

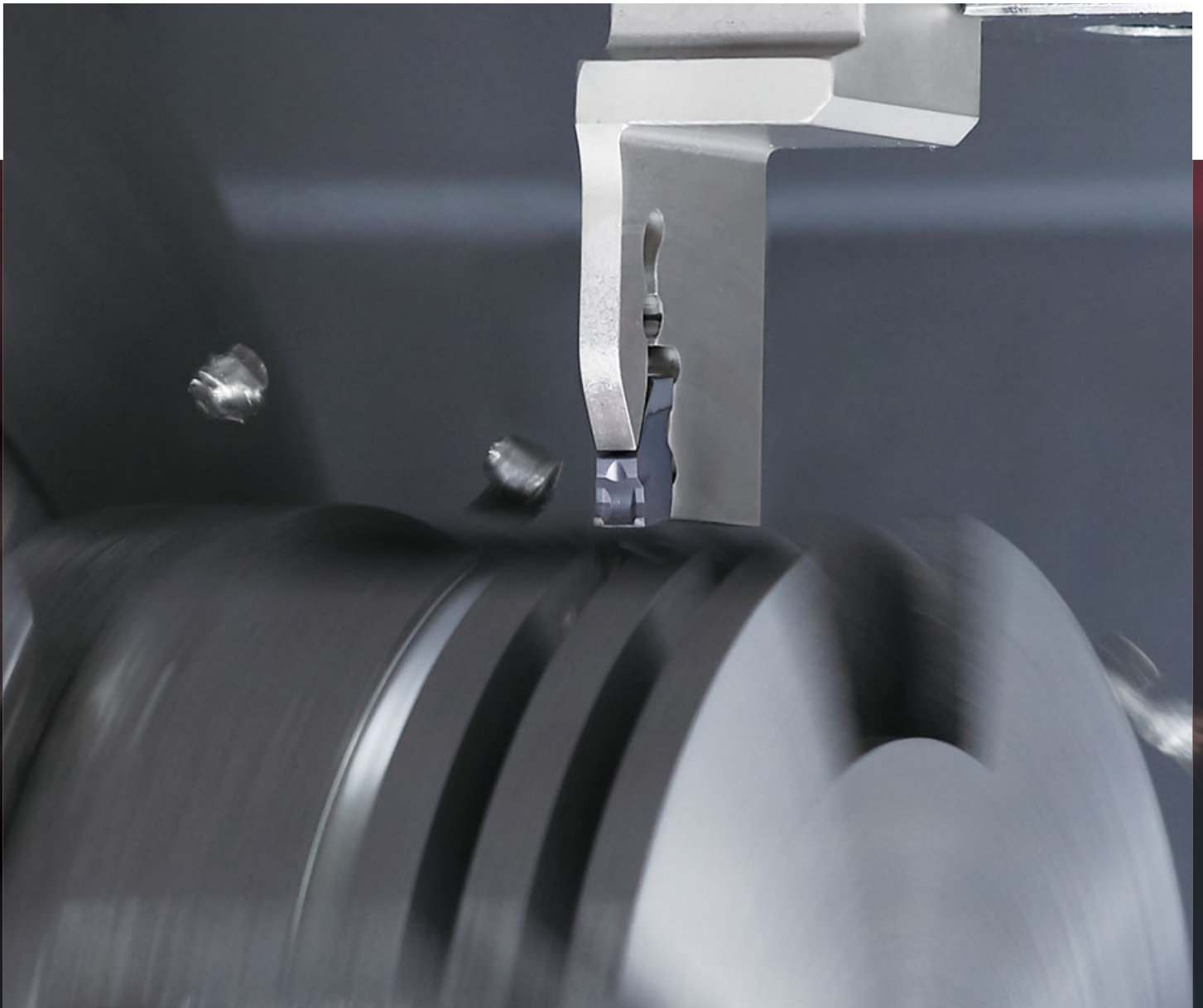


Grooving and parting-off tool

ADD^{ORCE}**F****CUT**

Tungaloy Report No. 543S3-G

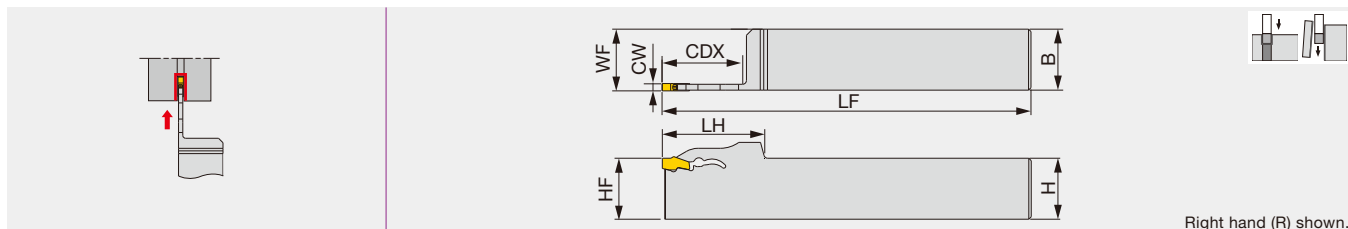
Introducing inserts and toolholders for 6 and 8 mm groove widths, along with super-tough AH6235 grade for all AFC inserts.



HOLDER

QSER/L

External toolholders for grooving and parting



Designation	CW	CDX	Seat size	H	B	LF	LH	HF	WF
QSER/L2020-2T26	2	26	2	20	20	125	36	20	20.1
QSER/L2020-2T33	2	33	2	20	20	125	42	20	20.1
QSER/L2525-2T26	2	26	2	25	25	150	36	25	25.1
QSER/L2525-2T33	2	33	2	25	25	150	42	25	25.1
QSER/L2020-3T26	3	26	3	20	20	125	36	20	20.3
QSER/L2020-3T33	3	33	3	20	20	125	42	20	20.3
QSER/L2525-3T26	3	26	3	25	25	150	36	25	25.3
QSER/L2525-3T33	3	33	3	25	25	150	42	25	25.3
QSER/L2020-4T33	4	33	4	20	20	125	42	20	20.4
QSER/L2525-4T33	4	33	4	25	25	150	42	25	25.4
QSER/L2525-5T33	5	33	5	25	25	150	42	25	25.5
New QSER/L2525-6T36	6	36	6	25	25	150	48	25	25.4
New QSER/L3232-6T41	6	41	6	32	32	170	53	32	32.4
New QSER/L3232-8T41	8	41	8	32	32	170	53	32	32.4

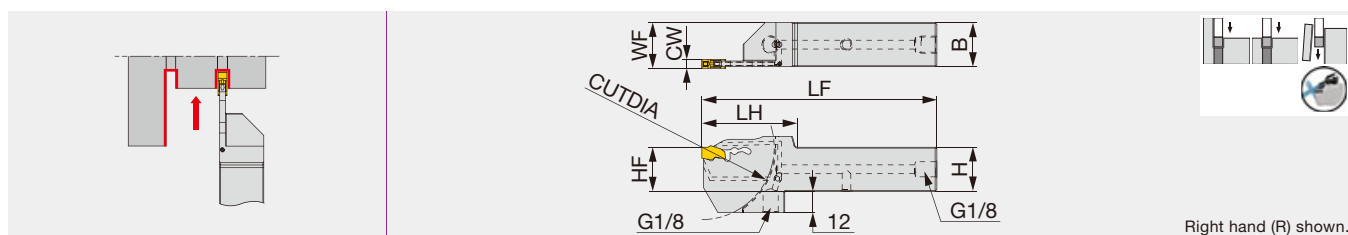
SPARE PARTS

Designation	Wrench
QSER/L...	QL-39

QSER-CHP

Direct connection Tube connection

External toolholders for grooving and parting



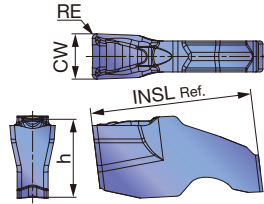
Designation	CW	Seat size	CUTDIA	H	B	LF	LH	HF	WF
QSER2525-3D66-CHP	3	3	66	25	25	121	42	25	25.3
QSER2525-4D82-CHP	4	4	82	25	25	132	53	25	25.4
QSER2525-5D82-CHP	5	5	82	25	25	132	53	25	25.5
New QSER3232-6D102-CHP	6	6	102	32	32	157	63	32	32.4
New QSER3232-8D102-CHP	8	8	102	32	32	157	63	32	32.4

SPARE PARTS

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

QTX

Face grooving



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

Designation	Seat size	CW±0.05	RE	Coated		INSL	h
				AH7025	AH6235		
QTX2-020	2	2	0.2	●	●	11	5.3
QTX3-030	3	3	0.3	●	●	11	5.3
QTX4-040	4	4	0.4	●	●	13	7.3
QTX5-040	5	5	0.4	●	●	13	7.3

● : New product
● : Line up

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Hardness	Priority	Grade	Cutting speed Vc (m/min)
P	Steels C45, 34CrMo4, etc.	< 300 HB	First choice	AH7025	50 - 180
		< 300 HB	Impact resistance	AH6235	50 - 120
M	Stainless steel X10CrNiS18-9, etc.	< 200 HB	First choice	AH7025	50 - 120
		< 200 HB	Impact resistance	AH6235	50 - 120
K	Gray cast iron GG25, 250, etc.	-	First choice	AH7025	50 - 180
		-	Impact resistance	AH6235	50 - 180
	Ductile cast irons GGG45, 450-10S, etc.	-	First choice	AH7025	50 - 120
		-	Impact resistance	AH6235	50 - 120
S	Superalloys Inconel718, etc.	< HRC 40	-	AH7025	20 - 60
	Titanium alloys Ti-6Al-4V, etc.	< HRC 40	-	AH7025	20 - 80



tungaloy.com
follow us at:
facebook.com/tungaloyjapan
twitter.com/tungaloyjapan
www.youtube.com/tungaloycorporation

Distributed by:



Tungaloy APP & SNS

FIND US ON THE CLOUD!
machiningcloud.com



AS9100 Certified
78006
2015.11.04
ISO 14001 Certified
EC97J1123
1997.11.26