

NTK DS-ACH Holders with Adjustable Centerline Height

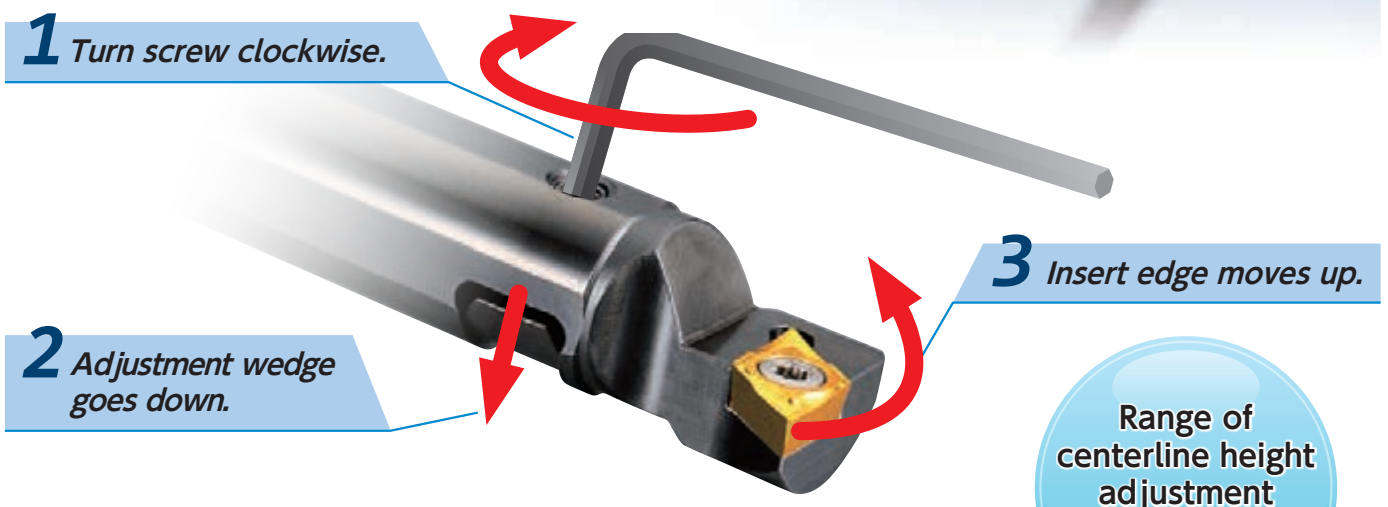
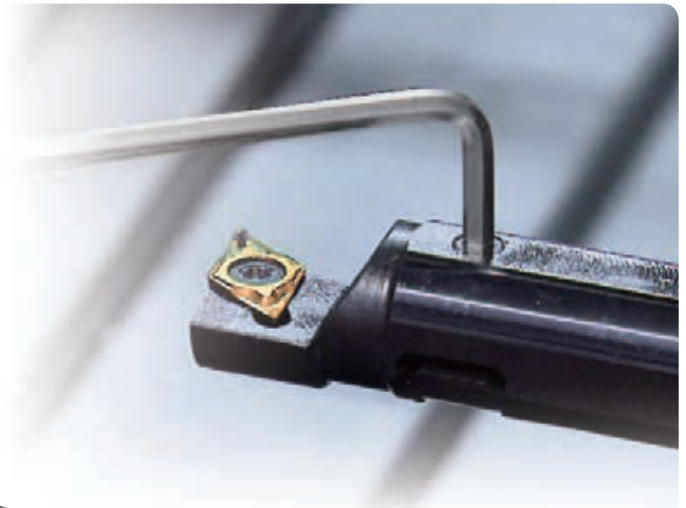


Features

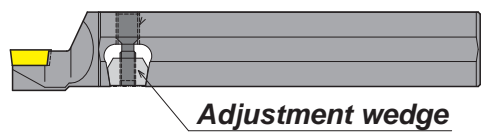
For Swiss Lathes without Y2 Axis Capability
Adjust centerline height simply by turning a wrench.

1 Adjust centerline height easily. Patented

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



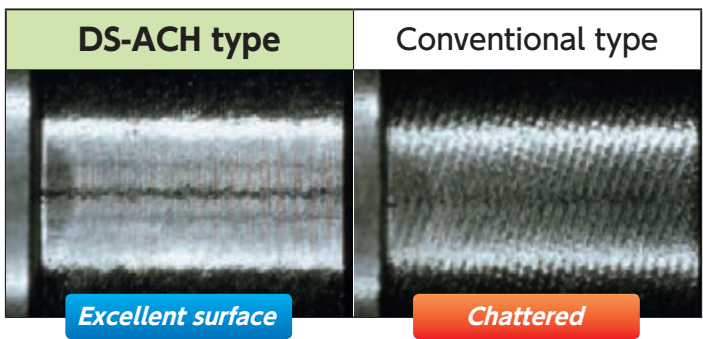
Range of centerline height adjustment
0 ~ .008"



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

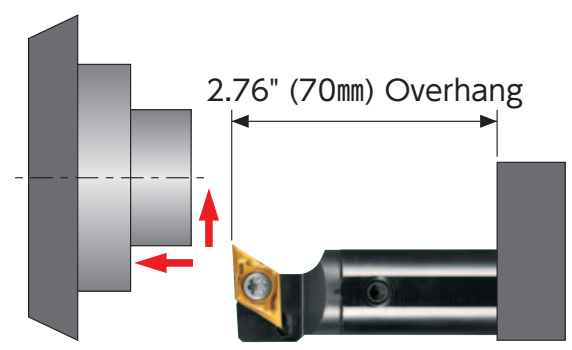
2 Optimized design reduces vibration.

Improved chatter resistance.



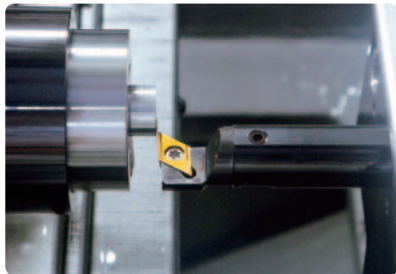
Tested cutting conditions (304 Stainless).

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

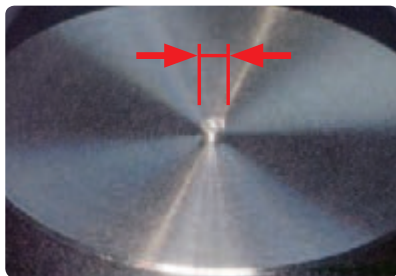


How to use

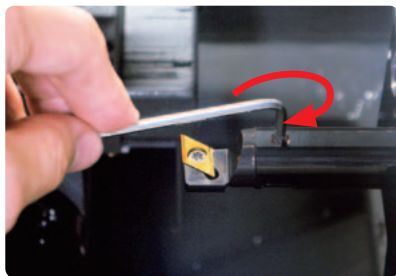
Loosen wedge screw before making any adjustment.



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



② Measure the diameter of the center boss.

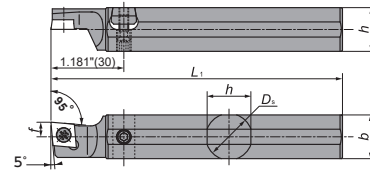


③ Raise the center height by one half of the diameter of the boss. **Adjustment references are available in the tool case.**



④ Re-machine the end face.

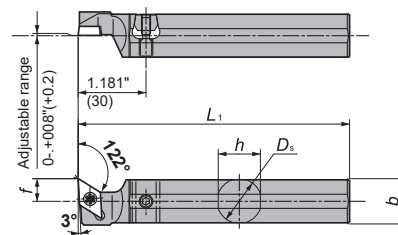
DS-SCLL-ACH



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

EDP	Item Number	Hand	Dimensions (Inch)					Applicable Insert
			D_s	h	b	L_1	f	
5833694	DS-SCLL16F-09-ACH	●	16mm (.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	●	20mm (.787")	.748	.748	4.724	.394	
5833728	DS-SCLL22-09-ACH	●	22mm (.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	

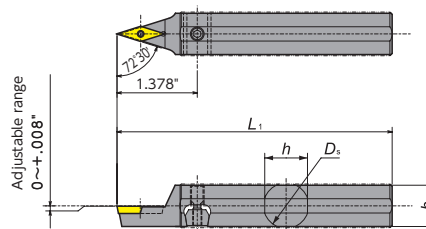
DS-SDU-ACH



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

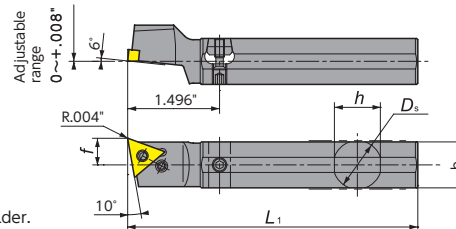
EDP	Item Number	Hand		Dimensions (Inch)					Applicable Insert
		R	L	D_s	h	b	L_1	f	
5906532 / 5805635	DS-SDUR / L16F-11-ACH	●	●	16mm (.630")	.610	.591	3.150	.394	DC..32.5..
5805627	DS-SDUL19-11-ACH	●	●	3/4"	.709	.709	4.724	.394	
5799614	DS-SDUL20-11-ACH	●	●	20mm (.787")	.748	.748	4.724	.394	
5799622	DS-SDUL22-11-ACH	●	●	22mm (.866")	.827	.827	4.724	.394	
5934021	DS-SDUL25-11MET-ACH	●	●	25mm (.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_s	h	b	L_1	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_s	h	b	L_1	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	