

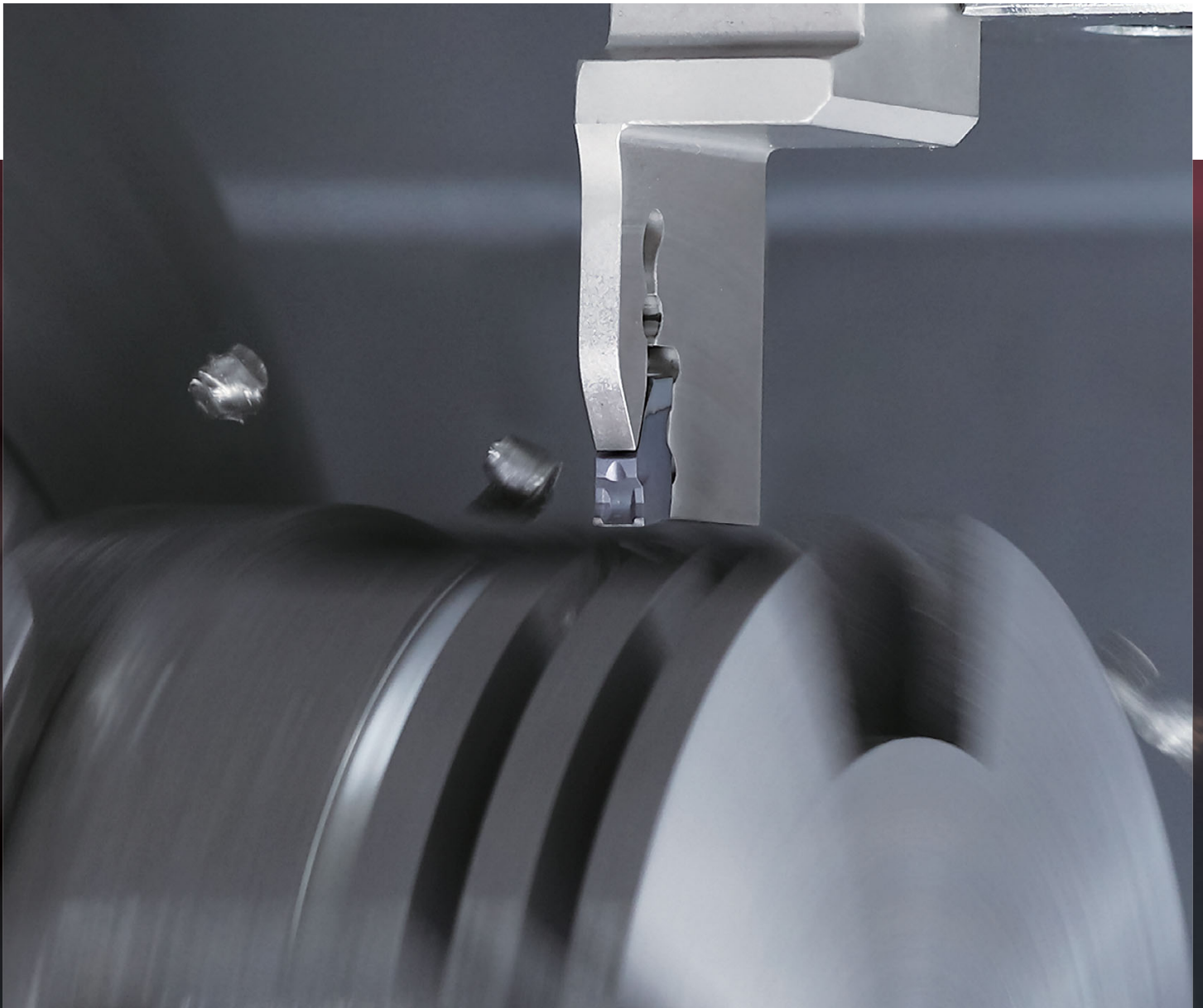


Grooving and parting-off tool

**ADD**<sup>ORCE</sup>**F****CUT**

Tungaloy Report No. 543S3-US

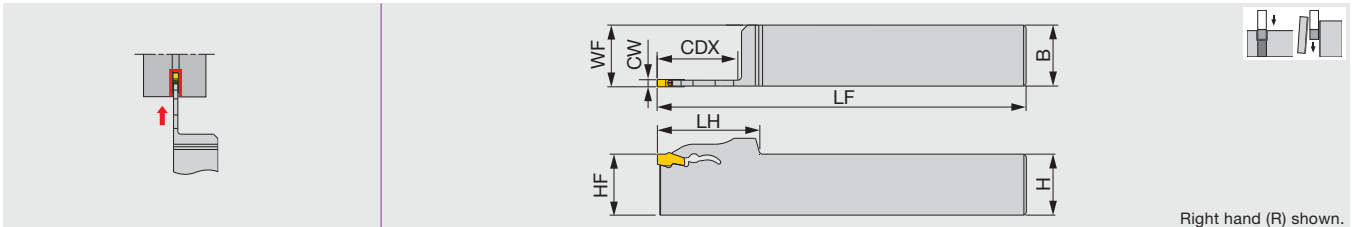
Introducing inserts and toolholders for 0.236" and 0.315" groove widths, along with super-tough AH6235 grade for all AFC inserts.



## HOLDER

### QSER/L

External toolholders for grooving and parting



Inch	CW	CDX	Seat size	H	B	LF	LH	HF	WF
QSER/L12-2T26	0.079	1.024	2	0.750	0.750	5.000	1.417	0.750	0.756
QSER/L12-2T33	0.079	1.299	2	0.750	0.750	5.000	1.654	0.750	0.756
QSER/L16-2T26	0.079	1.024	2	1.000	1.000	6.000	1.417	1.000	1.004
QSER/L16-2T33	0.079	1.299	2	1.000	1.000	6.000	1.654	1.000	1.004
QSER/L12-3T26	0.118	1.024	3	0.750	0.750	5.000	1.417	0.750	0.764
QSER/L12-3T33	0.118	1.299	3	0.750	0.750	5.000	1.654	0.750	0.764
QSER/L16-3T26	0.118	1.024	3	1.000	1.000	6.000	1.417	1.000	1.012
QSER/L16-3T33	0.118	1.299	3	1.000	1.000	6.000	1.654	1.000	1.012
QSER/L12-4T33	0.157	1.299	4	0.750	0.750	5.000	1.654	0.750	0.768
QSER/L16-4T33	0.157	1.299	4	1.000	1.000	6.000	1.654	1.000	1.016
QSER/L16-5T33	0.197	1.299	5	1.000	1.000	6.000	1.654	1.000	1.020
<b>New</b> QSER/L16-6T36	0.236	1.417	6	1.000	1.000	6.000	1.890	1.000	1.016
<b>New</b> QSER/L20-6T41	0.236	1.614	6	1.250	1.250	7.000	2.087	1.250	1.266
<b>New</b> QSER/L20-8T41	0.315	1.614	8	1.250	1.250	7.000	2.087	1.250	1.266

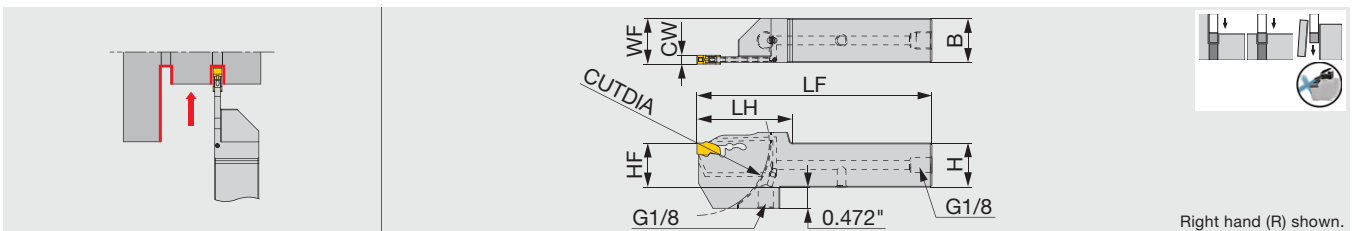
#### SPARE PARTS

Designation	Wrench
QSER/L...	QL-39

### QSER-CHP

Direct connection Tube connection

External toolholders for grooving and parting



Inch	CW	Seat size	CUTDIA	H	B	LF	LH	HF	WF
QSER16-3D66-CHP	0.118	3.000	2.598	1.000	1.000	6.000	1.654	1.000	1.010
QSER16-4D82-CHP	0.157	4.000	3.228	1.000	1.000	6.000	2.087	1.000	1.016
QSER16-5D82-CHP	0.197	5.000	3.228	1.000	1.000	6.000	2.087	1.000	1.020
<b>New</b> QSER20-6D102-CHP	0.236	6.000	4.016	1.250	1.250	7.000	2.480	1.250	1.266
<b>New</b> QSER20-8D102-CHP	0.315	8.000	4.016	1.250	1.250	7.000	2.480	1.250	1.266

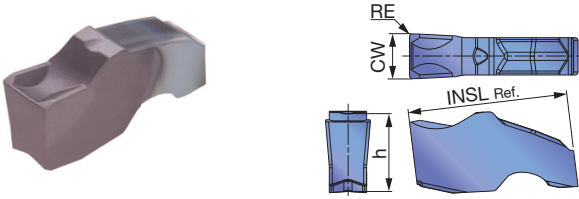
#### SPARE PARTS

Designation	Wrench	Screw for tube connection
QSER...	QL-39	PLUGG1/8-6.5TL360

## INSERTS

### QGM

External deep grooving and parting



P	Steel	★	★						
M	Stainless	★	★						
K	Cast iron	★	★						
N	Non-ferrous								
S	Superalloys	★							
H	Hard materials								

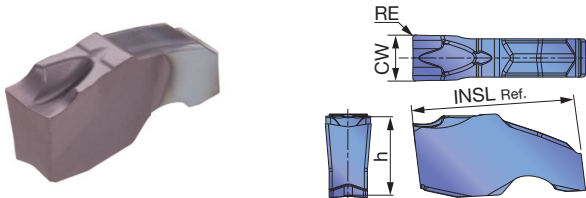
★ : First choice

Designation	Seat size	CW±0.05 (mm)	CW±0.002 (in)	RE (in)	Coated		INSL (in)	h (in)
					AH7025	AH6235		
QGM2-020	2	2	0.079	0.008	●	●	0.433	0.209
QGM3-020	3	3	0.118	0.008	●	●	0.433	0.209
QGM4-030	4	4	0.157	0.012	●	●	0.512	0.287
QGM5-030	5	5	0.197	0.012	●	●	0.512	0.287
QGM6-030	6	6	0.236	0.012	●	●	0.630	0.358
QGM8-040	8	8	0.315	0.016	●	●	0.630	0.358

● : New product  
● : Line up

### QGS

External deep grooving and parting



P	Steel	★	★					
M	Stainless	★	★					
K	Cast iron	★	★					
N	Non-ferrous							
S	Superalloys	★						
H	Hard materials							

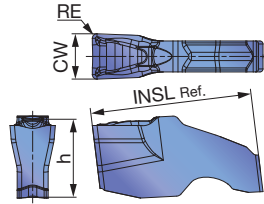
★ : First choice

Designation	Seat size	CW±0.05 (mm)	CW±0.002 (in)	RE (in)	Coated		INSL (in)	h (in)
					AH7025	AH6235		
QGS2-020	2	2	0.079	0.008	●	●	0.433	0.209
QGS3-020	3	3	0.118	0.008	●	●	0.433	0.209
QGS4-030	4	4	0.157	0.012	●	●	0.512	0.287
QGS5-030	5	5	0.197	0.012	●	●	0.512	0.287
QGS6-030	6	6	0.236	0.012	●	●	0.630	0.358
QGS8-040	8	8	0.315	0.016	●	●	0.630	0.358

● : New product  
● : Line up

# QTX

Face grooving



<b>P</b>	Steel	★	★							
<b>M</b>	Stainless	★	★							
<b>K</b>	Cast iron	★	★							
<b>N</b>	Non-ferrous									
<b>S</b>	Superalloys	★								
<b>H</b>	Hard materials									★ : First choice

Designation	Seat size	CW±0.05 (mm)	CW±0.002 (in)	RE (in)	Coated		INSL (in)	h (in)
					AH7025	AH6235		
QTX2-020	2	2	0.079	0.0079	●	●	0.433	0.209
QTX3-030	3	3	0.118	0.0118	●	●	0.433	0.209
QTX4-040	4	4	0.157	0.0157	●	●	0.512	0.287
QTX5-040	5	5	0.197	0.0157	●	●	0.512	0.287

● : New product  
● : Line up

## STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Hardness	Priority	Grade	Cutting speed Vc (sfm)
<b>P</b>	Steel 1045, 4135, etc.	< 300 HB	First choice	AH7025	160 - 590
		< 300 HB	Impact resistance	AH6235	160 - 390
<b>M</b>	Stainless steel 304SS, 316SS, 17-4 PH, etc.	< 200 HB	First choice	AH7025	160 - 390
		< 200 HB	Impact resistance	AH6235	160 - 390
<b>K</b>	Gray cast iron Class 25, Class 30, etc.	-	First choice	AH7025	160 - 590
		-	Impact resistance	AH6235	160 - 590
	Ductile cast iron 60-40-18, 80-55-06, etc.	-	First choice	AH7025	160 - 390
		-	Impact resistance	AH6235	160 - 390
<b>S</b>	Superalloys Inconel718, etc.	< HRC 40	-	AH7025	70 - 200
	Titanium alloys Ti-6Al-4V, etc.	< HRC 40	-	AH7025	70 - 200



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