JSWL2XR

Screw-on head with 95° approach angle, for WXGU inserts



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSWL2XR04	12	12	19.5	12	6	15	0.2	WXGU0403**L...	0.9

Use right-hand toolholders (R) with left-hand inserts (L).

\*Torque: Recommended clamping torque (N·m)

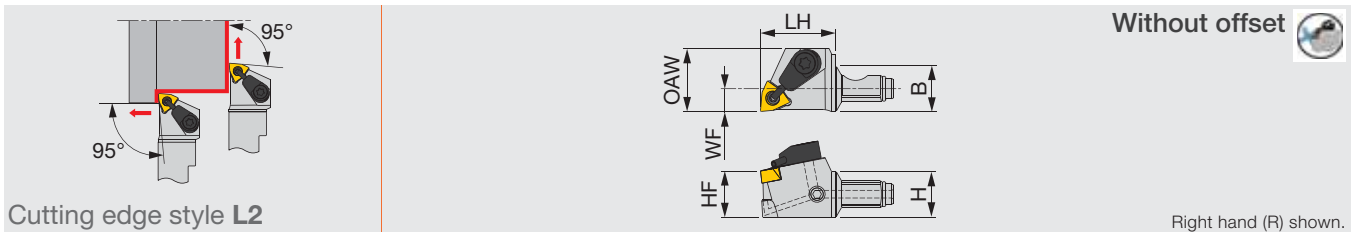
\*\*RE: Standard corner radius

#### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSWL2XR04	SR34-514	T-7F

### QC12-JSWL2XR-CHP

Screw-on head with 95° approach angle, for WXGU inserts, with high pressure coolant capability



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSWL2XR04-CHP	12	12	19.5	12	6	16.5	0.2	WXGU0403**L...	0.9

Use right-hand toolholders (R) with left-hand inserts (L).

Through-coolant head

\*Torque: Recommended clamping torque (N·m)

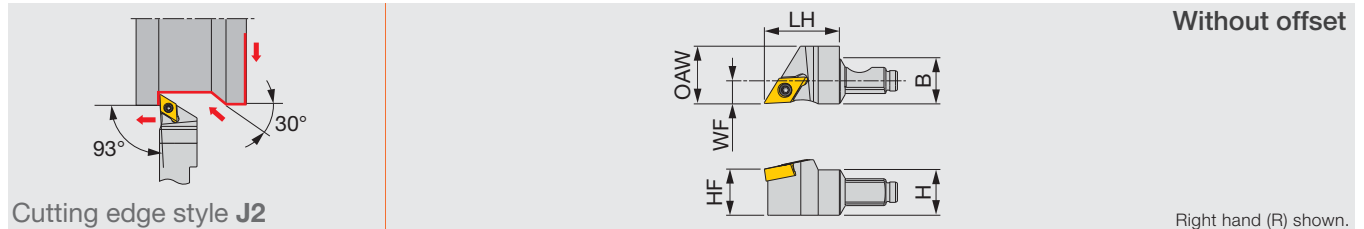
\*\*RE: Standard corner radius

#### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	O-ring
QC12-JSWL2XR04-CHP	SR34-514	S-CU-CHP	T-7F	ORSS-0454.5X1.0NBR70

## QC12-JSDJ2XR

Screw-on head with 93° approach angle, for DXGU inserts



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSDJ2XR07	12	12	19.5	12	6	15	0.2	DXGU0703**L...	0.9

Use right-hand toolholders (R) with left-hand inserts (L).

\*Torque: Recommended clamping torque (N-m)

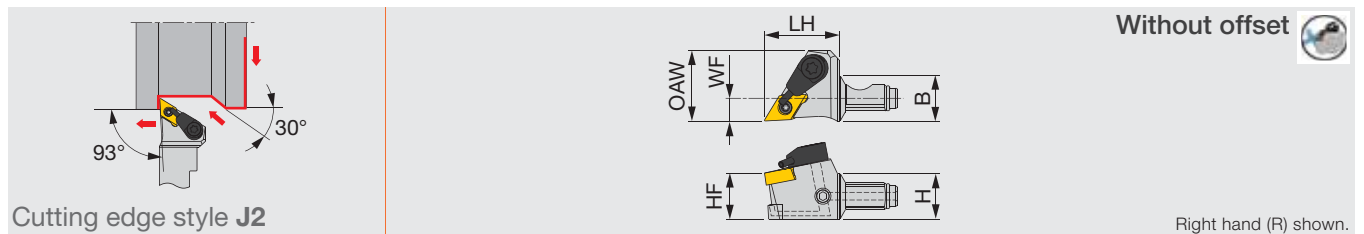
\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSDJ2XR07	SR34-514	T-7F

## QC12-JSDJ2XR-CHP

Screw-on head with 93° approach angle, for DXGU inserts, with high pressure coolant capability



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSDJ2XR07-CHP	12	12	19.5	12	6	18.4	0.2	DXGU0703**L...	0.9

Use right-hand toolholders (R) with left-hand inserts (L).

Through-coolant head

\*Torque: Recommended clamping torque (N-m)

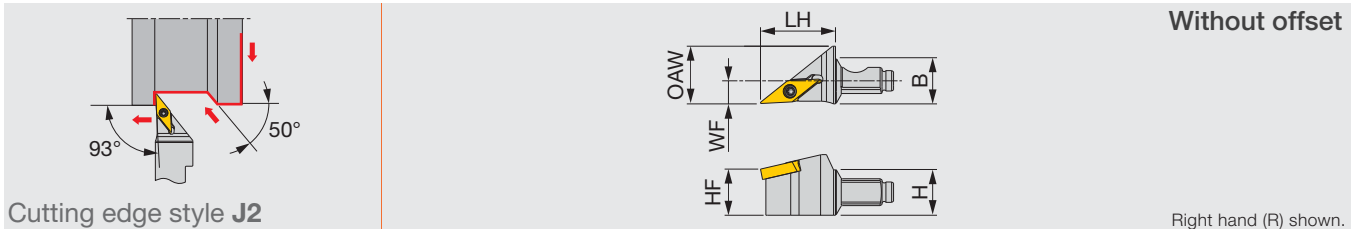
\*\*RE: Standard corner radius

### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	O-ring
QC12-JSDJ2XR07-CHP	SR34-514	S-CU-CHP	T-7F	ORSS-0454.5X1.0NBR70

### QC12-JSVJ2XR

Screw-on head with 93° approach angle, for VXGU inserts



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSVJ2XR09	12	12	19.5	12	6	15	0.2	VXGU09T2**L...	0.9

Use right-hand toolholders (R) with left-hand inserts (L).

\*Torque: Recommended clamping torque (N-m)

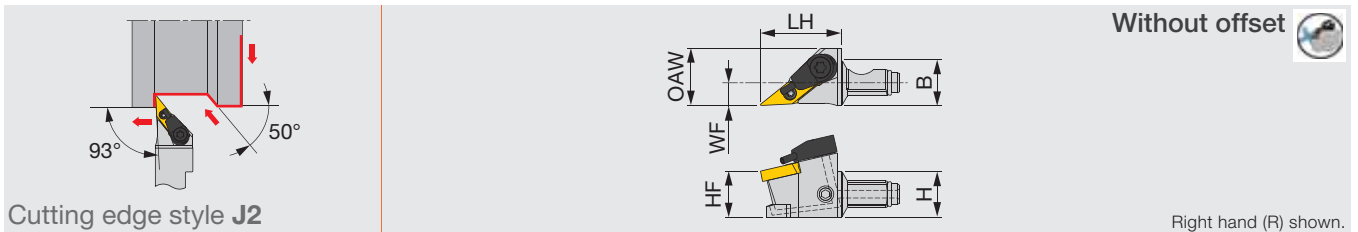
\*\*RE: Standard corner radius

#### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-JSVJ2XR09	SR34-508	T-7F

### QC12-JSVJ2XR-CHP

Screw-on head with 93° approach angle, for VXGU inserts, with high pressure coolant capability



Designation	H	B	LH	HF	WF	OAW	RE**	Insert	Torque*
QC12-JSVJ2XR09-CHP	12	12	21	12	6	15	0.2	VXGU09T2**L...	0.9

Use right-hand toolholders (R) with left-hand inserts (L).

Through-coolant head

\*Torque: Recommended clamping torque (N-m)

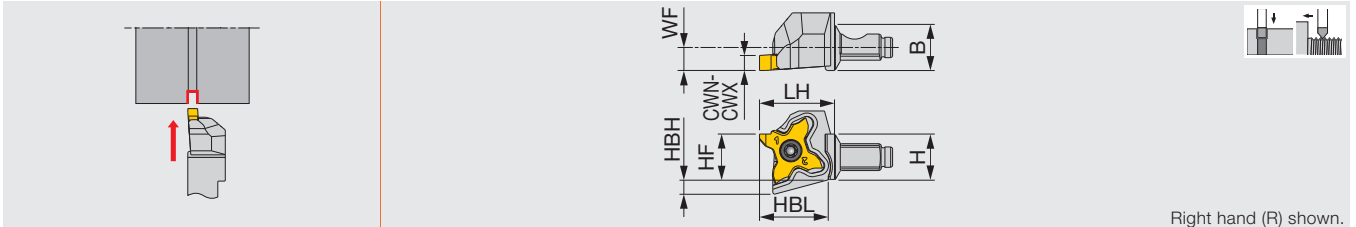
\*\*RE: Standard corner radius

#### SPARE PARTS

Designation	Clamping screw	Coolant unit	Wrench	O-ring
QC12-JSVJ2XR09-CHP	SR34-508	S-CU-CHP	T-7F	ORSS-0454.5X1.0NBR70

### QC12-STCR

External grooving and threading head



Right hand (R) shown.

Designation	CWN	CWX	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCR18	0.33	3	12	12	19.5	12	3.9	17.9	6	TC*18R...	1.2

The right hand insert (R) is used for the right hand toolholder (R).

\*Torque: Recommended clamping torque (N-m)

#### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-STCR18	CSTC-4L100DL	T-1008/5

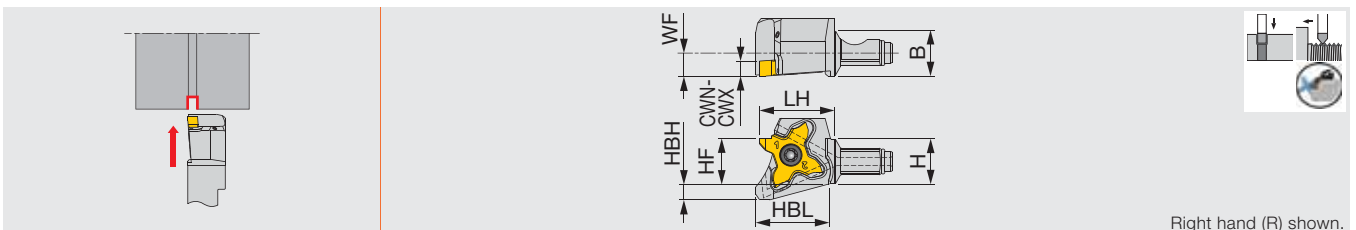
Right-hand insert



TC\*18R...

### QC12-STCR-CHP

External grooving and threading head, with high pressure coolant capability



Right hand (R) shown.

Designation	CWN	CWX	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCR18-CHP	0.33	3	12	12	19.5	12	4.2	19.3	6	TC*18R...	1.2

The right hand insert (R) is used for the right hand toolholder (R).

Through-coolant head

\*Torque: Recommended clamping torque (N-m)

#### SPARE PARTS

Designation	Clamping screw	Wrench	O-ring
QC12-STCR18-CHP	CSTC-4L100DL	T-1008/5	ORSS-0454.5X1.0NBR70

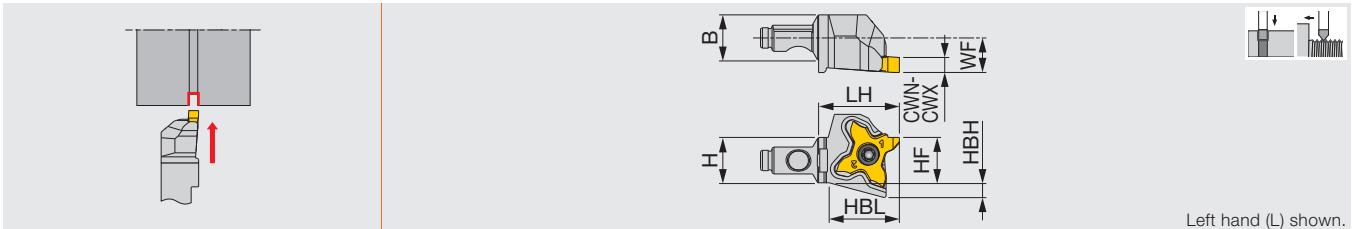
Right-hand insert



TC\*18R...

### QC12-STCL

External grooving and threading head



Designation	CWN	CWX	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCL18	0.33	3	12	12	21	12	3.9	18.3	9	TC*18L...	1.2

The left hand insert (L) is used for the left hand toolholder (L).  
\*Torque: Recommended clamping torque (N-m)

#### SPARE PARTS

Designation	Clamping screw	Wrench
QC12-STCL18	CSTC-4L100DR	T-1008/5

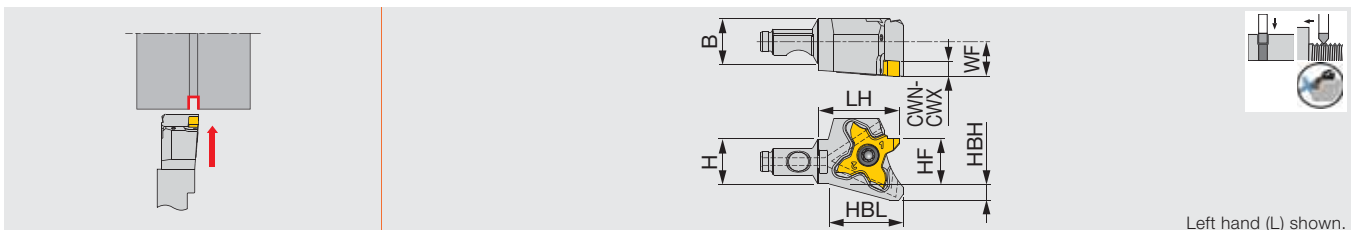
Left-hand insert



TC\*18L...

### QC12-STCL-CHP

External grooving and threading head, with high pressure coolant capability



Designation	CWN	CWX	H	B	LH	HF	HBH	HBL	WF	Insert	Torque*
QC12-STCL18-CHP	0.33	3	12	12	21	12	4.2	19.3	9	TC*18L...	1.2

The left hand insert (L) is used for the left hand toolholder (L).  
Through-coolant head  
\*Torque: Recommended clamping torque (N-m)

#### SPARE PARTS

Designation	Clamping screw	Wrench	O-ring
QC12-STCL18-CHP	CSTC-4L100DR	T-1008/5	ORSS-0454.5X1.0NBR70

Left-hand insert

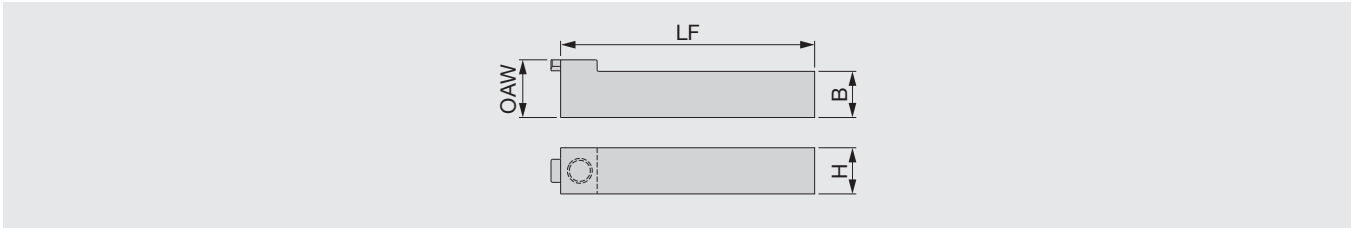


TC\*18L...

## SHANKS

### QC-1212

Shank for Interchangeable Heads



Designation	H	B	LF	OAW	Torque*
QC-1212F	12	12	65	15	4
QC-1212X	12	12	100	15	4

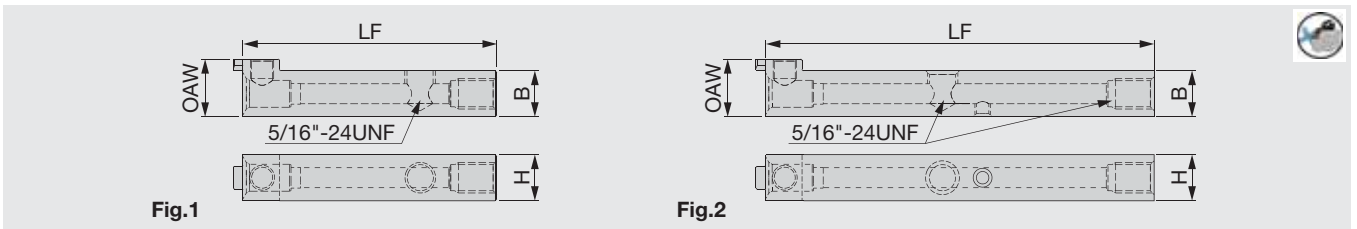
\*Torque: Recommended clamping torque (N-m)

#### SPARE PARTS

Designation	Clamping screw	Wrench
QC-1212*	SRM6X0.5-26977	P-3

### QC-1212-CHP

Shank for Interchangeable Heads, with high pressure coolant capability



Designation	H	B	LF	OAW	Torque*	Fig.
QC-1212F-CHP	12	12	65	15	4	1
QC-1212X-CHP <sup>(1)</sup>	12	12	100	15	4	2

(1) Compatible to the direct internal coolant supply system without the use of external coolant hose.

\*Torque: Recommended clamping torque (N-m)

#### SPARE PARTS

Designation	Clamping screw	Wrench	Coolant plug	Wrench	DirectJet plug	Wrench
QC-1212F-CHP	SRM6X0.5-26977	P-3	SR5/16UNFTL360	P-4	-	-
QC-1212X-CHP	SRM6X0.5-26977	P-3	SR5/16UNFTL360	P-4	SSHM4-6-TB	P-2

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