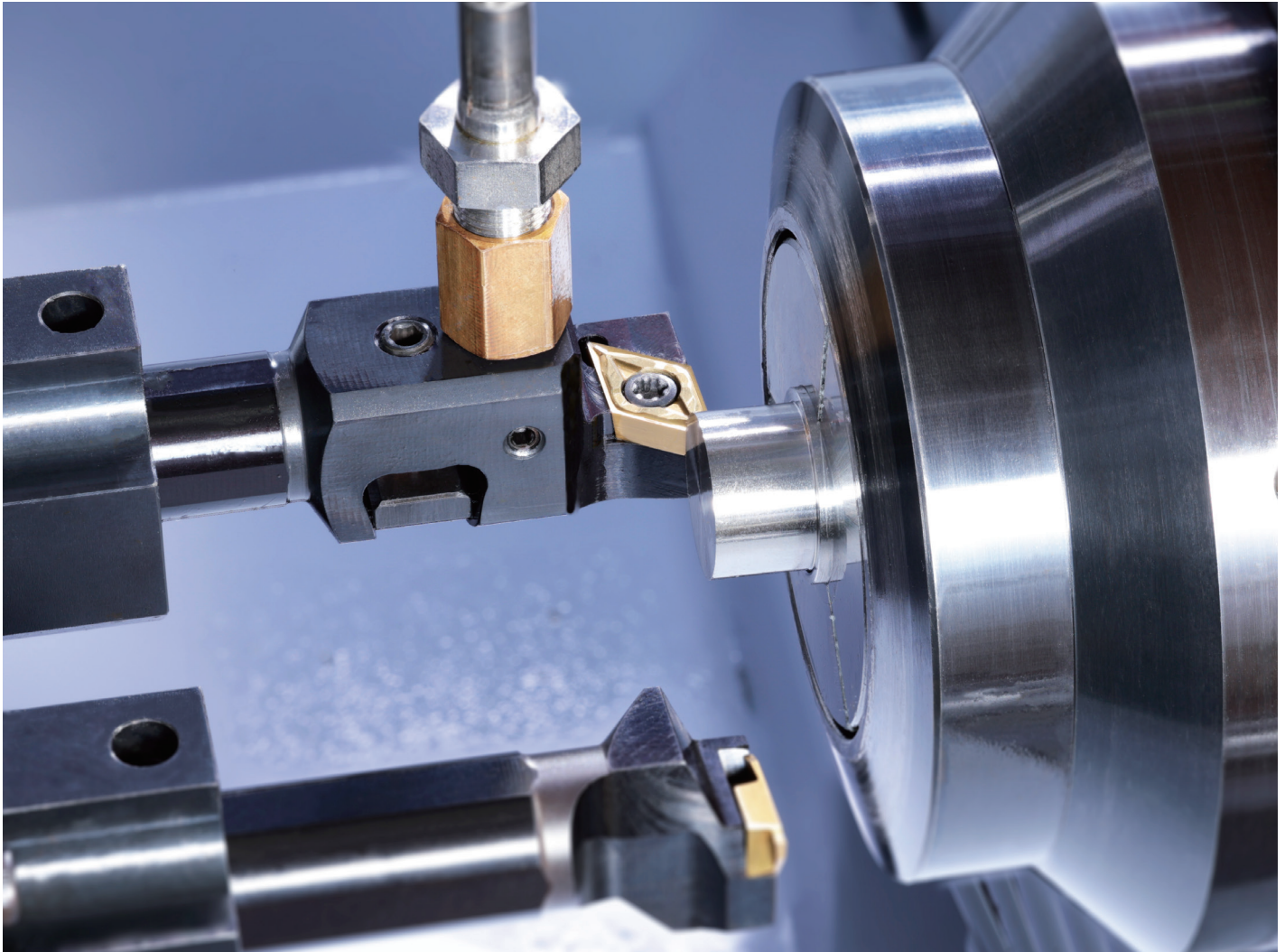
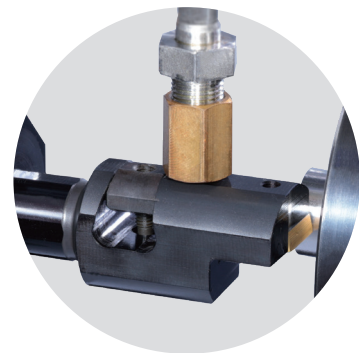


DS Holder Series

For back machining | CNC automatic lathes



Capable of using Inverted toolholder



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

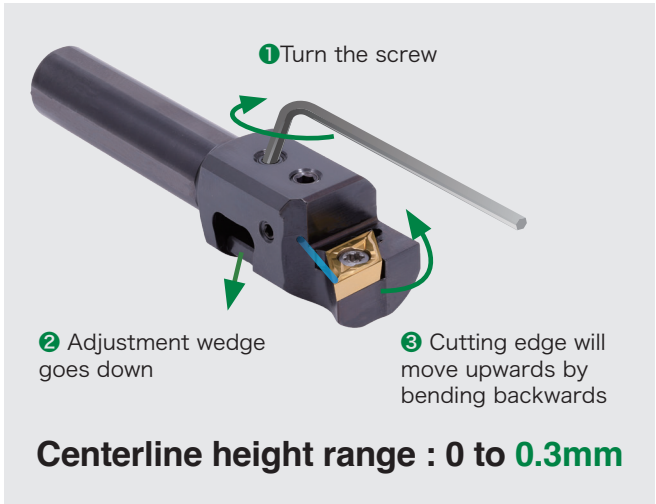
CERtainly (but not only) **CERamics**
Outstanding solutions for demanding applications



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.

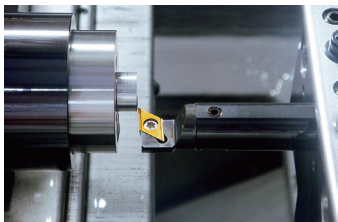


Feature 2.

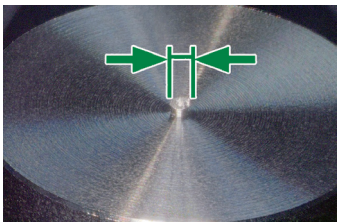
Internal coolant reduces insert wear and improve chip control.

	External + Internal coolant	External coolant only
Specification		
Lateral relief surface		

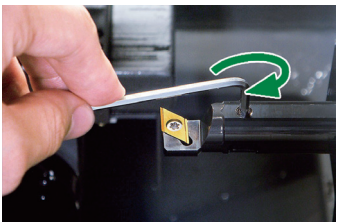
How to use * The insert moves in an upward direction only. (Loosen wedge screw before making any adjustments)



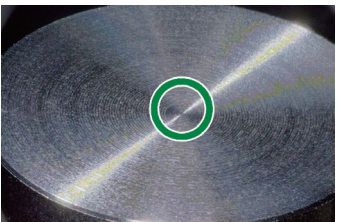
① Set the holder slightly below centerline and process the end face.



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



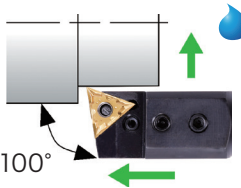
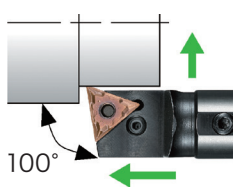
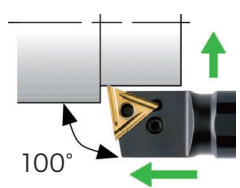
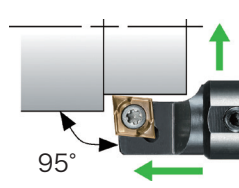
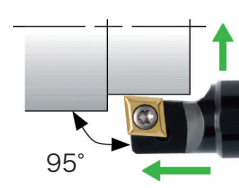
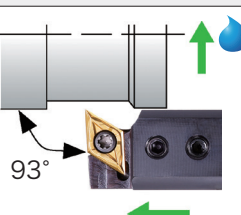
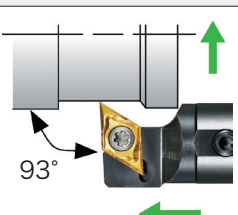
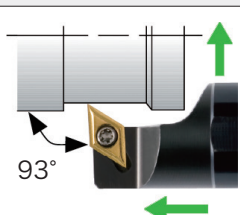
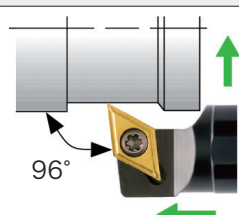
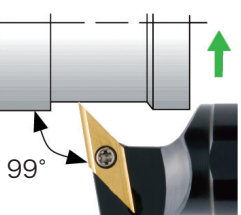
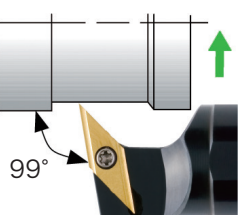
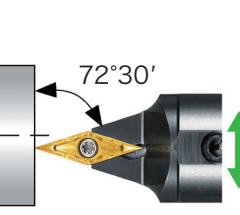
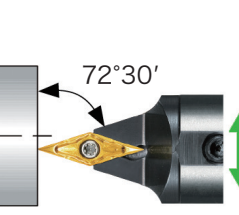
③ Raise the centerline height by one half of the diameter.



④ Re-machine the end face.

Lineup

Front Turning

DS-....-ACH		Centerline height adjustment		DS-....-ACH-OH		Centerline height adjustment + Internal coolant			
DS-PTX-ACH-OH		DS-PTX-ACH		DS-PTX		DS-SCL-ACH		DS-SCL	
									
New →Reverse side		→Q54		→Q54		→Q15		→Q16	
DS-SDU-ACH-OH		DS-SDU-ACH		DS-SDUL		DS-SDX			
									
New →Reverse side		→Q27		→Q28		→Q30			
DS-SVX		DS-SVXP		DS-SVVPN-ACH		DS-SVVPN			
									
→Q46		→Q46		→Q47		→Q48			

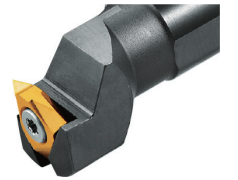
Back Turning

DS-TBP	DS-GTT
	
→R13	→R27

Grooving

DS-GTT	DS-FGV
	
→T16	→T35

Threading

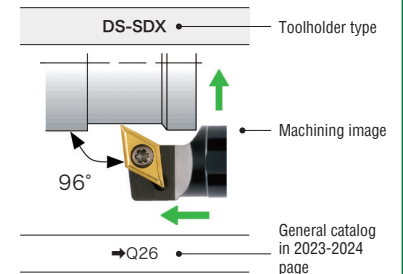
DS-TTP	DS-STT
	
→U18	→U22

Boring

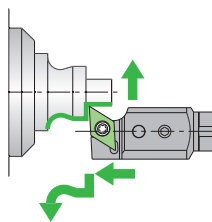
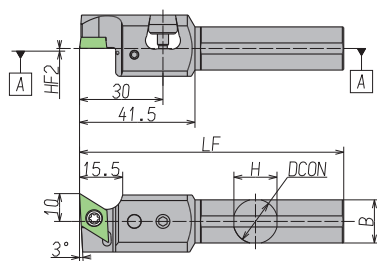
DS-LBMB

→V7

Example



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



Spare Parts

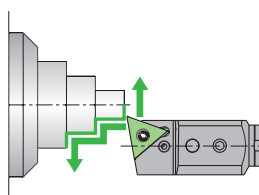
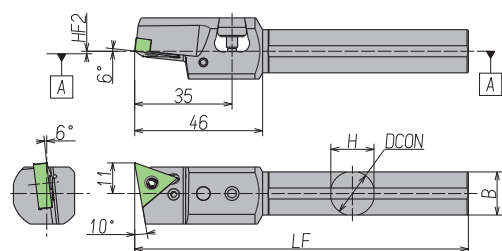
Screw (for clamping)	LRIS-4*10
Screw (for wedge)	WS060419-004
Wedge	ACH-W18
Wrench (for clamping)	LLR-25S-20*65
Wrench (for wedges)	LW-3

This figure shows the left hand (L).

Note: Use the Right (R) or Non-hand (N) insert

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-SDUL25-11-MET-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)



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

This figure shows the left hand (L).

Note: Use the Right (R) or Non-hand (N) insert

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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