

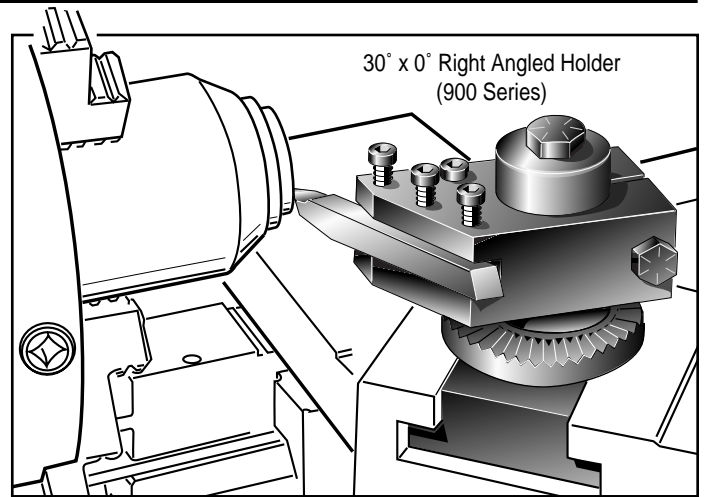
# The OMNI-POST Quick Change Tool Post System

Changing tools with OMNI-POST is a breeze. Just loosen the clamp bolt and remove the tool holder. Then, install the new tool holder and tighten the clamp bolt. The tool bit maintains its exact position from its previous setting. That's all there is to it. This whole process takes only seconds, saving you time and increasing versatility. Indexing allows the tool holder to be placed in the exact same position each time it is used. The unique OMNI-POST base provides 48 discrete radial positions for fine radial positioning.

Each quick change holder has a **self-locking** height adjustment separate from the mounting clamp. This feature lets you install any OMNI-POST holder without re-adjusting the height each time.

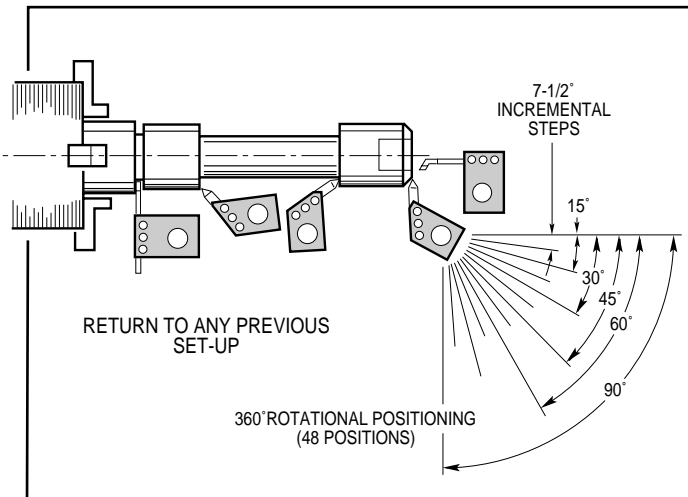
Full circumference clamping secures the tool holder to the post assembly with a vise-like grip, preventing the tool holder from moving on the post during heavy cuts.

The versatility and quality of these tool holders make them desirable in the commercial environment. Their low cost



design makes them affordable, even to the hobbyist. The OMNI-POST is designed with no moving parts. They are made of hardened steel to insure long and accurate tool life.

## Multi Positioning - Without Losing Reference



**MULTI-POSITION** - No need to loosen the tool post to get the correct tool angle. KRF Company designed the OMNI-POST system for situations requiring repeated set-ups. The same tool bit can be used for turning, chamfering and facing by reindexing the holder.

**QUICK SET-UP** - Changing holders is a snap with the quick and convenient self-locking height adjustment. There are no additional operations required to lock the height adjustment. The OMNI-POST provides 48 indexable, repeatable positions, not just 1 or 2.

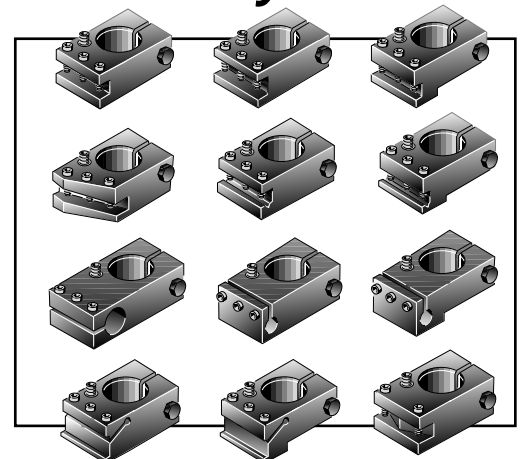
**LOW COST** - The OMNI-POST eliminates and replaces complex cams, gears, dovetails and slides found in other tool posts. It is rigid and chatter free. All components are machined from steel, then heat treated and have a black oxide finish. The OMNI-POST is made in the U.S.A. and grade 8 hardware is used throughout. The unhardened T-Nut is easily machined to custom fit your lathe if necessary.

## Wide Range of Holders provide versatility

There are many different OMNI-POST holders available to perform virtually any cutting operation.

- **Standard, Angled, V-Groove, Boring Bars and Cut-off Holders:** Available in several sizes for various applications.
- **Low-Profile Holders:** Excellent for small lathes.
- **Carbide Holders:** Allow cutting hardened steel, etc.
- **Post Assemblies:** T-Nuts on the Post Assembly are available in several sizes to fit various compounds.

All OMNI-POST tool holders can be ordered separately. This way you can "build" your set to suit your purpose.

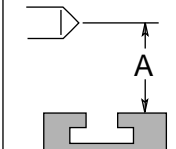


**KRF**  
COMPANY

P.O. Box 783 • St. Joseph, MI 49085 • Tel: (616) 429-7050 • Toll Free 1-800-857-6664

MADE IN U.S.A. 

## Selecting the Correct Series Holder



CENTER LINE HEIGHT (A)	ORDER THIS SERIES
.450 to .950	600
.850 to 1.450	900
.1.250 to 2.300	1200

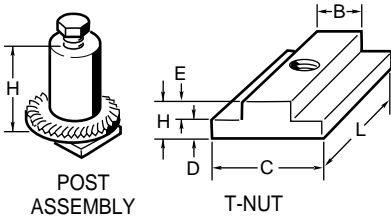
The height from the top of the compound to the lathe centerline (dimension A) is the most important dimension for selecting the proper tool holder. This dimension is more significant than the actual lathe size (i.e. 6" swing, 10" swing, etc.) Dimension 'A' for your lathe must fall within the MIN-MAX range of the tool bit cutting edge for the holder you select.

1. Low Profile Holders (600 series) have been designed to fit over the index base to further reduce the height of the tool bit cutting edge. These holders are normally used on small lathes. Due to reduced clamping area of this style holder and less material supporting the tool bit, they are recommended for lathes only where a low height is needed.

2. A smaller OMNI-POST System can be installed on a large lathe even though a greater tool bit height is needed. This is desirable when machining small parts on a large lathe. To do this, install a spacer (not supplied) between the index base and the lathe compound to raise the entire tool post and holder to the desired height. A longer bolt (not supplied) will be required.

3. For lathes that use a bolt instead of a T-Nut (i.e. Myford, Maximat, etc.) select the appropriate Post and Index Base Assembly. (See Pictorial 1 below)

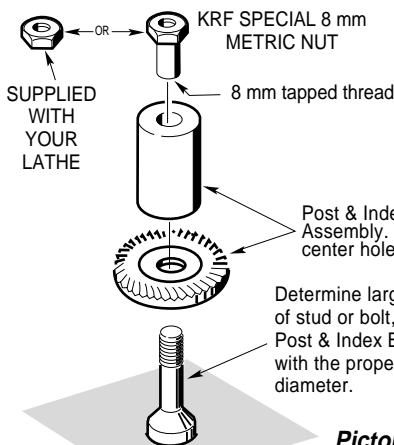
## Selecting the Correct Post, Index Base and T-Nut



The Post and Index Base Assembly consists of the post, index base, bolt, and T-nut unless otherwise noted. Be sure to specify the T-Nut (for 600 and 900 series holders) that fits the T-slot in the lathe compound. If the T-Nuts listed will not fit the T-slot in your lathe, select a T-Nut that is larger (dimension C) than your T-slot and machine it slightly rather than use a T-Nut that is considerably smaller than the T-Slot. These T-Nuts are unhardened and can easily be machined to size using your lathe (instructions provided). Special size T-Nuts are available on request for \$15.00.

SERIES		POST & INDEX BASE (DIMENSIONS)			T-NUT (DIMENSIONS)							Notes	Price
Series Applications	Part Number	Post Height (H)	Post Dia.	Center Bolt Hole Dia.	C	L	H	B	D	E			
600/900	8026	1.9	1.125	.390	1.125	1.500	.375	.562	.210	.165	Some Machining May Be Necessary	\$40.50	
600/900	8027	1.9	1.125	.390	1.500	1.500	.500	.800	.250	.250		\$40.50	
600/900	8028	1.9	1.125	.390	2.000	1.500	.500	1.250	.300	.200		\$40.50	
1200	8060	3.0	1.500	.578	MACHINE TO FIT							\$54.00	

## Special Purpose Post Assemblies Only

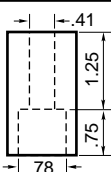


Pictorial 1

SERIES		POST & INDEX BASE (DIMENSIONS)			No T-Nut See Pictorial 1	
Series Applications	Part Number	Post Height (H)	Post Dia.	Center Bolt Hole Dia.	Comments	Price
900 G	8058	1.9	1.125	.438	For lathes using a bolt instead of a T-Nut	\$40.50
600/900V	8094	1.9	1.125	.390	Includes 8 mm special nut	\$40.50
900 S	8132	1.9	see below		Stepped post and index base	\$40.50

### Emco-Maer

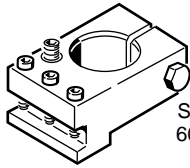
These lathes use several sizes of shoulder mounting bolts coming up through the compound. Post and Index Base #8132 is designed to fit over most of these shouldered bolts. Measure your bolt to make sure the Post & Index Base will fit. If your stud is different, send a dimensioned sketch.



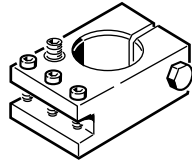
### QUICK REFERENCE

LATHE	SERIES	POST & BASE ASSY
Atlas / Craftsman 6"	600	8026
Myford Super 7	600	8058
Maximat 7	600	8094
Atlas / Craftsman 10", 12"	900	8026
South Bend 9", 10"	900	8027
Grizzly 8", 12"	900	8028
Emco-Maer	600/900	8132

## Standard Holders



STANDARD  
600 SERIES  
Fig. A

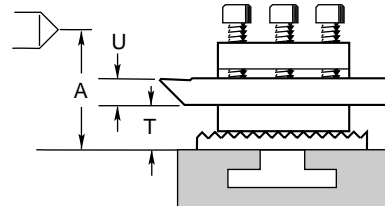


STANDARD  
900 SERIES  
Fig. B

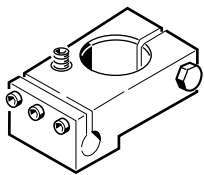
Fig.	Series	Part Number	Tool Support Height Above Compound 'T'		Max Tool Bit Size	Price	Notes
			Min.	Max.			
A	600	8082	.200	1.100	3/8"	\$43.50	[1]
B	900	8076	.505	1.205	3/8"	\$38.00	
B	900	8098	.400	1.100	1/2"	\$38.00	[2]

**Standard Holders** hold most conventional square tool bits. These holders are used for most all basic turning and facing operations. Tool bits can be mounted either way, placing the bit to the left or right of the tool post. This allows both right and left hand facing.

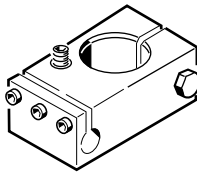
The height 'T' listed in the chart is measured from the top of the lathe compound to the bottom of the tool bit slot in the holder. Minimum height 'T' plus the tool bit 'U' must be less than the center height dimension 'A'. If the cutting edge is ground below the top of the tool bit, the total height is reduced by that amount.



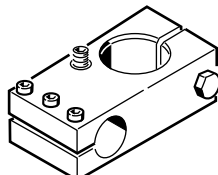
## Boring Bar Holders



BORING BAR  
600 SERIES  
Fig. C



BORING BAR  
900/1200 SERIES  
Fig. D

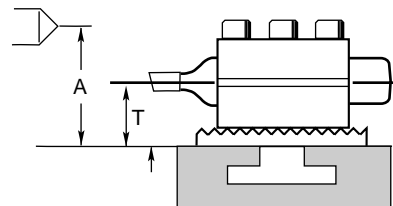


BORING BAR  
900/1200 SERIES  
Fig. E

Fig.	Series	Part Number	Centerline Height Above Compound 'T'		Boring Bar Hole Size	Price	Notes
			Min.	Max.			
C	600	8016	.350	1.250	.500	\$43.50	[1]
D	900	8023	.550	1.250	.500	\$38.00	
E	900	8015	.700	1.400	.750	\$38.00	
E	1200	8045	1.062	2.312	1.000	\$59.00	
D	1200	8113	.850	2.100	.750	\$59.00	

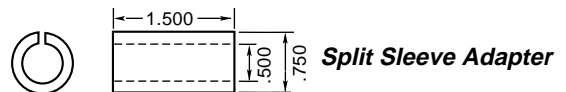
**Boring Bar Holders** accept round bar type boring bars for internal boring, threading or facing. Regular high speed steel, carbide tipped, or replaceable tip boring bars work well with these holders. Split sleeve adapters are available to mount 1/2" round bars into the 3/4" boring bar holders.

The height 'T' for the Boring Bar holders is measured from the top of the compound to the center of the boring bar. If the tool bit cutting edge is above or below the centerline of the boring bar be sure to allow for this difference when you determine the actual height of the cutting edge. You can make 'custom' split bushings to hold boring bars smaller than the hole in the Boring Bar holders. If you make the hole in the bushing off-center (nonconcentric) you can further adjust the height of the boring bar

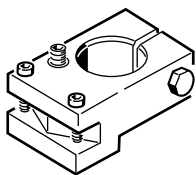


### Split Sleeve Adapter

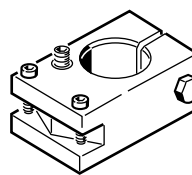
Series	Part No.	Description	Price
900 1200	8118	1/2" TO 3/4" Split Sleeve Adapter. Allows use of 1/2" dia. boring bars in a 3/4" boring bar holder.	\$16.50



## Carbide Holders



CARBIDE  
600 SERIES  
Fig. F



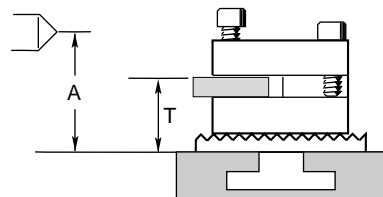
CARBIDE  
900 SERIES  
Fig. G

Fig.	Series	Part Number	Cutting Edge Height Above Compound 'T'		Carbide Size	Recommended Carbide	Price
			Min.	Max.			
F.	600	8084	.500	1.40	3/8 IC* 1/8 THK	TPG or TPU	\$43.50
G	900	8080	.700	1.40	3/8 IC* 1/8 THK	TPG or TPU	\$38.00

\* IC = Included Circle

**Carbide Holders** mount small (3/8" included circle) carbide tool inserts for machining hard materials or for machining with fewer sharpenings.

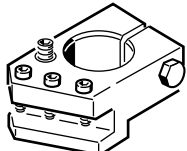
The Carbide holder has two angled grooves to position the tool bit for facing or turning with the holder square with the lathe. Two triangular tool bits can be mounted at the same time if you are careful not to let the second tool bit contact the surface being cut. If carbide bits with holes are used it is recommended that a soft steel spacer be placed between the bit and the clamp screw.



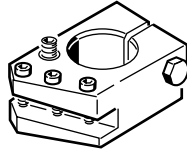
NOTES: [1] Recommended only where low minimum height is needed.

[2] Less rigid than #8076 due to less material supporting tool bit.

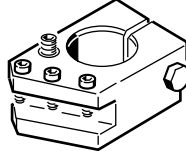
## Right Angled Holders



25° x 0°  
RIGHT ANGLED  
600 SERIES  
Fig. H



30° x 7°  
RIGHT ANGLED  
900 SERIES  
Fig. I



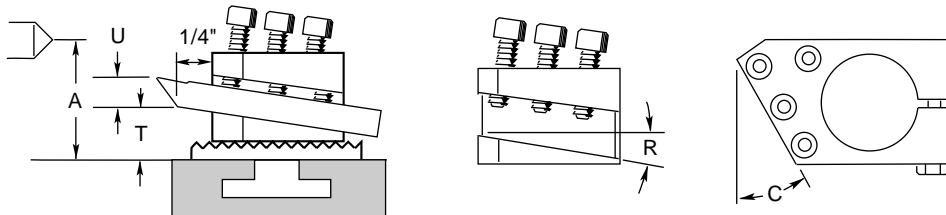
30° x 0°  
RIGHT ANGLED  
900/950/1200 SERIES  
Fig. J

Fig.	Series	Part Number	Tool Support Height Above Compound 'T'		Max Tool Bit Size	Angle "C"	Angle "R"	Price
			Min.	Max.				
H	600	8051	.200	1.100	3/8"	25°	0°	\$43.50
J	900	8075	.505	1.205	3/8"	30°	0°	\$38.00
I	900	8069	.542	1.242	3/8"	30°	7°	\$38.00
J	950	8122	.567	1.017	1/2"	30°	0°	\$42.00
J	1200	8052	.805	2.055	1/2"	30°	0°	\$59.00
I	1200	8100	.858	2.108	1/2"	30°	7°	\$59.00

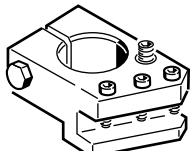
**Right-hand Angled Holders** can be used in most turning and facing operations. The 25° Low-Profile Holder, and the 30° holders provide more clearance around the tool bit and allows easier access in tight spaces.

The 30° x 7° holder has an angled slot. The height is measured from the top of the compound to the bottom of the tool bit slot 1/4" out from the holder. The pointed shape of the angled holder allows you to get into tighter spots than with the Standard holder. The 7° inclination of the tool bit lets you resharpen the tool bit by just grinding the front and side clearances. Like a conventional tool holder that has a 7° to 8° inclination, the top (back) rake generally need not be ground into the top of the tool bit. This lets you resharpen the tool bit many times, only shortening the tool bit a slight amount each time, without having to completely regrind the end of the tool as can be necessary with tool bits mounted without inclination.

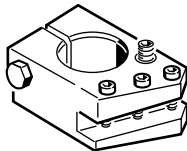
**HINT:** The ANGLED HOLDER will become your most used holder when you add it to your collection.



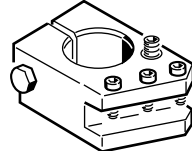
## Left Angled Holders



25° x 0°  
LEFT ANGLED  
600 SERIES  
Fig. K



30° x 7°  
LEFT ANGLED  
900 SERIES  
Fig. L



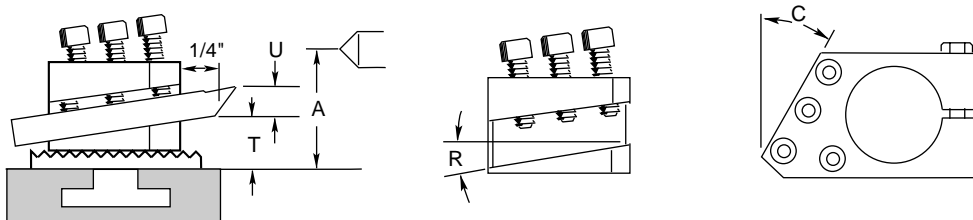
30° x 0° LEFT ANGLED  
900 / 950 / 1200 SERIES  
Fig. M

Fig.	Series	Part Number	Tool Support Height Above Compound 'T'		Max Tool Bit Size	Angle "C"	Angle "R"	Price
			Min.	Max.				
K	600	8115	.200	1.100	3/8"	25°	0°	\$43.50
M	900	8107	.505	1.205	3/8"	30°	0°	\$38.00
L	900	8109	.542	1.242	3/8"	30°	7°	\$38.00
M	950	8124	.567	1.017	1/2"	30°	0°	\$42.00
M	1200	8102	.805	2.055	1/2"	30°	0°	\$59.00
L	1200	8131	.858	2.108	1/2"	30°	7°	\$59.00

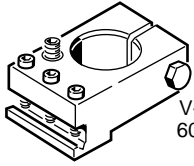
**Left-hand Angled Holders** offer the same advantages as the above holders and are a complement to the right-hand Angled Holder. While the right-hand Angled Holder can be used in most all circumstances, the left-hand Angled Holder is nice for turning and facing toward the lathe tail stock.

The 25° Low-Profile Holder, and the 30° holders provide more clearance around the tool bit and allows easier access in tight spaces.

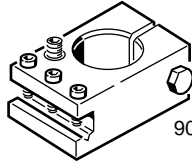
The 30° x 7° holder has an angled slot. The height is measured from the top of the compound to the bottom of the tool bit slot 1/4" out from the holder. The pointed shape of the angled holder allows you to get into tighter spots than with the Standard holder. The 7° inclination of the tool bit lets you resharpen the tool bit by just grinding the front and side clearances. Like a conventional tool holder that has a 7° to 8° inclination, the top (back) rake generally need not be ground into the top of the tool bit. This lets you resharpen the tool bit many times, only shortening the tool bit a slight amount each time, without having to completely regrind the end of the tool as can be necessary with tool bits mounted without inclination.



## V-Groove Holders



V-GROOVE  
600 SERIES  
Fig. N

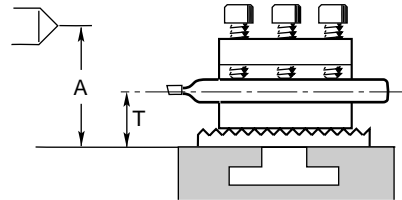


V-GROOVE  
900/1200 SERIES  
Fig. O

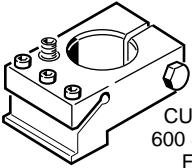
Fig.	Series	Part Number	Centerline Height Above Compound 'T'		Max Square Bit Size	Max Round Bit Size	Price	Notes
			Min.	Max.				
N	600	8083	.315	1.215	3/8"	1/4"	\$43.50	[1]
O	900	8077	.677	1.377	3/8"	3/8"	\$38.00	
O	900	8096	.572	1.272	1/2"	3/8"	\$38.00	[3]
O	1200	8054	1.000	2.250	1/2"	7/16"	\$59.00	

**V-Groove Holders** are designed to hold round tool bits, such as boring bars and/or special cutters mounted to round stock. This holder also functions as a standard holder in that it will also hold square or rectangular style tool bits.

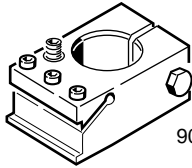
The height 'T' for V-Groove holders is measured from the top of the compound to the center of the maximum size boring bar. If the tool bit cutting edge is above or below the centerline of the boring bar be sure to allow for this difference when you determine the actual height of the cutting edge.



## Cut-Off Holders



CUT-OFF  
600 SERIES  
Fig. P



CUT-OFF  
900/1200 SERIES  
Fig. Q

Fig.	Series	Part Number	Centerline Height Above Compound 'T'		Cut Off Blade Size	Price	Notes
			Min.	Max.			
P	600	8081	.675*	1.575	3/32" x 1/2"	\$43.50	[1]
P	600	8128	.675*	1.575	.040" x 1/2"	\$38.00	[1]
Q	900	8078	.875	1.575	3/32" x 1/2"	\$38.00	
Q	900	8120	.875	1.575	.040" x 1/2"	\$38.00	
Q	1200	8047	1.075	2.325	3/32" x 1/2"	\$59.00	

\*Actual Height of Cut-Off Blade is .476"

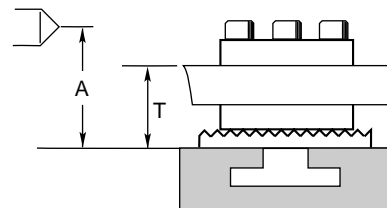
### Cut-Off Blades

Series	Part No.	Cut-Off Blade Size	Price
600/900	8126	.040"x1/2"*x3-1/2" T-type (P-1N)	\$12.00**
600/900/1200	8125	.3/32"x1/2"x4-1/2" T-type (P-2)	12.00**

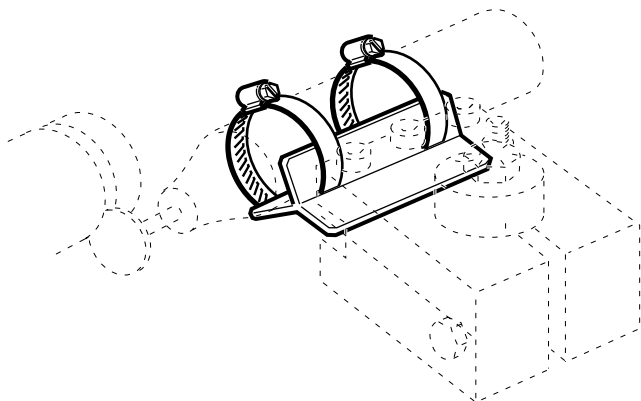
\*\* \$10.00 When purchased with Cut-Off holder

**Cut-Off Holders** accept both type "B" and "T" cutoff blades. This holder is initially setup so that it is perpendicular to the work piece and parallel to the face of the chuck. This insures that the holder will always return to its proper position (perpendicular) whenever it is removed and then replaced on the tool post. We recommend the narrow (.040") Cut-Off Holders and cut-off blades for the fastest and surest parting operations because less material is removed and less force is placed on the tool.

The height 'T' for Cut-off holders is measured from the top of the compound to the top of the tool bit. For lathes requiring a height lower than those listed in the chart, grind down the top of a beveled tool bit to the necessary height. The beveled tool bit will still provide the proper side clearances.



## Omni-Post Grinder Attachment



The Omni-Post Grinder Attachment turns your lathe into a universal grinding center. Almost all hand held die grinders, hobby grinders, pneumatic grinders and flexible shaft style grinders with a diameter of 1" to 2" can be mounted in this tool holder.

Mount the Grinder Attachment in any of several Omni-Post tool holders. The Standard, V-Groove or 30° x 0° Angled holders will clamp the Grinder Attachment securely.

Grind valves, sharpen tools, re-grind lathe centers and chucks, the list is endless. Make O-ring grooves in hardened shafts or grind precision inside and outside diameters.

Series	Part No.	Description	Price
All	8117	Holds most die grinders 1"- 2" dia.	\$22.00

NOTES: [1] Recommended only where low minimum height is needed.

[3] Less rigid than #8077 due to less material supporting tool bit.

## SMALL LATHE OWNERS!

Add quick change tool features to your small lathe!

The Low Profile Series (600 Series) OMNI-POST holders are designed for small lathes that have a centerline height (above compound ) of .450" to 1.25". These holders accept the same size tool bits as the 900 Series holders.

### Myford Super 7 Lathes

Use 600 Series holders on your MYFORD Super 7 lathe.

NOTE: you will need to order the special post and index base (shown on page 2 to use the OMNI-POST System on you MYFORD Super 7 lathe.

Be sure to include the following number when ordering  
#8058 Post and Index Base

### Maximat 7 Lathes

Use 600 Series Holders on your MAXIMAT 7 lathe

NOTE: You will need to order a special metric nut in order to use the OMNI-POST System on your MAXIMAT 7 lathe. The Metric nut, as shown on page 2, is supplied instead of the bolt and T-nut.

#8094 Post & Index Base (includes 8 mm Special Nut)

## PRICING

Take a 5% discount when you buy six or more holders. This does not apply to our already discounted sets. All orders payable in U.S. funds. Michigan residents add 6% sales tax.



CHARGE YOUR ORDER  
SEE ORDER BLANK FOR DETAILS

NOTE: Postage charges subject to change without notice.

POSTAGE & HANDLING IN  
THE CONTINENTAL U.S.A.

0 - \$99	\$5.50
\$100 - \$199	\$6.50
\$200 - \$374	\$7.50
\$375 - UP	Add 2%
C.O.D.	Add \$6.00

## SAVE WHEN YOU BUY IN SETS

### STARTER SETS

Series	Part #	Description (See Note Below)	Price
600	9014	(1)-Post Assembly	\$ 79.00
900	9015	(1)-30° x 0° Angled Rt. Holder**	74.00
1200	9016		112.00

### 4-HOLDER SETS

Series	Part #	Boring Bar Diameter*	Description (See Note Below)	Price
600	9018	1/2"	(1)-Post Assembly (1)-30° x 0° Angled Rt. **	\$200.00
900	9019	3/4"	(1)-V-Groove (1)-Boring*	179.00
1200	9020	1"	(1)-Cut-Off	279.00

### 6-HOLDER SETS

Series	Part #	Description (See Note Below)	Price
600	9022	(1)-Post Assembly (1)-1/2" Boring (1)-Standard (1)-Cut-Off (1)-25° x 0° Angled Rt. (1)-Carbide (1)-V-Groove	\$285.00
900	9023	(1)-Post Assembly (1)-3/4" Boring (1)-Standard (1)-1/2" Boring (1)-30° x 0° Angled Rt. (1)-Cut-Off (1)-V-Groove	252.00
1200	9024	(1)-Post Assembly (1)-Boring (3)-30° x 0° Angle Rt. (1)-Cut-Off (1)-V-Groove	384.00

### 8-HOLDER SETS

Series	Part #	Description (See Note Below)	Price
600	N/A	N/A	N/A
900	9026	(1)-Post Assembly (1)-3/4" Boring (1)-Standard (1)-1/2" Boring (1)-30° x 0° Angled Rt. (1)-Cut-Off (1)-30° x 7° Angled Rt. (1)-Carbide (1)-V-Groove	\$323.50

Post Assembly (8027) is supplied with 600 & 900 series sets, and Post Assembly (8056) is supplied with 1200 series sets unless otherwise specified. \*\*25° x 0° Angled supplied with 600 series.

**NOTE:** Holders listed in above sets are our recommendations. You may substitute any holders of the same series for those listed above. Please specify when ordering.

# KRF

COMPANY

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