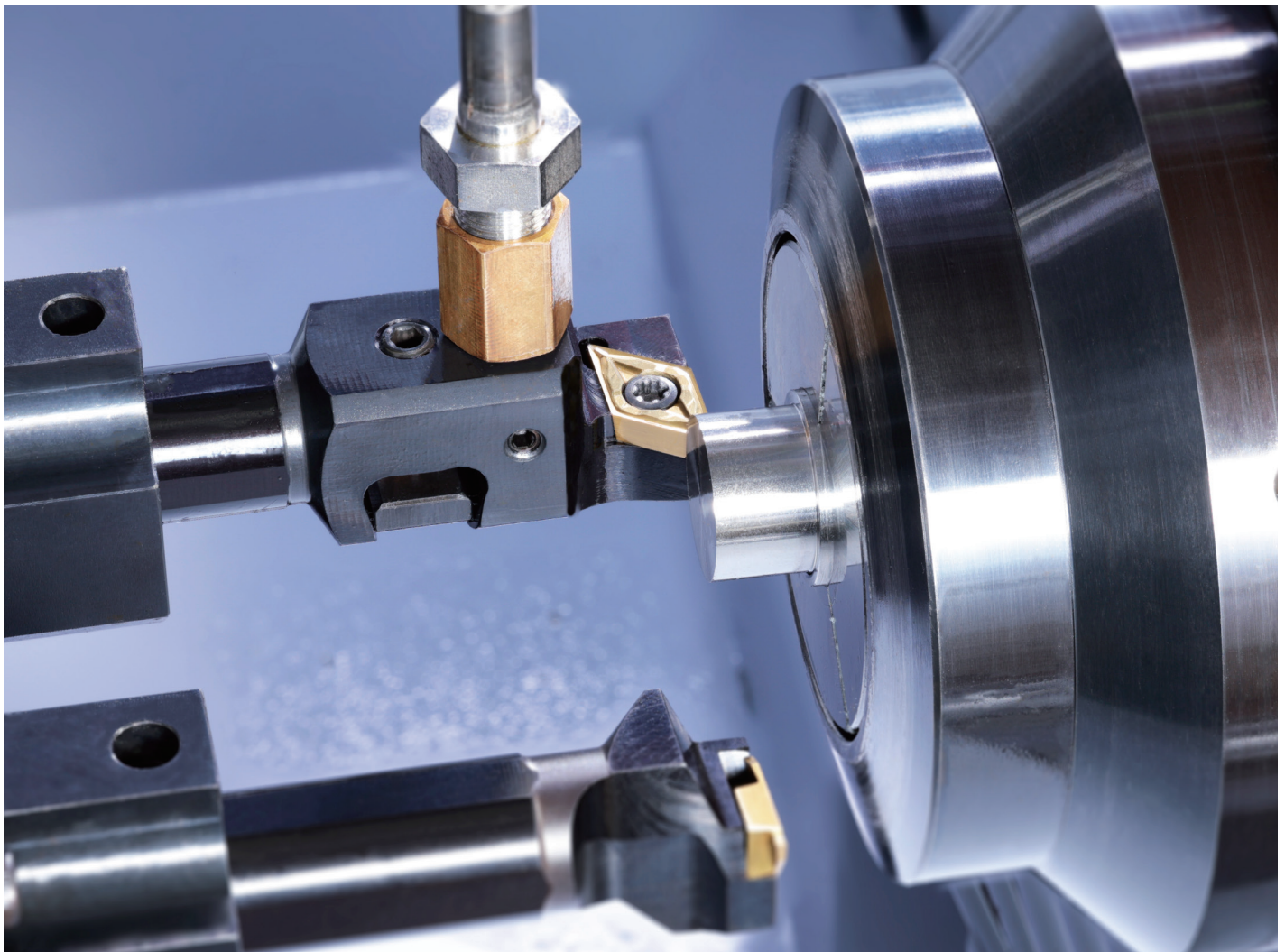
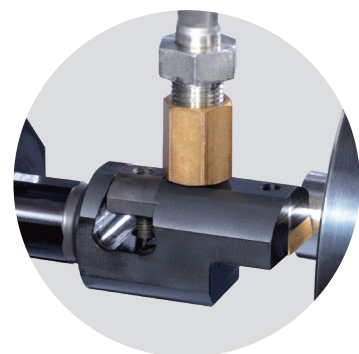


DS Holder Series

For back machining | CNC automatic lathes



Capable of using Inverted toolholder



The cutting edge height can be adjusted with a single wrench.
The internal coolant system reduces insert wear and improves chip control.

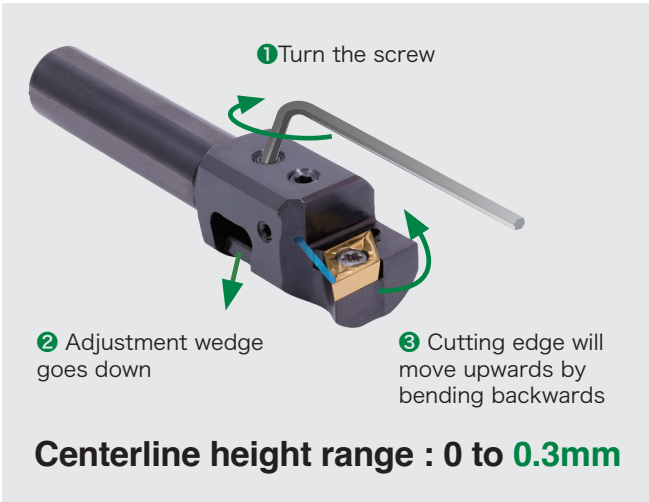
CERtainly | but not only | **CERamics**
Outstanding solutions for demanding applications



Internal coolant type is now available in the DS toolholder series

| Feature 1.

The cutting edge height can be easily adjusted with a wrench reducing setup time.

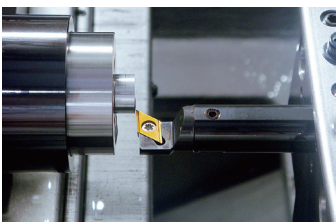


| Feature 2.

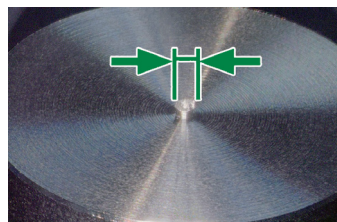
Internal coolant reduces insert wear and improve chip control.

	External + Internal coolant	External coolant only
Specification		
Lateral relief surface		

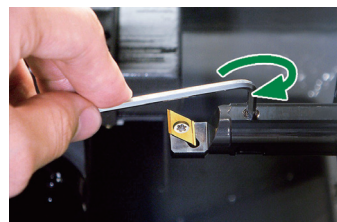
| How to use * The insert moves in an upward direction only. (Loosen wedge screw before making any adjustments)



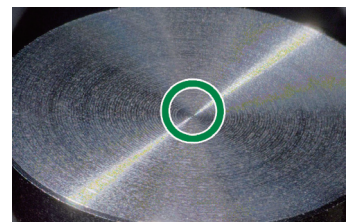
① Set the holder slightly below centerline and process the end face.



② Measure the diameter of the center boss of the workpiece.



③ Raise the centerline height by half of the diameter.



④ Re-machine the end face.

Lineup

Front Turning

DS-...-ACH		DS-...-ACH-OH		
Centerline height adjustment		Centerline height adjustment + Internal coolant		
DS-PTX-ACH-OH 100° New →Reverse side	DS-PTX-ACH 100° →Q54	DS-PTX 100° →Q54	DS-SCL-ACH 95° →Q15	DS-SCL 95° →Q16
DS-SDU-ACH-OH 93° New →Reverse side	DS-SDU-ACH 93° →Q27	DS-SDUL 93° →Q28	DS-SDX 96° →Q30	
DS-SVX 99° →Q46	DS-SVXP 99° →Q46	DS-SVVPN-ACH 72°30' →Q47	DS-SVVPN 72°30' →Q48	

Back Turning

DS-TBP →R13	DS-GTT →R27
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Grooving

DS-GTT →T16	DS-FGV →T35
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Threading

DS-TTP →U18	DS-STT →U22
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Boring

DS-LBMB →V7

Example

DS-SDX — Toolholder type

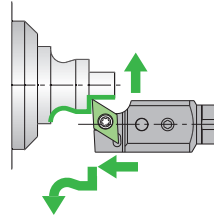
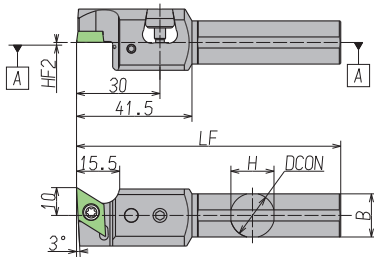
Machining image

96°

→Q26

General catalog in 2023-2024 page

DS-SDU-ACH-OH Adjustable Centerline Height DS toolholder (Internal coolant type)

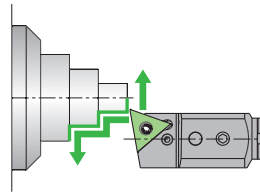
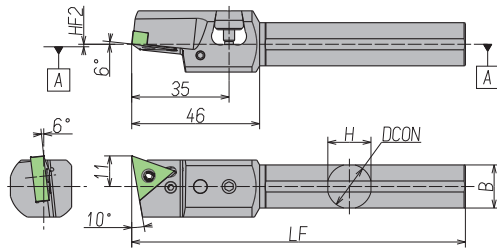


This figure shows the left hand (L).
Note: Use the Right (R) or Non-hand (N) insert

Spare Parts	
Screw (for clamping)	LRIS-4*10
Screw (for wedge)	WS060419-004
Wedge	ACH-W18
Wrench (for clamping)	LLR-25S-20*65
Wrench (for wedges)	LW-3

Item Number	Hand	DCON mm	H mm	B mm	LF mm	HF2 mm	Insert
DS-SDUL16-11-ACH-OH	L	16.00	15.5	15.5	95	TypeA(0--+0.2)	DC..11T3.. DC..11T3..WP(TFD11..)
DS-SDUL19-11-ACH-OH	L	19.05	18	18	120		
DS-SDUL20-11-ACH-OH	L	20.00	19	19	120		
DS-SDUL22-11-ACH-OH	L	22.00	21	21	120		
DS-SDUL25-11MET-ACH-OH	L	25.00	24	24	150		
DS-SDUL25-11-ACH-OH	L	25.40	24	24	150		

DS-PTX-ACH-OH Adjustable Centerline Height DS toolholder (Internal coolant type)



This figure shows the left hand (L).
Note: Use the Right (R) or Non-hand (N) insert

Spare Parts	
Screw (for clamping)	LCS33
Screw (for wedge)	WS060419-004
Lever (for clamping)	LCL33N
Wedge	ACH-W18
Wrench (for clamping)	LW-2
Wrench (for wedges)	LW-3

Item Number	Hand	DCON mm	H mm	B mm	LF mm	HF2 mm	Insert
DS-PTXL16-33-ACH-OH	L	16.00	15.5	15.5	120	TypeA(0--+0.2)	TN..1604..
DS-PTXL19-33-ACH-OH	L	19.05	18	18	120		
DS-PTXL20-33-ACH-OH	L	20.00	19	19	120		
DS-PTXL22-33-ACH-OH	L	22.00	21	21	120		
DS-PTXL25-33MET-ACH-OH	L	25.00	24	24	150		
DS-PTXL25-33-ACH-OH	L	25.40	24	24	150		



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