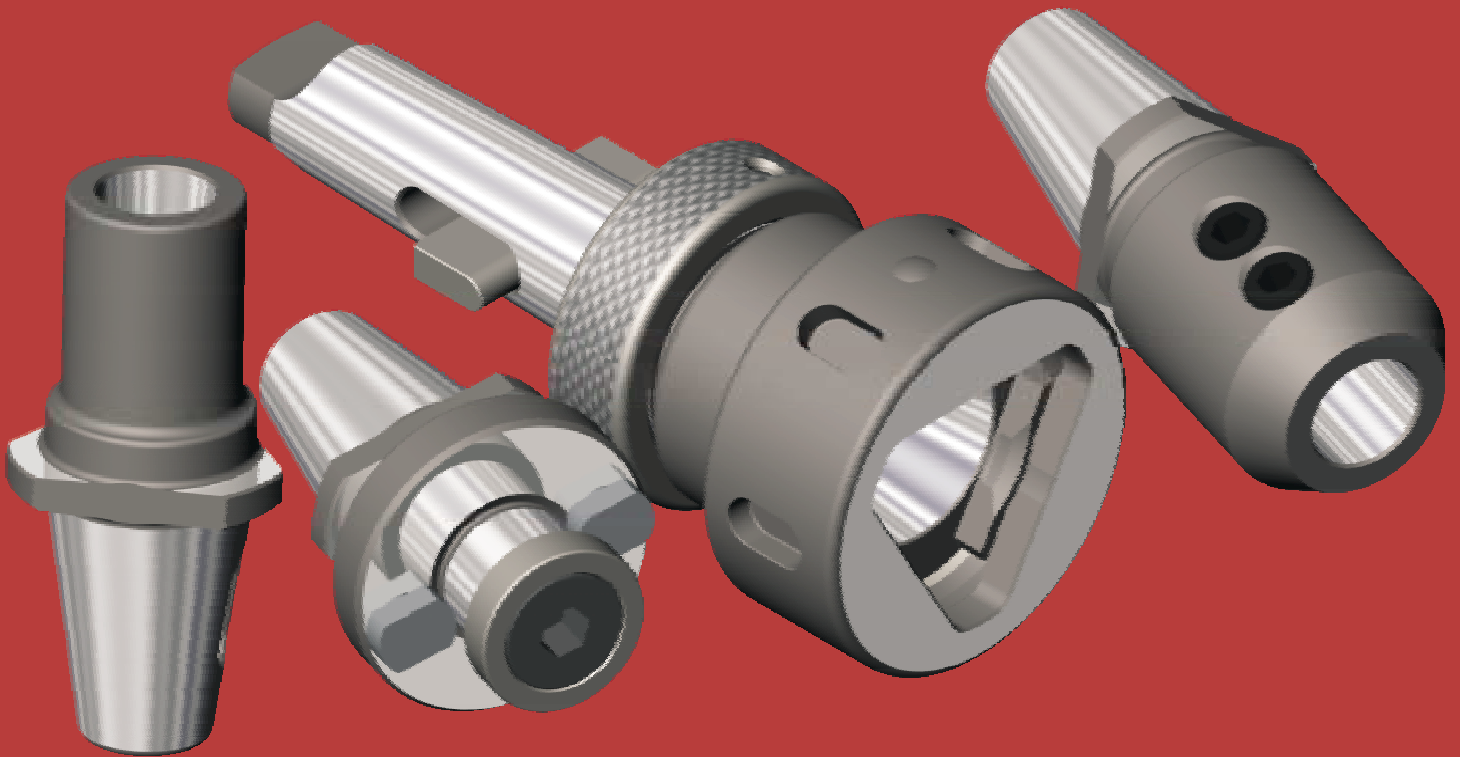


*Quick*Change TOOLING



Catalog 101



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Why Quick Change?

Advantages of a Quick Change tooling system



Changing tools on a machine tool is often a long and difficult procedure. First the machinist must uncouple the tool holder. This usually involves either a drawbolt or keeper key. Then he must dislodge the tool holder, which usually involves a hammer. The machinist must next remove the tool holder and replace it with the next tool and recouple it. This procedure can easily take five minutes, or more. Because changing tools can be a hassle there are quite often times that an improper or inappropriate tool is used.

With a quick change tooling system the time required to change tools can be reduced to seconds. Typically a locking nut or collar is loosened, the tool adapter is removed and replaced with another tool adapter, and the nut is retightened. Use of a quick change tooling system will drastically increase efficiency by reducing the time to change tools, as well as make it easy to use the proper tool for the job. A 30% increase in productivity is not an uncommon occurrence.

The use of a quick change tooling system has some, not insignificant, side benefits. The machinist no longer has to pound on the spindle to



dislodge the tool. By not having to beat on the spindle with a hammer, the life and accuracy of the spindle bearings is greatly increased. In most quick change tooling systems a master holder is inserted into the machine spindle, and is not removed. All tool changes involve removing and inserting adapters into the master holder. This eliminates wear on the machine tool spindle due to tool changes.

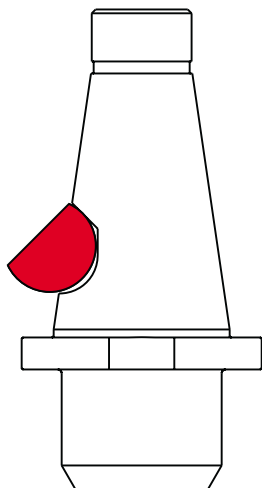
Advantages of PDQ

Why is PDQ better?



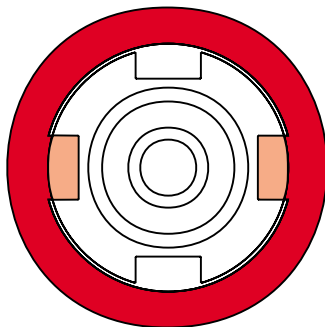
Powerful Three-Point Balanced Locking System Gives PDQ Tool Holders Unmatched "Holding Action"

1 point locking



ECCENTRIC CAM LOCK
Can cause uneven wear

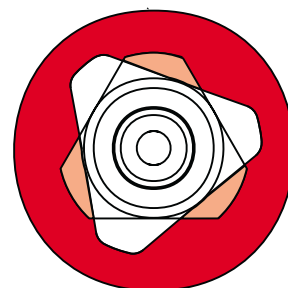
2 point locking



LOBE TYPE LOCK

Less bearing surface for locking...

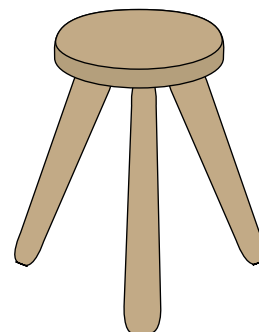
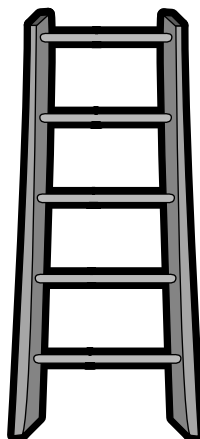
3 point locking



PDQ THREE POINT LOCK

Offers rigid holding power, precise positioning of tool and permits tremendous amount of torque to be transferred from holder to adapter without danger of twisting

**How do you
want your tools
supported?**





Advantages of PDQ

Why is PDQ better?

PDQ tool holders are made of premium alloy steel and through hardened for even more strength and rigidity. Many others are case hardened with a soft interior



Through hardened

1/2"

PDQ tooling systems require less room for a tool change than other systems, as little as 1/2". This results in less wasted movement, to get the work out of the way saving even more time.

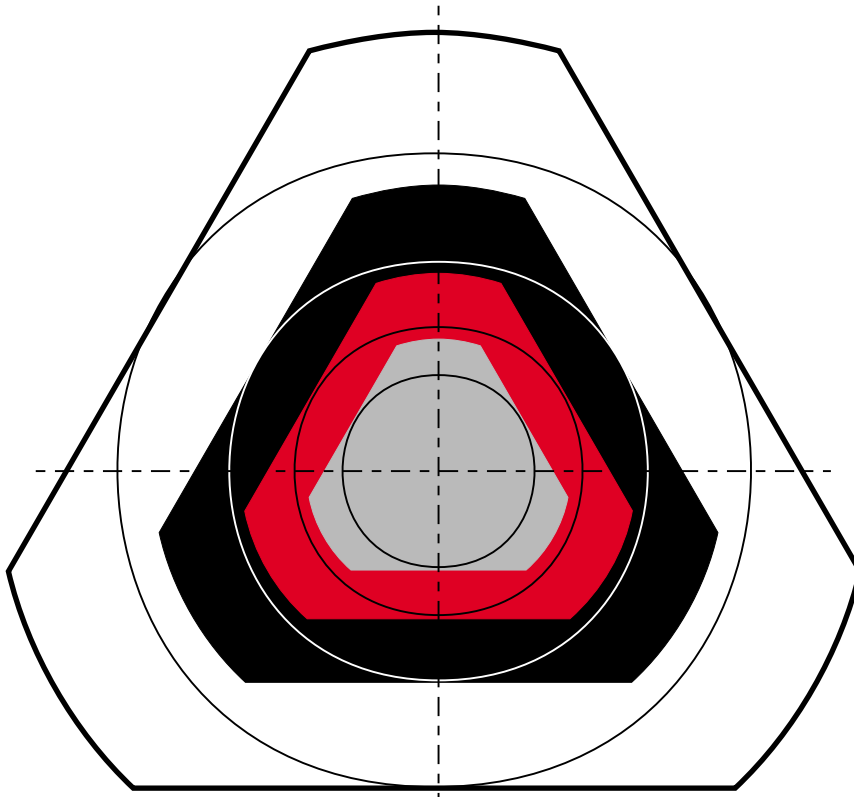
PDQ quick change tools come in 4 different shank sizes, VS, S, M and L. This allows matching the size of the tooling system to the size and power of the machine tool.



PDQ offers a very complete assortment of adapters to hold any type of cutting tool.

Series Sizes

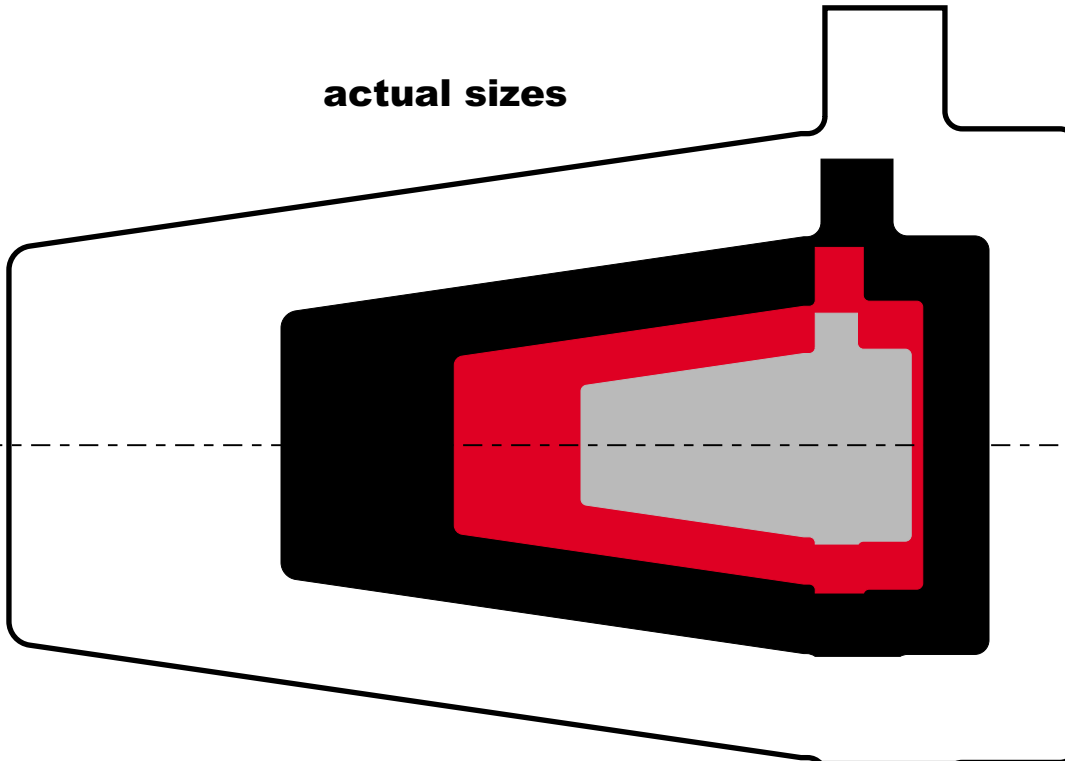
PDQ Tooling comes in 4 shank sizes



PDQ Quick Change Tooling comes in 4 different shank sizes, from "VS" to "L". This allows sizing the tooling to the machine, from small knee mills to very large horizontals.

When ordering tooling select holders and adapters from the same color groups to insure compatibility.

actual sizes



"L" Series

"M" Series

"S" Series

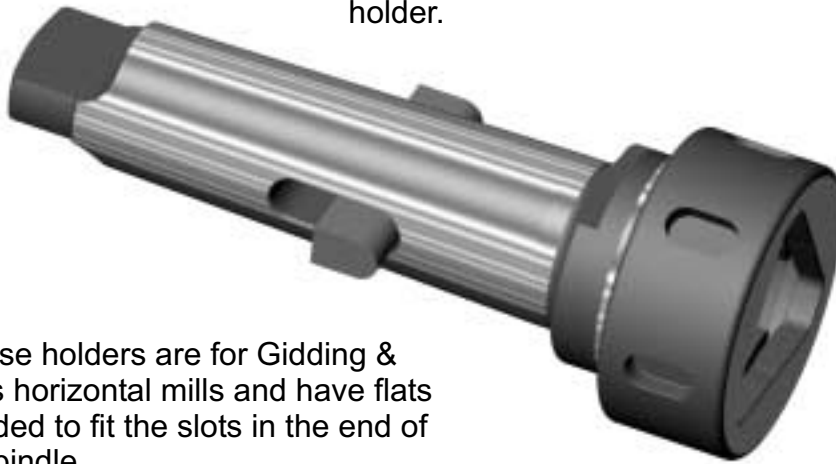
"VS" Series



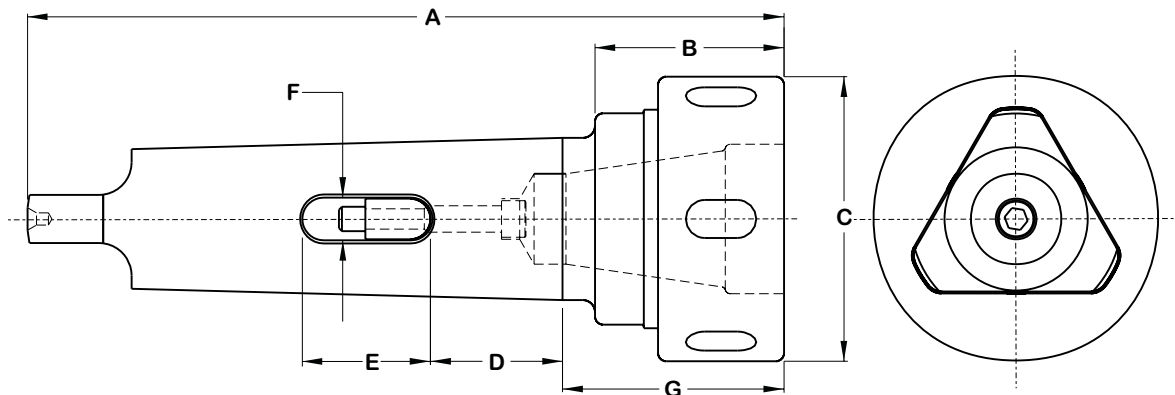
Morse Taper Holders

Master holders for machines with 4-7 taper spindles

PDQ Morse Taper Holders are designed to fit any spindle that has a standard #4, #5, #6, or #7 morse taper spindle. All holders have keeper keys and slots to lock them in place in the spindle. Our *Universal Keeper Key* makes it possible to use these holders in any make machine with a morse taper spindle. All holders are heat treated and precision ground. Spanner wrenches are furnished with each holder.



* These holders are for Gidding & Lewis horizontal mills and have flats provided to fit the slots in the end of the spindle.



Morse Taper Holders

Part Number	PDQ Series	Morse Taper	A	B	C	D	E	F	G
702-41-001	S	4	7 11/16	2 13/16	3 1/8	1 3/8	1 1/2	25/64	3 1/16
702-41-002	S	5	8 3/16	2 1/16	3 1/8	1 3/8	1 3/4	17/32	2 5/16
702-41-003 *	S	5	8 3/16	2 1/16	3 1/8	1 3/8	1 3/4	17/32	2 5/16
702-21-001	M	5	10 7/16	4 5/16	4 3/8	1 3/8	1 3/4	17/32	5 1/32
702-21-002 *	M	5	10 13/16	4 11/16	4 3/8	1 3/8	1 3/4	17/32	5 13/32
702-21-003	M	6	11 9/16	2 11/16	4 3/8	2	2 1/2	21/32	3 25/32
702-21-004 *	M	6	11 11/16	2 15/16	4 3/8	2 15/16	1 13/16	21/32	3 29/32
702-21-005	M	7	14 1/16	2 3/16	4 3/8	2 1/8	3 1/8	11/16	3 9/32
702-01-001	L	7	16 1/16	4 9/16	5 7/8	2 1/8	3 1/8	11/16	4 13/16

Order by part number

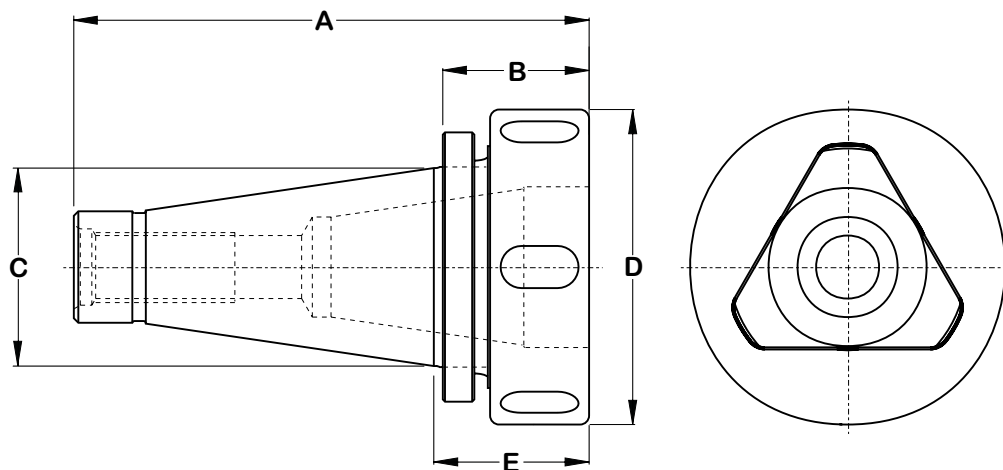
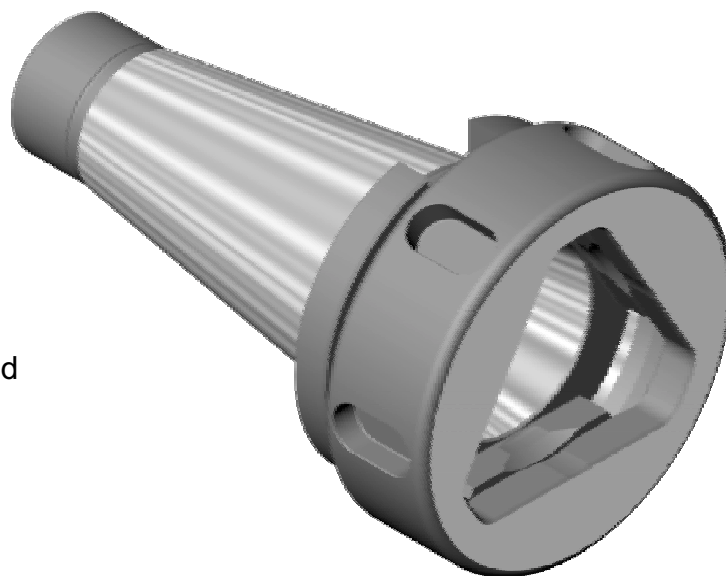
Specials furnished on request

Milling Machine Holders

Master holders for machines with #30-60 NMTB spindles

QuickChange
TOOLING

These holders are designed to fit any spindle that has a standard #30, #40, #45, #50 or #60 NMTB tapered spindle hole. All holders have keyways for positive drive and are tapped in the small end for a draw bolt, the same as any other conventional tool. All holders are heat treated and precision ground. Spanner wrenches are furnished with each holder



Milling Machine Holders

Part Number	PDQ Series	Taper	A	B	C	D	E
702-61-168	VS	30	4 1/4	1 1/2	1-1/4	2 3/16	1 9/16
702-41-168	S	40	5 3/16	1 7/16	1 3/4	3 1/8	1 17/32
702-21-170	M	45	7 3/8	3	2 1/4	4 3/8	3 1/8
702-21-168	M	50	7 1/8	2	2 3/4	4 3/8	2 1/8
702-01-168	L	60	12 7/16	4 1/8	3 1/4	5 7/8	4 1/4

Order by part number

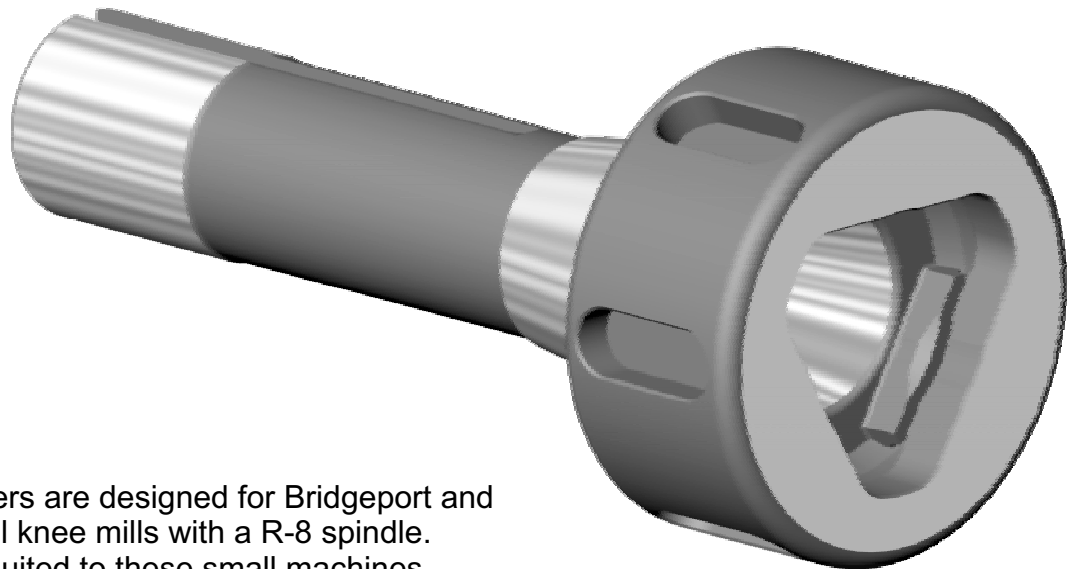
Specials furnished on request

Phone (800) 821-8010 ☎ Fax (330) 920-0972 ☎ e-mail sales@pdq-marlin.com

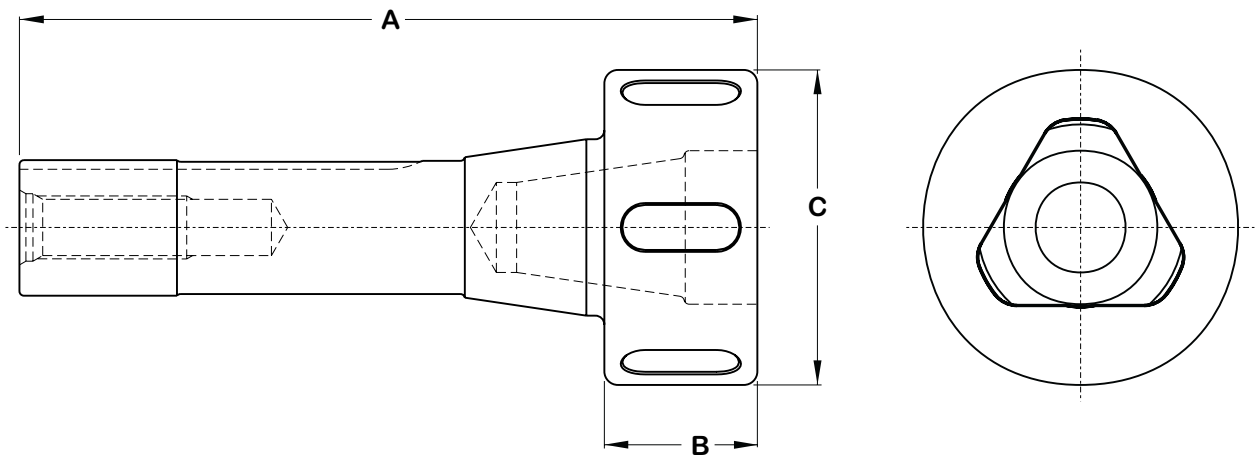


R-8 Master Holders

R-8 Master holder for Bridgeport and similar machines



These holders are designed for Bridgeport and similar small knee mills with a R-8 spindle. Especially suited to these small machines, tools can be changed with only one half of an inch clearance between the end of the tool and the workpiece. All holders are heat treated and precision ground. Spanner wrenches are provided with each holder.



R-8 Master Holder

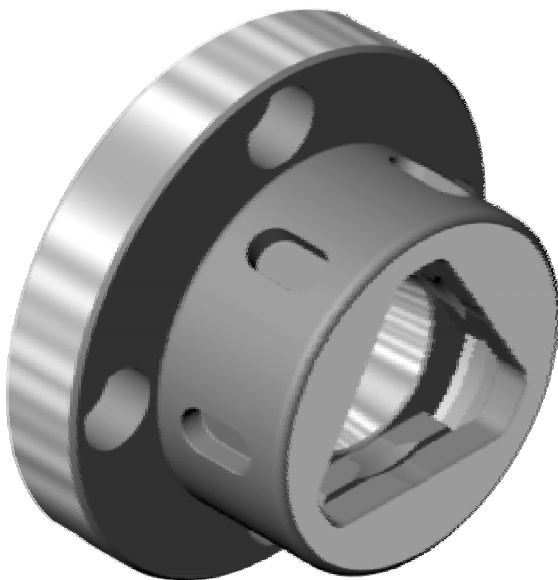
Part Number	PDQ Series	A	B	C
702-61-835	VS	4 1/4	1 1/16	2 3/16

Order by part number

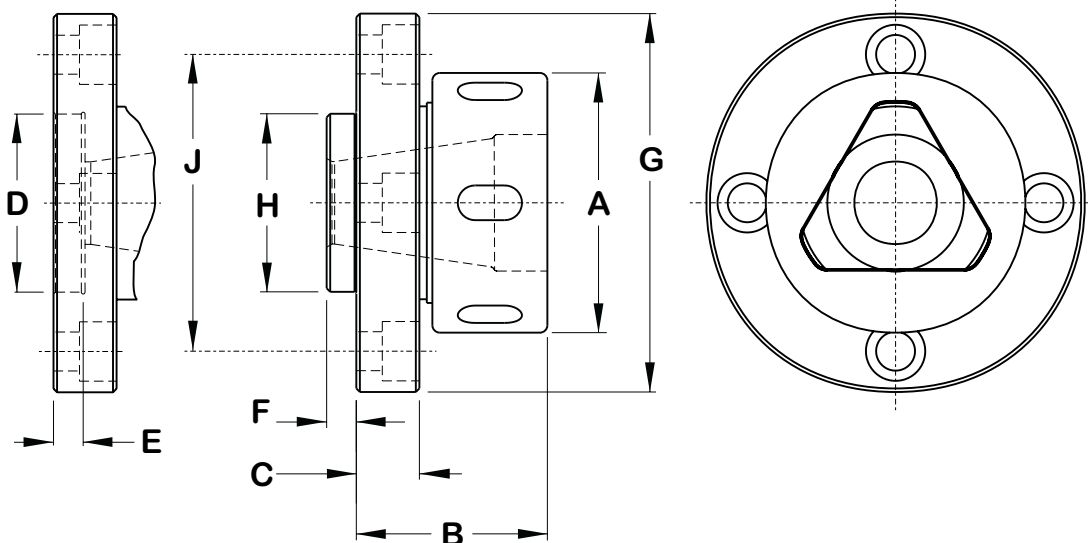
Specials furnished on request

Flange Type Holders

Master Holders to be mounted to end of spindle



These flange type holders are designed for use on automatic boring machines. Flange type holders have many other uses on machines where extreme rigidity is a prime factor, or where the shank type tools are impractical. Any size or variation of flange is available to suite the customer's needs. All holders are heat treated and precision ground. Spanner wrenches are furnished with each holder. When ordering this type of holder please furnish all dimensions or a sketch.



Flange Type Holders

Part Number PDQ Series A B C D E F G H J
Screw hole size, number & location

702-61-XXX	VS	2 3/16	To Suit Customer				
702-41-XXX	S	3 1/8	To Suit Customer				
702-21-XXX	M	4 3/8	To Suit Customer				
702-01-XXX	L	5 7/8	To Suit Customer				

Order by part number

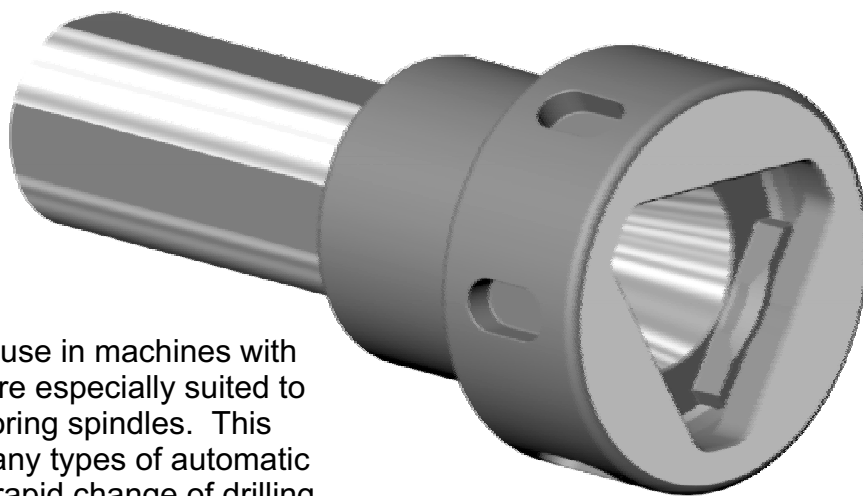
Part number to be assigned at time of order

Phone (800) 821-8010 • Fax (330) 920-0972 • e-mail sales@pdq-marlin.com

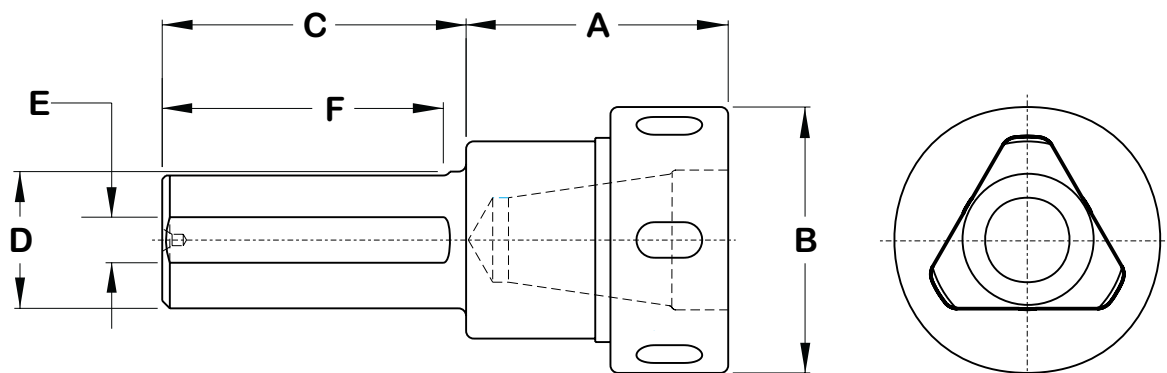


Straight Shank Holders

For use in a straight bore



These holders are designed for use in machines with straight bores. These holders are especially suited to remanufactured spindles and boring spindles. This type of holder is also used in many types of automatic turning equipment, allowing for rapid change of drilling and boring tooling. All holders are hardened and precision ground. Spanner wrenches are furnished with each holder. When ordering please specify the length and diameter of the shank required, also the size and number of flats required for your machine.



Straight Shank Holders

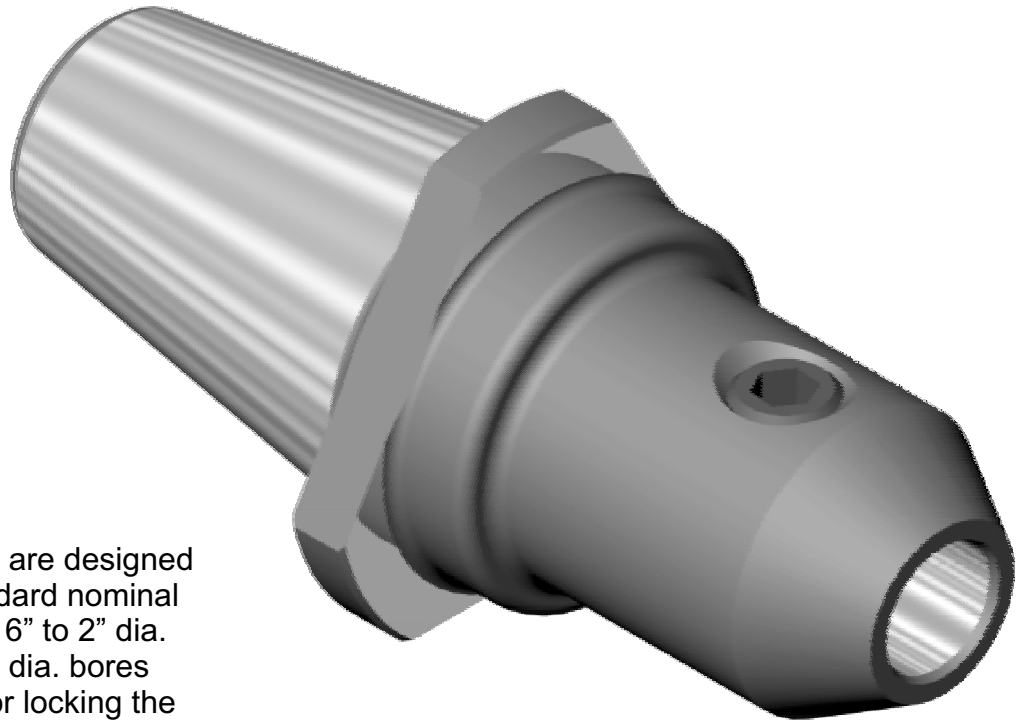
Part Number	PDQ Series	A min A max	B	C	D	E	F
702-61-XXX	VS	1 1/16 2 1/8	2 3/16				To Suit Customer
702-41-XXX	S	1 3/4 3 1/16	3 1/8				To Suit Customer
702-21-XXX	M	2 5/16 4 3/8	4 3/8				To Suit Customer
702-01-XXX	L	3 1/4 6 1/2	5 7/8				To Suit Customer

Order By Part Number

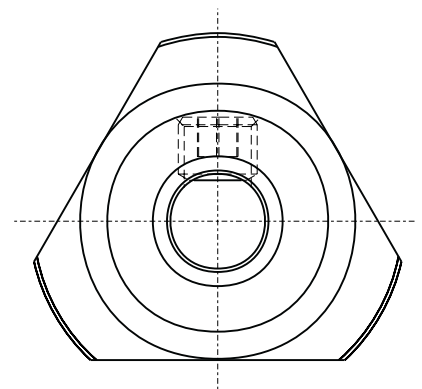
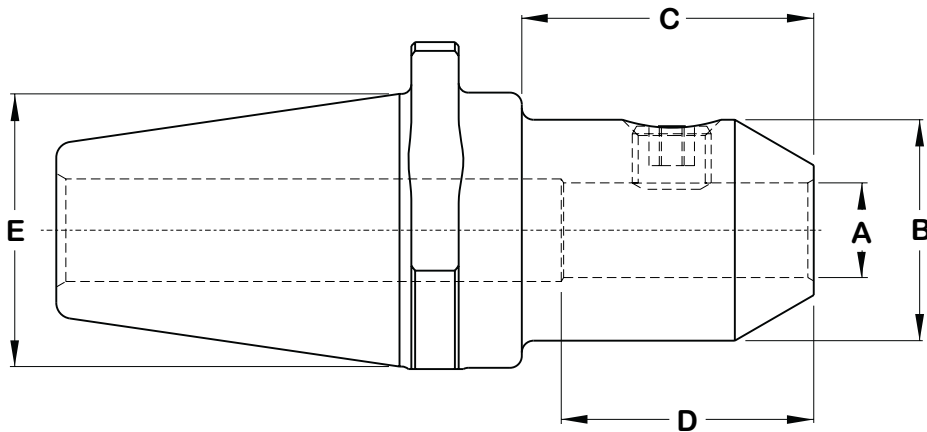
Part number to be assigned at time of order

End Mill Adapters

For end mill shanks from 3/16" - 2" dia.



All end mill adapters are designed for use with all standard nominal size shanks from 3/16" to 2" dia. Adapters with 1" - 2" dia. bores have 2 set screws for locking the end mill in place. All end mill adapters are hardened and precision ground.





End Mill Adapters

For end mill shanks from 3/16" to 2" dia.

End Mill Adapters

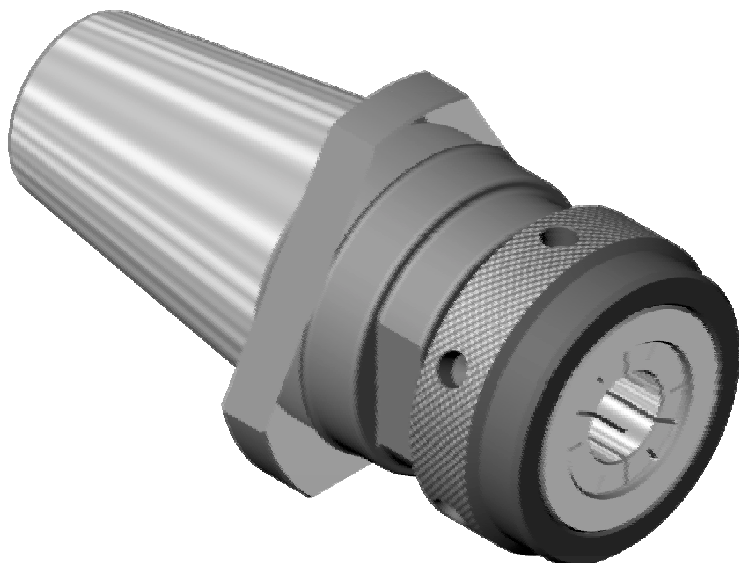
Part Number	PDQ Series	A	B	C	D	E
702-62-001	VS	3/16	7/8	3/4	1	15/16
702-62-002	VS	3/8	1 3/16	31/32	1 1/8	15/16
702-62-003	VS	1/2	1 1/4	1 1/8	1 13/16	15/16
702-62-004	VS	5/8	1 5/8	2 1/4	2	15/16
702-62-005	VS	3/4	1 3/4	2 1/2	2 3/16	15/16
702-42-001	S	3/8	1 1/4	15/16	1 1/8	1 7/16
702-42-002	S	1/2	1 1/2	1 3/32	1 13/16	1 7/16
702-42-003	S	5/8	1 5/8	1 3/32	2	1 7/16
702-42-004	S	3/4	1 3/4	1 5/16	2 3/16	1 7/16
702-42-005	S	7/8	2	1 5/16	2 3/16	1 7/16
702-42-006	S	1	2	2 5/8	2 3/8	1 7/16
702-42-007	S	1 1/4	2 3/8	2 15/16	2 7/16	1 7/16
702-22-001	M	3/8	1 3/16	2 5/16	1 1/8	2 3/16
702-22-002	M	1/2	1 1/2	2 5/16	1 5/8	2 3/16
702-22-003	M	5/8	1 5/8	2 5/16	1 7/8	2 3/16
702-22-004	M	3/4	1 3/4	2 5/16	2	2 3/16
702-22-005	M	7/8	2	2 9/16	4 3/16	2 3/16
702-22-006	M	1	2 3/16	2 13/16	4 5/16	2 3/16
702-22-007	M	1 1/4	2 5/8	3 1/16	2 7/16	2 3/16
702-22-008	M	1 1/2	2 15/16	3 3/8	2 3/4	2 3/16
702-22-009	M	2	3 3/8	4 1/16	3 1/4	2 3/16
702-02-001	L	3/8	1 3/16	2 5/16	3 1/16	3 1/4
702-02-002	L	1/2	1 1/2	2 5/16	3 1/16	3 1/4
702-02-003	L	5/8	1 5/8	2 5/16	3 1/16	3 1/4
702-02-004	L	3/4	1 3/4	2 5/16	3 1/16	3 1/4
702-02-005	L	7/8	2	2 9/16	3 1/16	3 1/4
702-02-006	L	1	2 3/16	2 13/16	2 1/4	3 1/4
702-02-007	L	1 1/4	2 5/8	3 1/16	2 7/16	3 1/4
702-02-008	L	1 1/2	3	3 3/8	2 3/4	3 1/4
702-02-009	L	2	3 1/2	3 3/8	3 1/2	3 1/4

Order by part number

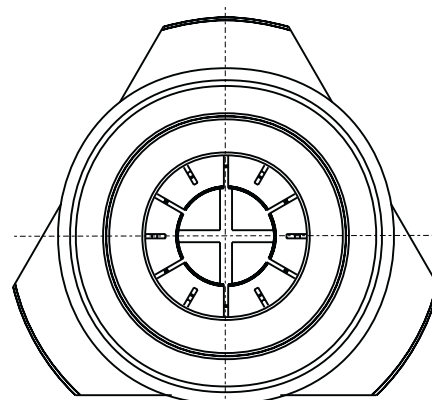
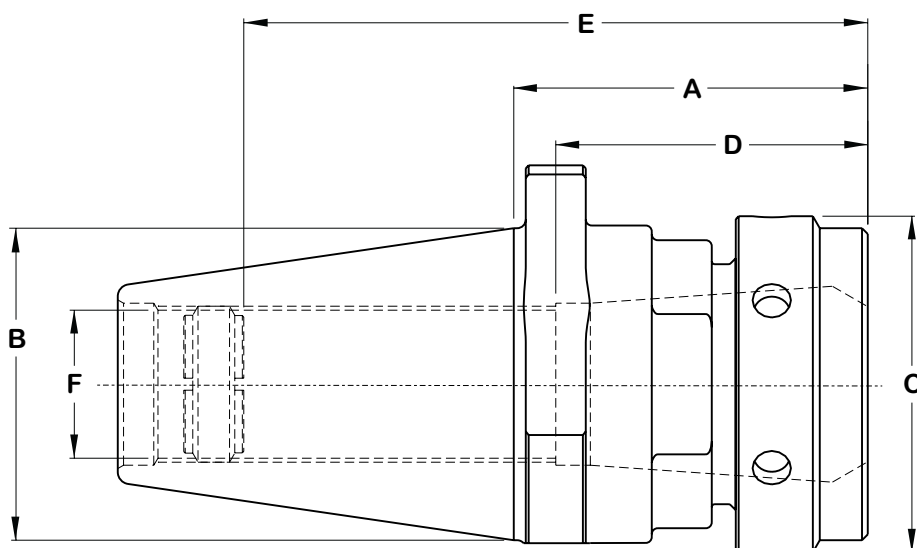
Specials furnished on request

TG Collet Chucks

For use with TG collets series 075, 100 & 150



These collet chucks are for use with TG style collets of both standard and non-pullout types. All PDQ collet chucks are hardened & precision ground. Back-up screws are included in these adapters for presetting the tools.



TG Collet Chuck Adapters

Part Number	PDQ Series	Collet Series	Chuck Capacity	A	B	C	D	E	F
702-63-075	VS	075	1/16 - 3/4	3 1/32	15/16	1 7/8 Hex	1 7/8	3	5 1/6
702-43-075	S	075	1/16 - 3/4	1 7/8	1 7/16	1 7/8 Hex	1 7/8	2 3/8	3/4
702-43-100	S	100	3/32 - 1	2 15/16	1 7/16	2 1/4 Hex	2 9/16	3 3/16	7/8
702-23-100	M	100	3/32 - 1	2 9/32	2 3/16	2 1/4 Hex	2 9/16	4 5/16	1
702-23-150	M	150	1/2 - 1 1/2	3 23/32	2 3/16	3 1/2 Dia	3 1/8	3 15/16	1 1/2
702-03-150	L	150	1/2 - 1 1/2	3 11/16	3 1/4	3 1/2 Dia	3 1/8	6 1/2	1 1/2

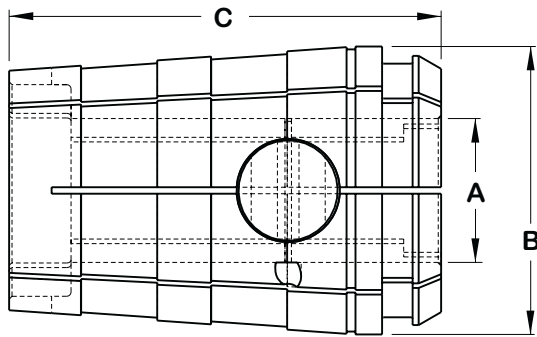
Order by part number

Specials furnished on request

TG Collets

Standard & Non-Pullout Collets

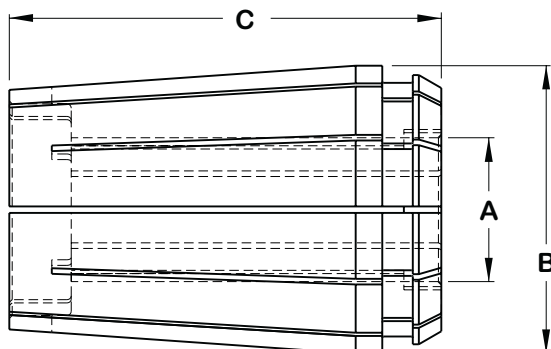
Non-pullout collets have a button that fits into the notch of the end mill locking the end mill in a fixed axial position. This eliminates tool weave and push or pull.



TG Non-Pullout Collets

Part Number	Collet Series	Chuck Capacity	A	B	C
0375-NP-075	075	1/16 - 3/4	3/8	1 1/16	1 27/32
0500-NP-075	075	1/16 - 3/4	1/2	1 1/16	1 27/32
0625-NP-075	075	1/16 - 3/4	5/8	1 1/16	1 27/32
0750-NP-075	075	1 16 - 3/4	3/4	1 1/16	1 27/32
0375-NP-100	100	3/32 - 1	3/8	1 3/8	2 3/8
0500-NP-100	100	3/32 - 1	1/2	1 3/8	2 3/8
0625-NP-100	100	3/32 - 1	5/8	1 3/8	2 3/8
0750-NP-100	100	3/32 - 1	3/4	1 3/8	2 3/8
0875-NP-100	100	3/32 - 1	7/8	1 3/8	2 3/8
1000-NP-100	100	3/32 - 1	1	1 3/8	2 3/8
0500-NP-150	150	1/2 - 1 1/2	1/2	2	3
0625-NP-150	150	1/2 - 1 1/2	5/8	2	3
0750-NP-150	150	1/2 - 1 1/2	3/4	2	3
0875-NP-150	150	1/2 - 1 1/2	7/8	2	3
1000-NP-150	150	1/2 - 1 1/2	1	2	3
1250-NP-150	150	1/2 - 1 1/2	1 1/4	2	3
1500-NP-150	150	1/2 - 1 1/2	1 1/2	2	3

Order by part number



Standard collets accurately hold the tool on the centerline of the collet chuck for precise positioning. These collets grip the entire shank of the tool.

TG Collets

Part Number	Collet Series	Chuck Capacity	A	B	C
XXXX-TG-075	075	1/16 - 3/4	*	1 1/16	1 27/32
XXXX-TG-100	100	3/32 - 1	*	1 3/8	2 3/8
XXXX-TG-150	150	1/2 - 1 1/2	*	2	3

Available in 64th increments

Replace XXXX with size in thousandths

25/64" Collet = 0391-TG-075

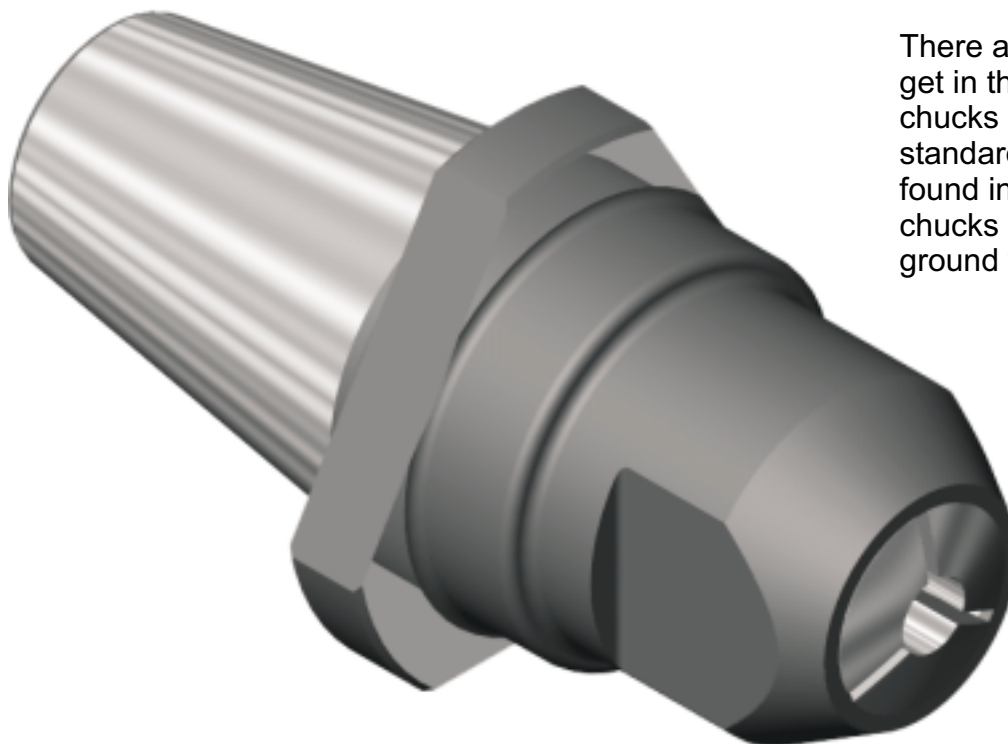
1" Collet = 1000-TG-100

1 1/16" Collet = 1062-TG-150

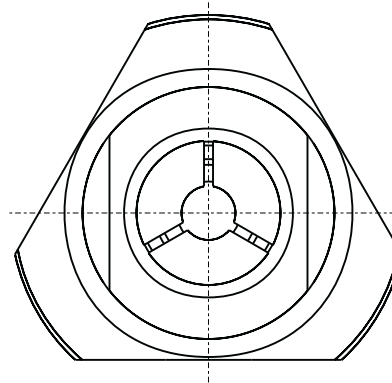
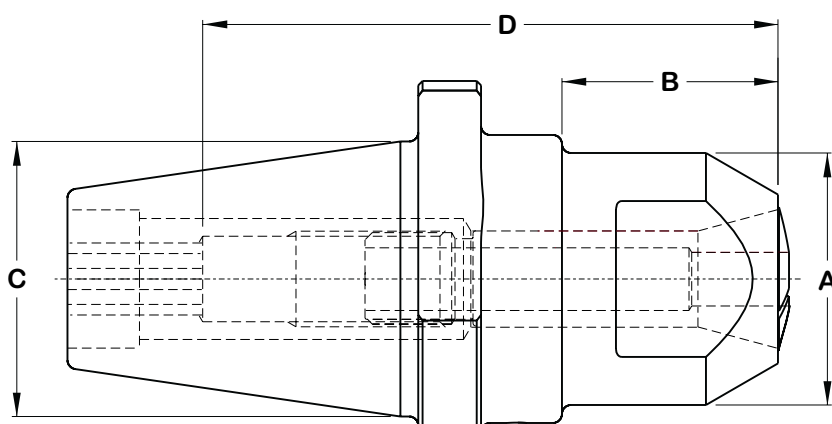
Draw Type Collet Chucks

For use with R-8, 1-C & 3-C Collets

QuickChange
TOOLING



There are no bulky nosepieces to get in the way! These collet chucks are designed to use standard rear actuated collets found in most shops. All collet chucks are harden and precision ground for long accurate life.



Draw Collet Chuck Adapters

Part Number	PDQ Series	Collet Series	Chuck Capacity	A	B	C	D
702-63-001	VS	1-C	1/32 - 1/4	7/8	1 7/16	15/16	3
702-43-001	S	3-C	1/32 - 1/2	1 3/8	1 3/8	1 7/16	3
702-43-002	S	R-8	1/16 - 3/4	1 3/4	2 13/16	1 7/16	3
702-23-001	M	R-8	1/16 - 3/4	2	2 5/16	2 3/16	3

Order by part number

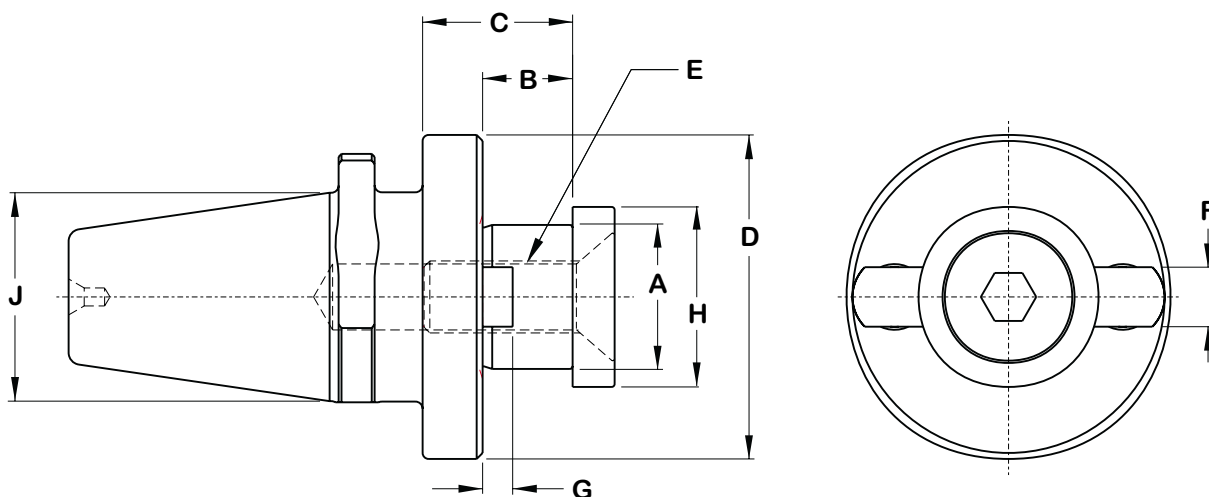
Specials furnished on request



Face Mill Adapters

With 3/4" to 2-1/2" Dia. Pilots

These adapters are designed for any standard shell or face mill that has a standard nominal bore size from 3/4" to 2-1/2" dia. bore. These adapters are also designed to keep the milling cutters as close to the machine spindle as possible to insure maximum rigidity. All face mill adapters are hardened & ground and include lock screw and washer.



Face Mill Adapters

Part Number	PDQ Series	A	B	C	D	E	F	G	H
702-64-001	VS	3/4	11/16	1 3/16	2 3/16	3/8-24	5/16	5/32	15/16
702-64-002	VS	1	11/16	1 3/16	2 3/16	1/2-20	3/8	3/16	15/16
702-44-001	S	3/4	11/16	1 3/16	2 3/16	3/8-24	5/16	5/32	1 7/16
702-44-002	S	1	11/16	1 3/16	2 3/16	1/2-20	3/8	3/16	1 7/16
702-44-003	S	1 1/4	11/16	1 3/16	2 7/8	3/4-16	1/2	1/4	1 7/16
702-44-004	S	1 1/2	15/16	1 9/16	3	3/4-16	5/8	5/16	1 7/16
702-24-001	M	1	11/16	1 3/16	2 3/16	1/2-20	3/8	3/16	2 3/16
702-24-002	M	1 1/4	11/16	1 3/16	2 7/8	3/4-16	1/2	1/4	2 3/16
702-24-003	M	1 1/2	15/16	1 9/16	3 3/8	3/4-16	5/8	5/16	2 3/16
702-24-004	M	2	15/16	1 13/16	4 7/8	3/4-16	3/4	3/8	2 3/16
702-04-001	L	1 1/2	15/16	1 9/16	3 3/8	3/4-16	5/8	5/16	3 1/4
702-04-002	L	2	15/16	1 13/16	4 7/8	3/4-16	3/4	3/8	3 1/4
702-04-003	L	2 1/2	1 1/8	1 7/8	4 7/8	3/4-16	1	1/2	3 1/4

Order by part number

Specials furnished on request

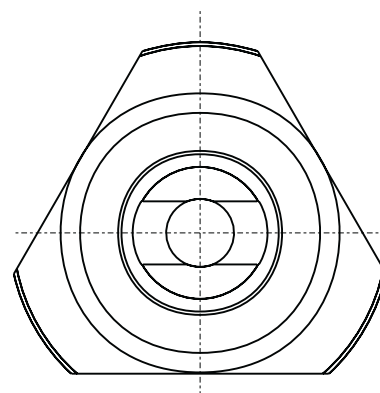
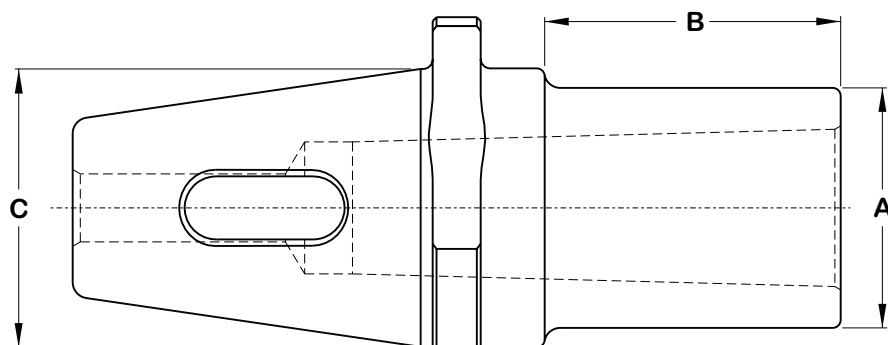
Morse Taper Adapters

Number 1, 2, 3, 4 & 5 tapers

QuickChange
TOOLING



These short morse taper sleeves are designed to shorten up the coupling as much as possible. All morse taper sleeves are hardened and precision ground.



Morse Taper Adapters

Part Number	PDQ Series	Morse Taper	A	B	C
702-65-001	VS	1	1 3/8	7/8	15/16
702-65-002	VS	2	2 27/32	1 1/8	15/16
702-45-001	S	2	1 3/16	1 1/4	1 7/16
702-45-002	S	3	2 1/16	1 1/2	1 7/16
702-25-001	M	2	7/8	1 1/4	2 3/16
702-25-002	M	3	1 3/4	1 1/2	2 3/16
702-25-003	M	4	2 5/16	1 7/8	2 3/16
702-25-004	M	5	3 9/16	2 1/2	2 3/16

Order by part number

Specials furnished on request

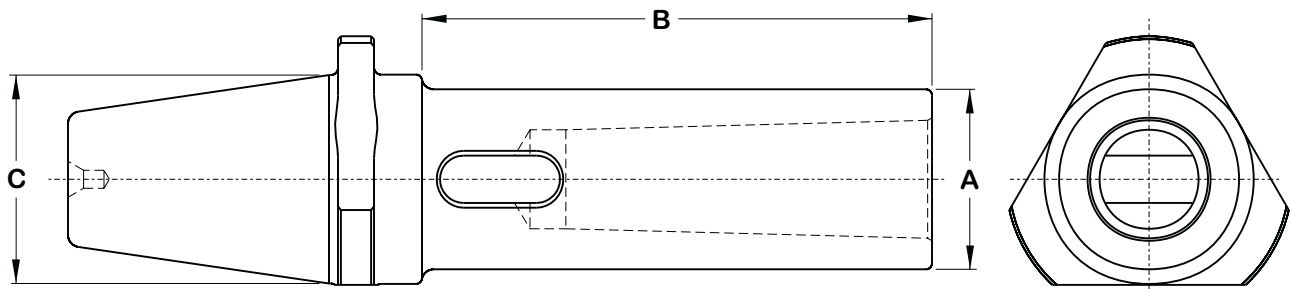


Long Morse Taper Adapters

Number 2, 3, 4 & 5 Morse Tapers



These long series morse taper adapters are used when extra reach is required. All morse taper sleeves are hardened and precision ground.



Long Morse Taper Adapters

Part Number	PDQ Series	Morse Taper	A	B	C
702-45-490	S	2	3 7/16	1 1/4	1 7/16
702-45-491	S	3	4 5/16	1 1/2	1 7/16
702-45-492	S	4	5 1/4	1 7/8	1 7/16
702-25-490	M	2	3 9/16	1 1/4	2 3/16
702-25-491	M	3	4 7/16	1 1/2	2 3/16
702-25-492	M	4	5 5/16	1 7/8	2 3/16
702-25-493	M	5	6 11/16	2 1/2	2 3/16
702-05-490	L	3	4 3/8	1 1/2	3 1/4
702-05-491	L	4	5 1/4	1 7/8	3 1/4
702-05-492	L	5	6 9/16	2 1/2	3 1/4

Order by part number

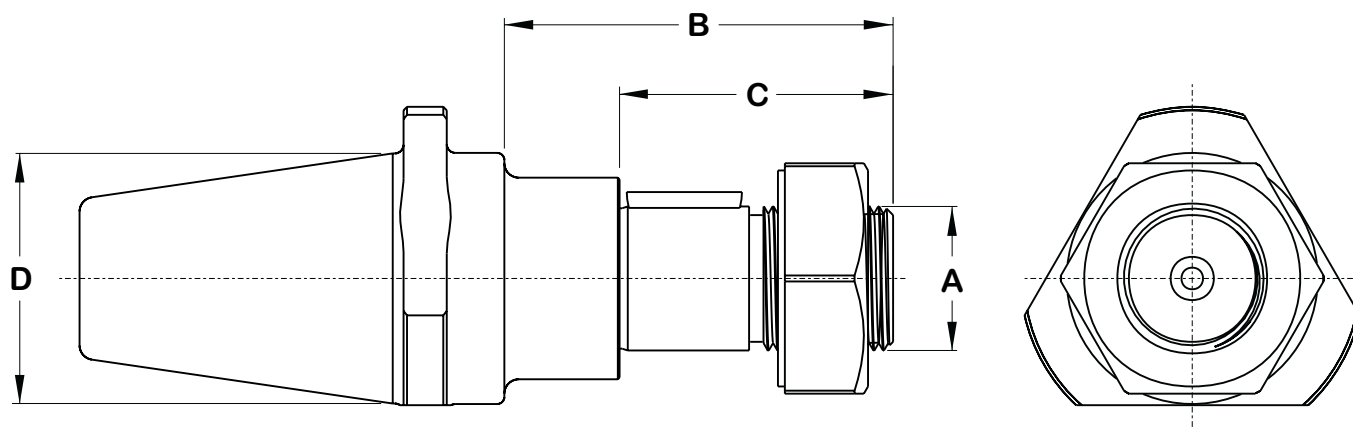
Specials furnished on request

Short Stub Arbors

3/4", 1" & 1-1/4" Arbors



The arbors are designed to fit cutters having a standard nominal hole size of 3/4", 1" or 1-1/4" dia. Retaining nut and drive key is included. All short stub arbors are hardened and precision ground.



Short Stub Arbors

Part Number	PDQ Series	A	B	C	D
702-46-001	S	3/4	1 3/4	2 11/16	1 7/16
702-46-002	S	1	2 1/8	3 1/16	1 7/16
702-26-001	M	1	2 1/8	3 1/8	2 3/16
702-26-002	M	1 1/4	2 3/8	3 3/8	2 3/16
702-06-001	L	1 1/4	2 3/8	3 3/8	3 1/4

Order by part number

Specials furnished on request

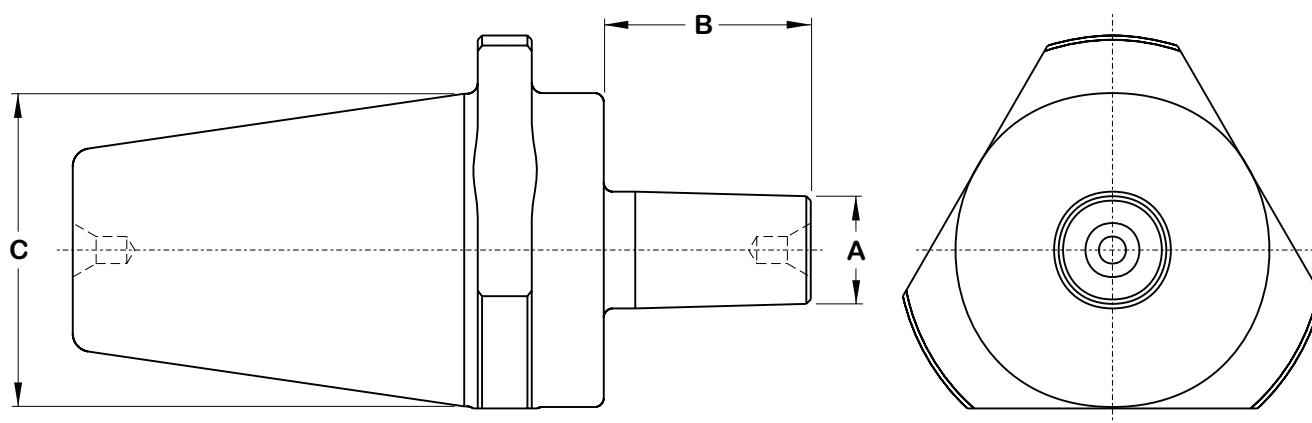


Jacobs Chuck Adapters

For Jacobs style chucks



These adapter are designed for Chucks that have a Jacobs taper mount. All jacobs chuck adapters are hardened and precision ground.



Jacobs Chuck Adapters

Part Number	PDQ Series	Jacobs Taper	A	B	C
702-67-001	VS	1	27/32	0.334	15/16
702-67-002	VS	2	1 1/16	0.488	15/16
702-67-003	VS	6	1 3/16	0.624	15/16
702-67-004	VS	33	1 3/16	0.561	15/16
702-67-005	VS	3	1 7/16	0.746	15/16
702-47-001	S	3	1 7/16	0.746	1 7/16
702-47-002	S	2	1 1/16	0.488	1 7/16
702-27-001	M	3	1 7/16	0.746	2 3/16
702-27-002	M	4	1 27/32	1.037	2 3/16
702-07-001	L	4	1 27/32	1.037	3 1/4
702-07-002	L	5	2 1/16	1.316	3 1/4

Order by part number

Specials furnished on request

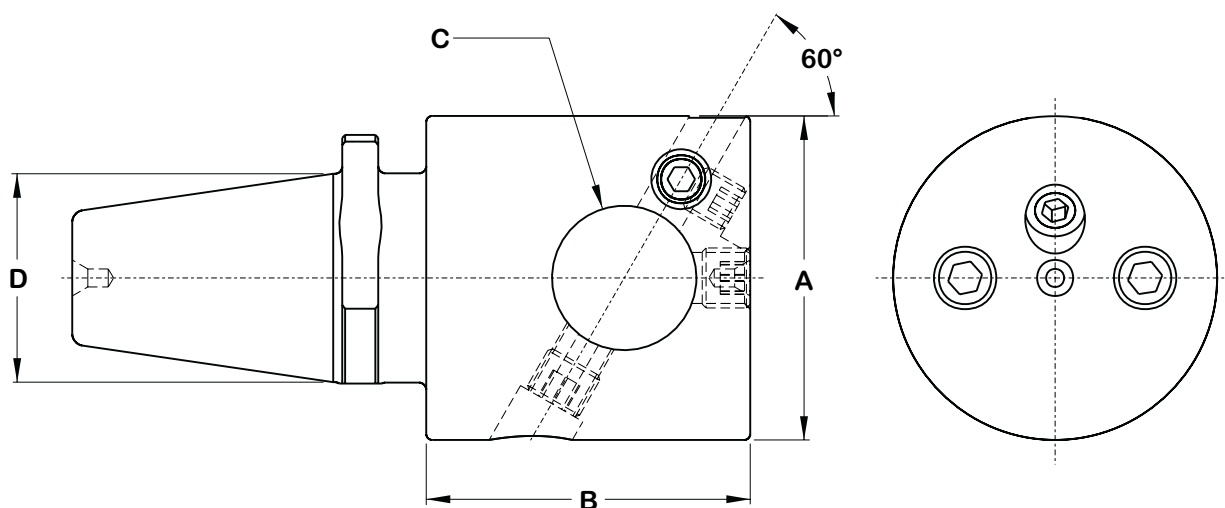
"Bar Bit" Boring Heads

For large hole boring

QuickChange
TOOLING



PDQ boring heads are designed for boring large diameter holes. An adjusting screw in the tool slot makes it simple to make minute tool adjustments. By using the boring bars on the following page even larger hole may be bored. All heads are hardened and precision ground.



Bar Bit Boring Heads

Part Number	PDQ Series	A	B	C	D	Tool Slot
702-48-001	S	2 7/16	2 3/8	1 1/4	1 7/16	1/2 sq
702-28-001	M	3 3/8	3 3/8	1 1/2	2 3/16	1/2 sq
702-08-001	L	4 1/2	4 1/2	2	3 1/4	5/8 sq

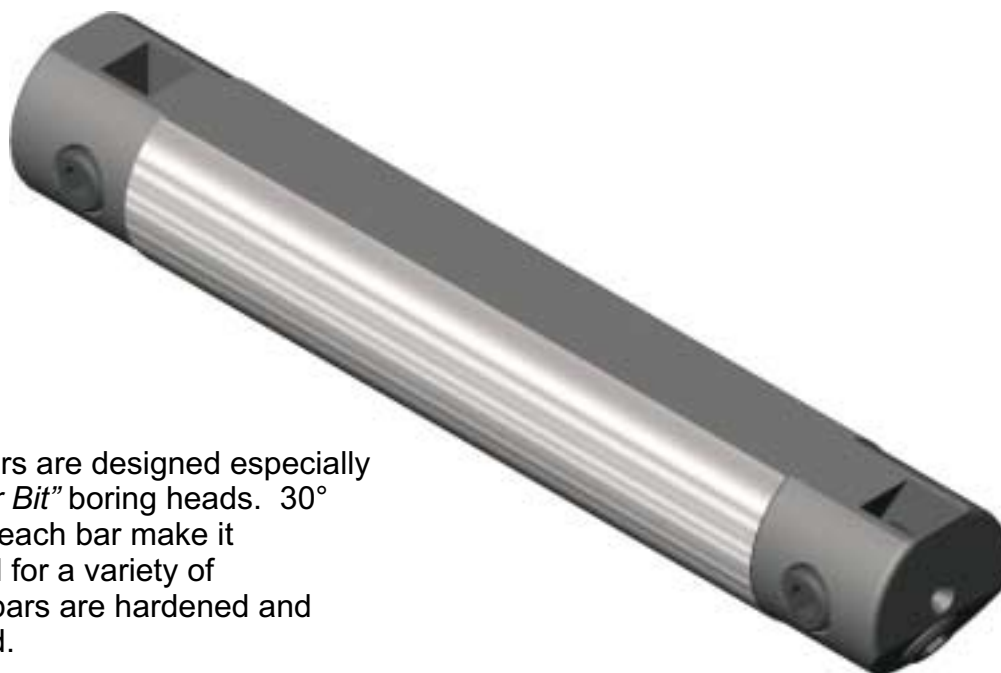
Order by part number

Specials furnished on request

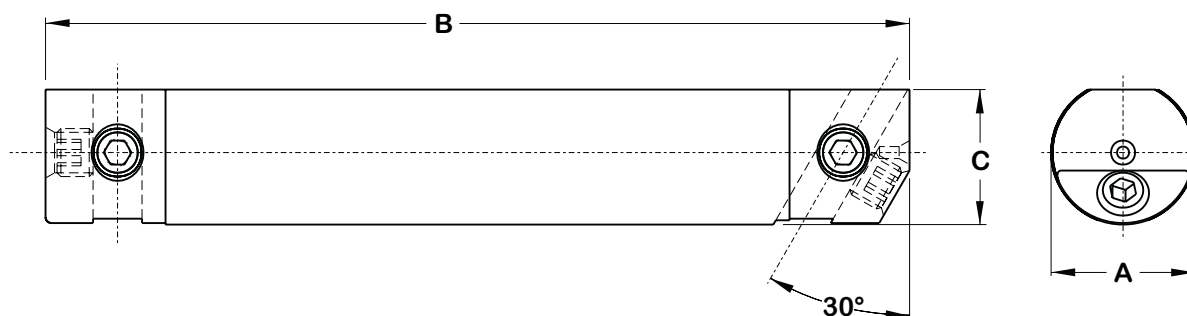


“Bar Bit” Boring Bars

Slotted Boring Bars



These boring bars are designed especially for use with “Bar Bit” boring heads. 30° and 90° slots in each bar make it extremely useful for a variety of operations. All bars are hardened and precision ground.



Boring Bars for Bar Bit Boring Heads

Part Number	PDQ Series	A	B	C	Tool Slot
702-49-001	S	1 1/4	6	1 5/32	3/8 sq
702-49-002	S	1 1/4	9	1 5/32	3/8 sq
702-29-001	M	1 1/2	6	1 13/32	1/2 sq
702-29-002	M	1 1/2	9	1 13/32	1/2 sq
702-09-001	L	2	6	1 7/8	5/8 sq
702-09-002	L	2	9	1 7/8	5/8 sq
702-09-003	L	2	12	1 7/8	5/8 sq

Order by part number

Specials furnished on request

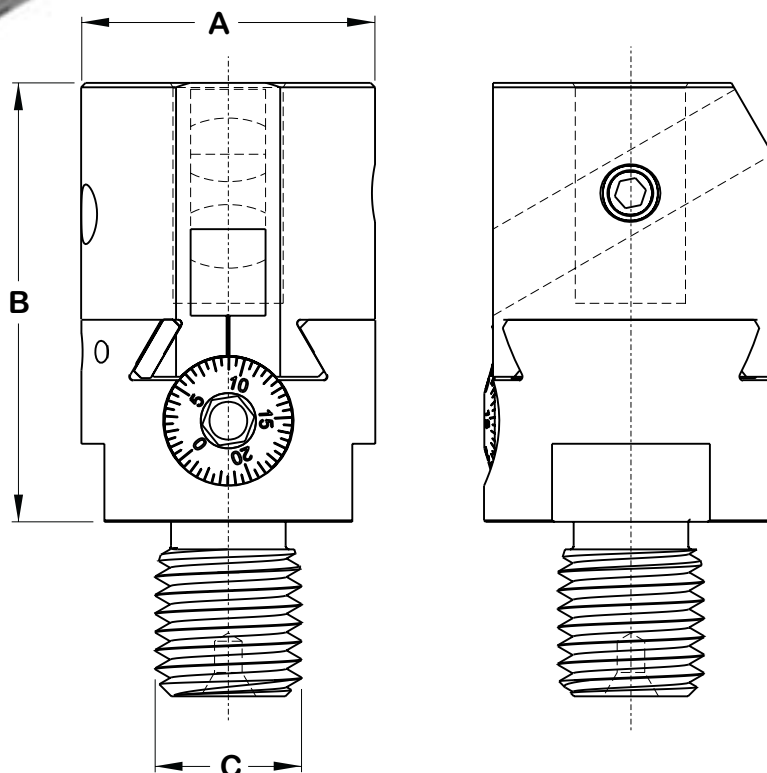
2" Adjustable Boring Heads

Boring Range 3/8" to 5-1/2"

QuickChange
TOOLING



This is a precision built boring head which is especially good for jig-boring where fine adjustment and rigidity are very important. A precision screw allows for very accurate micrometer adjustments of the tool bit slide. The slide has a travel of 5/8". A 3/4" diameter hole in the top end of the head permits the insertion of a 3/4" diameter shank boring bar for small hole boring. All parts are heat treated precision fitted and/or ground.



2" Adjustable Boring Heads

Part Number	PDQ Series	A	B	C	Tool Slot
702-30-001	S	2	3	1"-8	1/2 sq
702-30-001	M	2	3	1"-8	1/2 sq
702-30-001	L	2	3	1"-8	1/2 sq

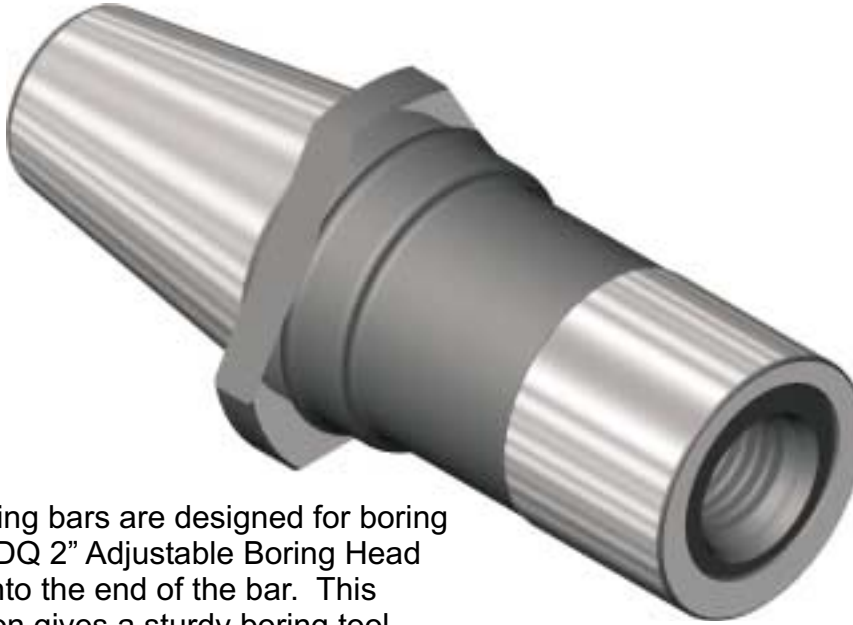
Order by part number

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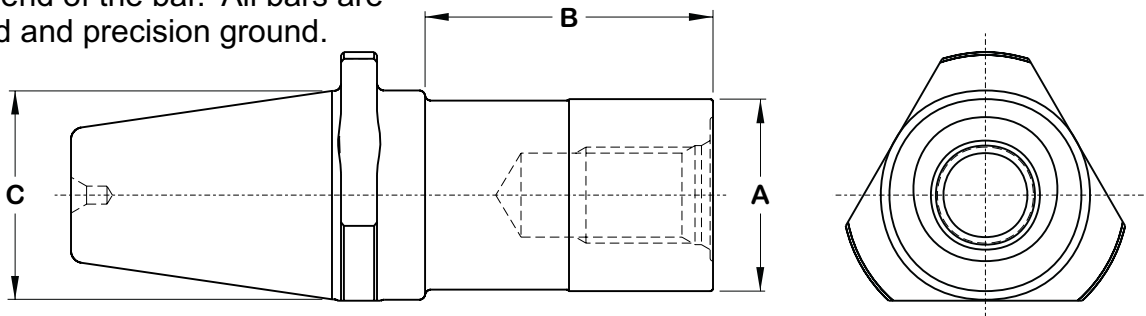


Extended Boring Adapters

For 2" Adjustable Boring Heads



These boring bars are designed for boring with the PDQ 2" Adjustable Boring Head screwed into the end of the bar. This combination gives a sturdy boring tool with only the minimum amount of mass that is off-center, since everything runs true with the centerline except the tool bit and the small adjustable slide at the extreme end of the bar. All bars are hardened and precision ground.



Adapters for 2" Adjustable Boring Heads

Part Number	PDQ Series	A	B	C
702-51-001	S	2	3	1 7/16
702-31-001	M	2	3	2 3/16
702-31-002	M	2	6	2 3/16
702-31-003	L	2	9	2 3/16
702-11-001	L	2	3	3 1/4
702-11-002	L	2	6	3 1/4
702-11-003	L	2	9	3 1/4

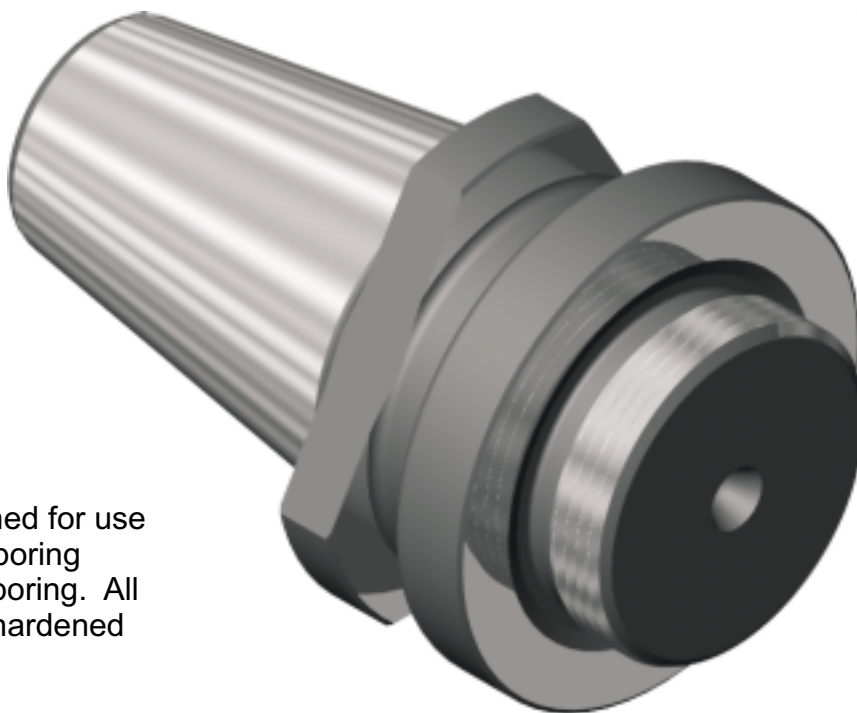
Order by part number

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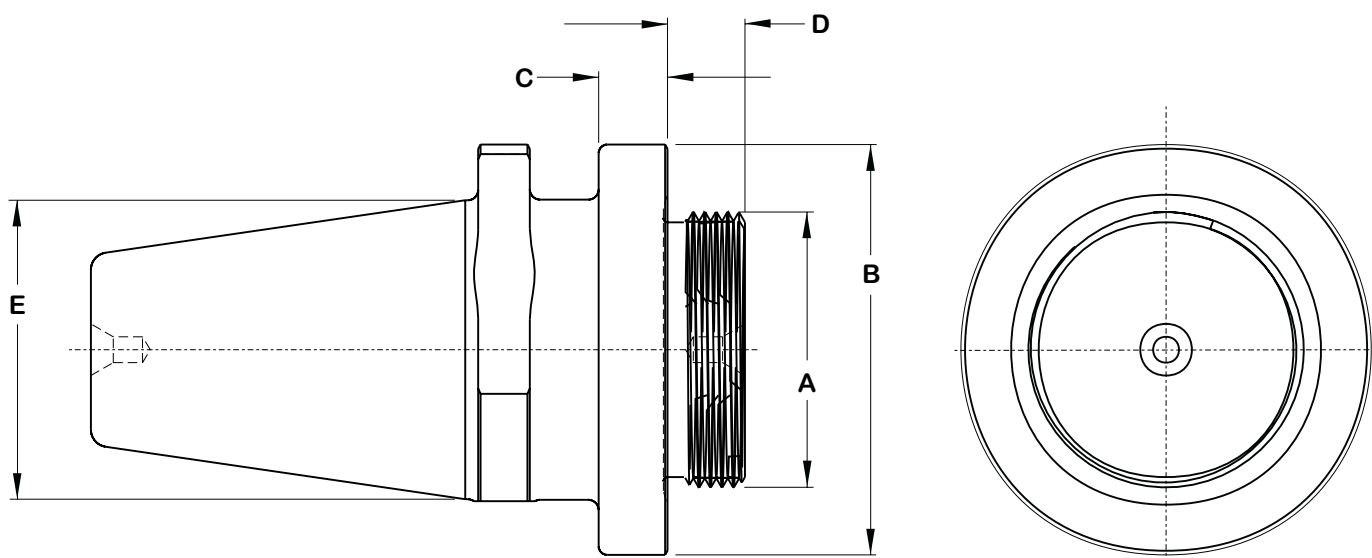
Boring Head Adapters

For mounting of boring heads

QuickChange
TOOLING



These adapters are designed for use with other manufacturer's boring heads, allowing precision boring. All boring head adapters are hardened and precision ground.





Boring Head Adapters

For mounting of Boring Heads

Boring Head Adapters

Part Number	PDQ Series	A	B	C	D	E	For
702-72-001	VS	7/8-18	1 1/2	5/16	7/16	15/16	Craley #1 & #3
702-72-002	VS	5/8-18	1		7/16	15/16	Bridgeport #1
702-72-003	VS	1 1/4-20	1 5/8	3/16	17/32	15/16	Bridgeport #2
702-72-004	VS	1/2-20	1 1/2	1/4	5/15	15/16	Chandler Model J
702-72-005	VS	3/4-16	1	1/4	1/2	15/16	Maxwell #30, #40 & #50
702-72-006	VS	1-14	1 1/4	1/4	3/4	15/16	Maxwell #60
702-72-007	VS	1 7/16-12	2	1/4	9/16	15/16	Flynn #8, #10, #12, #30 & #35
702-52-001	S	7/8-18	2 1/8	3/8	1 7/16	1 7/16	Craley #1 & #3
702-52-002	S	1 5/16-18	2 5/8	3/8	5/8	1 7/16	Craley #2 & #4
702-52-003	S	3/4-16	1 3/4		5/8	1 7/16	Chandler "D" - 1 1/2 - 2 1/2
702-52-004	S	3/4-16	1 3/4		9/16	1 7/16	Chandler Model D
702-52-005	S	1/2-20	1 3/16		5/16	1 7/16	Chandler Model J
702-32-001	M	7/8-18	2-3/16		7/16	2 3/16	Craley #1 & #3
702-32-002	M	1 5/16-18	3 1/16	3/8	5/8	2 3/16	Craley #2 & #4
702-32-003	M	3/4-16	1 3/4		5/8	2 3/16	Chandler "D" - 1 1/2 - 2 1/2
702-32-004	M	3/4-16	1 3/4		9/16	2 3/16	Chandler Model D
702-32-005	M	1/2-20	1 3/16		5/16	2 3/16	Chandler Model J
702-32-006	M	1 1/4-10	2 5/8	1/2	19/32	2 3/16	Chandler 3 1/2 - 4 1/2
702-32-007	M	1 7/16-12	3 1/16	1/2	9/16	2 3/16	Flynn #8, #10, #12, #30, #35 & #45
702-32-008	M	2-12	3 1/2	1/2	9/16	2 3/16	Flynn #20, #32, #33, #36, #47, #48 & #49
702-32-009	M	1 1/2-12	2		17/32	2 3/16	Everede
702-32-010	M	1 1/2-18	1 7/8	1/4	1/2	2 3/16	Criterion #3
702-32-011	M	3/4-16	1	1/4	1/2	2 3/16	Maxwell #30, #40 & #50
702-32-012	M	1-14	1 1/4	1/4	3/4	2 3/16	Maxwell #60
702-32-013	M	1 1/4-12	1 1/2	1/4	7/8	2 3/16	Maxwell #31, #41 & #70
702-32-014	M	1 3/4-12	2	1/4	1 1/2	2 3/16	Maxwell #32 & #42
702-12-001	L	1 5/16-18	3 5/16		5/8	3 1/4	Craley #2 & #4
702-12-002	L	1 1/4-10	2 5/8	1/2	19/32	3 1/4	Chandler 3 1/2 - 4 1/2
702-12-003	L	1 7/16-12	3 1/2	1/2	9/16	3 1/4	Flynn #8, #10, #12, #30, #35 & #45
702-12-004	L	2-12	3 1/2	1/2	9/16	3 1/4	Flynn #20, #32, #33, #36, #47, #48 & #49
702-12-005	L	1 1/2-18	1 7/8	1/4	1/2	3 1/4	Criterion #3
702-12-006	L	1 3/4-12	2	1/4	1 1/2	3 1/4	Maxwell #32 & #42

Order by part number

Specials furnished on request

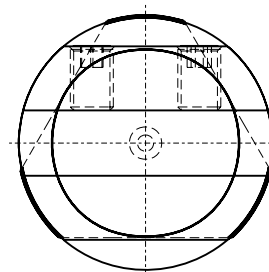
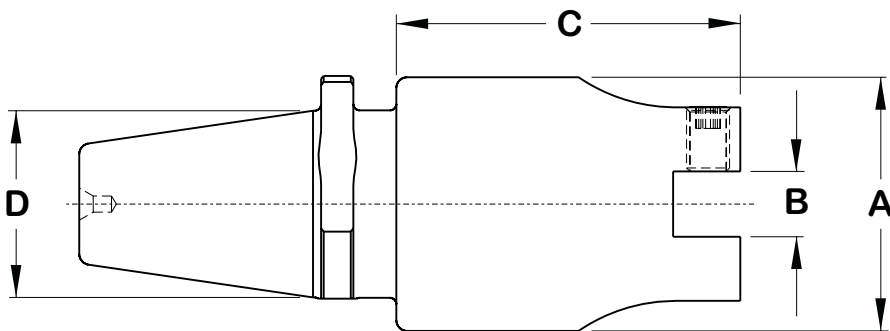
Open End Boring Bars

For flat bottom bores

QuickChange
TOOLING



These boring bars are designed for flat bottom bores or counterbores. They are especially good for “hole-hogging” with carbide tools. All bars are hardened and precision ground.



Open End Boring Bars

Part Number	PDQ Series	A	B	C	D
702-53-001	S	2 3/16	1/2	3	1 7/16
702-53-002	S	2 3/16	1/2	6	1 7/16
702-33-001	M	2 15/16	3/4	4	2 3/16
702-33-002	M	2 15/16	3/4	8	2 3/16
702-13-001	L	4	1	4	3 1/4
702-13-002	L	4	1	8	3 1/4

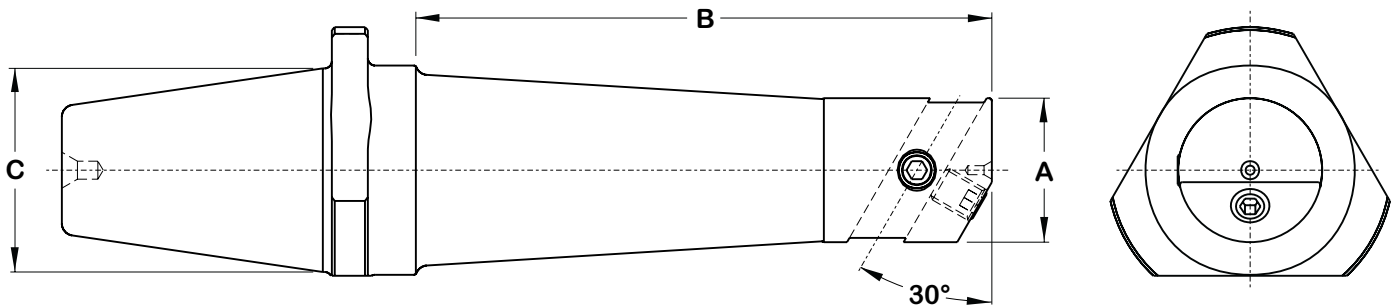
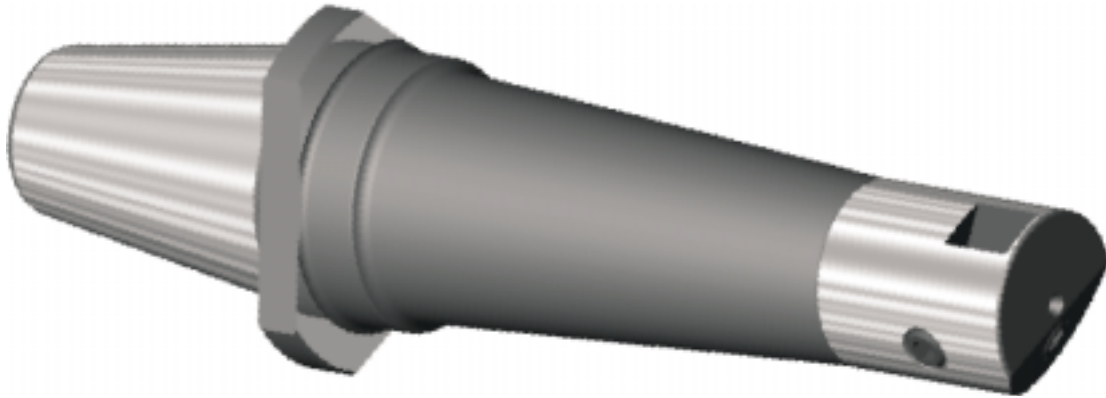
Order by part number

Specials furnished on request



Tapered Boring Bars

30° Tool Slots



Tapered Boring Bars

Part Number	PDQ Series	A	B	C	Tool Size
702-73-200	VS	5/8	3	15/16	1/4 sq
702-73-201	VS	5/8	6	15/16	1/4 sq
702-53-200	S	5/8	3	1 7/16	1/4 sq
702-53-201	S	5/8	6	1 7/16	1/4 sq
702-53-202	S	5/8	9	1 7/16	1/4 sq
702-53-203	S	1	3	1 7/16	3/8 sq
702-53-204	S	1	6	1 7/16	3/8 sq
702-53-205	S	1	9	1 7/16	3/8 sq
702-33-200	M	1	6	2 3/16	3/8 sq
702-33-201	M	1	9	2 3/16	3/8 sq
702-33-202	M	1	12	2 3/16	3/8 sq
702-33-203	M	1 1/2	6	2 3/16	1/2 sq
702-33-204	M	1 1/2	9	2 3/16	1/2 sq
702-33-205	M	1 1/2	12	2 3/16	1/2 sq
702-13-200	L	1	6	3 1/4	3/8 sq
702-13-201	L	1	9	3 1/4	3/8 sq
702-13-202	L	1	12	3 1/4	3/8 sq
702-13-203	L	1 1/2	6	3 1/4	1/2 sq
702-13-204	L	1 1/2	9	3 1/4	1/2 sq
702-13-205	L	1 1/2	12	3 1/4	1/2 sq
702-13-206	L	2	6	3 1/4	1/2 sq
702-13-207	L	2	9	3 1/4	1/2 sq
702-13-208	L	2	12	3 1/4	1/2 sq

These boring bars are designed to cover a wide variety of boring operations. The tapered design gives a maximum amount of rigidity for small hole boring. Bar diameters at the tip range from 5/8" to 2", while the boring length range is from 3" to 12" long. 30° tool slots add to the convenience and versatility of these bars. All bars are hardened for extra rigidity and precision ground.

Order by part number

Specials furnished on request

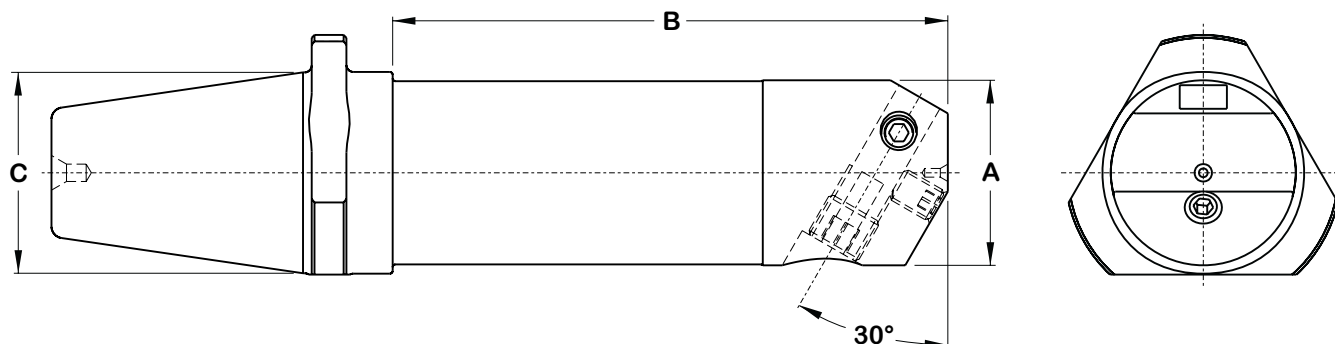
Straight Boring Bars

30° Tool Slots

QuickChange
TOOLING



These boring bars are designed for maximum rigidity and accuracy. 30° tool slots with adjusting screws add to the versatility of the bars. All bars are hardened, for increased rigidity and precision ground.



Straight Boring Bars

Part Number	PDQ Series	A	B	C	Tool Size
702-73-400	VS	1	3	15/16	3/8 sq
702-73-401	VS	1	6	15/16	3/8 sq
702-53-400	S	1 1/2	3	1 7/16	1/2 sq
702-53-401	S	1 1/2	6	1 7/16	1/2 sq
702-53-402	S	1 1/2	9	1 7/16	1/2 sq
702-33-400	M	2	6	2 3/16	1/2 sq
702-33-401	M	2	9	2 3/16	1/2 sq
702-33-402	M	2	12	2 3/16	1/2 sq
702-13-400	L	3	6	3 1/4	5/8 sq
702-13-401	L	3	9	3 1/4	5/8 sq
702-13-402	L	3	12	3 1/4	5/8 sq

Order by part number

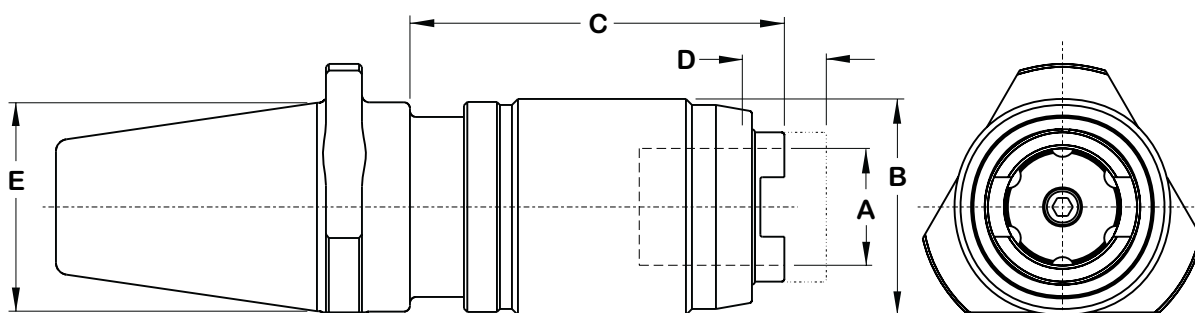
Specials furnished on request



Tapping Adapters

For series 1, 2 & 3 Tap Chucks

PDQ tapping adapters accept industry-standard tap chucks of either ball drive or ear drive styles. These tapping adapters feature tension and/or compression, which is completely adjustable by the end user. Tap chucks may be quickly changed by simply sliding the locking sleeve. All tapping adapters are hardened and precision ground.



Tapping Adapters

Part Number	PDQ Series	Chuck Series	Tap Range	A	B	C	D	E
702-74-001	VS	1	#0 - 9/16	0.75	1 1/2	2 1/4	1/2	15/16
702-54-001	S	1	#0 - 9/16	0.75	1 1/2	2 1/4	1/2	1 7/16
702-54-002	S	2	1/4 - 7/8	1.22	2 1/4	4 5/32	7/8	1 7/16
702-34-001	M	1	#0 - 9/16	0.75	1 1/2	2 1/4	1/2	2 3/16
702-34-002	M	2	1/4 - 7/8	1.22	2 1/4	3 29/32	7/8	2 3/16
702-34-003	M	3	3/4 - 1 3/8	1.89	3 3/8	5 5/16	1 1/4	2 3/16
702-14-001	L	2	1/4 - 7/8	1.22	2 1/4	3 29/32	7/8	3 1/4
702-14-002	L	3	3/4 - 1 3/8	1.89	3 3/8	5 5/16	1 1/4	3 1/4

Order by part number

Specials furnished on request

Solid Tap Chucks

For series 1, 2 and 3 Tapping Adapters

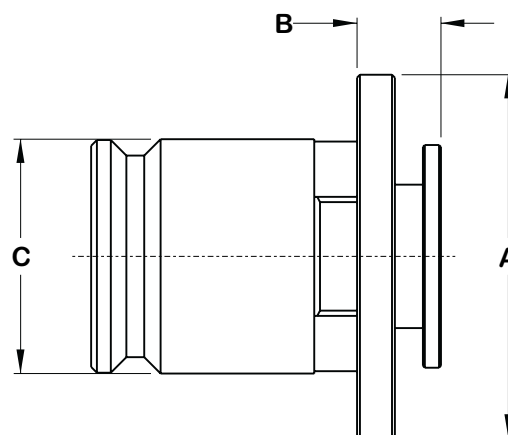


Solid Tap Chucks

Part Number	Chuck Series	Tap Size	A	B	C
0141-STC-01	1	#0 - #6	1 3/16	9/32	0.75
0168-STC-01	1	#8	1 3/16	9/32	0.75
0194-STC-01	1	#10	1 3/16	9/32	0.75
0220-STC-01	1	#12	1 3/16	9/32	0.75
0255-STC-01	1	1/4	1 3/16	9/32	0.75
0318-STC-01	1	5/16	1 3/16	9/32	0.75
0381-STC-01	1	3/8	1 3/16	9/32	0.75
0323-STC-01	1	7/16	1 3/16	9/32	0.75
0367-STC-01	1	1/2	1 3/16	9/32	0.75
0429-STC-01	1	9/16	1 3/16	9/32	0.75
0313-STC-01	1	1/16 Pipe	1 3/16	9/32	0.75
0438-STC-01	1	1/8 Pipe	1 3/16	9/32	0.75
0255-STC-02	2	1/4	1 7/8	7/16	1.22
0318-STC-02	2	5/16	1 7/8	7/16	1.22
0381-STC-02	2	3/8	1 7/8	7/16	1.22
0323-STC-02	2	7/16	1 7/8	7/16	1.22
0367-STC-02	2	1/2	1 7/8	7/16	1.22
0429-STC-02	2	9/16	1 7/8	7/16	1.22
0480-STC-02	2	5/8	1 7/8	7/16	1.22
0542-STC-02	2	11/16	1 7/8	7/16	1.22
0590-STC-02	2	3/4	1 7/8	7/16	1.22
0652-STC-02	2	13/16	1 7/8	7/16	1.22
0697-STC-02	2	7/8	1 7/8	7/16	1.22
0438-STC-02	2	1/8 Pipe	1 7/8	7/16	1.22
0563-STC-02	2	1/4 Pipe	1 7/8	7/16	1.22
0700-STC-02	2	3/8 Pipe	1 7/8	7/16	1.22
0688-STC-02	2	1/2 Pipe	1 7/8	7/16	1.22
0590-STC-03	3	3/4	2 3/4	9/16	1.89
0652-STC-03	3	13/16	2 3/4	9/16	1.89
0697-STC-03	3	7/8	2 3/4	9/16	1.89
0760-STC-03	3	15/16	2 3/4	9/16	1.89
0800-STC-03	3	1	2 3/4	9/16	1.89
0896-STC-03	3	1 1/8	2 3/4	9/16	1.89
1021-STC-03	3	1 1/4	2 3/4	9/16	1.89
1108-STC-03	3	1 3/8	2 3/4	9/16	1.89
0700-STC-03	3	3/8 Pipe	2 3/4	9/16	1.89
0688-STC-03	3	1/2 Pipe	2 3/4	9/16	1.89
0906-STC-03	3	3/4 Pipe	2 3/4	9/16	1.89
1125-STC-03	3	1 Pipe	2 3/4	9/16	1.89



These tap chucks are of the positive drive type. Taps are easily changed without removing the chuck by simply depressing the retaining collar. All tap chucks are hardened and precision ground.



Order by part number

Specials furnished on request

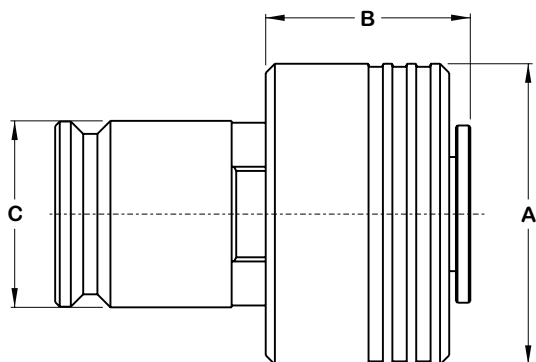


Torque Control Tap Chucks

For series 1, 2 & 3 Tapping Adapters



These tap chucks have torque control to eliminate tap breakage. The torque setting in torque control tap chucks is adjustable allowing for different types of taps as well as different materials. All torque control tap chucks are hardened and precision ground.



Torque Limiting Tap Chucks

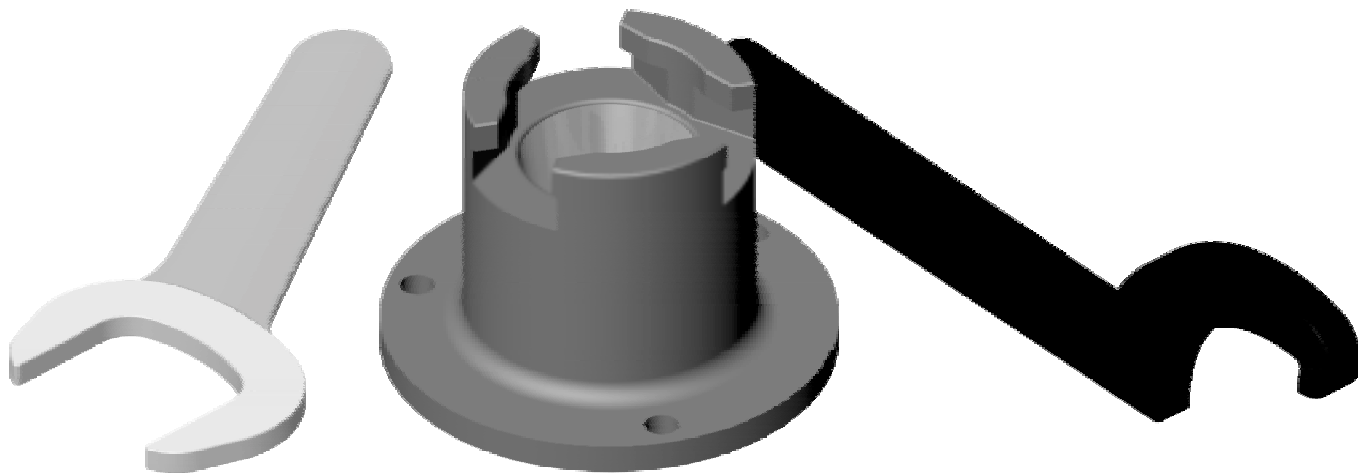
Part Number	Chuck Series	Tap Size	A	B	C
0141-TCC-01	1	#0 - #6	1 1/4	1	0.75
0168-TCC-01	1	#8	1 1/4	1	0.75
0194-TCC-01	1	#10	1 1/4	1	0.75
0220-TCC-01	1	#12	1 1/4	1	0.75
0255-TCC-01	1	1/4	1 1/4	1	0.75
0318-TCC-01	1	5/16	1 1/4	1	0.75
0381-TCC-01	1	3/8	1 1/4	1	0.75
0323-TCC-01	1	7/16	1 1/4	1	0.75
0367-TCC-01	1	1/2	1 1/4	1	0.75
0429-TCC-01	1	9/16	1 1/4	1	0.75
0313-TCC-01	1	1/16 Pipe	1 1/4	1	0.75
0438-TCC-01	1	1/8 Pipe	1 1/4	1	0.75
0255-TCC-02	2	1/4	1 15/16	1 11/32	1.22
0318-TCC-02	2	5/16	1 15/16	1 11/32	1.22
0381-TCC-02	2	3/8	1 15/16	1 11/32	1.22
0323-TCC-02	2	7/16	1 15/16	1 11/32	1.22
0367-TCC-02	2	1/2	1 15/16	1 11/32	1.22
0429-TCC-02	2	9/16	1 15/16	1 11/32	1.22
0480-TCC-02	2	5/8	1 15/16	1 11/32	1.22
0542-TCC-02	2	11/16	1 15/16	1 11/32	1.22
0590-TCC-02	2	3/4	1 15/16	1 11/32	1.22
0652-TCC-02	2	13/16	1 15/16	1 11/32	1.22
0697-TCC-02	2	7/8	1 15/16	1 11/32	1.22
0438-TCC-02	2	1/8 Pipe	1 15/16	1 11/32	1.22
0563-TCC-02	2	1/4 Pipe	1 15/16	1 11/32	1.22
0700-TCC-02	2	3/8 Pipe	1 15/16	1 11/32	1.22
0688-TCC-02	2	1/2 Pipe	1 15/16	1 11/32	1.22
0590-TCC-03	3	3/4	2 27/32	1 25/32	1.89
0652-TCC-03	3	13/16	2 27/32	1 25/32	1.89
0697-TCC-03	3	7/8	2 27/32	1 25/32	1.89
0760-TCC-03	3	15/16	2 27/32	1 25/32	1.89
0800-TCC-03	3	1	2 27/32	1 25/32	1.89
0896-TCC-03	3	1 1/8	2 27/32	1 25/32	1.89
1021-TCC-03	3	1 1/4	2 27/32	1 25/32	1.89
1108-TCC-03	3	1 3/8	2 27/32	1 25/32	1.89
0700-TCC-03	3	3/8 Pipe	2 27/32	1 25/32	1.89
0688-TCC-03	3	1/2 Pipe	2 27/32	1 25/32	1.89
0906-TCC-03	3	3/4 Pipe	2 27/32	1 25/32	1.89
1125-TCC-03	3	1 Pipe	2 27/32	1 25/32	1.89

Order by part number

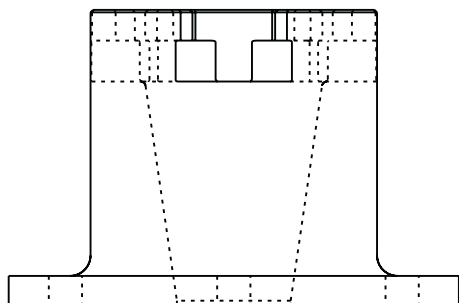
Specials furnished on request

Accessories

Tightening fixtures & wrenches



TIGHTENING FIXTURES



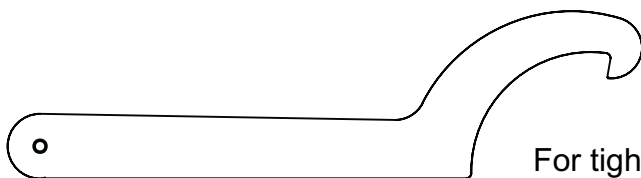
These tightening fixtures are used to tighten & loosen collets, set screws and other items.

Tightening Fixtures

Part Number	PDQ Series
702-80-100	VS
702-60-100	S
702-40-100	M
702-20-100	L

Order by part number

SPANNER WRENCHES



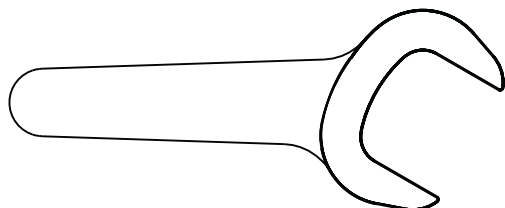
For tightening & loosening the lock nut on master holders.

Spanner Wrenches

Part Number	PDQ Series
702-75-001	VS
702-55-001	S
702-35-001	M
702-15-001	L

Order by part number

COLLET WRENCHES



For collet chuck nosepieces

Collet Wrenches

Part Number	Collet Series	Wrench Type	Size
702-43-075	075	open end	1-7/8
702-23-101	100	open end	2-1/4
702-03-151	150	pin	3-1/2

Order by part number



Special Quick Change

Special Adapters & Holders

Master Holders



PDQ makes many special master holders. Use a special PDQ holder in your machine with a non-standard spindle taper. This allows the use of standard off the shelf adapters and eliminates the need for costly special tool holders. Add quick tool changing to your high production machinery by using special PDQ master holders. Have a machine with a worn and oversize spindle taper? PDQ can make a special master holder with an oversized standard taper to save that machine.

Special Adapters



Special PDQ adapters can be made to satisfy almost any tool holding requirement. We can make extended adapters to get into a deep pocket, or special shortened adapters for areas where space is at a premium. PDQ can make adapters with cavities or pilots that are different than our standard sizes, metrics, for example. Special adapters can be made to hold modular boring systems. Although PDQ quick change tooling is primarily used in milling applications, we have users in turning applications as well. If you don't see it in this catalog, just ask. PDQ

can make adapters to hold all sorts of shank tools such as stub morse tapers, twist lock and many others.

At PDQ specials are easy!

Special Rotary Tooling

Special Rotating Tool Holders

Custom built tool holders



When you can not find a standard tool holder to do your job, let PDQ design and build the tool holder you need. PDQ has a complete engineering staff that uses the latest CAD/CAM and analysis software to design the best possible tool holder for your job. Next our skilled toolmakers build the custom tools using the finest materials with state of the art equipment and techniques. For the highest quality tool holder, in quantities of 1 pc to 1000, at a reasonable cost call PDQ.



Angle Heads

Right & Custom Angle Heads for Machining Centers



PDQ manufactures angle heads of all styles & configurations . These heads are designed to go through the tool-changers of most machining centers, allowing all of the advantages of CNC. Angle heads permit parts to be machined in less setups, and with greater accuracy than with conventional machining practices. Our standard heads come in many styles and configurations including tapping with tension & compression.



We can also design & build a custom head to meet your exact needs. These custom heads can have multiple output spindles, coolant through the spindle, at any fixed angle or even be adjustable. PDQ has the right angle for you!



Live Tooling

Driven Tool Holders for Turning Centers



PDQ designs and builds a large variety of custom driven tool holders for turning centers. These driven heads can include many unique features, such as special gear ratios, orientation or angle. PDQ can also design live tooling

to reach into the bores of parts, or any other tight area. All types of output spindle are available including collet



chucks, straight shank, face mill, stub arbor, morse taper, jacobs taper, tapping with tension & compression, as well as many other types.

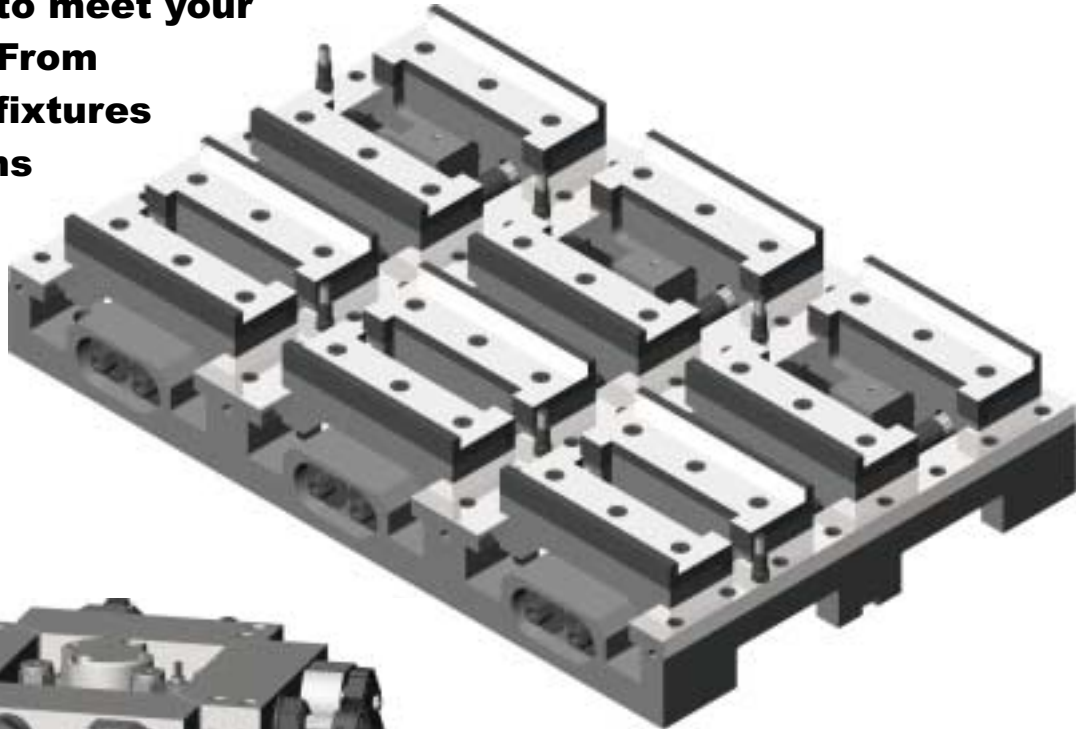


Custom Work Holding

Work Holding Fixtures

Whatever your work holding needs,

PDQ's staff can engineer and build a system to meet your requirements. From simple manual fixtures to total solutions that are integrated with the CNC control, PDQ can deliver a complete solution.



Our staff has over 50 years of experience designing custom work holding and manufacturing systems, including turn-key answers to some very complex parts.

Use the best! Use PDQ work holding devices.

A proud "family portrait"
A representative sampling of quality Marlin standard and special tools.



Quick-change tooling systems
Ideal for manual & CNC milling machines

Angle heads * Special V-flange tooling * Custom holding fixtures
Live (driven) tooling * Special rotary tooling



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