

NEW

DS-ACH Holders with Adjustable Centerline Height

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Features

Adjust centerline height simply with a wrench.

1 Adjust centerline height easily.

Patented

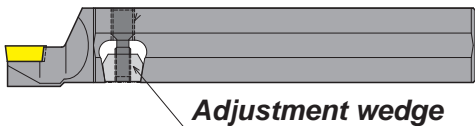
Eliminate center boss on end faces.
Provide constant OD dimension.
Adjust easily in machine.

1 Turn a screw clockwise.

2 Adjustment wedge goes down.

3 Insert edge moves up.

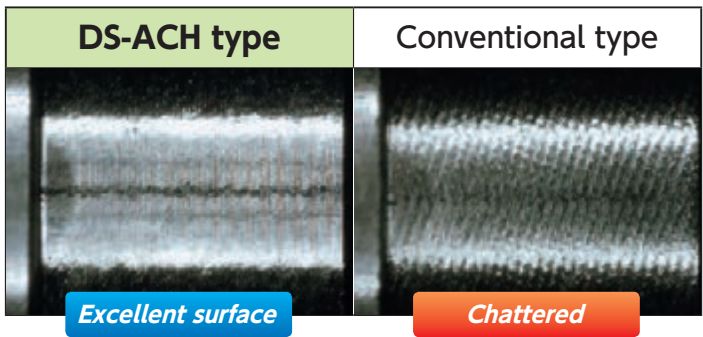
Range of centerline height adjustment
0 ~ .008"



Note: Insert moves in an upward direction only.
See the instruction shown on the back page.

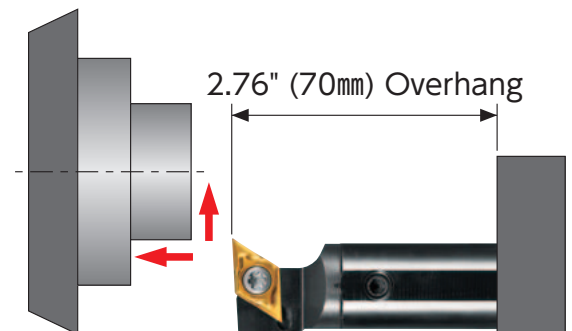
2 Optimized design reduces vibration.

Improved chatter resistance.



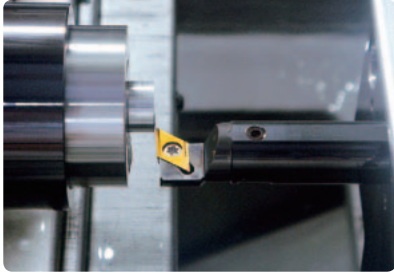
Tested cutting conditions (304 Stainless).

Work material : 304 Stainless
Holder : DS-SDUL19-11-ACH
Insert : DCGT32.508MCL TM4
Cutting condition: $v_c=250$ SFM, $f=.002$ IPR, $a_p=.079$ "

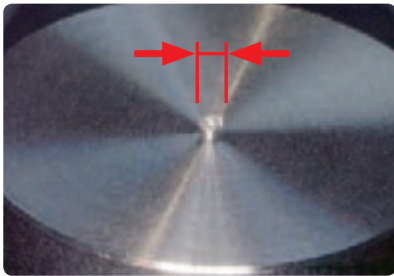


How to use

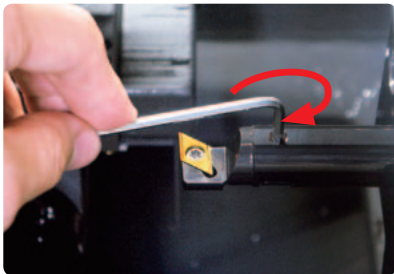
Loosen wedge screw before making any adjustment.



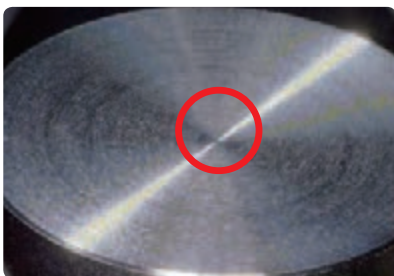
① Install the holder slightly below centerline. Then take a facing test cut.



② Measure the diameter of the center boss.



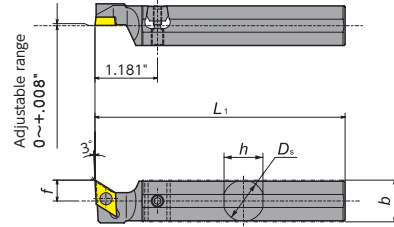
③ Raise the center height by one half of the diameter of the boss. Adjustment references are available in the tool case.



④ Re-machine the end face.

Stock list

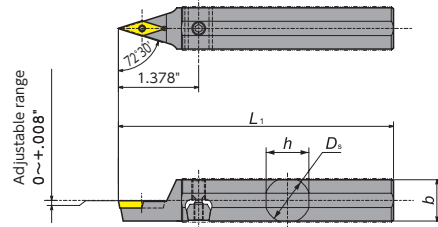
DS-SDU-ACH



• L-hand shown
☆ R-hand or neutral insert fit to L-hand toolholder.

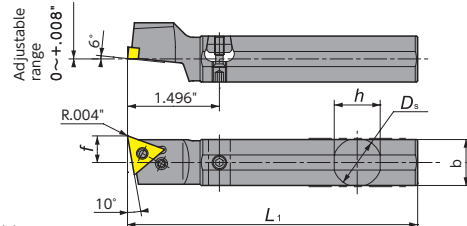
Order Code	Item Number	Left Hand	Dimensions (Inch)					Applicable Insert
			L	D_s	h	b	L_1	
5805635	DS-SDUL16F-11-ACH	●	16mm (.630")	.610	.591	3.150	.394	DC..32.5.. TFD11..
5805627	DS-SDUL19-11-ACH	●	3/4"	.709	.709	4.724	.394	
5799614	DS-SDUL20-11-ACH	●	20mm (.787")	.748	.748	4.724	.394	
5799622	DS-SDUL22-11-ACH	●	22mm (.866")	.827	.827	4.724	.394	
5799648	DS-SDUL25-11-ACH	●	1"	.945	.945	5.906	.394	

DS-SVVP-ACH



Order Code	Item Number	Left Hand	Dimensions (Inch)					Applicable Insert
			L	D_s	h	b	L_1	
5805643	DS-SVVPN16-11-ACH	●	16mm (.630")	.610	.591	4.724	—	VP..22..
5799655	DS-SVVPN19-11-ACH	●	3/4"	.709	.709	4.724	—	
5799663	DS-SVVPN20-11-ACH	●	20mm (.787")	.748	.748	4.724	—	
5799671	DS-SVVPN22-11-ACH	●	22mm (.866")	.827	.827	4.724	—	
5807524	DS-SVVPN25-11-ACH	●	1"	.945	.945	5.906	—	

DS-PTX-ACH



• L-hand shown
☆ R-hand or neutral insert fit to L-hand toolholder.

Order Code	Item Number	Left Hand	Dimensions (Inch)					Applicable Insert
			L	D_s	h	b	L_1	
5805650	DS-PTXL16-33-ACH	●	16mm (.630")	.610	.591	4.724	.433	TN..33..
5799689	DS-PTXL19-33-ACH	●	3/4"	.709	.709	4.724	.433	
5799697	DS-PTXL20-33-ACH	●	20mm (.787")	.748	.748	4.724	.433	
5799705	DS-PTXL22-33-ACH	●	22mm (.866")	.827	.827	4.724	.472	
5799713	DS-PTXL25-33-ACH	●	1"	.945	.945	5.906	.512	

Please refer to an instruction guide, which comes with above tool holders, for setup procedure and recommended centerline height adjustment amount.



NTK Cutting Tools

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