

# DS-ACH Toolholders

## Features

- Adjust centerline height simply with a wrench



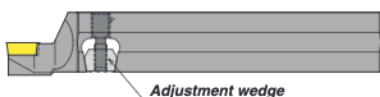
### 1 Adjust centerline height easily

Patented

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

1 Turn screw clockwise

2 Adjustment wedge goes down



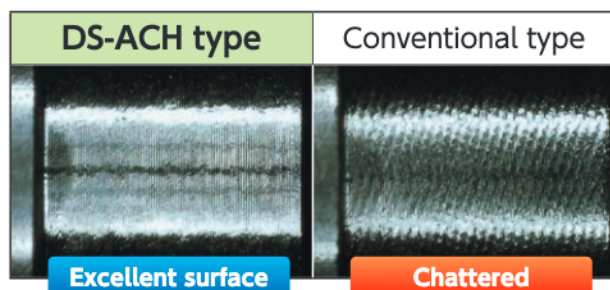
Adjustment wedge

3 Insert edge moves up

Range of centerline height adjustment  
0 - .008"

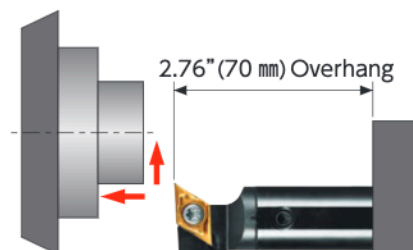
### 2 Optimized design reduces vibration

Improved chatter resistance.



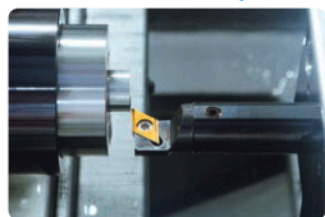
### Tested cutting conditions (304 SS)

Work material : 304 SS  
Holder : DS-SDUL19-11-ACH  
Insert : DCGT32.508MCL TM4  
Cutting condition : 250 SFM .002 IPR .079" DOC WET

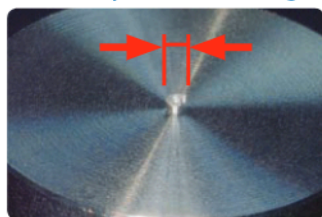


## How to use

Insert moves in an upward direction only. (Loosen wedge screw before making any adjustment)



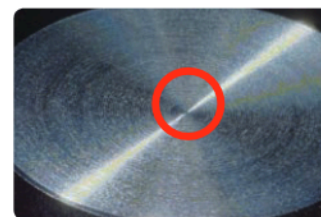
① Install the holder slightly below centerline. Then take a facing test cut.



② Measure the diameter of the centerboss.



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.

\*Adjustment instructions are supplied in the tool case