



Exchangeable head turning tool system for Swiss machines

# MODUM<sup>INI</sup>TURN

Tungaloy Report No. 541S4-G

## New QC10 series with 10 mm square shanks



## Lineup

### Modular heads

#### For external turning

| Application   | Insert shape                                                                                            | Insert Designation | Approach angle | Page     |
|---------------|---------------------------------------------------------------------------------------------------------|--------------------|----------------|----------|
| Front turning | <b>J-SERIES</b><br>    | <b>CC**09T3...</b> | 95°            | <b>4</b> |
|               | <b>MINIFTURN</b><br>   | <b>WXGU0403...</b> | 95°            | <b>4</b> |
|               | <b>J-SERIES</b><br>    | <b>DC**0702...</b> | 93°            | <b>5</b> |
|               | <b>MINIFTURN</b><br>  | <b>DX*U0703...</b> | 93°            | <b>5</b> |
|               | <b>MINIFTURN</b><br> | <b>DX*U0703...</b> | 62.5°          | <b>6</b> |
|               | <b>MINIFTURN</b><br> | <b>VXGU09T2...</b> | 93°            | <b>6</b> |
|               | <b>MINIFTURN</b><br> | <b>VXGU09T2...</b> | 72.5°          | <b>7</b> |
| Back turning  | <b>J-SERIES</b><br>  | <b>J10ER...</b>    | 60°            | <b>7</b> |

#### For parting

| Application          | Insert shape                                                                                           | Insert Designation | Groove width<br>CW (mm) | Page     |
|----------------------|--------------------------------------------------------------------------------------------------------|--------------------|-------------------------|----------|
| Parting and grooving | <b>TUNG CUT</b><br> | <b>DGS...</b>      | 1.2 - 1.4               | <b>8</b> |

## For grooving and threading

| Application | Insert shape                                                                      | Insert Designation | Groove width<br>CW (mm) | Thread pitch<br>range<br>(mm) | Page     |
|-------------|-----------------------------------------------------------------------------------|--------------------|-------------------------|-------------------------------|----------|
| Grooving    |  | <b>VGP10...</b>    | 0.5 - 1                 | -                             | <b>8</b> |
| Threading   |  | <b>VGT10...</b>    | -                       | 0.4 - 2                       | <b>8</b> |

## For threading

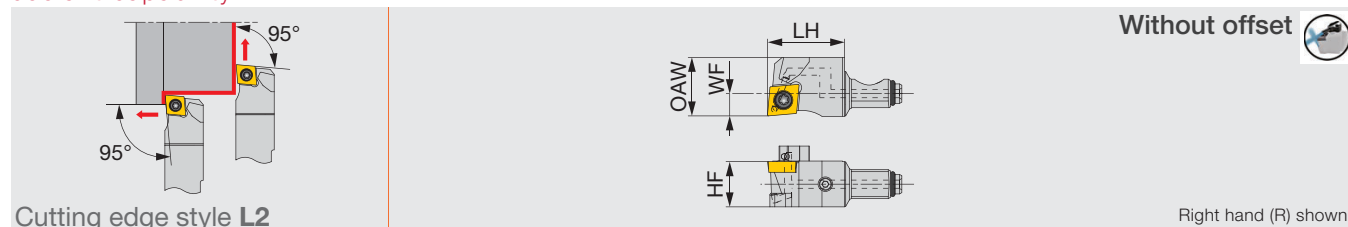
| Application | Insert shape                                                                        | Insert Designation | Thread pitch range<br>(mm) | Page     |
|-------------|-------------------------------------------------------------------------------------|--------------------|----------------------------|----------|
| Threading   |  | <b>11ER...</b>     | 0.35 - 1.5                 | <b>9</b> |

## MODULAR HEADS

### QC10-JSCL2CR-CHP

**J-SERIES**

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



| Designation        | LH | HF | WF | OAW | RE** | Insert      | Torque* | Shank      |
|--------------------|----|----|----|-----|------|-------------|---------|------------|
| QC10-JSCL2CR06-CHP | 17 | 10 | 5  | 13  | 0.2  | CC**0602... | 1.2     | QC-1012... |

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

RE\*\*: Standard corner radius

Assembled dimensions with shank are shown on page 9.

Related Items



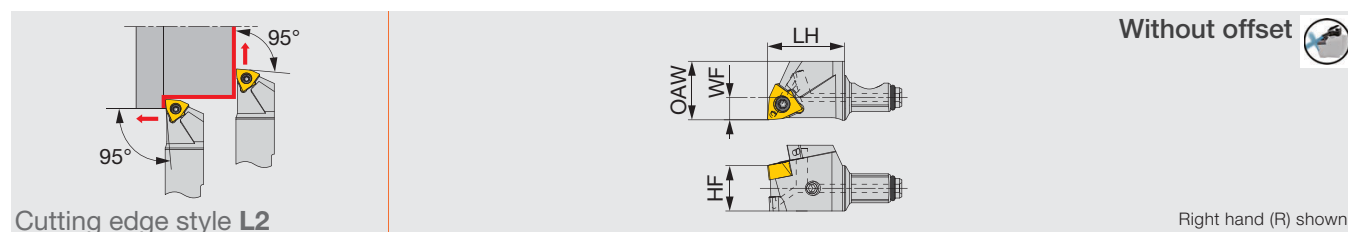
#### SPARE PARTS

| Designation        | Clamping screw | Wrench | O-ring               |
|--------------------|----------------|--------|----------------------|
| QC10-JSCL2CR06-CHP | CSTB-2.5       | T-8F   | ORSS-0353.5X1.0NBR70 |

### QC10-JSWL2XR-CHP

**MINIF<sup>ORCE</sup>TURN**

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



| Designation        | LH | HF | WF | OAW | RE** | Insert         | Torque* | Shank      |
|--------------------|----|----|----|-----|------|----------------|---------|------------|
| QC10-JSWL2XR04-CHP | 17 | 10 | 5  | 13  | 0.2  | WXGU0403**L... | 0.9     | QC-1012... |

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

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

RE\*\*: Standard corner radius

Assembled dimensions with shank are shown on page 9.

Related Items



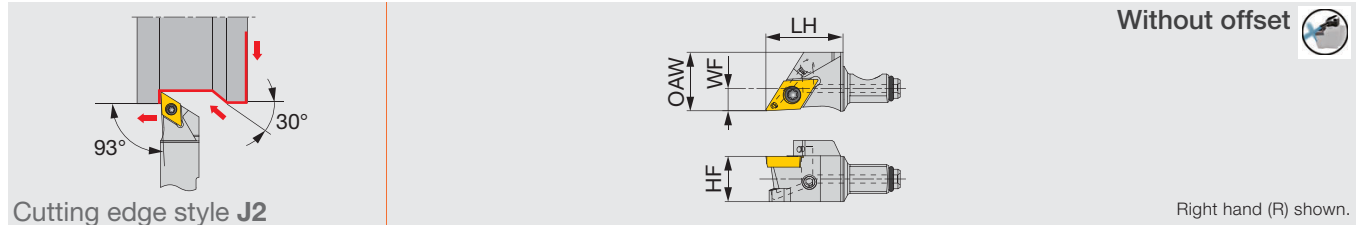
#### SPARE PARTS

| Designation        | Clamping screw | Wrench | O-ring               |
|--------------------|----------------|--------|----------------------|
| QC10-JSWL2XR04-CHP | SR34-514       | T-7F   | ORSS-0353.5X1.0NBR70 |

## QC10-JSDJ2CR-CHP

**J-SERIES**

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



| Designation        | LH | HF | WF | OAW | RE** | Insert      | Torque* | Shank      |
|--------------------|----|----|----|-----|------|-------------|---------|------------|
| QC10-JSDJ2CR07-CHP | 17 | 10 | 5  | 13  | 0.2  | DC**0702... | 1.2     | QC-1012... |

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

RE\*\*: Standard corner radius

Assembled dimensions with shank are shown on page 9.

Related Items



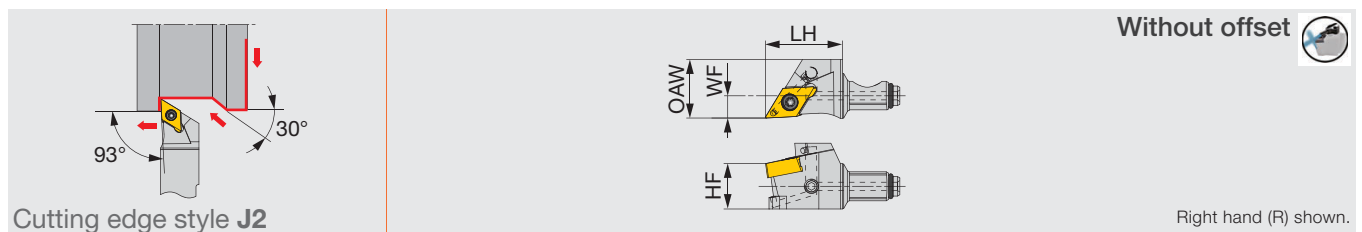
### SPARE PARTS

| Designation        | Clamping screw | Wrench | O-ring               |
|--------------------|----------------|--------|----------------------|
| QC10-JSDJ2CR07-CHP | CSTB-2.5       | T-8F   | ORSS-0353.5X1.0NBR70 |

## QC10-JSDJ2XR-CHP

**MINIFURN**

Screw-on modular head with 93° approach angle, for DX\*U inserts, with high pressure coolant capability



| Designation        | LH | HF | WF | OAW | RE** | Insert         | Torque* | Shank      |
|--------------------|----|----|----|-----|------|----------------|---------|------------|
| QC10-JSDJ2XR07-CHP | 17 | 10 | 5  | 13  | 0.2  | DX*U0703**L... | 0.9     | QC-1012... |

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

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

RE\*\*: Standard corner radius

Assembled dimensions with shank are shown on page 9.

Related Items



### SPARE PARTS

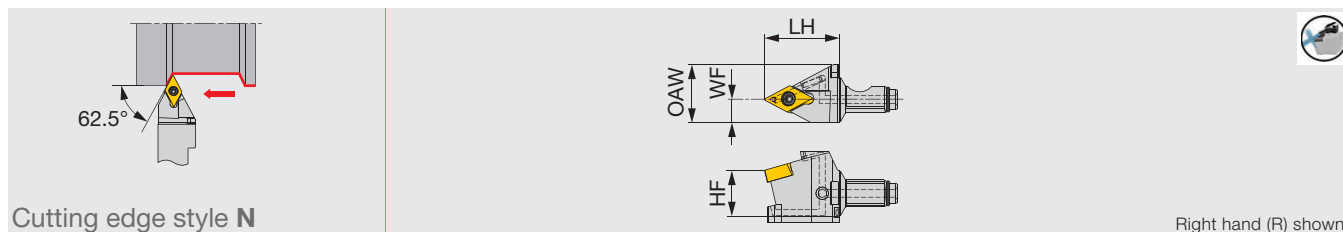
| Designation        | Clamping screw | Wrench | O-ring               |
|--------------------|----------------|--------|----------------------|
| QC10-JSDJ2XR07-CHP | SR34-514       | T-7F   | ORSS-0353.5X1.0NBR70 |



## QC10-JSDNXR-CHP

MINIF<sup>orci</sup>TURN

Screw-on modular head with 62.5° approach angle, for DX\*U inserts, with high pressure coolant capability



| Designation       | LH | HF | WF | OAW | RE** | Insert         | Torque* | Shank      |
|-------------------|----|----|----|-----|------|----------------|---------|------------|
| QC10-JSDNXR07-CHP | 17 | 10 | 6  | 13  | 0.2  | DX*U0703**L... | 0.9     | QC-1012... |

Use right-hand toolholders (R) with left-hand inserts (L).  
Torque\*: Recommended clamping torque (N·m)  
RE\*\*: Standard corner radius  
Assembled dimensions with shank are shown on page 9.

Related Items



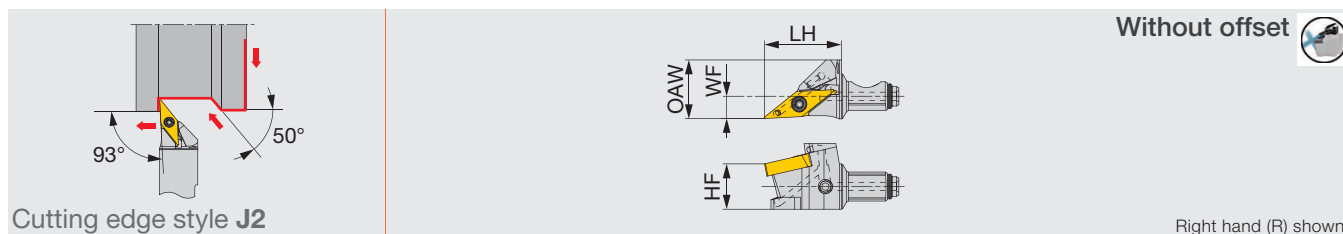
### SPARE PARTS

| Designation       | Clamping screw | Wrench | O-ring               |
|-------------------|----------------|--------|----------------------|
| QC10-JSDNXR07-CHP | SR34-514       | T-7F   | ORSS-0353.5X1.0NBR70 |

## QC10-JSVJ2XR-CHP

MINIF<sup>orci</sup>TURN

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



| Designation        | LH | HF | WF | OAW | RE** | Insert         | Torque* | Shank      |
|--------------------|----|----|----|-----|------|----------------|---------|------------|
| QC10-JSVJ2XR09-CHP | 17 | 10 | 5  | 13  | 0.2  | VXGU09T2**L... | 0.9     | QC-1012... |

Use right-hand toolholders (R) with left-hand inserts (L).  
Torque\*: Recommended clamping torque (N·m)  
RE\*\*: Standard corner radius  
Assembled dimensions with shank are shown on page 9.

Related Items



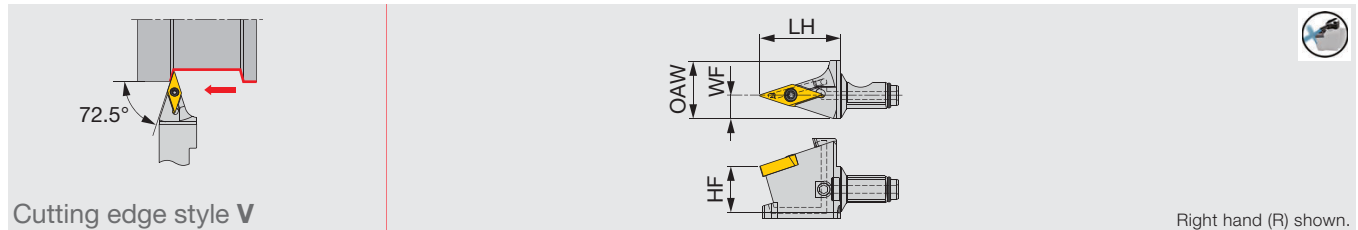
### SPARE PARTS

| Designation        | Clamping screw | Wrench | O-ring               |
|--------------------|----------------|--------|----------------------|
| QC10-JSVJ2XR09-CHP | SR34-508       | T-7F   | ORSS-0353.5X1.0NBR70 |

## QC10-JSVVXR-CHP

MINIFURN

Screw-on modular head with 72.5° approach angle, for VXGU inserts, with high pressure coolant capability



Cutting edge style V

Right hand (R) shown.

| Designation       | LH   | HF | WF | OAW | RE** | Insert         | Torque* | Shank      |
|-------------------|------|----|----|-----|------|----------------|---------|------------|
| QC10-JSVVXR09-CHP | 17.5 | 10 | 5  | 13  | 0.2  | VXGU09T2**L... | 0.9     | QC-1012... |

Use right-hand toolholders (R) with left-hand inserts (L).  
Torque\*: Recommended clamping torque (N·m)  
RE\*\*: Standard corner radius  
Assembled dimensions with shank are shown on page 9.

Related Items



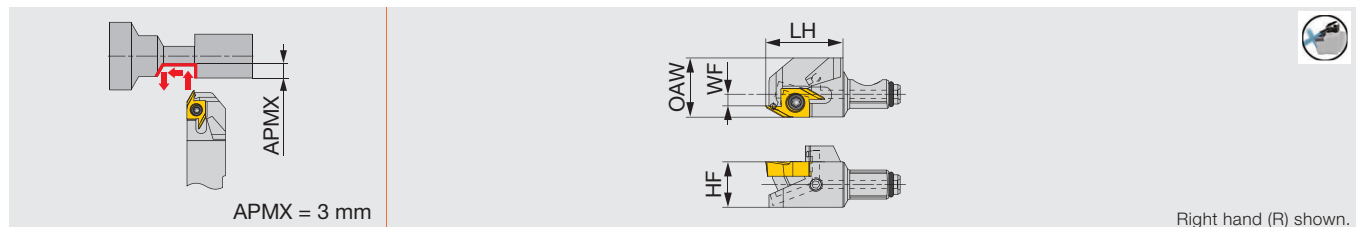
### SPARE PARTS

| Designation       | Clamping screw | Wrench | O-ring               |
|-------------------|----------------|--------|----------------------|
| QC10-JSVVXR09-CHP | SR34-508       | T-7F   | ORSS-0353.5X1.0NBR70 |

## QC10-JSEGR-CHP

J-SERIES

Screw-on modular head for back turning, with high pressure coolant capability



APMX = 3 mm

Right hand (R) shown.

| Designation      | LH | HF | WF  | OAW | Insert   | Torque* | Shank      |
|------------------|----|----|-----|-----|----------|---------|------------|
| QC10-JSEGR10-CHP | 17 | 10 | 2.5 | 13  | J10ER... | 1.2     | QC-1012... |

Torque\*: Recommended clamping torque (N·m)  
Assembled dimensions with shank are shown on page 9.

Related Items



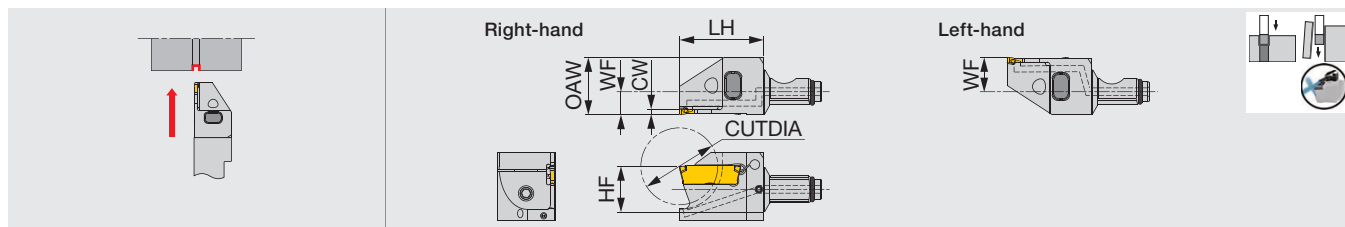
### SPARE PARTS

| Designation      | Clamping screw | Wrench | O-ring               |
|------------------|----------------|--------|----------------------|
| QC10-JSEGR10-CHP | CSTB-2.5       | T-8F   | ORSS-0353.5X1.0NBR70 |

## QC10-JTTER/L-CHP

**TUNG**CUT

Modular head for external grooving and parting, with high pressure coolant capability



| Designation            | CW  | Seat size | CUTDIA | LH <sup>(1)</sup> | HF | WF <sup>(2)</sup> | OAW | Insert    | Torque* | Shank      |
|------------------------|-----|-----------|--------|-------------------|----|-------------------|-----|-----------|---------|------------|
| QC10-JTTER/L1.2D12-CHP | 1.2 | 0.9       | 12     | 17/19             | 10 | 5/8               | 13  | DGS1.2... | 1.5     | QC-1012... |
| QC10-JTTER/L1.4D16-CHP | 1.4 | 1         | 16     | 19                | 10 | 5/8               | 13  | DGS1.4... | 1.5     | QC-1012... |

(1) The first value before "/" indicates the LH for the right-hand holder and the second value after "/" for the left-hand holder.

(2) "WF" value is calculated with groove width "CW" shown in the table. The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

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

Assembled dimensions with shank are shown on page 9.

Related Items



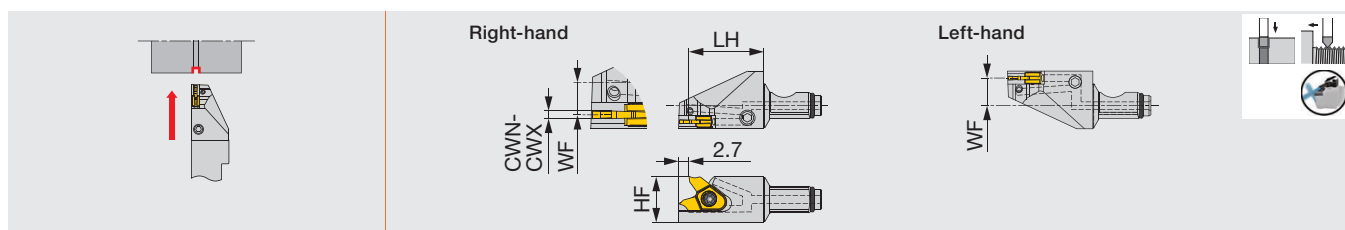
### SPARE PARTS

| Designation     | Clamping screw | Clamping pin | Wrench | O-ring               |
|-----------------|----------------|--------------|--------|----------------------|
| QC10-JTTER/L... | SSM3.5x0.35    | PIN-SL-TC    | P-2F   | ORSS-0353.5X1.0NBR70 |

## QC10-SVER/L-CHP

**MINI**V<sup>LOCK</sup>GROOVE

Modular head for external grooving and threading, with high pressure coolant capability



| Designation       | CWN | CWX | LH | HF | WF <sup>(1)</sup> | Insert   | Torque* | Shank      |
|-------------------|-----|-----|----|----|-------------------|----------|---------|------------|
| QC10-SVER/L10-CHP | 0.5 | 1   | 17 | 10 | 3.19/6.19         | VG*10... | 1.3     | QC-1012... |

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

(1) "WF" indicates the distance from the reference position to the center of the cutting edge width. The first value before "/" indicates the WF for the right-hand holder and the second value after "/" for the left-hand holder.

Assembled dimensions with shank are shown on page 9.

Related Items



### SPARE PARTS

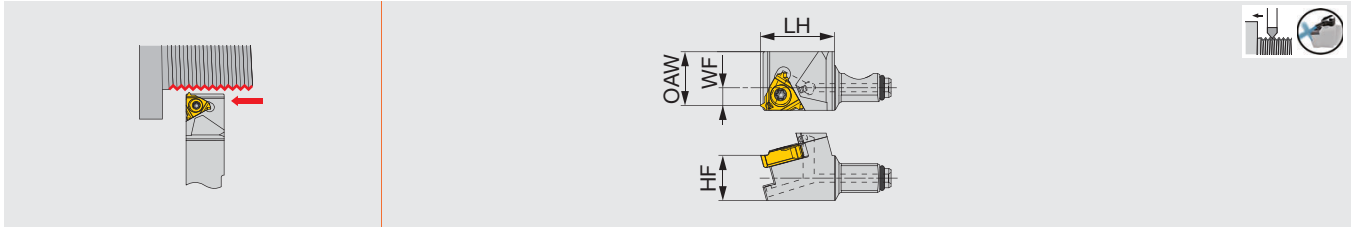
| Designation  | Clamping screw | Wrench | O-ring               |
|--------------|----------------|--------|----------------------|
| QC10-SVER... | CSTB-2.5L054DL | T-7F   | ORSS-0353.5X1.0NBR70 |
| QC10-SVEL... | CSTB-2.5L054DR | T-7F   | ORSS-0353.5X1.0NBR70 |



## QC10-SER-CHP

**TUNGTHREAD**

Modular head for external threading, with high pressure coolant capability



| Designation    | LH | HF | WF | OAW | Insert  | Torque* | Shank      |
|----------------|----|----|----|-----|---------|---------|------------|
| QC10-SER11-CHP | 17 | 10 | 5  | 13  | 11ER... | 1.3     | QC-1012... |

Torque\*: Recommended clamping torque (N-m)  
Assembled dimensions with shank are shown on page 9.

Related Items



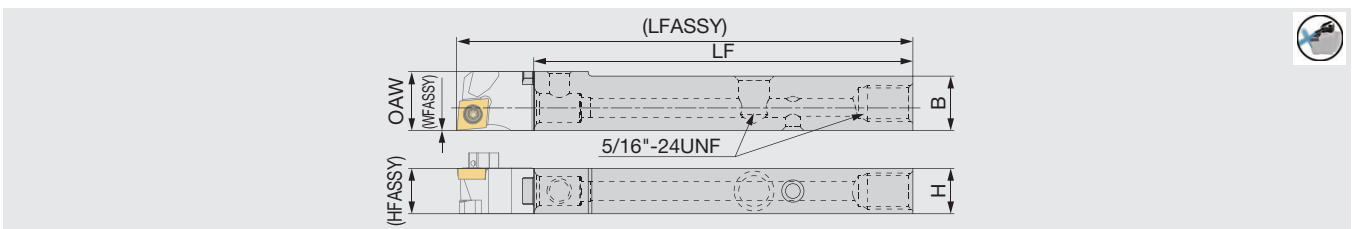
### SPARE PARTS

| Designation    | Clamping screw   | Wrench | O-ring               |
|----------------|------------------|--------|----------------------|
| QC10-SER11-CHP | SR M2.6-L6.7-S11 | T-8F   | ORSS-0353.5X1.0NBR70 |

## SHANK

### QC-1012-CHP

Shank for modular heads, with high pressure coolant capability



| Designation  | H  | B  | LF | WFASSY | OAW | HFASSY | LFASSY <sup>(1)</sup> | Torque* | Head    |
|--------------|----|----|----|--------|-----|--------|-----------------------|---------|---------|
| QC-1012H-CHP | 10 | 12 | 83 | 0      | 13  | 10     | 100                   | 2.5     | QC10... |

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

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

(1) The size is true when the modular head with LH = 17 mm is mounted.

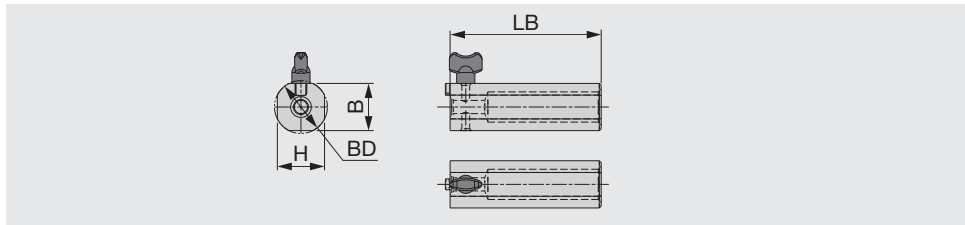
### SPARE PARTS

| Designation  | Clamping screw | Wrench | Coolant plug   | Wrench | DirectJet plug | Wrench |
|--------------|----------------|--------|----------------|--------|----------------|--------|
| QC-1012H-CHP | SRM5X0.5       | P-2.5  | SR5/16UNFTL360 | P-4    | SSHM4-4-TB     | P-2    |

## ACCESSORIES

### QC-D28EXC

Modular head holder for insert change



| Designation | BD | LB | H  | B  | Head    |
|-------------|----|----|----|----|---------|
| QC-10D28EXC | 27 | 80 | 24 | 24 | QC10... |

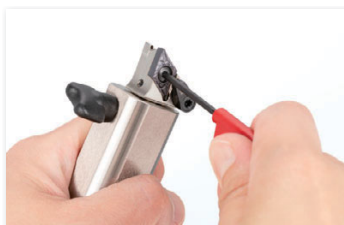
Note: This is a dedicated modular-head holder designed to facilitate insert changes.

Do not use this holder for machining as it may cause damages to tool, workpiece, machine, and possible human injury.

#### SPARE PARTS



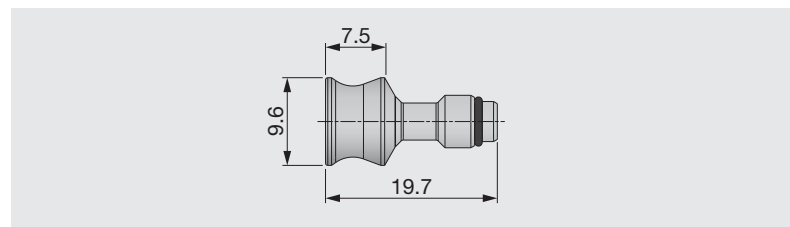
| Designation | Fixing screw |
|-------------|--------------|
| QC-10D28EXC | KNOBM5X10    |



**ModuMini-Turn** modular heads are small. When changing inserts becomes challenging while holding the modular head with your fingers, use the dedicated holder to simplify the process.

### QC10-STOPPER

Protective plug for shank

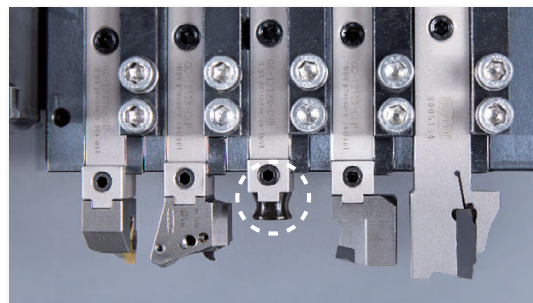


| Designation  | Shank      |
|--------------|------------|
| QC10-STOPPER | QC-1012... |

#### SPARE PARTS



| Designation  | O-ring               |
|--------------|----------------------|
| QC10-STOPPER | ORSS-0353.5X1.0NBR70 |

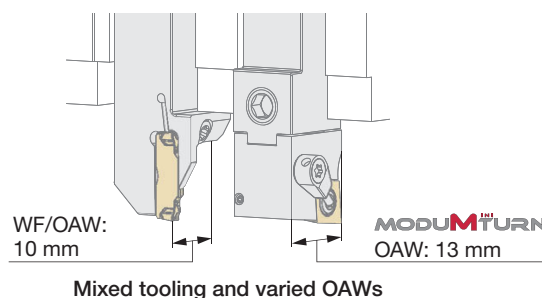


Attach the plug to the shank to protect the coupling surface from chips, as well as prevent coolant leakage during machining

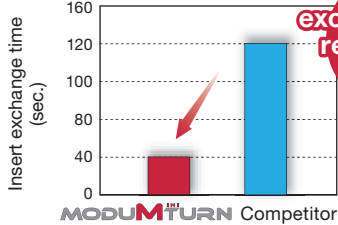
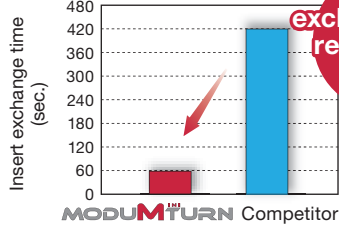
## Caution when using with sub-spindle

### ● Possible tool collision with the sub-spindle during parting operation

**ModuMini-Turn** may collide with the sub-spindle when being used with a non **ModuMini-Turn** parting tool set in the adjacent position. This is due to variations in the overall widths (OAWs) of the cutting heads. In such case, please implement necessary compensations to the programming to offset the size difference and avoid collision.



## PRACTICAL EXAMPLES

| Workpiece type     |                               | Pin                                                                                                                                                                                                                                                      | Torsion bar                                                                                                                                                                                                                                                                                                                    |
|--------------------|-------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Shank              |                               | QC-1012H-CHP                                                                                                                                                                                                                                             | QC-1012H-CHP                                                                                                                                                                                                                                                                                                                   |
| Head               |                               | QC10-JSDJ2CR07-CHP                                                                                                                                                                                                                                       | QC10-JTTER1.4D16-CHP                                                                                                                                                                                                                                                                                                           |
| Insert             |                               | DCGT070201FN-JP                                                                                                                                                                                                                                          | DGS1.4-016                                                                                                                                                                                                                                                                                                                     |
| Grade              |                               | SH725                                                                                                                                                                                                                                                    | AH7025                                                                                                                                                                                                                                                                                                                         |
| Workpiece material |                               | SUS316L / X2CrNiMo17-12-2                                                                                                                                                                                                                                | Alloy steel                                                                                                                                                                                                                                                                                                                    |
|                    |                               |  <b>M</b>                                                                                                                                                               |  <b>P</b>                                                                                                                                                                                                                                   |
| Cutting conditions | Cutting speed : $V_c$ (m/min) | 30                                                                                                                                                                                                                                                       | 85                                                                                                                                                                                                                                                                                                                             |
|                    | Feed : $f$ (mm/rev)           | 0.04                                                                                                                                                                                                                                                     | 0.08                                                                                                                                                                                                                                                                                                                           |
|                    | Machining                     | External turning                                                                                                                                                                                                                                         | Parting                                                                                                                                                                                                                                                                                                                        |
|                    | Coolant                       | Wet                                                                                                                                                                                                                                                      | Wet                                                                                                                                                                                                                                                                                                                            |
| Results            |                               |  <p>Insert exchange time (sec.)</p> <p>Insert exchange time reduced by 67%</p> <p>Using <b>ModuMini-TURN</b> modular tooling enabled 67% shorter tool change time.</p> |  <p>Insert exchange time (sec.)</p> <p>Insert exchange time reduced by 86%</p> <p>Using <b>ModuMini-TURN</b> modular tooling system eliminated time-consuming external coolant subassembly and provided 86% shorter insert change time.</p> |

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