

EXCLUSIVE FROM SOMMA

RESHARPENABLE QUICK-CHANGE FORM TOOL HOLDERS AND INSERTS, SHAVE TOOL HOLDERS AND INSERTS, CIRCULAR CUTOFF HOLDERS AND INSERTS (ALSO AVAILABLE WITH "THROW-AWAY" INSERTS, SEE PAGE 14).

FEATURES OF SOMMA RESHARPENABLE QUICK CHANGE INSERT TOOLHOLDERS

INSERTS CAN BE RESHARPENED BY GRINDING MATERIAL FROM TOP SURFACE AND REUSED WITHOUT RESETTING.

INSERTS CAN BE RESHARPENED 20 TO 30 TIMES.

INSERTS CAN BE CHANGED IN LESS THAN ONE MINUTE.

ONCE INSERT IS SET TO CENTER IT NEED NEVER BE RESET.

ONCE INSERT IS SET TO PROPER DIAMETER, IT NEED NEVER BE RESET.

LATERAL POSITIONING OF FORM NEVER CHANGES.

INSERTS DO NOT REQUIRE MATCHING BACKUP ANVILS FOR SUPPORT.

ALSO AVAILABLE WITH "THROW-AWAY" INSERTS (SEE PAGE 14).

Inserts available in C6 Micrograin Carbide, C2 Micrograin Carbide and 76PM High Speed Steel plus Tin Coating. Also available in Maxamet High Speed Steel.

To assist you in selecting appropriate insert material for your application, it has been our experience that the following grades usually give the best results.

- | | |
|------------------------------------|---|
| • BRASS: | 76PM HIGH SPEED STEEL |
| FOR LONG RUNS | C2 MICROGRAIN CARBIDE |
| • ALUMINUM, COPPER, BRONZE: | C2 MICROGRAIN CARBIDE |
| • FERROUS MATERIALS: | 76PM HIGH SPEED STEEL OR C2 MICROGRAIN CARBIDE OR C6 MICROGRAIN CARBIDE |

Somma can supply the blanks for EDMing at your facility or Somma can supply the finished form insert if you send us your part print. Prices on application.

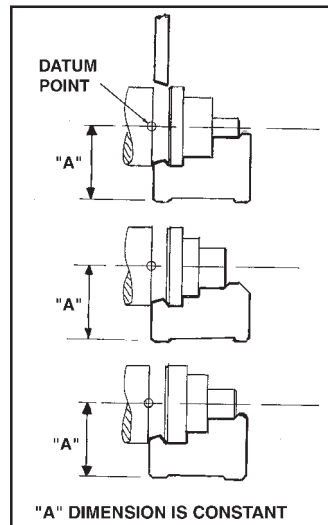
"DATUM POINT" TECHNOLOGY... *for speedy job changeovers*

"Datum Point" tooling for screw machines, whereby a family of similar parts can be made by simply changing the form tool, has been made simple with the introduction of Somma's patented "Resharpenable Quick Change" Insert Type Form Tool Holders.

Once the insert holder is set to the proper center height and lateral location for one job, it never has to be moved. All that is necessary when changing to a new job is to change the insert.

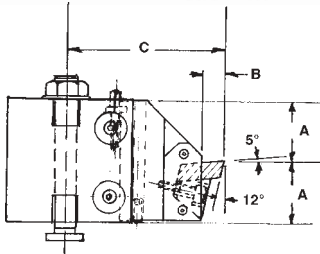
The form on each insert is calculated so that it will produce the diameters and lengths as required for each job and the inserts are mounted into a pocket in the toolholder of controlled width and depth, in relation to which the form of each insert is calculated.

Contact Somma to find out how "Datum Point" tooling can work for you!



RESHARPENABLE QUICK CHANGE INSERT TOOL POSTS FOR BROWN & SHARPE MACHINES (Patent No. 5,345,846)

- Replaces circular and dovetail form tools
- Can be used on front slide or rear slide
- For right hand or left hand operation
- Flange screw adjustment for center setting of insert holder slide



SEE PAGE 14 FOR INSERTS.

CAT. NO.	W/COOLANT ATTACHMENT	A	B	C	INSERT SIZE	COOLANT ATTACHMENT ONLY
RQC00	RQC00-CS	1"	5/16	2-3/16	3/4 WIDE X 5/16	RQC5/16-CA
RQC00-W	RQC00-W-CS	1"	5/16	2-3/16	1-1/8 WIDE X 5/16	
RQC0	RQC0-CS	1-5/16"	5/16	2-7/8	3/4 WIDE X 5/16	
RQC0-W	RQC0-W-CS	1-5/16"	5/16	2-7/8	1-1/8 WIDE X 5/16	RQC3/8-CA
RQC2	RQC2-CS	1-7/16"	1/2	3-5/8	1-1/4 WIDE X 3/8	
RQC2-1-3/4	RQC2-1-3/4-CS	1-7/16"	1/2	3-5/8	1-3/4 WIDE X 3/8	RQC5/16-CA
RQC2-3/4	RQC2-3/4-CS	1-7/16"	5/16	3-5/8	3/4 WIDE X 5/16	
RQC2-1-1/8	RQC2-1-1/8-CS	1-7/16"	5/16	3-5/8	1-1/8 WIDE X 5/16	

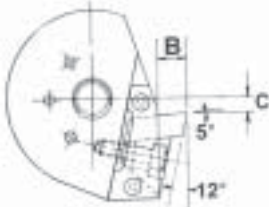
CONVERT THE INSERT WIDTH SIZE OF YOUR EXISTING HOLDER WITH INTERCHANGEABLE INSERT SLIDES

COMPLETE INSERT SLIDES ONLY					
CAT. NO.	W/COOLANT ATTACHMENT	FITS		INSERT SIZE	COOLANT ATTACHMENT ONLY
RQC00-.75-SL	RQC00-.75-SL-CS	RQC00	RQC0	3/4 WIDE X 5/16	RQC5/16-CA
RQC00-.375-SL	RQC00-.375-SL-CS	RQC00-W	RQC0-W	3/8 WIDE X 5/16	RQC5/16-CA
		RQC16/20-A	RQC16/20-B		
		RQC16/20-A-N	RQC16/20-B-N		
RQC00-1.125-SL	RQC00-1.125-SL-CS			1-1/8 WIDE X 5/16	RQC5/16-CA
RQC2-.75-SL	RQC2-.75-SL-CS	RQC2	RQC2-3/4	3/4 WIDE X 5/16	RQC5/16-CA
RQC2-1.125-SL	RQC2-1.125-SL-CS			1-1/8 WIDE X 5/16	RQC3/8-CA
RQC2-1.25-SL	RQC2-1.25-SL-CS			1-1/4 WIDE X 3/8	
RQC2-1.75-SL	RQC2-1.75-SL-CS		RQC2-1-3/4	1-3/4 WIDE X 3/8	

RESHARPENABLE QUICK CHANGE INSERT CIRCULAR TOOL HOLDERS FOR BROWN AND SHARPE MACHINES (Patent No. 5,345,846)



SHOWN WITH COOLANT ATTACHMENT



- Replaces conventional circular form tools.
- Pinholes provided both sides for right or left hand operation on B&S machines.
- Machine downtime less than one minute for insert resharpenings or replacement.

SEE PAGE 14 FOR INSERTS.

CAT. NO.	W/COOLANT ATTACHMENT	MACH. SIZE	DIA.	CENTER HOLE	B	C	INSERT SIZE	COOLANT ATTACHMENT ONLY
RQC00-C-N	RQC00-C-N-CS	#00 B&S	1-3/4	3/8-16	5/16	1/8	3/8 X 5/16	RQC5/16-C-CA
RQC00-C	RQC00-C-CS	#00 B&S	1-3/4	3/8-16	5/16	1/8	3/4 X 5/16	
RQC00-C-W	RQC00-C-W-CS	#00 B&S	1-3/4	3/8-16	5/16	1/8	1-1/8 X 5/16	
RQC0-C	RQC0-C-CS	#0 B&S	2-1/4	1/2-13	5/16	5/32	3/4 X 5/16	RQC5/16-C-CA
RQC0-C-W	RQC0-C-W-CS	#0 B&S	2-1/4	1/2-13	5/16	5/32	1-1/8 X 5/16	RQC5/16-C-CA
RQC2-C-N	RQC2-C-N-CS	#2 B&S	3"	5/8-11	5/16	1/4	3/4 X 5/16	RQC5/16-C-CA
RQC2-C-NW	RQC2-C-NW-CS	#2 B&S	3"	5/8-11	5/16	1/4	1-1/8 X 5/16	RQC5/16-C-CA
RQC2-C-NN	RQC2-C-NN-CS	#2 B&S	3"	5/8/2011	5/16	1/4	3/8 X 5/16	RQC5/16-C-CA
RQC2-C	RQC2-C-CS	#2 B&S	3"	5/8-11	1/2	1/4	1-1/4 X 3/8	RQC3/8-C-CA
RQC2-C-W	RQC2-C-W-CS	#2 B&S	3"	5/8-11	1/2	1/4	1-3/4 X 3/8	

RESHARPENABLE QUICK CHANGE INSERT SLIDE ADAPTER FOR EURO TSE SHAVE TOOL HOLDERS 760200-1, 760600-1, 766000-1 (Patent No. 5848562)

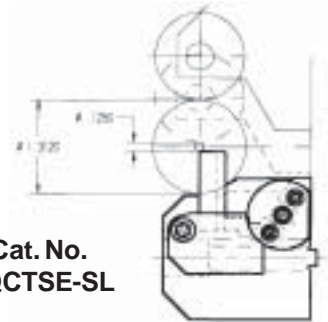


Can be used with "RQC" Resharpenable inserts or with throwaway (Single usage) inserts.

Insert dims:
Resharpenable = 1-3/4 X 3/8
Throwaway = 1-3/4 X 1/8

Max Part Length = 1.750"
Max Part Dia. = 1.312"
Min. Part Dia. = .000"

Cat. No.
RQCTSE-SL

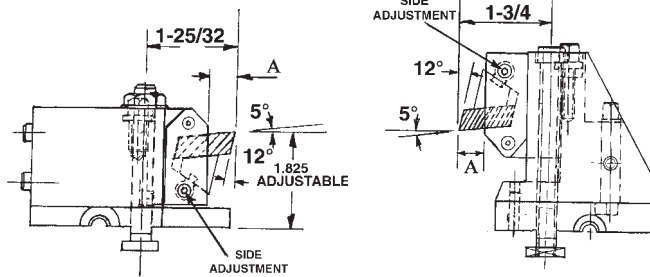


RESHARPENABLE QUICK-CHANGE INSERT TOOL POSTS FOR DAVENPORT MACHINE With Side Adjusting Insert Clamp

(Patent No. 5,848,562)



**1st Position
Shown with
Coolant Attachment**



2nd Position

NOW AVAILABLE WITH COOLANT ATTACHMENT

- Increases tool life
- Improves part finish

COMPLETE TOOL POST 1ST POSITION

COMPLETE TOOL POST 2ND POSITION

CAT. NO.	W/COOLANT ATTACHMENT CAT. NO.	INSERT SIZE	A	COOLANT ATTACHMENT ONLY
RQCDAV-S	RQCDAV-S-CS	1-1/4W X 3/8	1/2"	RQCDAV-CA
RQCDAV-W-S	RQCDAV-W-S-CS	1-3/4W X 3/8	1/2"	RQCDAV-CA
RQCDAV-N-S	RQCDAV-N-S-CS	1-1/8W X 5/16	5/16"	RQC5/16-CA
RQCDAV-NN-S	RQCDAV-NN-S-CS	3/4W X 5/16	5/16"	RQC5/16-CA

CAT. NO.	W/COOLANT ATTACHMENT CAT. NO.	INSERT SIZE	A	COOLANT ATTACHMENT ONLY
RQCDVB-S	RQCDVB-S-CS	1-1/4W X 3/8	1/2"	RQCDAV-CA
RQCDVB-W-S	RQCDVB-W-S-CS	1-3/4W X 3/8	1/2"	RQCDAV-CA
RQCDVB-N-S	RQCDVB-N-S-CS	1-1/8W X 5/16	5/16"	RQC5/16-CA
RQCDVB-NN-S	RQCDVB-NN-S-CS	3/4W X 5/16	5/16"	RQC5/16-CA

REPLACEMENT SIDE ADJUSTING INSERT SLIDES ONLY - TO FIT EXISTING RQCDAV & RQCDVB HOLDERS	W/COOLANT ATTACHMENT		FITS	INSERT
	CAT. NO.	CAT. NO.		
	RQCDV-SA	RQCDV-SA-CS	RQCDAV RQCDVB	1-1/4 WIDE X 3/8
	RQCDV-W-SA	RQCDV-W-SA-CS		1-3/4 WIDE X 3/8
	RQCDV-N-SA	RQCDV-N-SA-CS		1-1/8 WIDE X 5/16
	RQCDV-NN-SA	RQCDV-NN-SA-CS		3/4 WIDE X 5/16

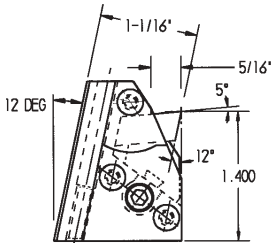
SEE PAGE 14 FOR INSERTS.

RESHARPENABLE QUICK CHANGE INSERT DOVETAIL FORM TOOL HOLDERS

With Side Adjusting Insert Clamp Fit Davenport Cross Slide Tool Holders

(Patent No. 5,848,562)

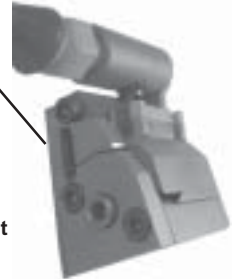
- Replaces HSS form tools and brazed on carbide form tools.



SEE PAGE 14 FOR INSERTS.

DOVETAIL SIZE	INSERT SIZE	CAT. NO.	W/COOLANT ATTACHMENT
5/8	1-1/8 WIDE X 5/16 THICK	RQCDAV-DT	RQCDAV-DT-CS
		COOLANT ATTACHMENT ONLY	CAT. NO. RQCDAV-DT-CA

SWINGING SIDE PLATE FOR EASY INSERT REMOVAL

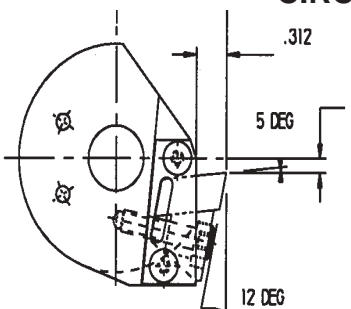


With coolant attachment.

RESHARPENABLE QUICK CHANGE INSERT CIRCULAR TOOL HOLDERS FOR DAVENPORT MACHINES

(Patent No. 5,345,846)

- Machine downtime less than one minute for insert resharpenings or replacement.
- Replaces conventional circular form tools.



SEE PAGE 14 FOR INSERTS.

DIA.	CENTER HOLE	INSERT SIZE	CAT. NO.	W/COOLANT ATTACHMENT CAT. NO.
2"	9/16" DIA.	3/8 X 5/16*	RQCDAV-C-N	RQCDAV-C-N-CS
2"	9/16" DIA.	3/4 X 5/16	RQCDAV-C	RQCDAV-C-CS
2"	9/16" DIA.	1-1/8 X 5/16	RQCDAV-C-W	RQCDAV-C-W-CS
			COOLANT ATTACHMENT ONLY	CAT. NO. RQCDAV-C-CA

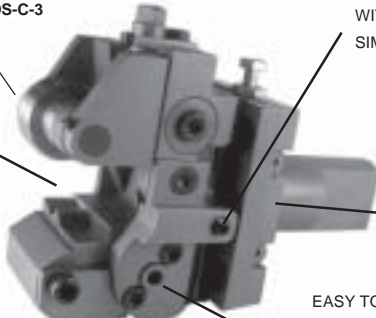


RESHARPENABLE QUICK CHANGE SHAVE TOOL HOLDERS FOR DAVENPORT MACHINES (Patent No. 5,848,562)

AT LAST... A SHAVE TOOL WITH ALL THE FEATURES YOU ALWAYS WANTED:

THE ONLY QUICK CHANGE SHAVE TOOL INSERT THAT CAN BE RESHARPENED WITHOUT AFFECTING ITS ORIGINAL:

- CENTER SETTING • PART DIAMETER SETTING • LATERAL SETTING
- CAN ALSO BE USED WITH RESHARPENABLE OR THROWAWAY INSERTS • IDEAL FOR DATUM POINT APPLICATIONS



OFFSET ROLL CARRIER AVAILABLE FOR WORKING CLOSER TO SPINDLE .
CAT. NO. RQCDS-C-3

LATERAL FINE ADJUSTING SCREW. SHAVING HEAD CAN BE MOVED SIDEWAYS. WITHOUT MOVING SHANK OR TOOLHOLDER BLOCK. SIMPLIFIES ALIGNMENT WITH ROUGHING TOOLS.

PIPE THREAD COOLANT CONNECTION

ADJUSTABLE DOVETAIL GIB ELIMINATES CHATTER DUE TO NORMAL WEAR. SPRING TENSION ADJUSTABLE TO SUIT SIZE OF WORKPIECE.

EASY TO GET AT FROM THE SIDE CLAMPING OF INSERT. INSERT CAN BE CHANGED IN LESS THAN A MINUTE. SINGLE HEX WRENCH ADJUSTMENT FOR CLAMPING AND UNCLAMPING OF INSERTS. SWING AWAY SIDE PLATE FOR EASY INSERT REPLACEMENT.

PATENTED DESIGN CLAMPS INSERT FORWARD AGAINST HOLDER FACE. INSERT ALWAYS LOCATED ON ROLL CENTERLINE. MAINTAINS PART DIAMETER AND LENGTHS EVEN AFTER RESHARPENING.

SHAVING HEAD PRESETTABLE FOR DIAMETER OFF THE MACHINE. SHAVE TOOL ROLL HEAD EASILY REMOVABLE FROM BODY. SETTINGS NOT AFFECTED BECAUSE SHANK AND BODY OF SHAVE. TOOL HOLDER REMAIN CLAMPED IN MACHINE. EASY ONE SCREW CLAMPING LOCKS HEAD IN PLACE. SIMPLIFIES DIAMETER SETUP OF HOLDER WHEN CHANGING JOBS.

CAT. NO.	STYLE	CAPACITY	INSERT SIZE	SHANK
RQCDS-A	A	0-7/8"	1-1/8 X 3/8	1"
*RQCDS-SL	A	0-7/8"	1-1/8 X 3/8	1"
RQCDS-DV	A	0-7/8"	1-1/8 X 3/8	1-1/8"

* CENTERLINE OF SHAVE HEAD OFFSET 1/8" FROM CENTERLINE OF SHANK FOR USE WITH SLITTERS OR SLATER ADAPTER BLOCKS OR STC-DVAB-3 BLOCK SHOWN BELOW.

SEE PAGE 14 FOR INSERTS.

SHAVE TOOL HOLDERS FOR DAVENPORT CIRCULAR POSITIONS (Patent No. 5,848,562)



Cat. No. RQCDS-C

- MOUNTS ON SWING ARM-SAME AS CIRCULAR TOOLS
- ALL FEATURES SAME AS ABOVE SHANK TYPE SHAVE TOOL
- CAN BE ROTATED TO CENTER SAME AS CIRCULAR SHAVE TOOL HOLDERS
- ADJUSTABLE FOR PART TAPERS

SEE PAGE 14 FOR INSERTS.

SHAVE TOOL ADAPTER BLOCKS FOR DAVENPORT MACHINES



SECOND POSITION ADAPTER BLOCK
Cat. No. STC-DVAB-2

FOR RQCDS-A SHAVE TOOLS - OR - ANY SHAVE TOOL WITH SHANK THAT IS ON CENTER WITH MACHINE SPINDLE



THIRD POSITION ADAPTER BLOCK
Cat. No. STC-DVAB-3

FOR RQCDS-SL SHAVE TOOLS - OR - SLITTER/SLATER SHAVE TOOLS THAT ARE 1/8" OFF CENTER

To be used with Davenport Tool Arm #5080-64-1

RESHARPENABLE QUICK CHANGE DOVETAIL FORM TOOL HOLDERS FOR MULTIPLE SPINDLE MACHINES

(Patent No. 5,345,846)

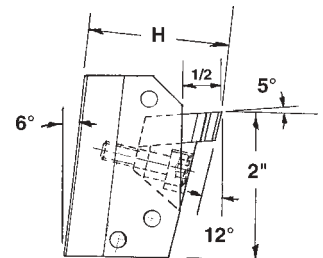
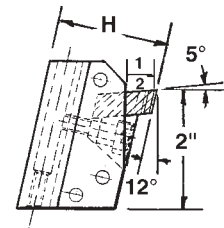
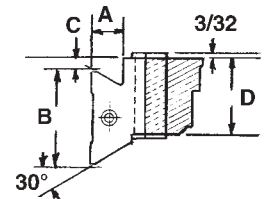
NOW AVAILABLE WITH COOLANT ATTACHMENT

- Increases insert life
- Improves part finish

Coolant attachment assembly available for updating existing holders.



COOLANT ATTACHMENT STYLE



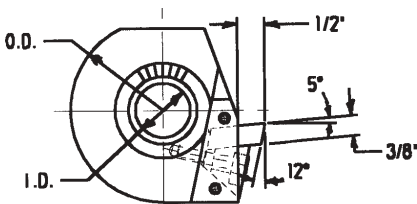
WICKMAN STYLE

SEE PAGE 14 FOR INSERTS

DOVETAIL SIZE	A	B	C	INSERT SIZE	H	CAT. NO.	W/COOLANT ATTACHMENT CAT. NO.
FOR NATIONAL ACME MACHINES							
5/8	19/64	.951	3/16	1-1/4 WIDE	1-1/2	RQC5/8DT	RQC5/8DT-CS
1	35/64	1.614	3/16	X	1-7/8	RQC1DT	RQC1DT-CS
1-1/4	35/64	1.882	3/16	3/8 THICK	1-7/8	RQC1-1/4DT	RQC1-1/4DT-CS
5/8	19/64	.951	7/16	1-3/4 WIDE	1-1/2	RQC5/8DT-W	RQC5/8DT-W-CS
1	35/64	1.614	7/16	X	1-7/8	RQC1DT-W	RQC1DT-W-CS
1-1/4	35/64	1.882	7/16	3/8 THICK	1-7/8	RQC1-1/4DT-W	RQC1-1/4DT-W-CS
5/8	19/64	.951	3/16	3/4 WIDE	1-5/8	RQC5/8DT-N	RQC5/8DT-N-CS
1	35/64	1.614	3/16	X	2"	RQC1DT-N	RQC1DT-N-CS
1-1/4	35/64	1.882	3/16	3/8 THICK	2"	RQC1-1/4DT-N	RQC1-1/4DT-N-CS
1-1/4	35/64	1.882	7/16	2-1/4 WIDE	1-7/8	RQC1-1/4DT-XW	RQC1-1/4DT-XW-CS
				X 3/8 THICK			
1-1/4	35/64	1.882	7/16	2-3/4 WIDE	1-7/8	RQC1-1/4DT-WW	RQC1-1/4DT-WW-CS
				X 3/8 THICK			
2-1/8	43/64	2.883	5/32	2-3/4 WIDE	2"	RQC2-1/8DT-WW	RQC2-1/8DT-WW-CS
				X 3/8 THICK			
FOR NEW BRITAIN MACHINES							
1.253	35/64	1.253	3/16	1-1/4 WIDE	1-7/8	RQCNBDT	RQCNBDT-CS
1.827	37/64	1.827	3/16	X 3/8 THICK	1-7/8	RQCNBDT-1.827	RQCNBDT-1.827-CS
1.253	35/64	1.253	7/16	1-3/4 WIDE	1-7/8	RQCNBDT-W	RQCNBDT-W-CS
1.827	37/64	1.827	7/16	X 3/8 THICK	1-7/8	RQCNBDT-1.827-W	RQCNBDT-1.827-W-CS
1.253	35/64	1.253	3/16	3/4 WIDE	1-7/8	RQCNBDT-N	RQCNBDT-N-CS
1.827	37/64	1.827	3/16	X 3/8 THICK	1-7/8	RQCNBDT-1.827-N	RQCNBDT-1.827-N-CS
FOR WICKMAN MACHINES							
.951"	21/64	.951	3/16	1-1/4 WIDE	1-5/8	RQCWK-951	RQCWK-951-CS
1.433"	25/64	1.433	3/16	X	1-5/8	RQCWK-1433	RQCWK-1433-CS
1.845"	33/64	1.845	3/16	3/8 THICK	1-7/8	RQCWK-1845	RQCWK-1845-CS
1.897"	33/64	1.897	3/16		1-7/8	RQCWK-1897	RQCWK-1897-CS
.951"	21/64	.951	7/16	1-3/4 WIDE	1-5/8	RQCWK-951W	RQCWK-951W-CS
1.433"	25/64	1.433	7/16	X	1-5/8	RQCWK-1433W	RQCWK-1433W-CS
1.845"	33/64	1.845	7/16	3/8 THICK	1-7/8	RQCWK-1845W	RQCWK-1845W-CS
1.897"	33/64	1.897	7/16		1-7/8	RQCWK-1897W	RQCWK-1897W-CS

CAT. NO. RQCDT-CA-1.25
CAT. NO. RQCWK-CA
COOLANT ATTACHMENT ONLY

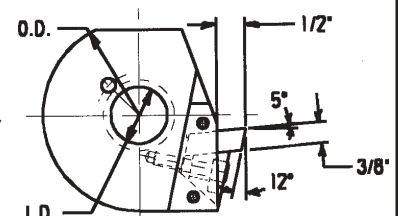
RESHARPENABLE QUICK CHANGE CIRCULAR FORM TOOL HOLDERS FOR MULTIPLE SPINDLE MACHINES (PATENT NO. 5,345,846)



SIDE TEETH STYLE

Available:

- 2-3/8" and 3-3/8" O.D. with pinholes or side teeth for National Acme Machines
- 2-1/4", 2-1/2", 3" and 3-1/2" O.D. with pinholes for New Britain and other machines
- with 3/8" x 1-1/4", 3/8 x 1-3/4", 3/8" x 2-1/4" resharpenable or throw-away inserts
- with coolant attachment



PINHOLE STYLE

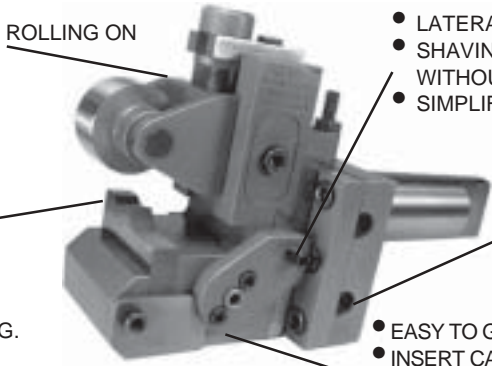
RESHARPENABLE QUICK CHANGE SHAVE TOOL HOLDERS FOR MULTIPLE SPINDLE MACHINES

(Patent No. 5,848,562)

THE ONLY QUICK CHANGE SHAVE TOOL INSERT THAT CAN BE RESHARPENED WITHOUT AFFECTING ITS ORIGINAL:

- CENTER SETTING • PART DIAMETER SETTING • LATERAL SETTING
- CAN ALSO BE USED WITH THROW-AWAY INSERTS
- IDEAL FOR DATUM POINT APPLICATIONS

- ROLL SLIDE CAN BE ROTATED 180° FOR ROLLING ON OUT BOARD END OF WORKPIECE.
- CARBIDE ROLL PIN

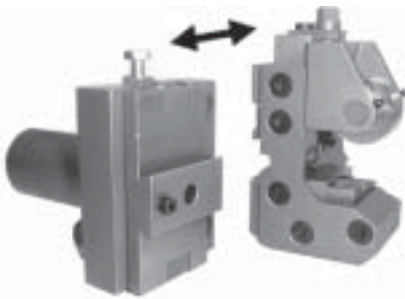


- LATERAL FINE ADJUSTING SCREW
- SHAVING HEAD CAN BE MOVED SIDWAYS WITHOUT MOVING SHANK OR TOOL HOLDER BLOCK.
- SIMPLIFIES ALIGNMENT WITH ROUGHING TOOLS.

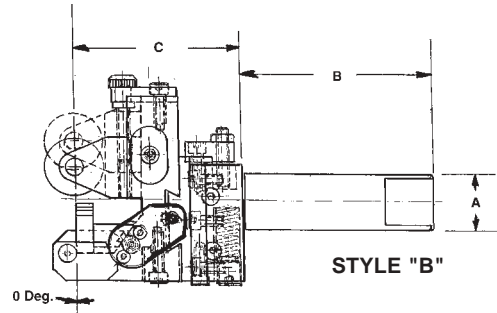
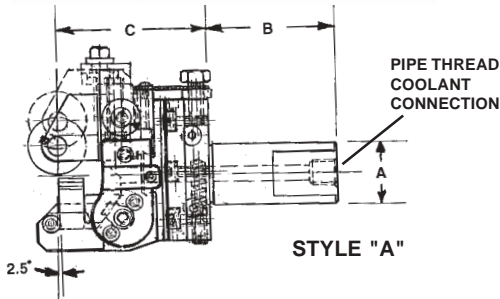
- PATENTED DESIGN CLAMPS INSERT FORWARD AGAINST HOLDER FACE.
- INSERT ALWAYS LOCATED ON ROLL CENTERLINE.
- MAINTAINS PART DIAMETER AND LENGTHS EVEN AFTER RESHARPENING.

- ADJUSTABLE DOVETAIL GIB ELIMINATES CHATTER DUE TO NORMAL WEAR.
- ADJUSTABLE SPRING TENSION TO SUIT SIZE OF WORKPIECE.

- EASY TO GET AT FROM THE SIDE CLAMPING OF INSERT.
- INSERT CAN BE CHANGED IN LESS THAN A MINUTE.
- SINGLE HEX WRENCH ADJUSTMENT FOR CLAMPING AND UNCLAMPING OF INSERTS.
- SWING AWAY SIDE PLATE FOR EASY INSERT REPLACEMENT.



- SHAVING HEAD PRESETTABLE FOR DIAMETER OFF THE MACHINE.
- SHAVE TOOL ROLL HEAD EASILY REMOVABLE FROM BODY.
- SETTINGS NOT AFFECTED BECAUSE SHANK AND BODY OF SHAVE TOOLHOLDER REMAIN CLAMPED IN MACHINE.
- EASY ONE SCREW CLAMPING LOCKS HEAD IN PLACE.
- SIMPLIFIES DIAMETER SETUP OF HOLDER WHEN CHANGING JOBS.



RESHARPENABLE QUICK CHANGE SHAVE TOOL HOLDERS FOR MULTIPLE SPINDLE MACHINES - STYLE "A"

CAT. NO.	CAPACITY	INSERT			
		SIZE	A	B	C
RQCMS-0	0-7/8"	1-1/8 X 3/8	1"	3-1/2	2-3/8
RQCMS-0-1	1/8-1"	1-1/8 x 3/8	1"	3-1/2	2-3/8
RQCMS-1	1/8-1"	1-1/8 X 3/8	1-1/4	4"	3-1/8

SEE PAGE 14 FOR INSERTS

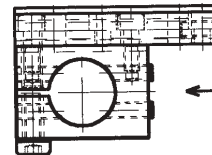
RESHARPENABLE QUICK CHANGE SHAVE TOOL HOLDERS FOR MULTIPLE SPINDLE MACHINES - STYLE "B"

CAT. NO.	CAPACITY	INSERT			
		SIZE	A	B	C
RQCMS-2	1/8-1-1/4"	1-3/4 X 3/8	1-1/4	4"	3-1/2
RQCMS-3	1/2-1-5/8"	1-3/4 X 3/8	1-1/2	4-1/2	3-1/2
RQCMS-5	1-1/8-2-1/4"	1-3/4 X 3/8	1-1/2	4-1/2	3-1/2

SHAVE TOOL MOUNTING BLOCKS FOR GILDEMEISTER AND OTHER METRIC MACHINES



CAT. NO.	CENTER HEIGHT	SHANK DIA.
RQCGLD20-SB	30MM	1.000"
RQCGLD50-SB	50MM	1.500"

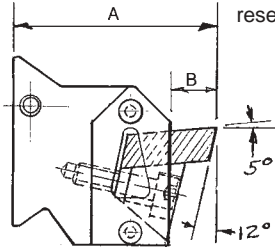


SHANK HOLDING BLOCK CAN BE REPOSITIONED ON BASE PLATE CLOSE TO SPINDLE FOR UPSIDE DOWN CROSS SLIDE POSITIONS.

RESHARPENABLE QUICK CHANGE INSERT TOOL HOLDERS FOR TRAUB TNM28 AND TNM42 MACHINES

(Patent No. 5,345,846)

- Replaces horizontal dovetail form tool holders.
- Center height adjustment never has to be reset after sharpening insert.
- Machine downtime less than one minute for insert resharpenings or replacement.



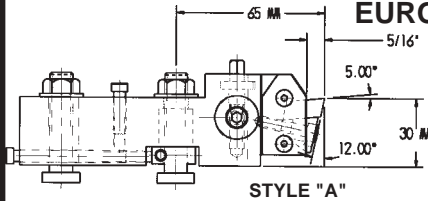
SEE PAGE 14 FOR INSERTS.

CAT. NO.	W/COOLANT ATTACHMENT	"A"	"B"	INSERT SIZE
RQC-TNM28-.75	RQC-TNM28-.75-CS	57MM (2.244")	5/16	3/4" X 5/16
RQC-TNM28	RQC-TNM28-CS	57MM (2.244")	1/2	1-1/4" X 3/8
RQC-TNM28-1.75	RQC-TNM28-1.75-CS	57MM (2.244")	1/2	1-3/4" X 3/8
RQC-TNM42-1.25	RQC-TNM42-1.25-CS	80MM (3.150")	1/2	1-1/4" X 3/8
RQC-TNM42-1.75	RQC-TNM42-1.75-CS	80MM (3.150")	1/2	1-3/4" X 3/8
RQC-TNM42-.75	RQC-TNM42-.75-CS	80MM (3.150")	5/16	3/4" X 5/16

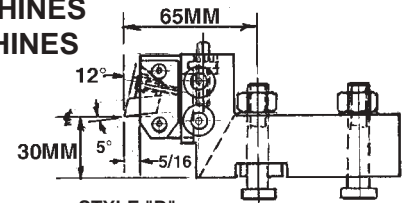
RESHARPENABLE QUICK CHANGE INSERT TOOL HOLDERS FOR TORNOS SAS16 MACHINES EUROTURN 6/20 AND GILDEMEISTER MACHINES

(Patent No. 5,345,846)

- Replaces dovetail form tools
- Replaces circular form tools
- Center height adjustment never has to be reset after sharpening insert.
- Machine downtime less than one minute for insert resharpenings or replacement.



STYLE "A"



STYLE "B"

CAT. NO.	W/COOLANT ATTACHMENT	INSERT SIZE
RQC16/20-A	RQC16/20-A-CS	1-1/8 X 5/16
RQC16/20-A-N	RQC16/20-A-N-CS	3/4 X 5/16
RQC16/20-A-NN	RQC16/20-A-NN-CS	3/8 X 5/16
COOLANT ATTACHMENT ONLY		RQC5/16-CA

Fits:
Tornos SAS16 Euroturn 6/20
 Positions 1,2 Positions 1,4,6
Gildemeister GM20
 Positions 1,4



SEE PAGE 14 FOR INSERTS.

FOR INSERT SLIDES ONLY, SEE RQC00 TOOLPOSTS PG.7.

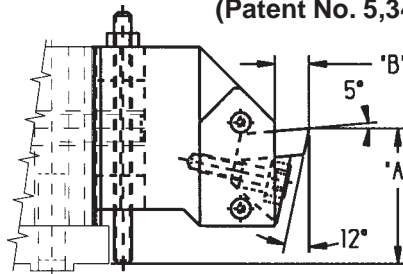
CAT. NO.	W/COOLANT ATTACHMENT	INSERT SIZE
RQC16/20-B	RQC16/20-B-CS	1-1/8 X 5/16
RQC16/20-B-N	RQC16/20-B-N-CS	3/4 X 5/16
RQC16/20-B-NN	RQC16/20-B-NN-CS	3/8 X 5/16
COOLANT ATTACHMENT ONLY		RQC5/16-CA

Fits:
Tornos SAS16 Euroturn 6/20
 Positions 3,4,5 Positions 2,3,5
Gildemeister GM20
 Positions 2,5

RESHARPENABLE QUICK CHANGE INSERT SERRATED TOOL HOLDERS FOR GILDEMEISTER AND EUROTURN MACHINES

(Patent No. 5,345,846)

- Fits serrated tool blocks.
- Inserts offset close to spindle
- Reversible for upside down positions.
- Replaces horizontal dovetail form tool holders.
- Center height adjustment never has to be reset after sharpening insert.
- Machine downtime less than one minute for insert resharpenings or replacement.



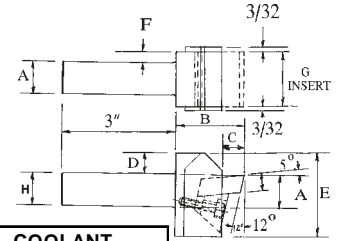
SEE PAGE 14 FOR INSERTS.

CAT. NO.	PRICE	W/COOLANT ATTACHMENT	PRICE	MACHINE	"B"	INSERT SIZE	COOLANT ATTACHMENT ONLY	PRICE
RQCGLD20	664.02	RQCGLD20-CS	725.92	GM16/20 &	5/16"	5/16 X 1-1/8	RQC5/16-CA	61.95
RQCGLD20-W	765.77	RQCGLD20-W-CS	827.72	EUROTURN 6/20	5/16"	5/16 X 1-3/4	RQC5/16-CA	61.95
RQCGLD35-42-A	791.16	RQCGLD35-42-A-CS	853.11	GM35/42	1/2"	3/8 X 1-3/4	RQC3/8-CA	61.95
RQCGLD35-42-1.25	791.16	RQCGLD35-42-1.25-CS	853.11		1/2"	3/8 X 1-1/4	RQC3/8-CA	61.95
RQCEUR-32-1.25	791.16	RQCEUR-32-1.25-CS	853.11	EUR6/32-8/32	1/2"	3/8 X 1-1/4	RQC3/8-CA	61.95
RQCEUR-32-1.75	791.16	RQCEUR-32-1.75-CS	853.11		1/2"	3/8 X 1-3/4	RQC3/8-CA	61.95



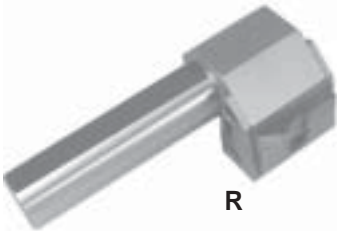
RESHARPENABLE QUICK CHANGE INSERT SHANK TYPE TOOL HOLDERS (Patent No. 5,345,846)

- Replaces full length H.S.S. toolbits
- Replaces brazed on type carbide tools



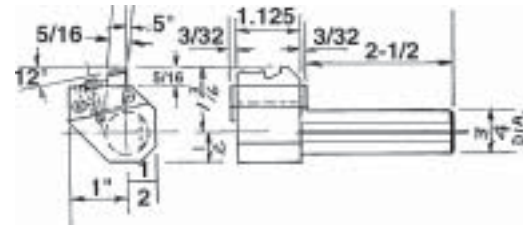
SEE PAGE 14 FOR INSERTS.

CAT. NO.	W/ COOLANT ATTACHMENT	H	A	B	C	D	E	F	G INSERT SIZE	COOLANT ATTACHMENT ONLY
RQC-312	--	1/2	5/8	1-1/4	5/16	3/8	1-1/4	--	5/16 X 5/16	--
RQC00-1/2	RQC00-1/2-CS	1/2	1/2	1-3/32	5/16	13/32	1-3/8	1/8	3/4 X 5/16	RQC5/16-CA
RQC00-5/8	RQC00-5/8-CS	5/8	5/8	1-3/32	5/16	13/32	1-3/8	1/16	3/4 X 5/16	
RQC00-3/4	RQC00-3/4-CS	3/4	3/4	1-3/32	5/16	13/32	1-3/8	--	3/4 X 5/16	
RQC-5/8	RQC-5/8-CS	5/8	5/8	1-5/8	1/2	1/2	1-15/16	5/16	1-1/4 X 3/8	RQC3/8-CA
RQC-3/4	RQC-3/4-CS	3/4	3/4	1-5/8	1/2	1/2	1-15/16	1/4	1-1/4 X 3/8	
RQC-1.0	RQC-1.0-CS	1"	1"	1-5/8	1/2	1/2	1-15/16	1/8	1-1/4 X 3/8	
RQC-1.0-W	RQC-1.0-W-CS	1"	1"	1-5/8	1/2	1/2	1-15/16	1/8	1-3/4 X 3/8	
RQC-1.25	RQC-1.25-CS	1-1/4	1-1/4	1-5/8	1/2	1/2	1-15/16	--	1-1/4 X 3/8	
RQC-1.25-W	RQC-1.25-W-CS	1-1/4	1-1/4	1-5/8	1/2	1/2	1-15/16	1/4	1-3/4 X 3/8	



RESHARPENABLE QUICK CHANGE INSERT GANG TYPE TOOL HOLDERS (Patent No. 5,345,846)

- Replaces stick type form tools.
- Center height adjustment never has to be reset after sharpening insert.
- Machine downtime less than one minute for insert resharpenings or replacement.



SEE PAGE 14 FOR INSERTS.

CAT. NO.	SHANK	INSERT
RQCCT-3/4	3/4" DIA.	1-1/8 X 5/16

RESHARPENABLE QUICK CHANGE INSERT CIRCULAR CUTOFF TOOLS FOR 5TH POSITION DAVENPORT (Patent No. 5,345,846)

- MOUNTS ON SWING ARM - SAME AS CIRCULAR TOOL.
- ONCE HOLDER IS SET ON CENTER NEVER NEEDS TO BE RESET.
- INSERTS ARE RESHARPENABLE 10 TO 15 TIMES (1/8").
- RESHARPENING FIXTURE AVAILABLE - SEE PAGE 15.
- INSERTS ALWAYS RETURN TO ORIGINAL DIAMETER AND LENGTH SETTINGS.
- INSERTS CAN BE CHANGED IN LESS THAN A MINUTE.
- INSERTS AVAILABLE TO FULL DIAMETER CAPACITY OF MACHINE.

MICRO-GRAIN CARBIDE INSERTS

BLADE CLOSE TO PICKOFF COLLET

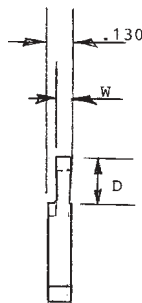
CAT. NO.	STYLE	W*	D
RQCT-047-0	A	.047	3/16
RQCT-063-0	A	.063	5/16
RQCT-078-0	A	.391	25/64
RQCT-094-0	A	.094	7/16
RQCT-125-0	A	.125	9/16

BLADE CLOSE TO SPINDLE

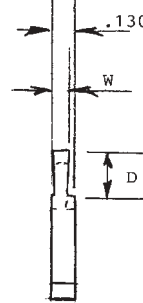
CAT. NO.	STYLE	W*	D
RQCT-047	B	.047	3/16
RQCT-063	B	.063	5/16
RQCT-078	B	.391	25/64
RQCT-094	B	.094	7/16



Cat. No. RQCDV-CO



STYLE "A"

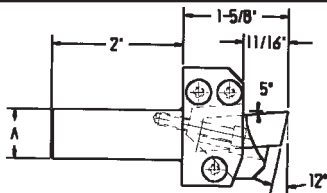


STYLE "B"

CUT OFF BLADE BLANKS FOR REWORKING TO YOUR REQUIREMENTS. GROUND HEIGHT, WIDTH & LENGTH	
	CAT. NO.
MICROGRAIN CARBIDE	RQCT-MIC
76PM HIGH SPEED STEEL	RQCT-A

- PRICES ON APPLICATION FOR WIDER INSERTS FOR PICKOFF COLLET FORM AND CUTOFF WORK.

* NOTE: CUTOFF WIDTH WILL BE REDUCED UP TO .001" PER SIDE (.002" TOTAL) AS INSERT IS RESHARPENED.



RESHARPENABLE QUICK CHANGE INSERT SHANK TYPE CUTOFF BLADE HOLDERS (Patent No. 5,345,846)

Uses same inserts as Davenport Holder shown above.
Inserts Resharpenable 10-15 times (1/8").

CAT. NO.	A
RQC-.75-CO	3/4"
RQC-.50-CO	1/2"
RQCGM20-CO	20MM

RESHARPENABLE QUICK CHANGE FORM TOOL INSERTS

Prices on application for inserts EDM'd to your part print.
 Inserts can be resharpened by grinding material from top surface and reused without resetting. Inserts can be resharpened 20 to 30 times. Adaptable for "Datum Point" Applications (See page 6)

RESHARPENABLE EDM READY BLANKS FOR THOSE WITH EDM FACILITIES

- Inserts are ground to 5/16" or 3/8" thickness only.
- Blanks oversize on width and length for EDMing.
- Blanks are recessed on back end for mounting in EDM fixture.



Resharpenable Insert

For best results, inserts should be cut in Wire EDM Fixtures shown on page 15.

Spacer

	INSERT SIZE - FOR FORM TOOLS								FOR SHAVE TOOLS	
	*5/16 X 3/4	5/16 X 1-1/8	5/16 X 1-3/4	3/8 X 3/4	3/8 X 1-1/4	3/8 X 1-3/4	3/8 X 2-1/4	3/8 X 2-3/4	3/8 X 1-1/8	3/8 X 1-3/4
C2 MICRO	RI-.75MIC	RI-1.125MIC	RI-1.75-N-MIC	RI-3/4MIC	RI-1.25MIC	RI-1.75MIC	RI-2.25MIC	RI-2.75MIC	RI-1.25MIC	RI-1.75MIC
C6 MICRO	RI-.75C6	RI-1.125C6	RI-1.75-N-C6	RI-3/4C6	RI-1.25C6	RI-1.75C6	RI-2.25C6	RI-2.75C6	RI-1.25C6	RI-1.75C6
76 PM HSS	RI-.75-A	RI-1.125-A	RI-1.75-N-A	RI-3/4-A	RI-1.25-A	RI-1.75-A	RI-2.25-A	RI-2.75-A	RI-1.25-A	RI-1.75-A
MAXAMET	RI-.75-M	RI-1.125-M	RI-1.75-N-M	RI-3/4-M	RI-1.25-M	RI-1.75-M	RI-2.25-M	RI-2.75-M	RI-1.25-M	RI-1.75-M
SPACER	RI-.75-3/32	RI-1.125-3/32	RI-1.75-N-3/32	RI-3/4-1/8	RI-1.25-1/8	RI-1.75-1/8	RI-2.25-1/8	RI-2.75-1/8	RI-1.25-1/8	RI-1.75-1/8

**Note: 5/16 x 3/4 blanks are used for 5/16 x 3/8 Inserts.*

QUICK CHANGE (THROWAWAY) FORM TOOL INSERTS

Prices on application for inserts EDM'd to your part print.

- For those who don't want to resharpen inserts but still want to enjoy advantages of "RQC" Holders
- Adaptable for "Datum Point" applications (see page 6)

EDM READY (THROWAWAY) BLANKS FOR THOSE WITH EDM FACILITIES

- Inserts are ground to 1/8" thickness only.
- Blanks oversize on width and length for EDMing.
- Blanks are recessed on back end for mounting in EDM fixture.



Throwaway Insert

For best results, inserts should be cut in Wire EDM Fixtures shown on page 15.

Back-up Anvil

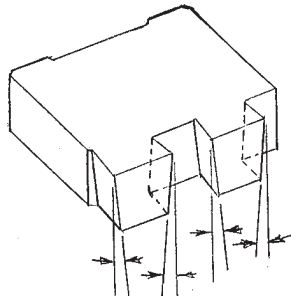
	INSERT SIZE - FOR FORM TOOLS								- FOR SHAVE TOOLS	
	*1/8 X 3/4	1/8 X 1-1/8	1/8 X 1-3/4-N	1/8 X 3/4	1/8 X 1-1/4	1/8 X 1-3/4	1/8 X 2-1/4	1/8 X 2-3/4	1/8 X 1-1/8	1/8 X 1-3/4
C2 MICRO	TA-.75MIC	TA-1.25MIC	TA-1.75MIC	TA-3/4MIC	TA-1.25MIC	TA-1.75MIC	TA-2.25MIC	TA-2.75MIC	TA-1.25MIC	TA-1.75MIC
C6 MICRO	TA-.75C6	TA-1.25C6	TA-1.75-C6	TA-3/4C6	TA-1.25C6	TA-1.75-C6	TA-2.25C6	TA-2.75C6	TA-1.25C6	TA-1.75-C6
76PM HSS	TA-.75-A	TA-1.25-A	TA-1.75-A	TA-3/4-A	TA-1.25-A	TA-1.75-A	TA-2.25-A	TA-2.75-A	TA-1.25-A	TA-1.75-A
MAXAMET	TA-.75-M	TA-1.25-M	TA-1.75-M	TA-3/4-M	TA-1.25-M	TA-1.75-M	TA-2.25-M	TA-2.75-M	TA-1.25-M	TA-1.75-M
ANVIL	BA-.75-3/16	BA-1.125-3/16	BA-1.75-3/16	BA-3/4-1/4	BA-1.25-1/4	BA-1.75-1/4	BA-2.25-1/4	BA-2.75-1/4	BA-1.25-1/4	BA-1.75-1/4

**Note: 1/8 x 3/4 blanks are used for 1/8 x 3/8 Inserts.*

QUICK CHANGE (THROWAWAY) FORM TOOL INSERTS WITH TOP TO BOTTOM CLEARANCE

Prices on application for inserts EDM'd to your part print.

Top to bottom clearance reduces side rubbing and tool wear.
 Adaptable for "Datum Point" Applications.



We can supply inserts with top to bottom clearance (see diagram) that reduces side rubbing, improves part finish and increases insert resharpenable life by reducing the amount of material that has to be removed with resharpening.

CENTERING GAGES FOR RQC INSERT HOLDERS



- Gages are same (B) length as standard inserts.
- Gages are "L" shaped and overhang holder for easy setting to center.
- Just clamp in holder and set to center as you would normally.

CAT. NO.	A	B	C
RQCG-5/16	3/4	.630	.500
RQCG-3/8	1-1/4	.956	.500

INSERT RESHARPENING FIXTURES

- For resharpener top surface of inserts
- Flexible jaw clamps insert securely
- For use on surface grinder with cup or dish wheel



CAT. NO.	INSERT WIDTH/TYPE
RQCSF	1-1/4" FORM
RQCSF-W	1-3/4" FORM/SHAVE
RQCSF00	3/4" FORM
RQCSF-DS	1-1/8" FORM/SHAVE
RQCSF00-N	3/8" FORM
RQCSF-CO	.130 CUTOFF
RQCSF-XW	2-1/4" FORM
RQCSF-WW	2-3/4" FORM

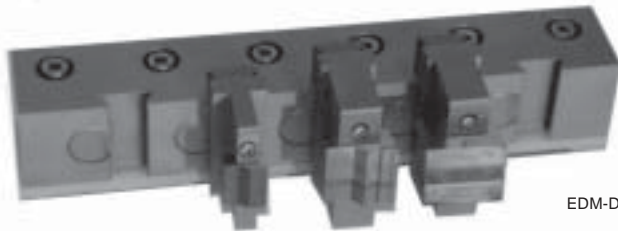
WIRE EDM MACHINING FIXTURES FOR RESHARPENABLE AND THROW-AWAY INSERTS

- Made of heat treated stainless steel
- Supplied with clamps for inserts and backup spacers
- Locates on recess in back side of insert for EDMing of all four sides
- Reversible for left hand cut



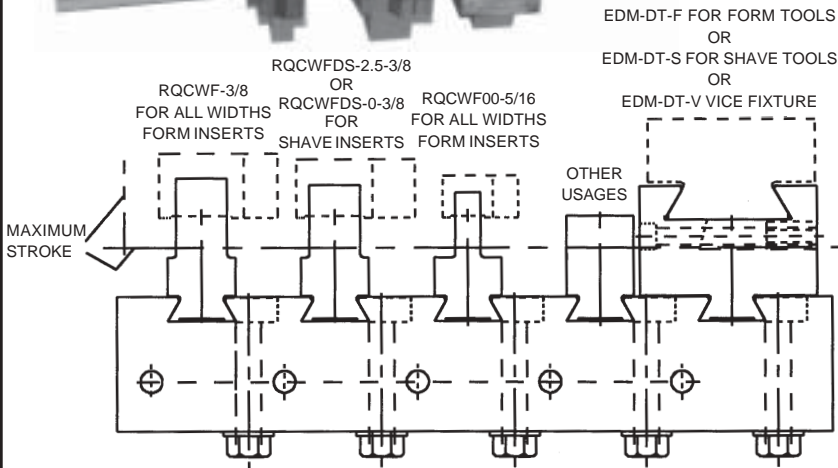
CATALOG NO. (INSERT WIDTHS)	NUMBER OF INSERTS	TYPE	OFFSET ANGLE
RQCWF (1.250 TO 2.750)	3 - 3/8" or 3 + 1 SPACER	SHARPENABLE	17°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	
RQCWF00 (.375 TO 1.750)	3 - 5/16" or 3 + 1 SPACER	SHARPENABLE	17°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	
RQCWFDS (1.125)	3 - 3/8" or 3 + 1 SPACER	SHARPENABLE	2-1/2°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	
RQCWFDS-0 (1.750)	3 - 3/8" or 3 + 1 SPACER	SHARPENABLE	0°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	

BASE PLATE AND FIXTURES FOR MULTIPLE EDMING OF INSERTS AND DOVETAIL TOOLS



WIRE EDM MACHINING FIXTURES FOR RESHARPENABLE AND THROW-AWAY INSERTS

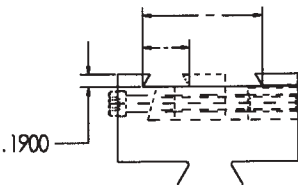
- Made of heat treated stainless steel
- Supplied with clamps for inserts and backup spacers
- Locates on recess in back side of insert for EDMing of all four sides
- Reversible for left hand cut



CATALOG NO. (INSERT WIDTHS)	NUMBER OF INSERTS	TYPE	OFFSET ANGLE
RQCWF-3/8 (1.250 TO 2.750)	3 - 3/8" or 3 + 1 SPACER	SHARPENABLE	17°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	
RQCWF00-5/16 (.375 TO 1.750)	3 - 5/16" or 3 + 1 SPACER	SHARPENABLE	17°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	
RQCWFDS-2.5-3/8 (1.125)	3 - 3/8" or 3 + 1 SPACER	SHARPENABLE	2-1/2°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	
RQCWFDS-0-3/8 (1.750)	3 - 3/8" or 3 + 1 SPACER	SHARPENABLE	0°
	8-1/8" or 6 + 1 BACKUP	THROW-AWAY	

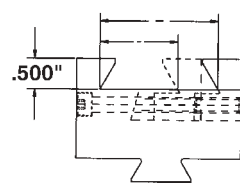
Base Plate Cat. No. RQCEDM-5A

EDM MACHINING FIXTURE ADJUSTABLE FOR DOVETAIL SHAVE TOOLS FROM .714" TO 1.787"



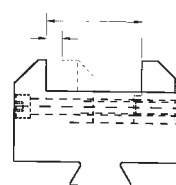
Cat. No. EDM-DT-S

EDM MACHINING FIXTURE ADJUSTABLE FOR DOVETAIL FORM TOOLS FROM 1.250" TO 1.897"



Cat. No. EDM-DT-F

EDM VISE FIXTURE ADJUSTABLE FROM 1/4" TO 1-1/2"



Cat. No. EDM-DT-V

- HOLDS ANY FIVE FIXTURES FOR UNATTENDED OPERATION.
- EDM FIXTURES ARE DOVETAIL MOUNTED AT ACCURATE CENTER TO CENTER LOCATION TO FACILITATE PROGRAMMING.
- MADE OF HEAT TREATED STAINLESS STEEL.
- MACHINE MOUNTING HOLES LOCATED TO SUIT YOUR EDM MACHINE.