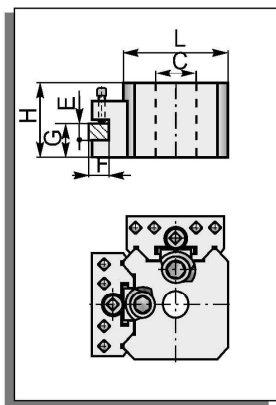


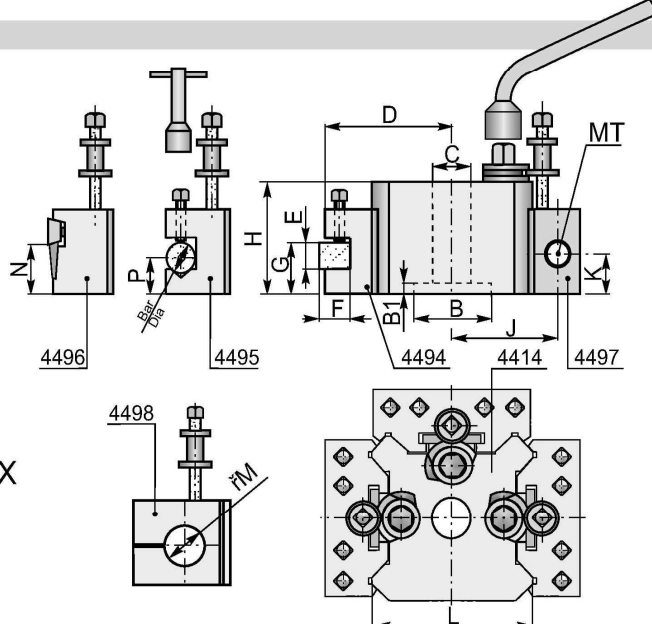
Type 4414

QUICK CHANGE TOOLPOST

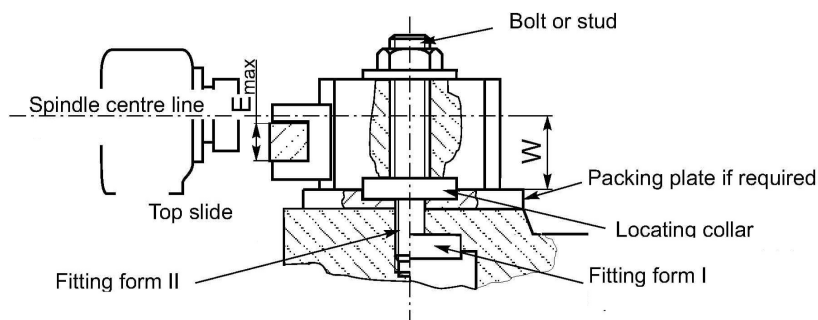
Size T.00.M
T.00.B
T.0



Size T.1
T.1.X
T.2
T.2.T
T.3
T.3.HX



Size	H	B	B ₁	C	D	E	F	G _{max}	G _{min}	Bar Dia	P _{max}	P _{min}	Taper	J	K _{max}	K _{min}	L	N	M
T.00.M	37,0	—	—	11,2	50,0	10,0	11,0	27,0	17,0	11,0	22,5	12,5	—	—	—	—	58,0	16,0	—
T.00.B	42,0	—	—	16,0	50,0	10,0	11,0	32,0	17,0	11,0	27,5	12,5	—	—	—	—	58,0	16,0	—
T.0	51,0	22,22	5,0	19,0	62,0	19,0	13,0	36,5	20,5	16,0	32,0	16,0	1	52,5	28,5	16,0	73,0	27,0	19,0
T.1	63,5	31,75	6,5	19,0	62,0	19,0	13,0	46,0	30,0	16,0	44,5	25,5	1	52,5	41,0	22,0	73,0	27,0	19,0
T.1.X	73,0	31,75	6,5	19,0	62,0	19,0	13,0	57,0	35,0	16,0	54,0	32,0	1&2	52,5	51,0	28,5	73,0	27,0	19,0
T.2	71,5	44,45	8,0	25,5	74,5	19,0	19,0	52,5	36,5	19,0	46,0	24,0	2	65,0	47,5	27,0	97,0	33,5	25,4
T.2.T	76,0	44,45	8,0	25,5	84,0	25,5	25,5	58,5	39,5	19,0	50,0	24,0	2	70,0	51,0	27,0	106,0	33,5	25,4
T.3	95,5	50,80	9,5	25,5	101,5	31,5	25,5	74,5	51,0	25,5	51,0	28,5	3	85,5	58,2	36,5	125,5	39,5	38,0
T.3.HX	108,0	50,50	12,5	25,5	101,5	31,5	25,5	84,0	62,0	25,5	65,0	41,0	3	85,5	58,2	36,5	125,5	39,5	38,0



Size	W	max. tools size max. wym. narz. E _{max}	bolt size średnica trzp.
T.00	33,5-19,0	12	11,5
T.0	36,5-21,0	12	16,0
T.1	46,0-30,0	20	16,0
T.2	54,0-36,5	20	16,0
T.2.T	55,5-40,0	25	16,0
T.3	73,0-51,0	32	24,0

Dimensions in mm *

Fitting Instructions

The Toolpost body is fixed to the centre lathe topline with a centre bolt or stud (see sketch). Where a tee slot is provided, a tee bolt of the appropriate size is employed.

The body is set square on the topline, flat face towards the operator; a hole should then be drilled and reamed into the topline to register with the locating pin. The depth of this hole need not exceed 8 mm.

The precision ground recess in the base of the main body is for locating purposes and a collar should be fitted as illustrated.

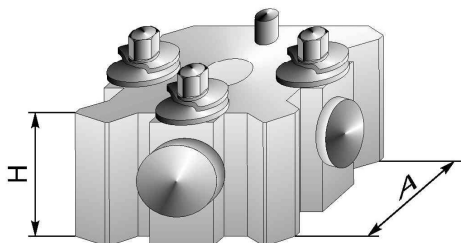
Operating Instructions

1. Tool height is adjusted by the knurled sleeve and locked by the screw with the key provided.
2. Clamping and release of the toolholders is with a single action of the operating key.
3. Tools should be re-ground without removing them from the toolholders.
4. Sets of toolholders can be stored for specific component production and called up in the same way as other tooling fixtures.
5. The number of operations and tool changes is limited only by the number of toolholders used.

Toolholders are available separately for all sizes of Quick Change Toolposts

Type 4414

QUICK CHANGE TOOLPOST



Code No. 0642 444...	PKWiU 29 402 135...	TYPE	A x H	LATHE CAPACITY	⚡ kg
141 200	434 414 001	T.00.M	48x37	Up to 89 mm	0,9
141 301	434 414 003	T.00.B	48x42	Up to 89 mm	1,1
142 109	434 414 100	T.0	62x51	Up to 114 mm	2,0
142 200	434 414 101	T.1	62x63	114 mm to 127 mm	2,3
142 302	434 414 102	T.1.X	62x73	114 mm to 127 mm	2,6
141 607	434 414 200	T.2	82x71	127 mm to 203 mm	4,6
141 505	434 414 201	T.2.T	82x76	127 mm to 203 mm	5,8
142 404	434 414 300	T.3	100x92	203 mm to 292 mm	10,8
142 506	434 414 301	T.3.HX	100x108	203 mm to 292 mm	11,5

Type 4494

STANDARD TOOLHOLDERS

Code No. 0642 444...	PKWiU 29 402 135...	Size	USED ON	b x h	⚡ kg
941 106	434 494 010	48	T.00M T.00B	58x27	0,23
942 107	434 494 100	62N	T.0	73x35	0,49
942 209	434 494 101	62	T.1 T.1X	73x44	0,53
941 401	434 494 200	82N	T.2	98,5x50	1,00
941 300	434 494 201	82	T.2T	98,5x57	1,10
942 300	434 494 300	100	T.3 T.3HX	124x70	2,00

Type 4496

P/O TOOLHOLDERS

Code No. 0642 444...	PKWiU 29 402 135...	Size	USED ON Stosować do	b x h	⚡ kg
961 102	434 496 010	48	T.00M T.00B	58x32	0,32
962 205	434 496 100	62	T.0,T.1 T.1X	73x47,5	0,68
961 306	434 496 210	82	T.2 T.2T	98,5x57	1,44
962 307	434 496 300	100	T.3 T.3HX	124x70	2,50

Type 4498

TOOLHOLDERS for boring bars

Code No. 0642 444...	PKWiU 29 402 135...	Size	USED ON	ØD	⚡ kg
980 200	434 498 101	62	T.0,T.1 T.1X	19	0,70
980 301	434 498 201	82	T.2 T.2T	25,4	1,50
980 505	434 498 301	100	T.3 T.3HX	38	2,60

Type 4495

VEE TOOLHOLDERS

Code No. 0642 444...	PKWiU 29 402 135...	Size	USED ON	Ød _{max}	⚡ kg
951 104	434 495 010	48	T.00M T.00B	11,0	0,24
952 105	434 495 100	62N	T.0	16,0	0,50
952 207	434 495 101	62	T.1 T.1X	16,0	0,58
951 400	434 495 200	82N	T.2	19,0	1,00
951 308	434 495 201	82	T.2T	19,0	1,10
952 309	434 495 300	100	T.3 T.3HX	25,5	2,00

Type 4497

MORSE TAPER TOOLHOLDERS

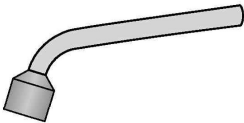
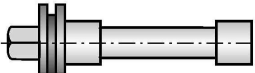




Code No. 0642 444...	PKWiU 29 402 135...	Size	USED ON	Morse	⚡ kg
972 101	434 497 100	62/1N	T.0	1	0,50
972 203	434 497 101	62/1	T.1 T.1X	1	0,60
972 229	434 497 102	62/2	T.1 T.1X	2	0,90
971 304	434 497 205	82/2	T.2 T.2T	2	1,20
972 305	434 497 305	100/3	T.3 T.3HX	3	2,50




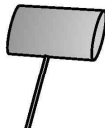

Type 4499

TOOLHOLDERS for boring bars

Code No. 0642 444...	PKWiU 29 402 135...	Size	USED ON	ØD	⚡ kg
990 208	434 499 100	62	T.0,T.1 T.1X	25	0,70
990 300	434 499 200	82	T.2 T.2T	32	1,30
990 401	434 499 300	100	T.3 T.3HX	40	4,50

SPARE PARTS FOR TOOLPOST

NAME OF PART	Code No. 0642 981...	PKWiU 29 402 231...	USED ON
HEX WRENCH 	446 008	414 414 631	T.00M, T.00B
	446 100	414 414 746	T.0, T.1, T.1X
	446 201	414 414 787	T.2, T.2T
	446 303	414 414 986	T.3, T.3HX
CLAMP BOLT 	441 003	414 414 632	T.00M
	441 105	414 414 633	T.00B
	441 207	414 414 741	T.0, T.1, T.1X
	441 309	414 414 782	T.2
	441 400	414 414 783	T.2T
	441 502	414 414 981	T.3, T.3HX
STOP 	449 013	414 494 720	T.00M
	449 000	414 494 630	T.00B
	449 102	414 494 740	T.0, T.1, T.1X
	449 204	414 494 780	T.2, T.2T
	449 306	414 494 980	T.3, T.3HX
LOCATION PIN 	442 208	414 414 742	T.0
	442 300	414 414 743	T.1, T.1X
	442 401	414 414 784	T.2, T.2T
	442 503	414 414 982	T.3
	442 605	414 414 983	T.3HX
SPRING 	443 005	414 414 634	T.00M, T.00B
	443 107	414 414 744	T.0, T.1, T.1X
	443 209	414 414 785	T.2, T.2T
	443 300	414 414 984	T.3, T.3HX
CLAMP PAD 	440 002	414 414 630	T.00M
	440 104	414 414 631	T.00B
	440 206	414 414 740	T.0, T.1, T.1X
	440 308	414 414 780	T.2
	440 400	414 414 781	T.2T
	440 501	414 414 980	T.3, T.3HX

NAME OF PART	Code No.	PKWiU	USED ON
STUD 	U-5515/1	—	T.00M
	U-5515/0	—	T.00B
	U-8578/0	—	T.0, T.1, T.1X
	U-5754/0	—	T.2, T.2T
	U-5997/0	—	T.3, T.3HX
SQUARE HEAD SCREW 	U-5516/1	—	T.00M
	U-5516/0	—	T.00B
	U-6877/0	—	T.0, T.1, T.1X
	U-7386/0	—	T.2, T.2T
	U-6881/0	—	T.3, T.3HX
STOP SCREW 	U-5517/1	—	T.00M
	U-5517/0	—	T.00B
	U-6877/1	—	T.0, T.1, T.1X
	U-7386/1	—	T.2, T.2T
	U-6881/1	—	T.3, T.3HX
T WRENCH 	448 000	414 414 639	T00M, T00B
NAME OF PART	Code No. 0642 982...	PKWiU 29 402 231...	USED ON
T WRENCH 	700 201	414 414 210	T0, T1, T1X
	700 507	414 414 260	T2, T2T
	700 802	414 414 330	T3, T3HX