



For more information

Grooving and parting-off tool

ADD^{ORCE}**FCUT**

Tungaloy Report No. 543S1-US

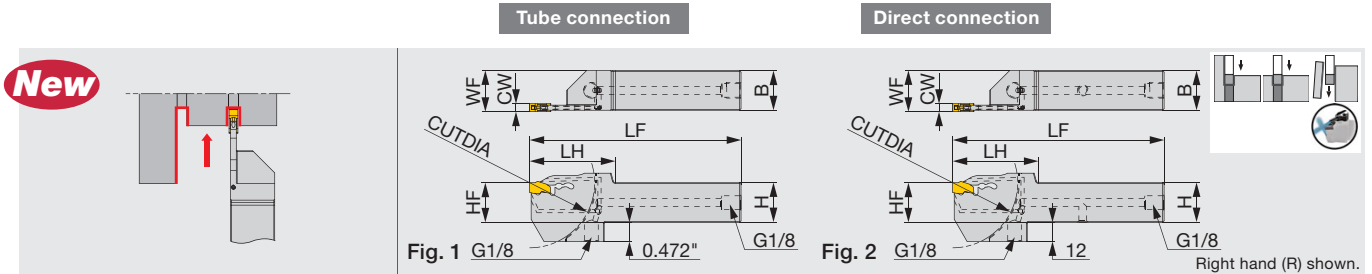
Introducing through-coolant toolholders and blades



TOOLHOLDER

QSER-CHP

External toolholders for grooving and parting



| Inch | CW | Seat size | CUTDIA | H | B | LF | LH | HF | WF | Fig. |
|-----------------|-------|-----------|--------|-------|-------|-------|-------|-------|-------|------|
| QSER16-3D66-CHP | 0.118 | 3 | 2.598 | 1.000 | 1.000 | 6.000 | 1.654 | 1.000 | 1.010 | 1 |
| QSER16-4D82-CHP | 0.157 | 4 | 3.228 | 1.000 | 1.000 | 6.000 | 2.087 | 1.000 | 1.016 | 1 |
| QSER16-5D82-CHP | 0.197 | 5 | 3.228 | 1.000 | 1.000 | 6.000 | 2.087 | 1.000 | 1.020 | 1 |

| Metric | CW | Seat size | CUTDIA | H | B | LF | LH | HF | WF | Fig. |
|-------------------|----|-----------|--------|----|----|-----|----|----|------|------|
| QSER2525-3D66-CHP | 3 | 3 | 66 | 25 | 25 | 121 | 42 | 25 | 25.3 | 2 |
| QSER2525-4D82-CHP | 4 | 4 | 82 | 25 | 25 | 132 | 53 | 25 | 25.4 | 2 |
| QSER2525-5D82-CHP | 5 | 5 | 82 | 25 | 25 | 132 | 53 | 25 | 25.5 | 2 |

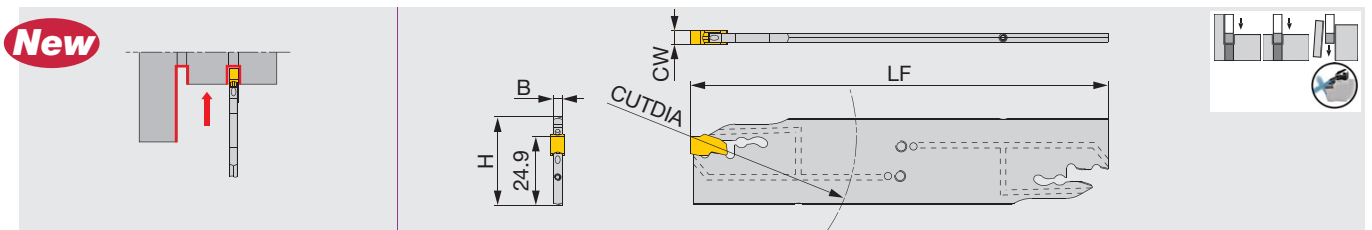
SPARE PARTS

| Designation | Wrench 1 | Screw for tube connection | Wrench 2 |
|-------------|----------|---------------------------|----------|
| QSER... | QL-39 | PLUGG1/8-6.5TL360 | P-5 |

BLADE

QSP-CHP

Blades for external deep grooving and parting



| Metric | CW | Seat size | CUTDIA | H | B | LF |
|--------------|----|-----------|--------|----|-----|-----|
| QSP32-2D-CHP | 2 | 2 | 66 | 32 | 1.8 | 151 |
| QSP32-3D-CHP | 3 | 3 | 120 | 32 | 2.5 | 151 |
| QSP32-4D-CHP | 4 | 4 | 120 | 32 | 3.2 | 151 |
| QSP32-5D-CHP | 5 | 5 | 120 | 32 | 4 | 151 |

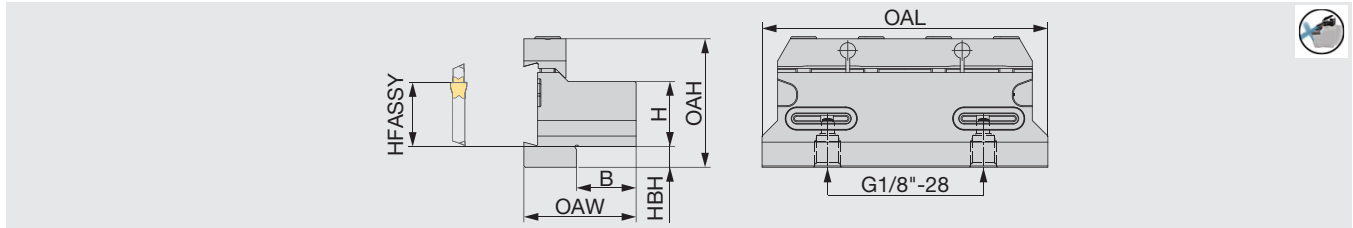
SPARE PARTS

| Designation | Wrench | Sealing screw |
|-------------|--------|---------------|
| QSP... | QL-39 | SGC340 |

TOOL BLOCK

CTBU-CHP

Tool blocks for high pressure coolant



| Inch | H | B | OAL | HFASSY | HBH | OAH | OAW | Blade (Optional) |
|-----------------|-------|-------|-------|--------|-------|------|-------|------------------|
| CTBU16-32-U-CHP | 1.000 | 0.906 | 4.331 | 1.000 | 0.315 | 1.97 | 1.654 | QSP32-*D-CHP |
| Metric | H | B | OAL | HFASSY | HBH | OAH | OAW | Blade (Optional) |
| CTBU25-32-CHP | 25 | 23 | 110 | 25 | 8 | 50 | 43.2 | QSP32-*D-CHP |

Applicable for 14 MPa coolant

SPARE PARTS

| Designation | Clamping screw | Clamp | Wrench | O-ring |
|-------------|--------------------|--------|--------|------------|
| CTBU... | SRM6X16DIN912-12.9 | CT-110 | P-5 | OR14X2.5NN |

PARTS FOR COOLANT HOSE

Connecting hose

Fig.1

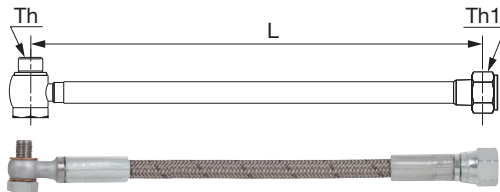
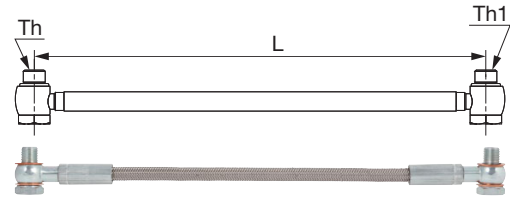
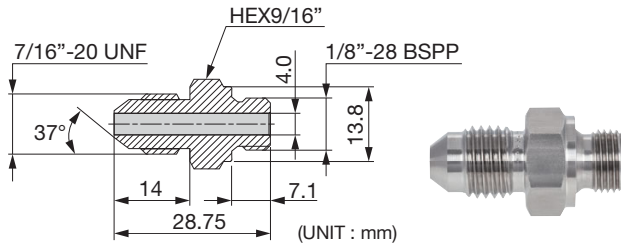


Fig.2



| Designation | Length L(in) | Th | Screw | Th1 | Max. pressure (Mpa) | Fig. |
|--------------------------|--------------|---------------|---------------|---------------|---------------------|------|
| CHP-HOSE-G1/8-7/16-200BS | 7.874 | G1/8"-28 BSPP | 7/16"-20 UNF | 7/16"-20 UNF | 26 | 1 |
| CHP-HOSE-G1/8-7/16-250BS | 9.843 | G1/8"-28 BSPP | 7/16"-20 UNF | 7/16"-20 UNF | 26 | 1 |
| CHP-HOSE-5/16-7/16-200BS | 7.874 | 5/16"-24UNF | 7/16"-20 UNF | 7/16"-20 UNF | 20 | 1 |
| CHP-HOSE-5/16-G1/8-200BS | 7.874 | 5/16"-24UNF | G1/8"-28 BSPP | G1/8"-28 BSPP | 20 | 1 |
| CHP-HOSE-G1/8-G1/8-200BB | 7.874 | G1/8"-28 BSPP | G1/8"-28 BSPP | G1/8"-28 BSPP | 26 | 2 |
| CHP-HOSE-G1/8-G1/8-250BB | 9.843 | G1/8"-28 BSPP | G1/8"-28 BSPP | G1/8"-28 BSPP | 26 | 2 |

Connector



| Designation |
|-------------------------|
| CHP-NIPPLE-G1/8-7/16UNF |

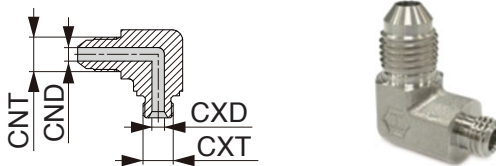
Seal washer



| Designation | øD | ød | W |
|-------------------------|-------|-------|-------|
| CHP-COPPER-SEAL1/8 | 0.591 | 0.394 | 0.039 |
| CHP-COPPER-SEAL5/16 | 0.469 | 0.321 | 0.053 |
| CHP-COPPER-SEAL5/16-2.5 | 0.370 | 0.315 | 0.098 |

(UNIT : in)

Connector elbow



| Designation | CNT | CND | CXT | CXD |
|---------------------------|--------------|-------|--------------|-------|
| CHP-ELBOW-90-G1/8-7/16UNF | 7/16"-20 UNF | 0.173 | 1/8"-28 BSPP | 0.157 |
| CHP-ELBOW-90-5/16-7/16UNF | 7/16"-20 UNF | 0.173 | 5/16"-24 UNF | 0.157 |

(UNIT : in)

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