



CJ WINTER

QCT

Quick Change Tooling

Tool Changeover in Minutes

Made in the USA

NEW

Patent-pending QCT Quick Change Tooling package for Davenport Servo B and Model B machines.

Quick Change Tooling (QCT), takes changeover of side-working and end-working tools on the Davenport from hours to minutes! Eliminating time-consuming adjustments and changing of tools, this patented design makes tool changeover simple and easy – saving time and money!

- Reduced Set-up Time
- Less Labor
- More Productive Turnout
- Faster Return on Investment

QCT STATIONARY AND REVOLVING SPINDLES

The NEW QCT stationary and revolving spindles make it easier than ever to change end-working tools on your Davenport.

A simple one turn screw-on and screw-off is all it takes. Other features include:

- Patented thread configuration allowing for easy thread locating, installation and removal, in less time.
- Substantial time savings in setup and less downtime while sharpening.
- Spindle length reduced by 1.10 inches, allowing for more room inside the machine, making tool changes easy and allowing for longer parts.
- Precision ground locating cone provides axial support and repeatable locking position.
- All spindles are cross tapped to accommodate a set screw to lock the drill holder in place.
- Spindles use all standard hardware, making them completely interchangeable with standard spindles.

CHANGE THE WAY YOU RUN YOUR DAVENPORTS!

QCT DRILL AND TAP HOLDERS

One Turn Installation and Removal!

Drill and tap holders with patented thread configuration are designed for easy use with QCT tool spindles. Shortened assembly height of .641 inches offers more clearance in the machine during setup.

Adjustable Drill Holder
2717-QCT



(Use with 2714-QCT)

- Floating front plate – loosen top bolts and plate “floats” to center. Rotational adjustment allows drill to clear adjacent tooling when installed in any position.

Bushing Style Drill Holder
2714-QCT



- Standard use drill holder

Collet Style Drill/Tap Holder
2714-ER-QCT



- For high precision and tapping needs

Cut Hours Off Your Set Up!



335-U-SA

QCT TOOL SPINDLE FRONT BOX

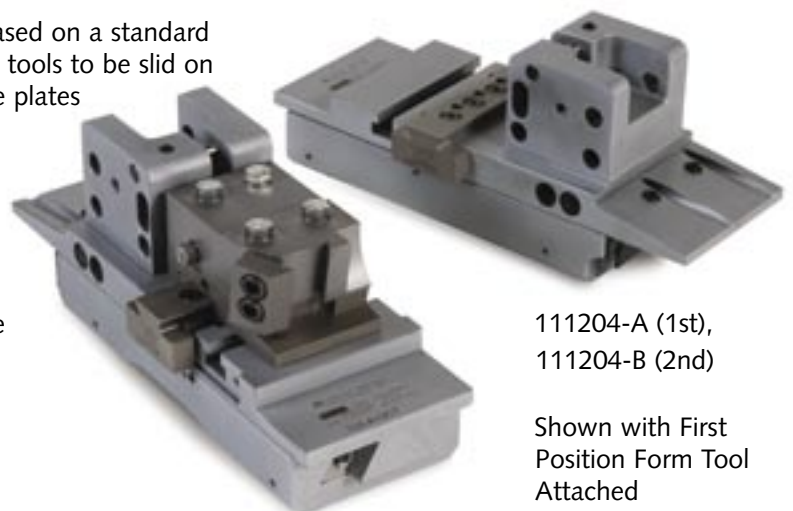
This Patent Pending product was developed in conjunction with our customers to cut HOURS off of every setup requiring a tool spindle change. When installing a standard one-piece box, it can commonly take one hour to properly align a tool spindle, especially a revolving spindle; with a QCT Front Box it can be done in minutes!

- Steel Outer Housing can be aligned and installed once, and interchangeable bronze liners can be swapped in less than a minute.
- Changing from a stationary spindle to a revolving spindle or to a broaching spindle can be done without disturbing the spindle alignment.
- Worn boxes in the machine can be replaced quickly and easily without hours of costly maintenance.

QCT SLIDES AND ADAPTER PLATE

NEW QCT Slides and Adapter Plates are based on a standard dovetail design that allows form and shave tools to be slid on and off the adapter plate, while leaving the plates attached to the machine.

- Tool changes in minutes!
- A locking gib allows for a quick change and secure locking of the entire tool and block assembly.
- Lateral adjustments can be made with the fine pitch set screw.



111204-A (1st),
111204-B (2nd)

Shown with First Position Form Tool Attached

*A Davenport Adapter Plate is also available.
Davenport Plate 111206-A (1st); 111206-B (2nd)

QCT FORM TOOLS

The NEW QCT 1st and 2nd Position Form Tool Holders have a standard dovetail design at the base of the tool holder allowing simple installation and removal from the slide. These form tool holders are available in 5 or 10 degree clamp angles.

- Top bolts maintain the taper even when the block assembly is removed from the adapter plate for changes.
- Finer taper adjustment is possible by using a 40 TPI thread.
- 2nd position tool has an additional t-bolt that can be used to keep tooling secure while running heavier jobs such as stainless or hex materials.



1st Position 3060-5-QCT,
3060-10-QCT



2nd Position 3092-5-QCT,
3092-10-QCT



5080-99-2-QCT

QCT CIRCULAR TOOL POST

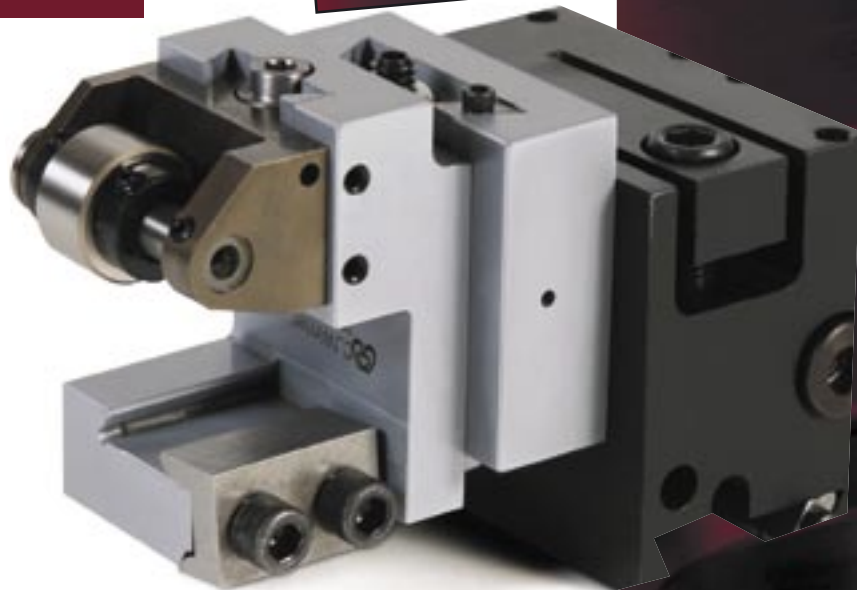
- Holds circular form or shave tools with the same common dovetail design.
- Worm screw has been placed on top of the holder to allow for easier adjustment with easier accessibility.

QCT SHAVE TOOL

The QCT Dovetail Model 111 Shave Tool can be mounted in multiple positions.

- Two roll brackets come standard for inboard and center roll positions and cover the entire range of .000 – .843 adjustments. The center bracket is used for most applications and supports roll pin at both ends, providing superior rigidity. The inboard bracket is used when the part geometry requires the support roll to be close to the spindle.
- Lower height of 2.98 inches allows for increased clearance between the 2nd and 3rd positions minimizing interference with adjacent tooling.
- Zero clearance matched assembly for more rigidity, virtually eliminating chatter.
- Micro Taper adjustments can be made within .0001 inches with taper adjust screw.

**Remove the Tool Without
Losing the Taper!**



111-14-QCT
Shave Tool and Block
Assembly are shown

* This tool is also available with high performance coating for less friction and corrosion

QCT PRE-SET FIXTURE

Set Tooling Offline!

The NEW QCT Pre-set Fixture gives set-up personnel the option of setting tool changes off the machine, while the machine is running. Prepare the tool position, tool height, and taper while running another job. This means increased efficiency and less down time!

- Micrometer head sets the location from the collet face
- Dial indicators and gages can set the taper on the tool face
- Record data to assist in future setups



111951

QCT ADDITIONAL PRE-SETTING FIXTURES

Machine Plate

New Machine Pre-set Plate can be used right at the machine to quickly set tool height after tools are removed for sharpening. This saves valuable time spent going back and forth to a preset fixture.

Drill Holder Setting Gage

Drill Holder Setting Gage can be used with a height gage to set drill length. The ground surface represents the spindle face.



Machine Plate
111952

Drill Holder Setting
Gage 111953

For more information about QCT contact CJWinter at 1-800-288-ROLL.
www.cjwinter.com • www.davenportmachine.com

END
ROLLING



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TANGENTIAL



TOOL HOLDERS
AND SLIDES



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