

# NTK DS-ACH Holders with Adjustable Centerline Height



## Features

Adjust centerline height simply by turning a wrench.

### 1 Adjust centerline height easily.

Patented

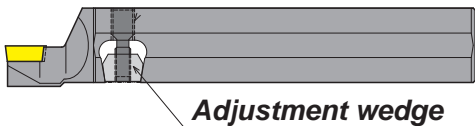
Eliminate center boss on end faces.  
Provide constant OD dimension.  
Adjust easily in machine.



1 Turn screw clockwise.

2 Adjustment wedge goes down.

3 Insert edge moves up.

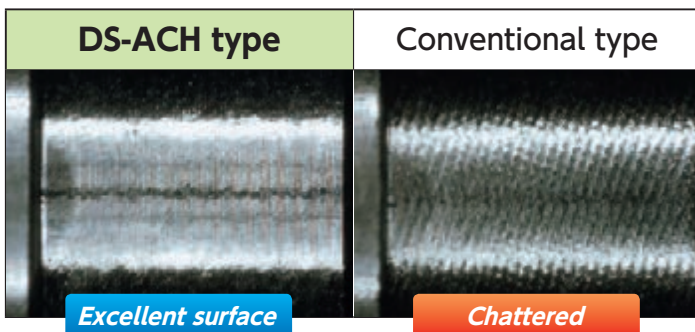


Range of centerline height adjustment  
0 ~ .008"

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

### 2 Optimized design reduces vibration.

Improved chatter resistance.



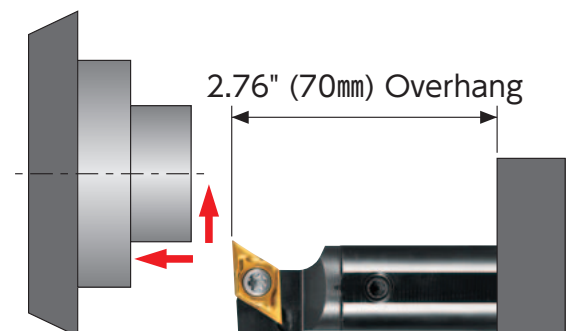
### Tested cutting conditions (304 Stainless).

Work material : 304 Stainless

Holder : DS-SDUL19-11-ACH

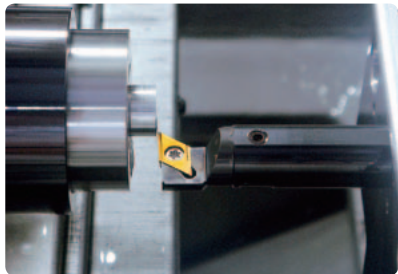
Insert : DCGT32.508MCL TM4

Cutting condition:  $v_c=250$  SFM,  $f=.002$  IPR,  $a_p=.079$ "

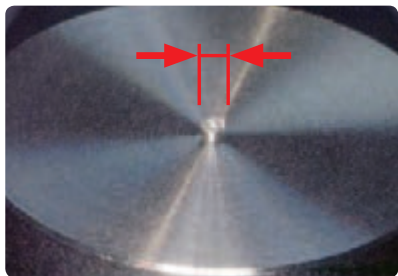


## How to use

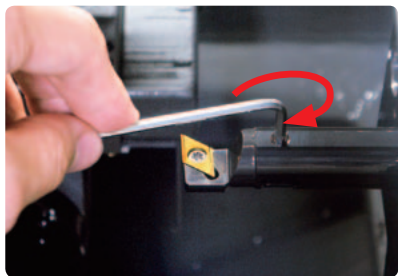
**Loosen wedge screw before making any adjustment.**



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



② Measure the diameter of the center boss.



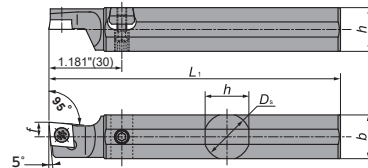
③ Raise the center height by one half of the diameter of the boss. **Adjustment references are available in the tool case.**



④ Re-machine the end face.

Also available for VC..22.. Inserts:  
DS-SVXL19-11-ACH (5938048)  
DS-SVXL25-11-ACH (5938055)

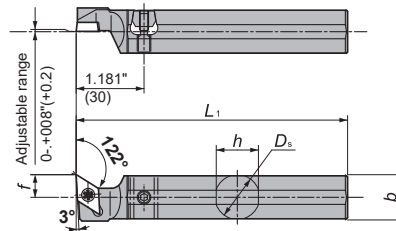
## DS-SCLL-ACH



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

EDP	Item Number	Hand	Dimensions (Inch)					Applicable Insert
			L	D <sub>s</sub>	h	b	L <sub>1</sub>	
5833694	DS-SCLL16F-09-ACH	●	16 { (.630")	.610	.591	3.150	.394	CC..32.5..
5833702	DS-SCLL19-09-ACH	●	3/4"	.709	.709	4.724	.394	
5833710	DS-SCLL20-09-ACH	●	20 { (.787")	.748	.748	4.724	.394	
5833728	DS-SCLL22-09-ACH	●	22 { (.866")	.827	.827	4.724	.394	
5934013	DS-SCLL25-09MET-ACH	●	25mm(.984")	.945	.945	5.906	.236	
5833736	DS-SCLL25-09-ACH	●	1"	.945	.945	5.906	.394	

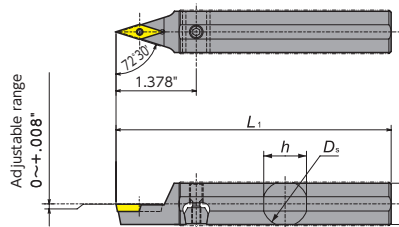
## DS-SDU-ACH



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

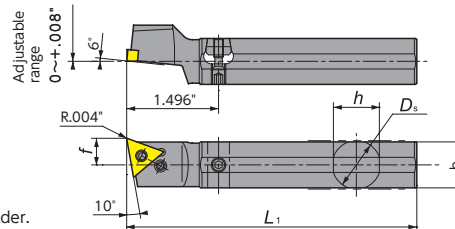
EDP	Item Number	Hand		Dimensions (Inch)					Applicable Insert
		R	L	D <sub>s</sub>	h	b	L <sub>1</sub>	f	
5906532 / 5805635	DS-SDUR / L16F-11-ACH	●	●	16 { (.630")	.610	.591	3.150	.394	DC..32.5..
5805627	DS-SDUL19-11-ACH	●	●	3/4"	.709	.709	4.724	.394	
5799614	DS-SDUL20-11-ACH	●	●	20 { (.787")	.748	.748	4.724	.394	
5799622	DS-SDUL22-11-ACH	●	●	22 { (.866")	.827	.827	4.724	.394	
5934021	DS-SDUL25-11MET-ACH	●	●	25 { (.984")	.945	.945	5.906	.394	
5799648	DS-SDUL25-11-ACH	●	●	1"	.945	.945	5.906	.394	

## DS-SVVP-ACH



EDP	Item Number	Hand	Dimensions (Inch)					Applicable Insert
			D <sub>s</sub>	h	b	L <sub>1</sub>	f	
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.

EDP	Item Number	Hand	Dimensions (Inch)					Applicable Insert
			D <sub>s</sub>	h	b	L <sub>1</sub>	f	
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	