

NPA

NEW

Member IMC Group
Ingersoll
Cutting Tools

New Product Announcement

NEW-381-1 • 07/2026

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TURNING

Shank Sizes

Inch: .500 and .625"

Metric: 12 and 16 mm

Heads (Turning Inserts)

SCLCR (CC_T32.5...)
SDJCR (DC_T32.5...)
SVJBR (VB_T22...)
SVJCR (VC_T22...)
SDJNR (DN_X2.22...)
SDJNR (DN_3.53.5...)
SFXCR - **Back Turn** (BTVC...)
SDJCR - **Y-Axis** (DC_T32.5...)

Heads (Grooving Inserts)

TTER/L (T-Clamp Ultra+)
TQHR/L (GoldFlex20)
TQHR - **Y-Axis** (GoldFlex20)

Heads (All)

With or without CoolBurst
(high pressure thru coolant)

FLEXTURN™

Time-Saving Modular Head and Holder System for Swiss Machines

- » Improved productivity due to reduced setup time.
- » Rigid clamping between shanks and heads, and excellent repeatability.
- » Reduced inventory due to the ability to mount multiple heads on one shank.



See it in
action! »



WINSPEED™
ADVANCED MACHINING

ingersoll-imc.com



Overview

Some tool holders within Swiss machines require the entire tool to be removed before inserts can be changed, making the process cumbersome and time-consuming.

With Ingersoll's new **FlexTurn** modular head product line, inserts can be indexed outside the machine by quickly and easily removing and replacing the modular head. With the shank remaining in the tool post, downtime is minimized.

By indexing the inserts "off line", FlexTurn also provides a less obstructive and more accurate way to change the cutting edge, also eliminating the chance of dropping and losing screws and inserts inside the machine.

Features & Benefits

- Modular head type holders for Swiss machines.
- Easy replacement of modular heads and inserts.
- Improved productivity due to reduced setup time.
- Rigid clamping between shanks and heads, and good repeatability.
- Reduced inventory due to the ability to mount multiple heads on one shank.
- Variety of modular heads available for turning, grooving, and parting applications.
- **COOLBURST™** system improves chip control and tool life (-TB holders) 
- Minimized risk of losing holder's spare parts and inserts.
- Error proof modular head and shank assembly system.



Assembly Overview

► Modular head and shank assembly for external machining applications

External coolant supply				
 QEI-SCLCR	 QE1-SDJCR	 QE1-SVJB(C)R	 QE1-SDJNR	 QE1-SDJNR
 QE1B-SVXCR	 QE1-TTER	 QE1-TTEL	 QE1-TQHR	 QE1-TQHL
COOLBURST High-pressure internal coolant supply				
 QE1-SCLCR-TB	 QE1-SDJCR-TB	 QE1-SVJB(C)R-TB	 QE1-SDJNR-TB	 QE1-SDJNR-TB
 QE1B-SVXCR-TB	 QE1-TTER-TB	 QE1-TTEL-TB	 QE1-TQHR-TB	 QE1-TQHL-TB


QE1-S12N-TB
 (Neutral type, 12x12 mm)


QE1-S12.7R-TB
 (Right hand type, .500")


QE1-S15.9R-TB
QE1-S16R-TB
 (Right hand type, .625"/16x16 mm)

► Right hand head and shank assembly for Y-axis machining

External coolant supply	
 QE1Y-SDJCR	 QE1Y-TQHR
COOLBURST High-pressure internal coolant supply	
 QE1Y-SDJCR-TB	 QE1Y-TQHR-TB


QE1-S12N-TB
 (Neutral type, 12x12 mm)

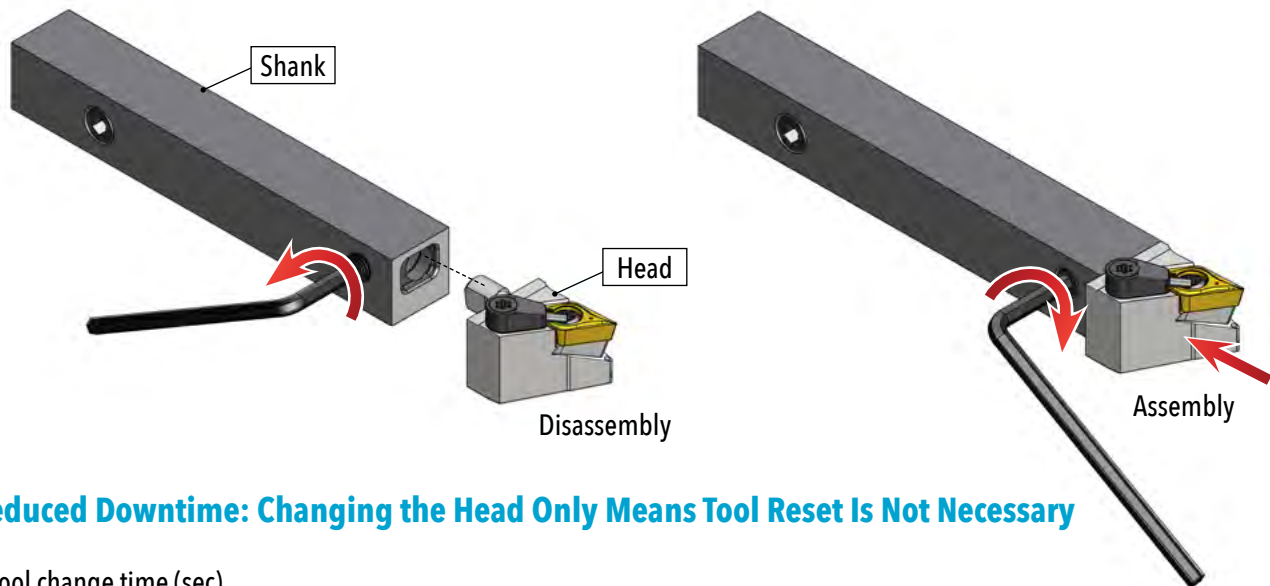

QE1-S12.7L-TB
 (Left hand type, .500")


QE1-S15.9L-TB
QE1-S16L-TB
 (Left hand type, .625"/16x16 mm)

Modular Heads

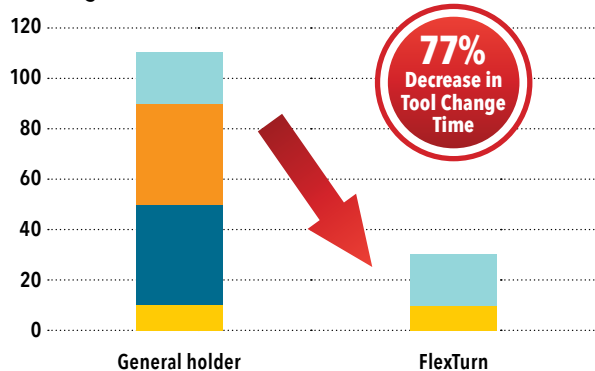
Easy Modular Head Replacement

- The shanks remain in the tool post.
- Disassemble the head from the shank with two rotations of the screw.
- Right hand modular heads for turning can be assembled with neutral and right hand shanks.
- Right hand modular heads for Y-axis machining can be assembled with neutral and left hand shanks.
- Modular heads for grooving can be assembled with neutral and right hand shanks.



Reduced Downtime: Changing the Head Only Means Tool Reset Is Not Necessary

Tool change time (sec)



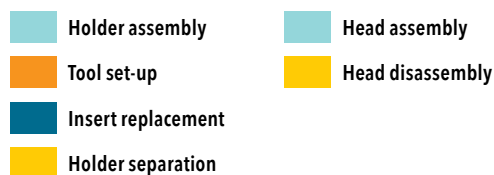
77%
Decrease in
Tool Change
Time



General holder



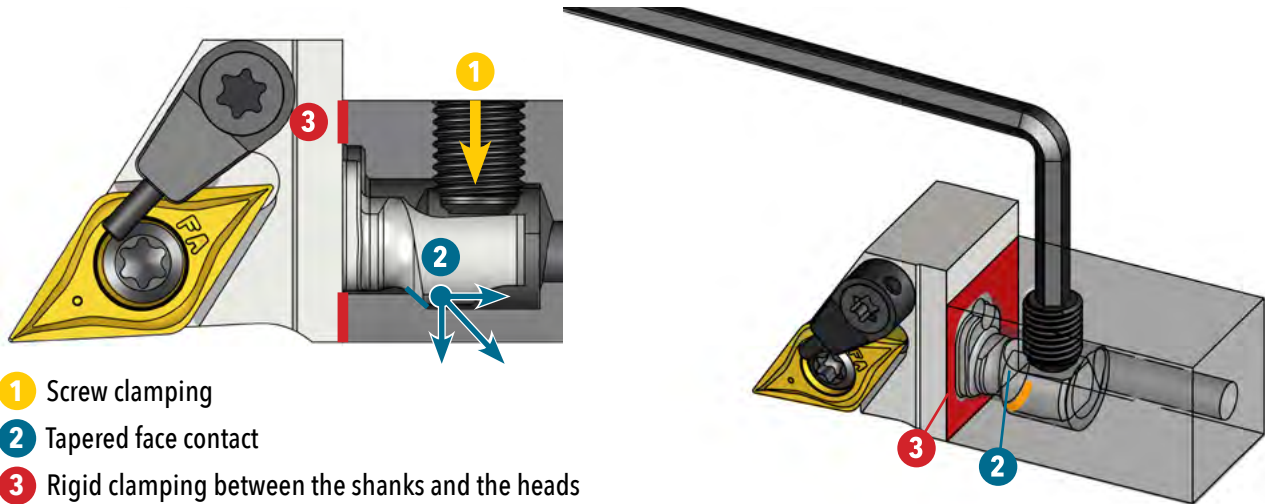
FlexTurn



Rigidity and Stability Features

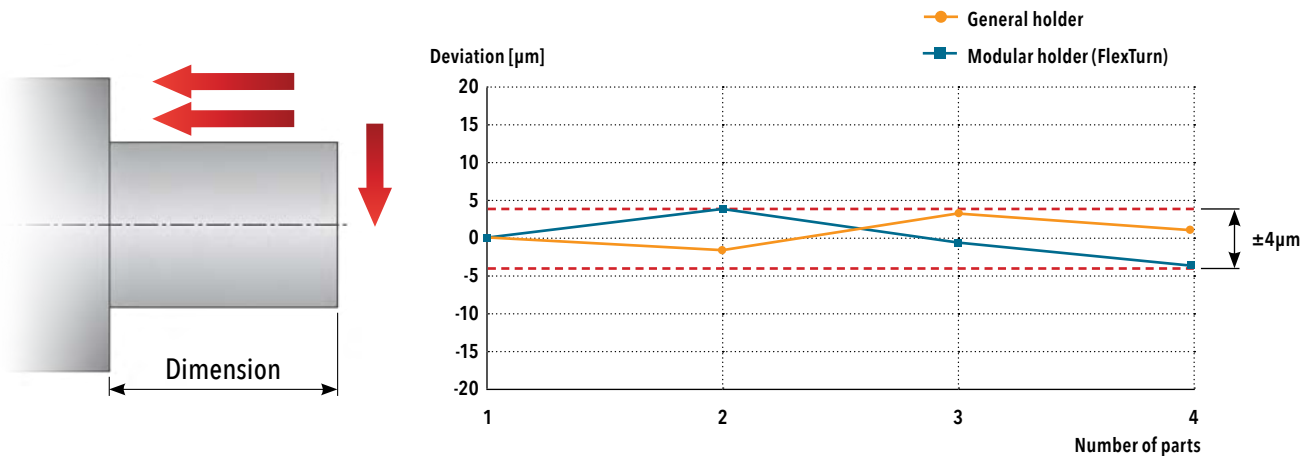
Rigid Clamping and Good Repeatability

Ingersoll's unique assembly mechanism provides higher rigidity than the competitors' products. Combining the taper with the lever principle ensures a rigid assembly.



Equivalent Machining Stability of a Conventional Holder

Ingersoll's FlexTurn features a unique and robust fastening structure that provides a level of machining displacement equivalent to that of a conventional holder.



	Holder	Insert	Cutting Speed (sfm)	Feed (ipr)	Testing Procedure
General holder	SDJCR 1616 K11-SH	DCGT 11T302M SH-F TT4430	400	.002"	Machining
Modular holder (FlexTurn)	QE1 SDJCR 11-TB + QE1 S16R-TB	DCGT 11T302M SH-F TT4430			1. Head disassembly 2. Head assembly 3. Machining

Coolant Feature

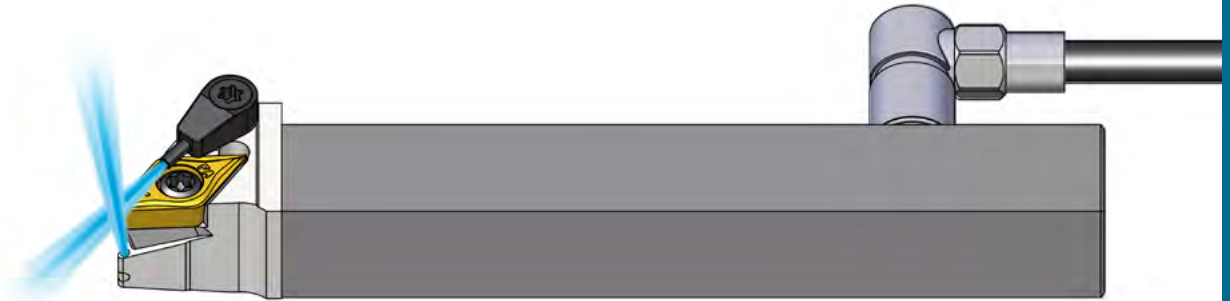
COOLBURST™ High-Pressure Coolant System

Improved chip control and tool life due to focused, high-pressure coolant on the insert's cutting edge.

Coolant



« This icon denotes a product with a CoolBurst coolant feature.



Part Number Designation System

► Modular Head

Q	E	1	(Y)	-	SDJCR	-	11	-	(TB)
1	2	3	4		5		6		7

- 1 - Quick change system
- 2 - External holder
- 3 - Holder type (1 = Swiss machines; 2 = ISO type)
- 4 - Option (Y = Y-axis machining; B = back turning)
- 5 - Head type (Identical to holder designation system)
- 6 - Cutting edge length (ISO)
- 7 - Option (TB = high-pressure coolant)

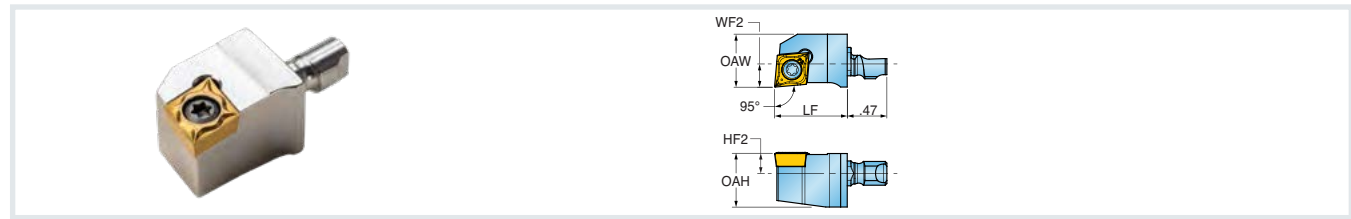
► Shank

Q	E	1	-	S16	-	R	-	(TB)
1	2	3		4		5		6

- 1 - Quick change system
- 2 - External holder
- 3 - Holder type (1 = Swiss machines; 2 = ISO type)
- 4 - Shank size (12 = 12 mm; 12.7 = .500"; 15.9 = .625"; 16 = 16 mm)
- 5 - Hand type (R = right hand; L = left hand; N = neutral)
- 6 - Option (TB = high-pressure coolant)

Series QE1-SCLCR

FOR EXTERNAL TURNING (CC_T INSERTS)



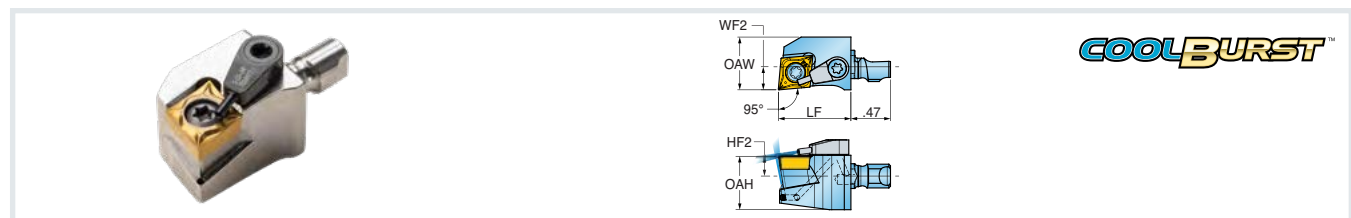
Approach Angle: 95°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SCLCR-09	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	CC_T32.5... (CC_T09T3...)

Coolant



Series QE1-SCLCR-TB

FOR EXTERNAL TURNING WITH HIGH PRESSURE COOLANT (CC_T INSERTS)



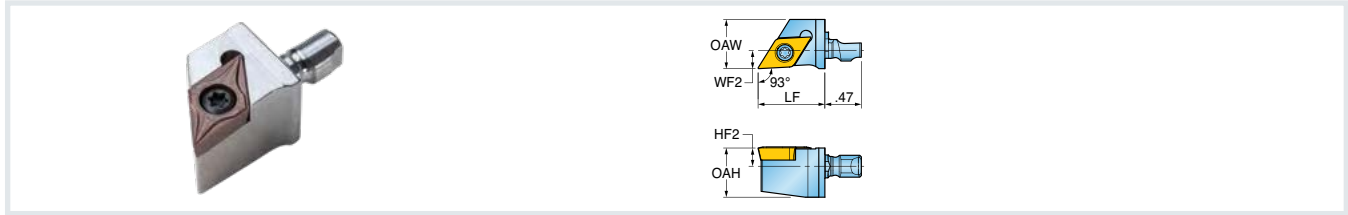
Approach Angle: 95°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SCLCR-09-TB	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	CC_T32.5... (CC_T09T3...)

Hardware

Part Number	Screw	Oil Supply Unit	Torx Driver
QE1-SCLCR-09	S035080I	-	T15
QE1-SCLCR-09-TB	S035080I	SC-CU-TB	T15

Series QE1-SDJCR

FOR EXTERNAL TURNING (DC_T INSERTS)



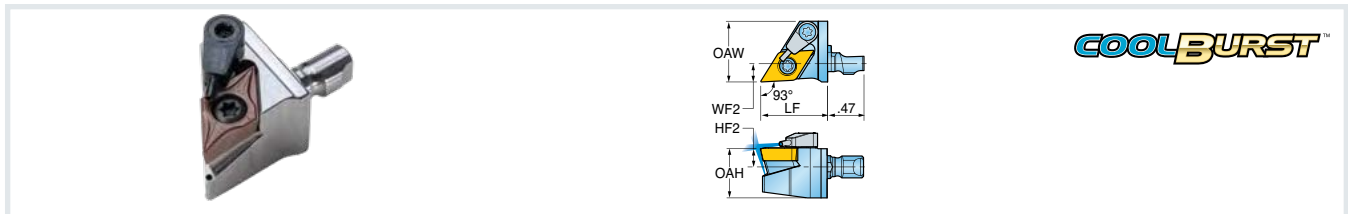
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
	QE1-SDJCR-11	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	DC_32.5... (DC_11T3...)

Coolant



Series QE1-SDJCR-TB

FOR EXTERNAL TURNING WITH HIGH PRESSURE COOLANT (DC_T INSERTS)



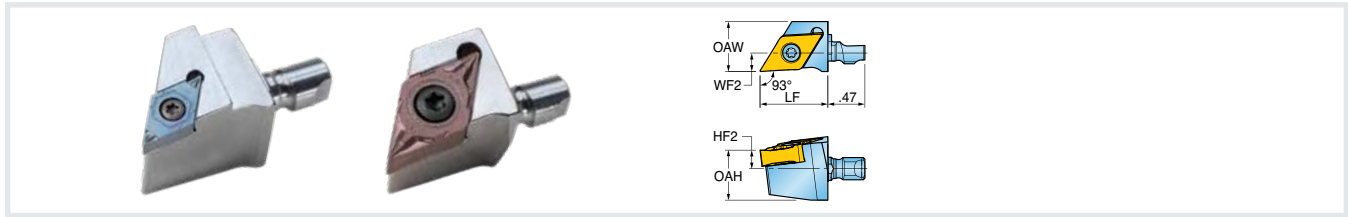
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
	QE1-SDJCR-11-TB	0.638	0.866	0.787	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	DC_32.5... (DC_11T3...)

Hardware

Part Number	Screw	Oil Supply Unit	Torx Driver
QE1-SDJCR-11	S035080I	-	T 15
QE1-SDJCR-11-TB	S035080I	S-CU-TB	T 15

Series QE1-SDJNR

FOR EXTERNAL TURNING



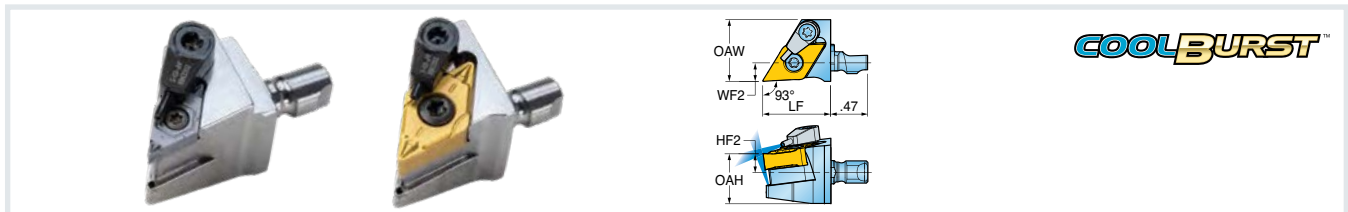
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SDJNR-0803	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB	DN_X2.22... (DN_X0803...)
	QE1-SDJNR-1305	0.638	0.866	0.638	0.236	0.276	QE1-S15.9R-TB QE1-S16R-TB	DN_3.53.5... (DN_1305...)

Coolant



Series QE1-SDJNR-TB

FOR EXTERNAL TURNING WITH HIGH PRESSURE COOLANT



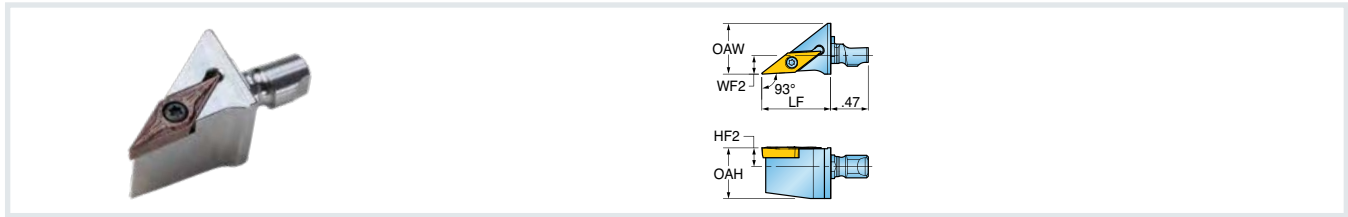
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SDJNR-0803-TB	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB	DN_X2.22... (DN_X0803...)
	QE1-SDJNR-1305-TB	0.638	0.866	0.787	0.236	0.276	QE1-S15.9R-TB QE1-S16R-TB	DN_3.53.5... (DN_1305...)

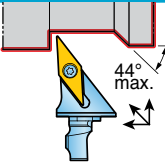
Hardware

Part Number	Screw	Oil Supply Unit	Torx Driver
QE1-SDJNR-0803	TS-25D060/HG-P	-	T7P
QE1-SDJNR-0803-TB	SM25-060-90	S-CU-TB	T7P
QE1-SDJNR-1305	SE02-78	-	T15
QE1-SDJNR-1305-TB	SE02-78	S-CU-TB	T15

Series QE1-SVJBR

FOR EXTERNAL TURNING (VB_T INSERTS)



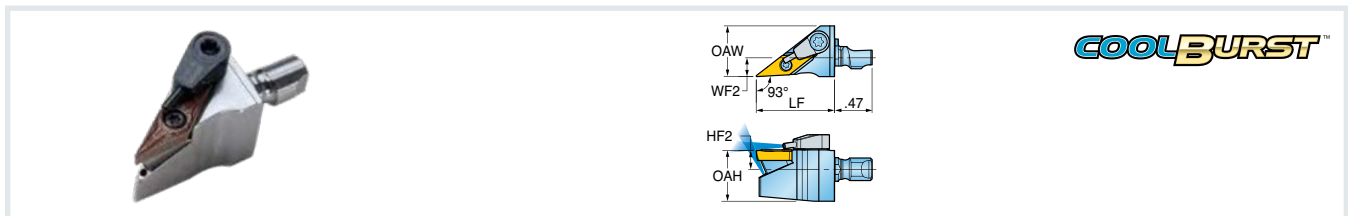
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SVJBR-11	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	VB_22... (VB_1103...)

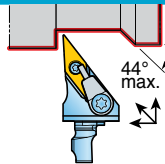
Coolant



Series QE1-SVJBR-TB

FOR EXTERNAL TURNING WITH HIGH PRESSURE COOLANT (VB_T INSERTS)



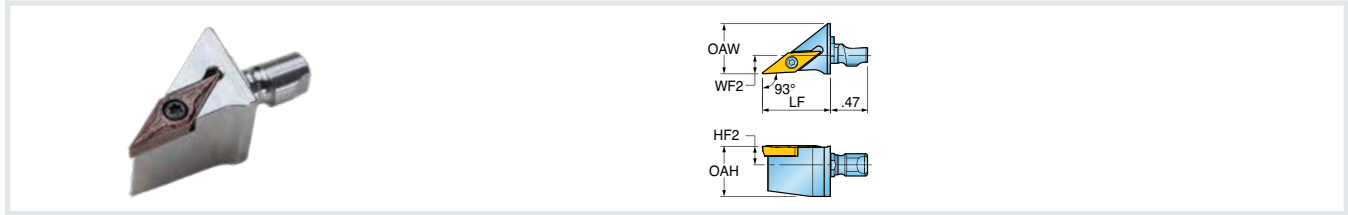
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SVJBR-11-TB	0.638	0.984	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	VB_22... (VB_1103...)

Hardware

Part Number	 Screw	 Oil Supply Unit	 Torx Driver
QE1-SVJBR-11	S025065I	-	T7
QE1-SVJBR-11-TB	S025065I	S-CU-TB	T7

Series QE1-SVJCR

FOR EXTERNAL TURNING (VC_T INSERTS)



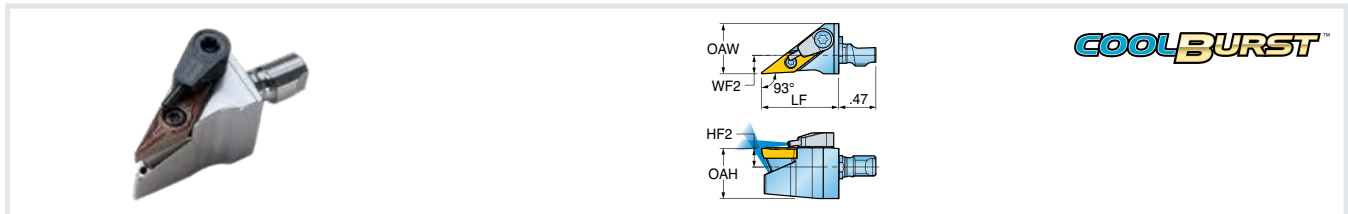
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SVJCR-11	0.638	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	VC_22... (VC_1103...)

Coolant



Series QE1-SVJCR-TB

FOR EXTERNAL TURNING WITH HIGH PRESSURE COOLANT (VC_T INSERTS)



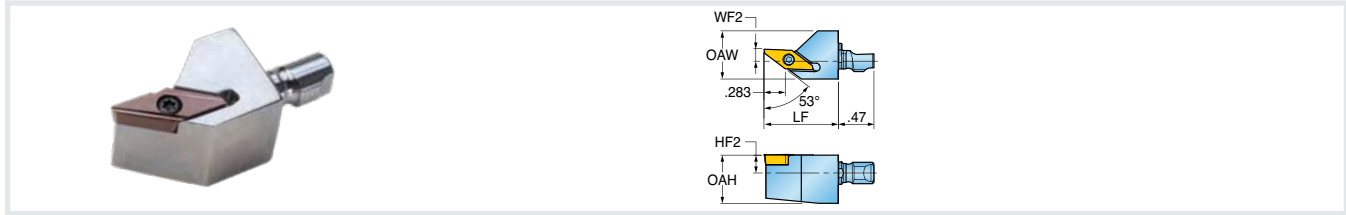
Approach Angle: 93°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1-SVJCR-11-TB	0.638	0.984	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	VC_22... (VC_1103...)

Hardware

Part Number	Screw	Oil Supply Unit	Torx Driver
QE1-SVJCR-11	S025065I	-	T7
QE1-SVJCR-11-TB	S025065I	S-CU-TB	T7

Series QE1B-SVXCR

FOR EXTERNAL BACK TURNING (BTVC INSERTS)



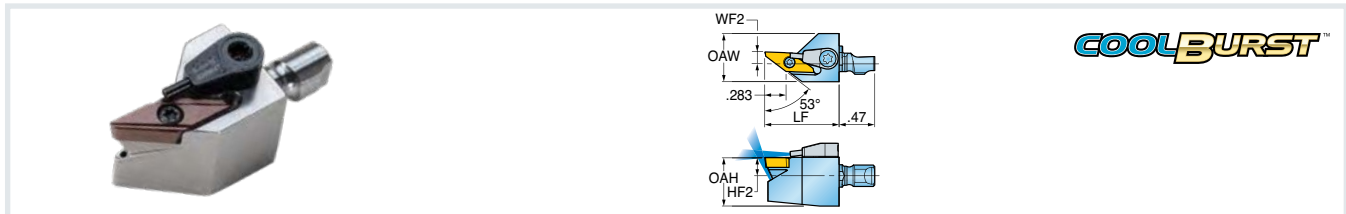
Approach Angle: 53°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1B-SVXCR-11	0.638	0.984	0.638	0.236	0.118	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	BTVC22... (BTVC1103...)

Coolant



Series QE1B-SVXCR-TB

FOR EXTERNAL BACK TURNING WITH HIGH PRESSURE COOLANT (BTVC INSERTS)



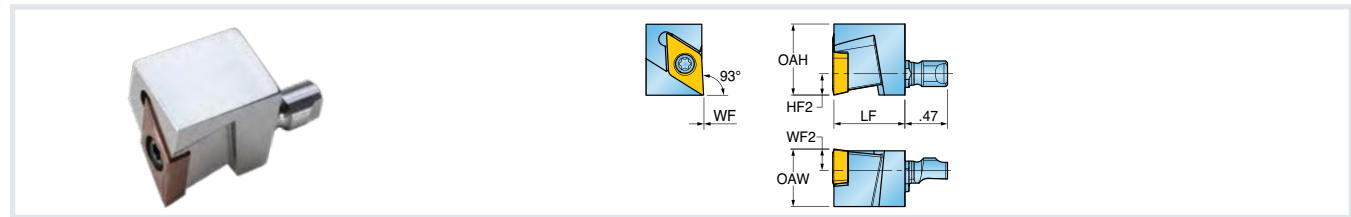
Approach Angle: 53°	Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH								
	QE1B-SVXCR-11-TB	0.638	0.984	0.638	0.236	0.118	QE1-S12N-TB QE1-S12.7R-TB QE1-S15.9R-TB QE1-S16R-TB	BTVC22... (BTVC1103...)

Hardware

Part Number	Screw	Oil Supply Unit	Torx Driver
QE1B-SVXCR	S025065I	-	T7
QE1B-SVXCR-TB	S025065I	S-CU-TB	T7

Series QE1Y-SDJCR

FOR Y-AXIS TURNING (DC_T INSERTS)



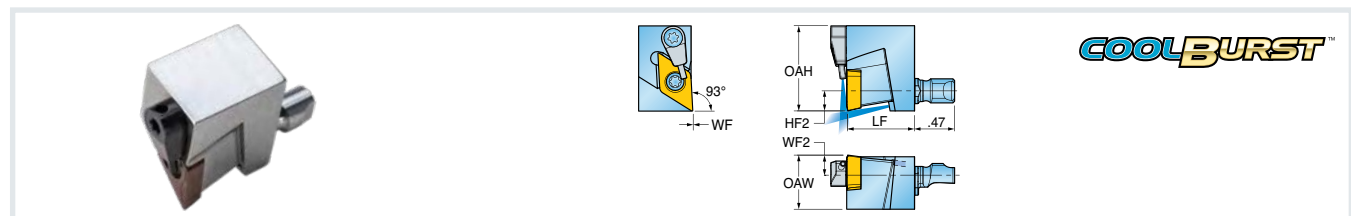
Approach Angle: 93°	Part Number Head	OAW Overall Width	OAH Overall Height	LF Functional Length	WF Functional Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH									
	QE1Y-SDJCR-11	0.638	0.787	0.787	0.000	0.236	0.276	QE1-S12N-TB QE1-S12.7L-TB QE1-S15.9L-TB QE1-S16L-TB	DC_32.5... (DC_11T3...)

Coolant



Series QE1Y-SDJCR-TB

FOR Y-AXIS TURNING WITH HIGH PRESSURE COOLANT (DC_T INSERTS)



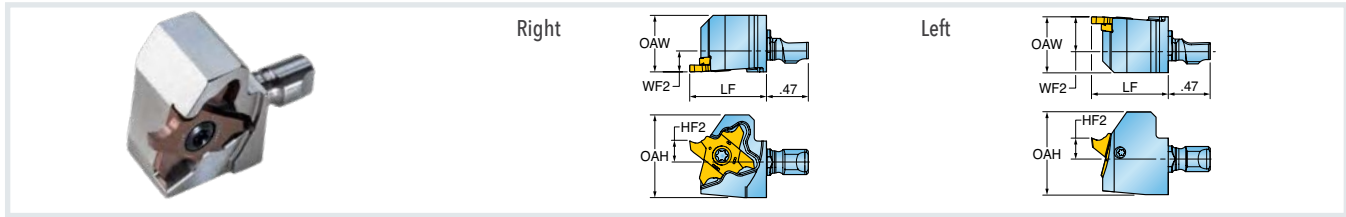
Approach Angle: 93°	Part Number Head	OAW Overall Width	OAH Overall Height	LF Functional Length	WF Functional Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH									
	QE1Y-SDJCR-11-TB	0.638	1.004	0.787	0.000	0.236	0.276	QE1-S12N-TB QE1-S12.7L-TB QE1-S15.9L-TB QE1-S16L-TB	DC_32.5... (DC_11T3...)

Hardware

Part Number	Screw	Oil Supply Unit	Torx Driver
QE1Y-SDJCR-11	SO-35080I	-	T15
QE1Y-SDJCR-11-TB	SO-35080I	S-CU-TB	T15

Series QE1-TQHR/L

FOR PARTING AND GROOVING (TQ_20 INSERTS)



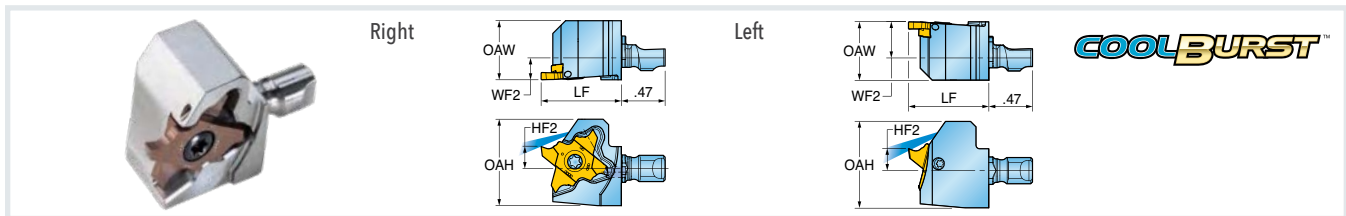
Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH							
QE1-TQHR-20	0.933	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB	TQ_20...
QE1-TQHL-20	0.933	0.866	0.630	0.236	0.354	QE1-S15.9R-TB QE1-S16R-TB	

Series QE1-TQHR/L-TB

Coolant



FOR PARTING AND GROOVING WITH HIGH PRESSURE COOLANT (TQ_20 INSERTS)



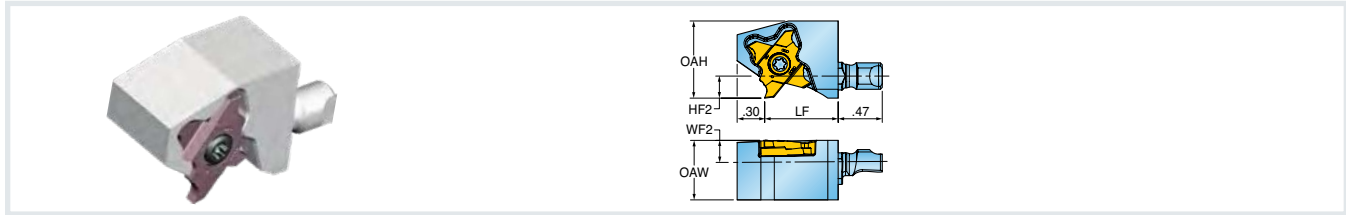
Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH							
QE1-TQHR-20-TB	0.933	0.866	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7R-TB	TQ_20...
QE1-TQHL-20-TB	0.933	0.866	0.630	0.236	0.354	QE1-S15.9R-TB QE1-S16R-TB	

Hardware

Part Number	 Screw	 Torx Driver
QE1-TQHR(-TB)	TS40A100L	T-1508/5
QE1-TQHL(-TB)	TS40A100	T-1508/5

Series QE1Y-TQHR

FOR Y-AXIS PARTING/GROOVING (TQ_20 INSERTS)



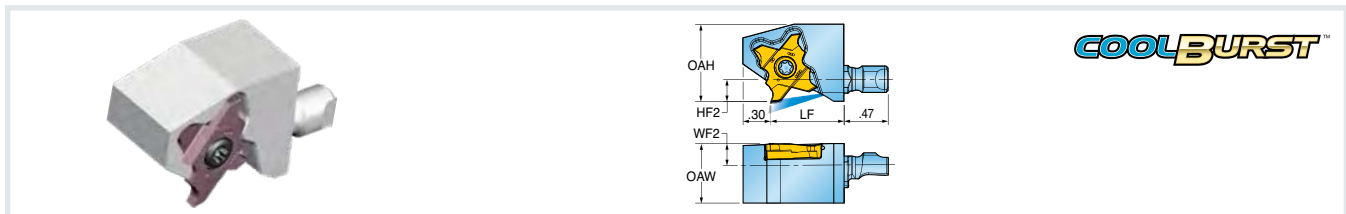
Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH							
QE1Y-TQHR-20	0.827	0.787	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7L-TB QE1-S15.9L-TB QE1-S16L-TB	TQ_20...

Coolant



Series QE1Y-TQHR-TB

FOR Y-AXIS PARTING/GROOVING W/ HIGH PRESSURE COOLANT (TQ_20 INSERTS)



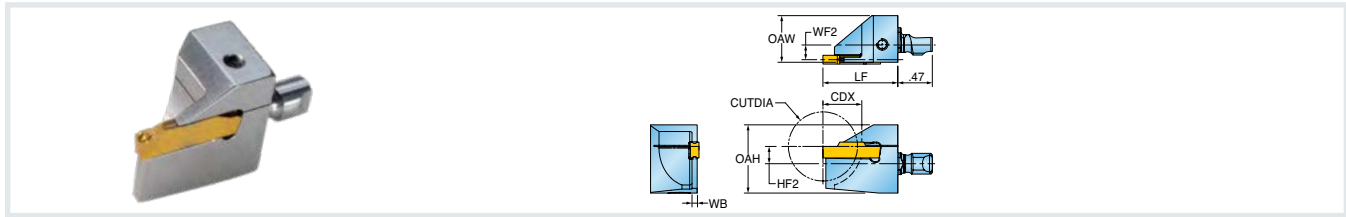
Part Number Head	OAH Overall Height	LF Functional Length	OAW Overall Width	HF ₂ Functional Height	WF ₂ Functional Width	Shank Part Number	Insert Part Number
INCH							
QE1Y-TQHR-20-TB	0.827	0.787	0.638	0.236	0.276	QE1-S12N-TB QE1-S12.7L-TB QE1-S15.9L-TB QE1-S16L-TB	TQ_20...

Hardware

Part Number	 Screw	 Torx Driver
QE1Y-TQHR-20(-TB)	TS40A100L	T-1508/5

Series QE1-TTER

FOR EXTERNAL TURNING/GROOVING (T-CLAMP ULTRA+ INSERTS)



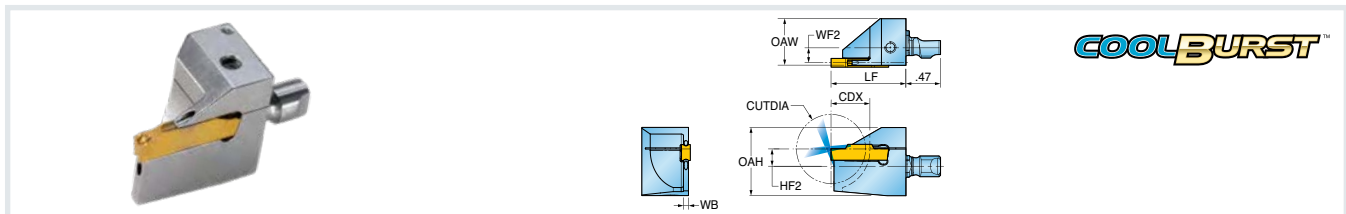
Part Number Head	SSC Insert Seat Size	OAH Overall Height	LF Funct. Length	OAW Overall Width	WB Body Width	CDX Cutting Depth Max.	CUT DIA Wkpc. Parting Dia. Max.	HF ₂ Funct. Height	WF ₂ Funct. Width	Shank Part Number	Insert Part Number
INCH											
QE1-TTER-2-12-24	2	0.933	1.024	0.638	0.071	0.472	0.945	0.236	0.240	QE1-S12N-TB	TDC/J/T/A
QE1-TTER-2-16-32	2	0.933	1.024	0.638	0.071	0.630	1.260	0.236	0.240	QE1-S12.7R-TB	TDXU/XT/XY/XC
QE1-TTER-3-12-24	3	0.933	1.024	0.638	0.094	0.472	0.945	0.236	0.228	QE1-S15.9R-TB	TSC/J/A
QE1-TTER-3-16-32	3	0.933	1.024	0.638	0.094	0.630	1.260	0.236	0.228	QE1-S16R-TB	TDUF/TDV

Coolant



Series QE1-TTER-TB

FOR EXTERNAL TURNING/GROOVING WITH HIGH PRESSURE COOLANT (T-CLAMP ULTRA+ INSERTS)



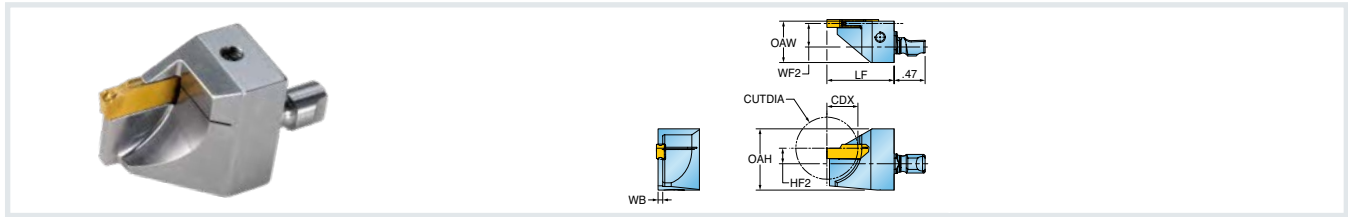
Part Number Head	SSC Insert Seat Size	OAH Overall Height	LF Funct. Length	OAW Overall Width	WB Body Width	CDX Cutting Depth Max.	CUT DIA Wkpc. Parting Dia. Max.	HF ₂ Funct. Height	WF ₂ Funct. Width	Shank Part Number	Insert Part Number
INCH											
QE1-TTER-2-12-24-TB	2	0.933	1.024	0.638	0.071	0.472	0.945	0.236	0.240	QE1-S12N-TB	TDC/J/T/A
QE1-TTER-2-16-32-TB	2	0.933	1.024	0.638	0.071	0.630	1.260	0.236	0.240	QE1-S12.7R-TB	TDXU/XT/XY/XC
QE1-TTER-3-12-24-TB	3	0.933	1.024	0.638	0.094	0.472	0.945	0.236	0.228	QE1-S15.9R-TB	TSC/J/A
QE1-TTER-3-16-32-TB	3	0.933	1.024	0.638	0.094	0.630	1.260	0.236	0.228	QE1-S16R-TB	TDUF/TDV

Hardware

Part Number	 Screw	 Hex Driver
QE1-TTER(-TB)	SHM4X0.7X16	L-W3

Series QE1-TTEL

FOR EXTERNAL TURNING/GROOVING (T-CLAMP ULTRA+ INSERTS)



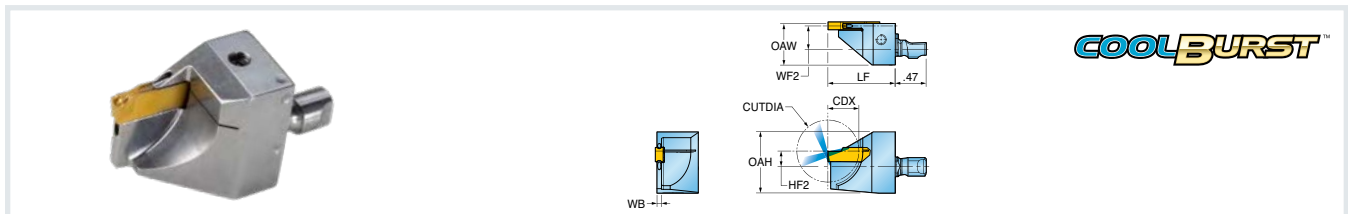
Part Number Head	SSC Insert Seat Size	OAH Overall Height	LF Funct. Length	OAW Overall Width	WB Body Width	CDX Cutting Depth Max.	CUT DIA Wkpc. Parting Dia. Max.	HF ₂ Funct. Height	WF ₂ Funct. Width	Shank Part Number	Insert Part Number
INCH											
QE1-TTEL-2-12-24	2	0.933	1.024	0.630	0.071	0.472	0.945	0.236	0.319	QE1-S12N-TB	TDC/J/T/A
QE1-TTEL-2-16-32	2	0.933	1.024	0.630	0.071	0.630	1.260	0.236	0.319	QE1-S12.7R-TB	TDXU/XT/XY/XC
QE1-TTEL-3-12-24	3	0.933	1.024	0.630	0.094	0.472	0.945	0.236	0.307	QE1-S15.9R-TB	TSC/J/A
QE1-TTEL-3-16-32	3	0.933	1.024	0.630	0.094	0.630	1.260	0.236	0.307	QE1-S16R-TB	TDUF/TDV

Coolant



Series QE1-TTEL-TB

FOR EXTERNAL TURNING/GROOVING WITH HIGH PRESSURE COOLANT (T-CLAMP ULTRA+ INSERTS)



Part Number Head	SSC Insert Seat Size	OAH Overall Height	LF Funct. Length	OAW Overall Width	WB Body Width	CDX Cutting Depth Max.	CUT DIA Wkpc. Parting Dia. Max.	HF ₂ Funct. Height	WF ₂ Funct. Width	Shank Part Number	Insert Part Number
INCH											
QE1-TTEL-2-12-24-TB	2	0.933	1.024	0.630	0.071	0.472	0.945	0.236	0.319	QE1-S12N-TB	TDC/J/T/A
QE1-TTEL-2-16-32-TB	2	0.933	1.024	0.630	0.071	0.630	1.260	0.236	0.319	QE1-S12.7R-TB	TDXU/XT/XY/XC
QE1-TTEL-3-12-24-TB	3	0.933	1.024	0.630	0.094	0.472	0.945	0.236	0.307	QE1-S15.9R-TB	TSC/J/A
QE1-TTEL-3-16-32-TB	3	0.933	1.024	0.630	0.094	0.630	1.260	0.236	0.307	QE1-S16R-TB	TDUF/TDV

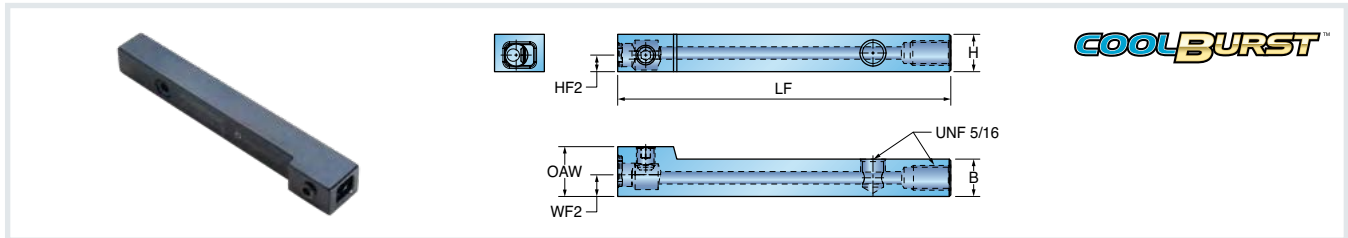
Hardware

Part Number	 Screw	 Hex Driver
QE1-TTEL(-TB)	SHM4X0.7X16	L-W3



Series QE1-S12.7R/L-TB

.500" SHANK WITH HIGH PRESSURE COOLANT

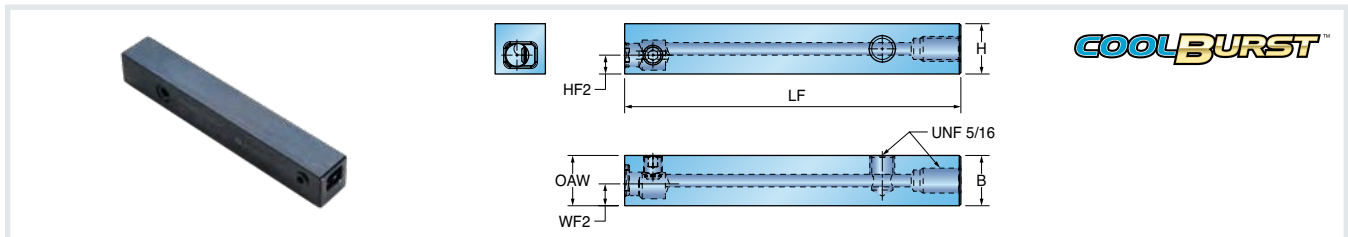


Part Number Shank	HF ₂ Functional Height	WF ₂ Functional Width	H Shank Height	B Functional Height	LF Functional Height	OAW Overall Width
INCH						
QE1-S12.7R/L-TB	0.236	0.276	0.500	0.500	4.210	0.630



Series QE1-15.9R/L-TB

.625" SHANK WITH HIGH PRESSURE COOLANT



Part Number Shank	HF ₂ Functional Height	WF ₂ Functional Width	H Shank Height	B Functional Height	LF Functional Height	OAW Overall Width
INCH						
QE1-S15.9R/L-TB	0.236	0.276	0.625	0.625	4.210	0.625

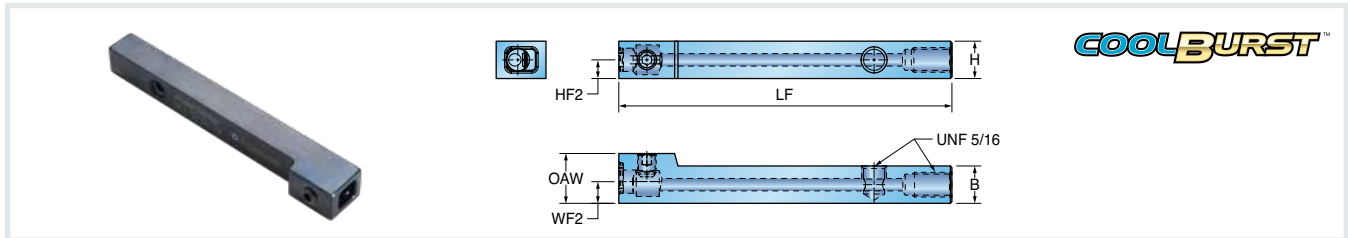
Hardware

Part Number	Screw	Plug	Hex Driver
QE1-S...-TB	SSM6F-7	PLG5/16UNF	L-W3 L-W4



Series QE1-S12N-TB

12 MM SHANK WITH HIGH PRESSURE COOLANT

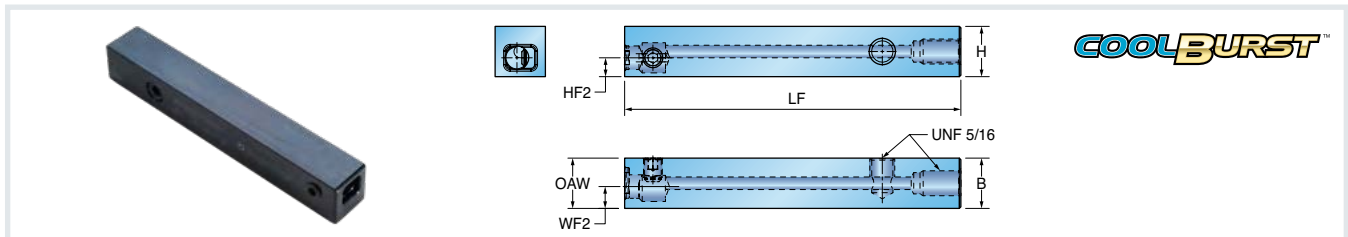


Part Number Shank	HF ₂ Functional Height	WF ₂ Functional Width	H Shank Height	B Functional Height	LF Functional Height	OAW Overall Width
METRIC						
QE1-S12N-TB	6.0 mm	7.0 mm	12.0 mm	12.0 mm	107.0 mm	16.0 mm



Series QE1-S16R/L-TB

16 MM SHANK WITH HIGH PRESSURE COOLANT



Part Number Shank	HF ₂ Functional Height	WF ₂ Functional Width	H Shank Height	B Functional Height	LF Functional Height	OAW Overall Width
METRIC						
QE1-S16R/L-TB	6.0 mm	7.0 mm	16.0 mm	16.0 mm	107.0 mm	16.0 mm

Hardware

Part Number	Screw	Plug	Hex Driver
QE1-...-TB	SS-M6F-7	PLG-5/16-UNF	L-W-3 L-W-4

Assembly Dimensions • INCH

EXTERNAL TURNING



Fig. 1

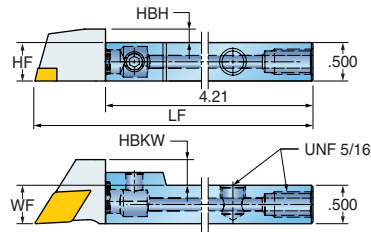


Fig. 2

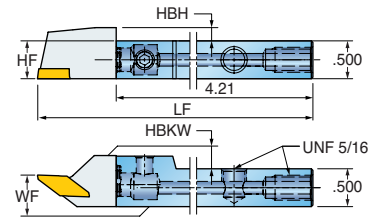
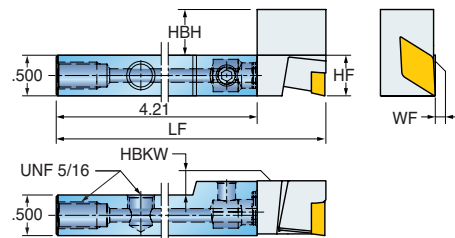


Fig. 3



SHANK: .500" (RIGHT/LEFT)

Shank Part Number	Head Part Number	Dimensions (inch)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1 S12.7R-TB Right hand type, 0.500"	QE1-SCLCR	0.625	0.000	5.080	0.625	0.138	1
	QE1-SCLCR-TB	0.625	0.000	5.080	0.625	0.161	
	QE1-SDJCR-11	0.500	0.138	5.080	0.500	0.138	
	QE1-SDJCR-11-TB	0.500	0.138	5.080	0.500	0.287	
	QE1-SDJNR-0803	0.500	0.138	5.080	0.500	0.138	
	QE1-SDJNR-0803-TB	0.500	0.138	5.080	0.500	0.138	
	QE1-SDJNR-1305	0.500	0.138	5.080	0.500	0.138	
	QE1-SDJNR-1305-TB	0.500	0.138	5.080	0.500	0.287	
	QE1-SVJBR-11	0.500	0.138	5.080	0.500	0.138	
	QE1-SVJBR-11-TB	0.500	0.138	5.200	0.500	0.138	
	QE1-SVJCR-11	0.500	0.138	5.080	0.500	0.138	
	QE1-SVJCR-11-TB	0.500	0.138	5.200	0.500	0.138	
	QE1B-SVXCR-11	0.500	0.138	5.200	0.394	0.138	2
	QE1B-SVXCR-11-TB	0.500	0.138	5.200	0.394	0.138	
QE1 S12.7L-TB Left hand type, 0.500"	QE1Y-SDJCR-11	0.500	0.287	5.000	0.000	0.138	3
	QE1Y-SDJCR-11-TB	0.500	0.504	5.000	0.000	0.138	

Assembly Dimensions • INCH

EXTERNAL TURNING



Fig. 1

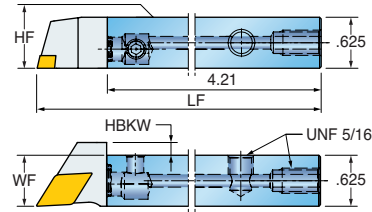


Fig. 2

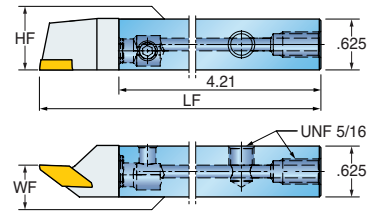
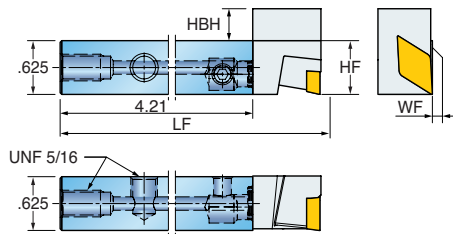


Fig. 3

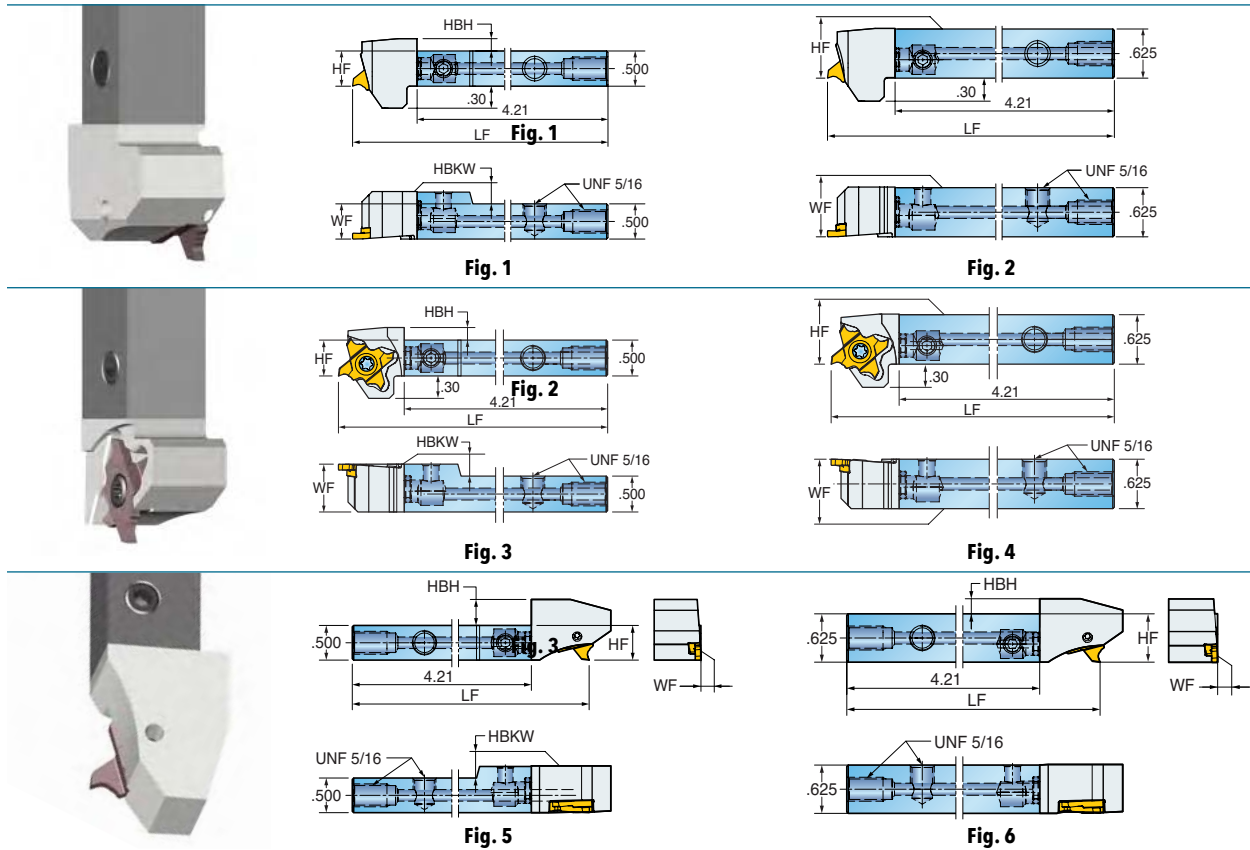


SHANK: .625" (RIGHT/LEFT)

Shank Part Number	Head Part Number	Dimensions (inch)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1 S15.9R-TB Right hand type, 0.625"	QE1-SCLCR	0.625	0.000	5.080	0.625	0.000	1
	QE1-SCLCR-TB	0.625	0.000	5.080	0.625	0.161	
	QE1-SDJCR-11	0.625	0.000	5.080	0.625	0.000	
	QE1-SDJCR-11-TB	0.625	0.000	5.080	0.625	0.161	
	QE1-SDJNR-0803	0.625	0.000	5.080	0.625	0.000	
	QE1-SDJNR-0803-TB	0.625	0.000	5.080	0.625	0.000	
	QE1-SDJNR-1305	0.625	0.000	5.080	0.625	0.000	
	QE1-SDJNR-1305-TB	0.625	0.000	5.080	0.625	0.161	
	QE1-SVJBR-11	0.625	0.000	5.080	0.625	0.000	
	QE1-SVJBR-11-TB	0.625	0.000	5.200	0.625	0.000	
	QE1-SVJCR-11	0.625	0.000	5.080	0.625	0.000	
	QE1-SVJCR-11-TB	0.625	0.000	5.200	0.625	0.000	
	QE1B-SVXCR-11	0.625	0.000	5.200	0.394	0.000	2
	QE1B-SVXCR-11-TB	0.625	0.000	5.200	0.394	0.000	
QE1 S15.9L-TB Left hand type, 0.625"	QE1Y-SDJCR-11	0.625	0.161	5.000	0.000	0.000	3
	QE1Y-SDJCR-11-TB	0.625	0.378	5.000	0.000	0.000	

Assembly Dimensions • INCH

PARTING AND GROOVING

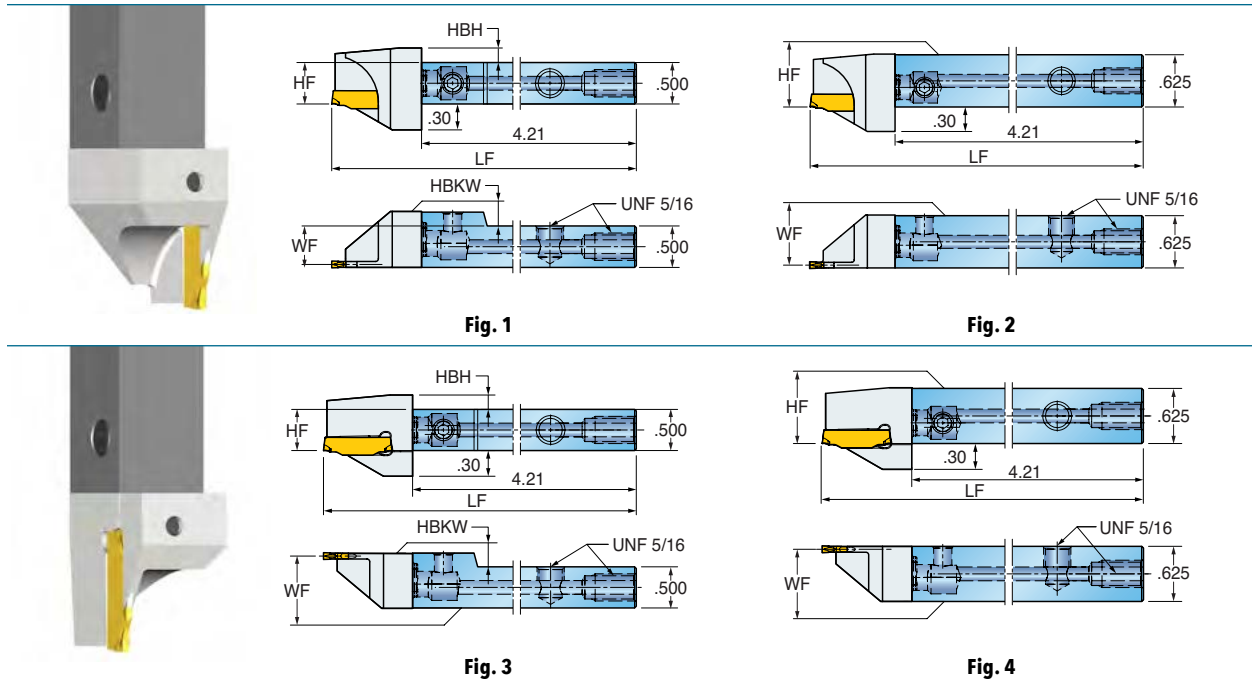


SHANKS: .500" (RIGHT/LEFT) AND .625" (RIGHT/LEFT)

Shank Part Number	Head Part Number	Dimensions (inch)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1-S12.7R-TB Right hand type, 0.500"	QE1-TQHR-20	0.500	0.138	5.080	0.500	0.130	1
	QE1-TQHR-20-TB	0.500	0.138	5.080	0.500	0.130	
	QE1-TQHL-20	0.500	0.138	5.080	0.630	0.138	3
	QE1-TQHL-20-TB	0.500	0.138	5.080	0.630	0.138	
QE1 S12.7L-TB Left hand type, 0.500"	QE1Y-TQHR-20	0.500	0.327	5.000	0.000	0.138	5
	QE1Y-TQHR-20-TB	0.500	0.327	5.000	0.000	0.138	
QE1 S15.9R-TB Right hand type, 0.625"	QE1-TQHR-20	0.625	0.000	5.080	0.625	0.000	2
	QE1-TQHR-20-TB	0.625	0.000	5.080	0.625	0.000	
	QE1-TQHL-20	0.625	0.130	5.080	0.625	0.000	4
	QE1-TQHL-20-TB	0.625	0.130	5.080	0.625	0.000	
QE1 S15.9L-TB Left hand type, 0.625"	QE1Y-TQHR-20	0.625	0.201	5.000	0.000	0.000	6
	QE1Y-TQHR-20-TB	0.625	0.201	5.000	0.000	0.000	

Assembly Dimensions • METRIC

PARTING AND GROOVING



SHANKS: .500" (RIGHT) AND .625" (RIGHT)

Shank Part Number	Head Part Number	Dimensions (mm)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1-S12.7R-TB Right hand type, 0.500"	QE1-TTER-2...	0.500	0.138	5.240	0.465	0.138	1
	QE1-TTER-2...-TB	0.500	0.138	5.240	0.465	0.138	
	QE1-TTER-3...	0.500	0.138	5.240	0.453	0.138	
	QE1-TTER-3...-TB	0.500	0.138	5.240	0.453	0.138	
	QE1-TTEL-2...	0.500	0.138	5.240	0.594	0.130	3
	QE1-TTEL-2...-TB	0.500	0.138	5.240	0.594	0.130	
	QE1-TTEL-3...	0.500	0.138	5.240	0.583	0.130	
	QE1-TTEL-3...-TB	0.500	0.138	5.240	0.583	0.130	
QE1-S15.9R-TB Right hand type, 0.625"	QE1-TTER-2...	0.625	0.000	5.240	0.591	0.000	2
	QE1-TTER-2...-TB	0.625	0.000	5.240	0.591	0.000	
	QE1-TTER-3...	0.625	0.000	5.240	0.579	0.000	
	QE1-TTER-3...-TB	0.625	0.000	5.240	0.579	0.000	
	QE1-TTEL-2...	0.625	0.000	5.240	0.594	0.000	4
	QE1-TTEL-2...-TB	0.625	0.000	5.240	0.594	0.000	
	QE1-TTEL-3...	0.625	0.000	5.240	0.583	0.000	
	QE1-TTEL-3...-TB	0.625	0.000	5.240	0.583	0.000	

Assembly Dimensions • METRIC

EXTERNAL TURNING



Fig. 1

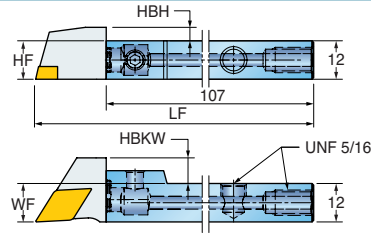


Fig. 2

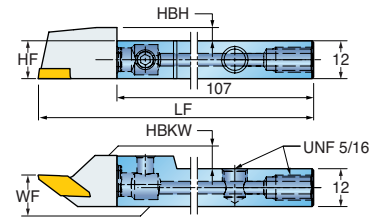
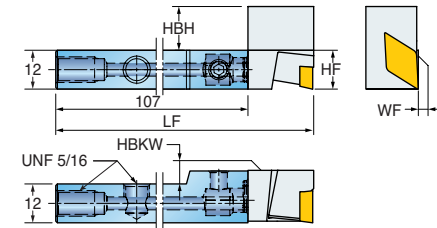


Fig. 3



SHANK: 12 MM (NEUTRAL)

Shank Part Number	Head Part Number	Dimensions (mm)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1-S12N-TB Neutral, 12 mm	QE1-SCLCR	12.0	4.2	129.0	12.0	4.2	1
	QE1-SCLCR-TB	12.0	4.2	129.0	12.0	8.0	
	QE1-SDJCR-11	12.0	4.2	129.0	12.0	4.2	
	QE1-SDJCR-11-TB	12.0	4.2	129.0	12.0	8.0	
	QE1-SDJNR-0803	12.0	4.2	129.0	12.0	4.2	
	QE1-SDJNR-0803-TB	12.0	4.2	129.0	12.0	4.2	
	QE1-SDJNR-1305	12.0	4.2	129.0	12.0	4.2	
	QE1-SDJNR-1305-TB	12.0	4.2	129.0	12.0	8.0	
	QE1-SVJBR-11	12.0	4.2	129.0	12.0	4.2	
	QE1-SVJBR-11-TB	12.0	4.2	132.0	12.0	4.2	
	QE1-SVJCR-11	12.0	4.2	129.0	12.0	4.2	
	QE1-SVJCR-11-TB	12.0	4.2	132.0	12.0	4.2	
	QE1B-SVXCR-11	12.0	4.2	132.0	10.0	4.2	2
	QE1B-SVXCR-11-TB	12.0	4.2	132.0	10.0	4.2	
	QE1Y-SDJCR-11	12.0	8.0	127.0	0.00	4.2	3
	QE1Y-SDJCR-11-TB	12.0	13.5	127.0	0.00	4.2	

Assembly Dimensions • METRIC

EXTERNAL TURNING



Fig. 1

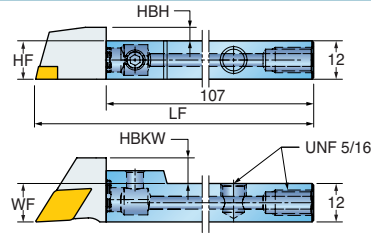


Fig. 2

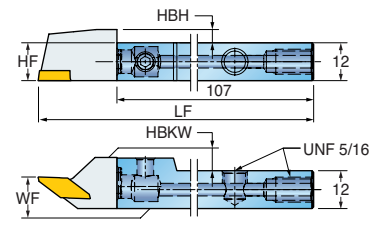
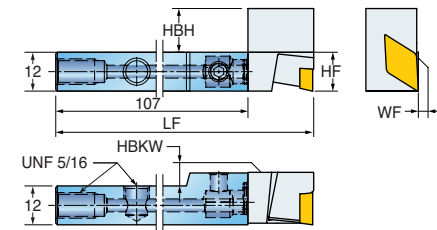


Fig. 3

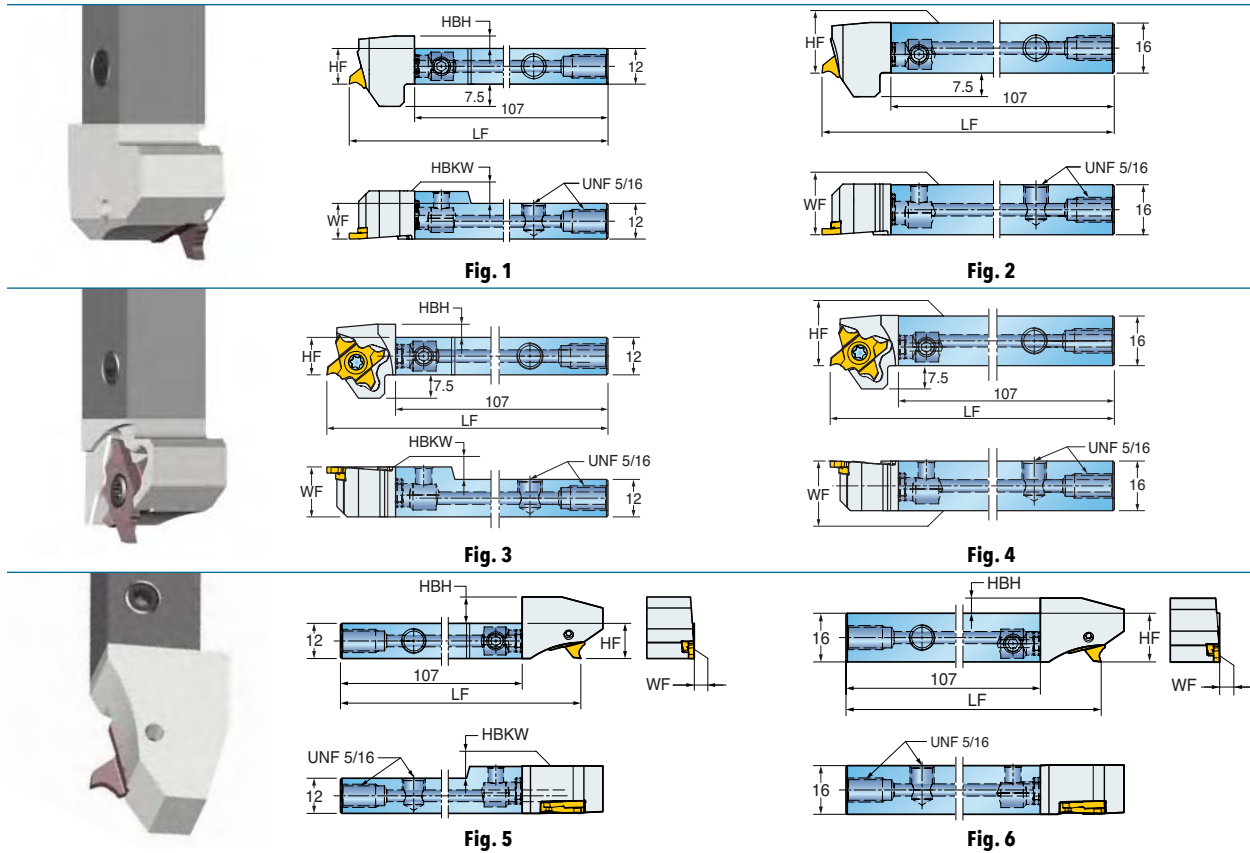


SHANK: 16 MM (RIGHT/LEFT)

Shank Part Number	Head Part Number	Dimensions (mm)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1-S16R-TB Right hand type, 16 mm	QE1-SCLCR	16.0	0.0	129.0	12.0	4.0	1
	QE1-SCLCR-TB	16.0	0.0	129.0	12.0	0.0	
	QE1-SDJCR-11	16.0	0.0	129.0	16.0	0.0	
	QE1-SDJCR-11-TB	16.0	0.0	129.0	16.0	4.0	
	QE1-SDJNR-0803	16.0	0.0	129.0	16.0	0.0	
	QE1-SDJNR-0803-TB	16.0	0.0	129.0	16.0	0.0	
	QE1-SDJNR-1305	16.0	0.0	129.0	16.0	0.0	
	QE1-SDJNR-1305-TB	16.0	0.0	129.0	16.0	4.0	
	QE1-SVJBR-11	16.0	0.0	129.0	16.0	0.0	
	QE1-SVJBR-11-TB	16.0	0.0	132.0	16.0	0.0	
	QE1-SVJCR-11	16.0	0.0	129.0	16.0	0.0	
	QE1-SVJCR-11-TB	16.0	0.0	132.0	16.0	0.0	
	QE1B-SVXCR-11	16.0	0.0	132.0	10.0	0.0	2
	QE1B-SVXCR-11-TB	16.0	0.0	132.0	10.0	0.0	
QE1-S16L-TB Left hand type, 16 mm	QE1Y-SDJCR-11	16.0	4.0	127.0	0.0	0.0	3
	QE1Y-SDJCR-11-TB	16.0	9.5	127.0	0.0	0.0	

Assembly Dimensions • METRIC

PARTING AND GROOVING

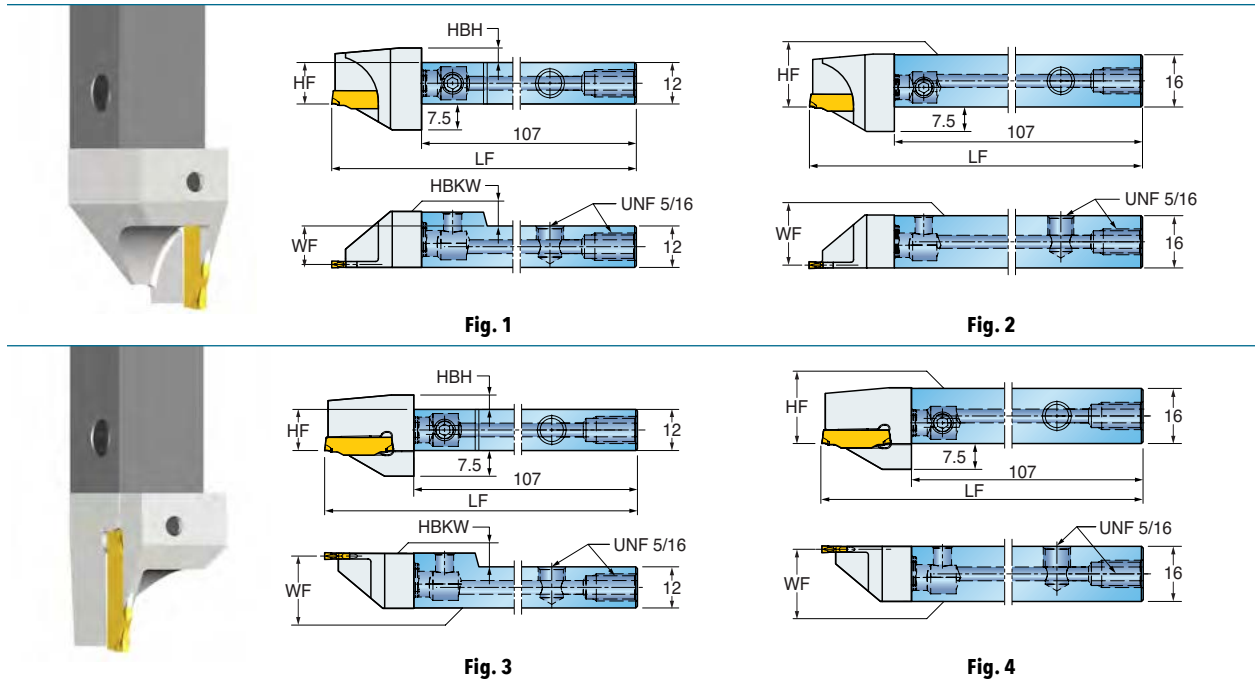


SHANKS: 12 MM (NEUTRAL) AND 16 MM (RIGHT/LEFT)

Shank Part Number	Head Part Number	Dimensions (mm)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1-S12N-TB Neutral, 12 mm	QE1-TQHR-20	12.0	4.2	129.0	12.0	4.2	1
	QE1-TQHR-20-TB	12.0	4.2	129.0	12.0	4.2	
	QE1-TQHL-20	12.0	4.2	129.0	16.0	4.0	3
	QE1-TQHL-20-TB	12.0	4.2	129.0	16.0	4.0	
	QE1Y-TQHR-20	12.0	9.0	127.0	0.0	4.2	5
	QE1Y-TQHR-20-TB	12.0	9.0	127.0	0.0	4.2	
QE1-S16R-TB Right hand type, 16 mm	QE1-TQHR-20	16.0	0.0	129.0	16.0	0.0	2
	QE1-TQHR-20-TB	16.0	0.0	129.0	16.0	0.0	
	QE1-TQHL-20	16.0	0.0	129.0	16.0	0.0	4
	QE1-TQHL-20-TB	16.0	0.0	129.0	16.0	0.0	
QE1-S16L-TB Left hand type, 16 mm	QE1Y-TQHR-20	16.0	5.0	127.0	0.0	0.0	6
	QE1Y-TQHR-20-TB	16.0	5.0	127.0	0.0	0.0	

Assembly Dimensions • METRIC

PARTING AND GROOVING

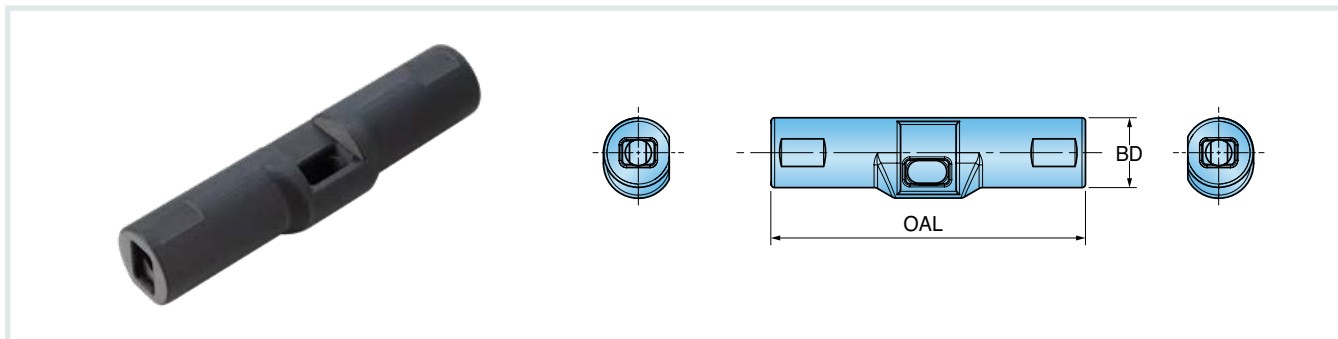


SHANKS: 12 MM (NEUTRAL) AND 16 MM (RIGHT)

Shank Part Number	Head Part Number	Dimensions (mm)					Fig.
		HF Functional Height	HBH Head Bottom Offset Height	LF Functional Length	WF Functional Width	HBKW Head Back Offset Width	
QE1-S12N-TB Neutral, 12 mm	QE1-TTER-2	12.0	4.2	133.0	11.10	4.2	1
	QE1-TTER-2-TB	12.0	4.2	133.0	11.10	4.2	
	QE1-TTER-3	12.0	4.2	133.0	10.80	4.2	
	QE1-TTER-3-TB	12.0	4.2	133.0	10.80	4.2	
	QE1-TTEL-2	12.0	4.2	133.0	15.10	4.0	3
	QE1-TTEL-2-TB	12.0	4.2	133.0	15.10	4.0	
	QE1-TTEL-3	12.0	4.2	133.0	14.80	4.0	
	QE1-TTEL-3-TB	12.0	4.2	133.0	14.80	4.0	
QE1-S16R-TB Right hand type, 16 mm	QE1-TTER-2	16.0	0.0	133.0	15.10	0.0	2
	QE1-TTER-2-TB	16.0	0.0	133.0	15.10	0.0	
	QE1-TTER-3	16.0	0.0	133.0	14.80	0.0	
	QE1-TTER-3-TB	16.0	0.0	133.0	14.80	0.0	
	QE1-TTEL-2	16.0	0.0	133.0	15.10	0.0	4
	QE1-TTEL-2-TB	16.0	0.0	133.0	15.10	0.0	
	QE1-TTEL-3	16.0	0.0	133.0	14.80	0.0	
	QE1-TTEL-3-TB	16.0	0.0	133.0	14.80	0.0	

Insert Replacement Fixture

QE1-FIX-20100



Part Number	Dimension inch (mm)	
	OAL Overall Length	D Diameter
QE1-FIX-020100	3.66" (93.0 mm)	0.79" (20.0 mm)

NOTE: Fixture ordered separately.

INSERT REPLACEMENT

Due to the FlexTurn's small head sizes, replacing the inserts could be difficult. Please use the fixture to facilitate insert replacement.

