

DS-ACH Toolholders

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Features

- Adjust centerline height simply with a wrench

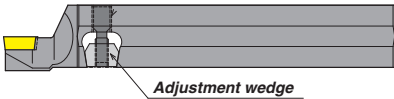
1 Adjust centerline height easily

Patented

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

1 Turn screw clockwise

2 Adjustment wedge goes down

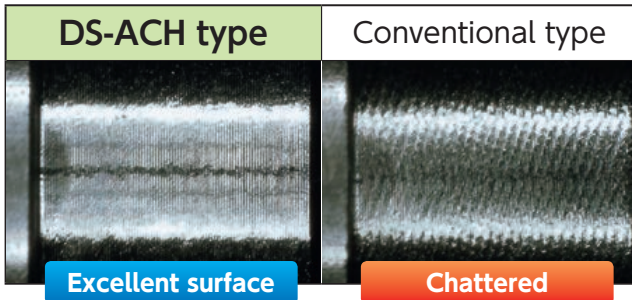


3 Insert edge moves up

Range of centerline height adjustment
0 - .008"

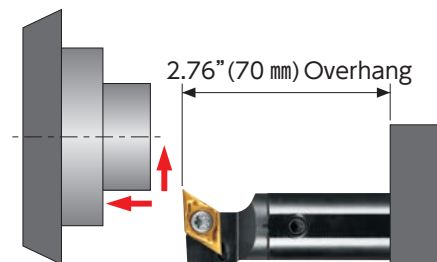
2 Optimized design reduces vibration

Improved chatter resistance.



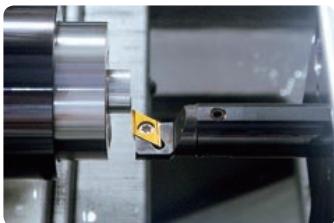
Tested cutting conditions (304 SS)

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

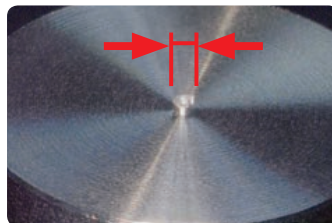


How to use

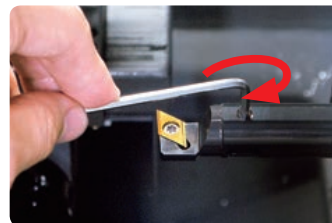
Insert moves in an upward direction only. (Loosen wedge screw before making any adjustment)



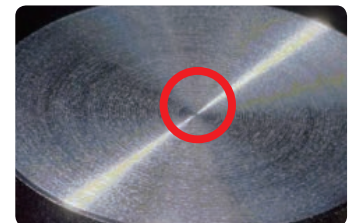
① Install the holder slightly below centerline. Then take a facing test cut.



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.



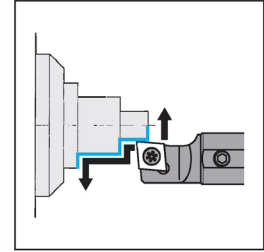
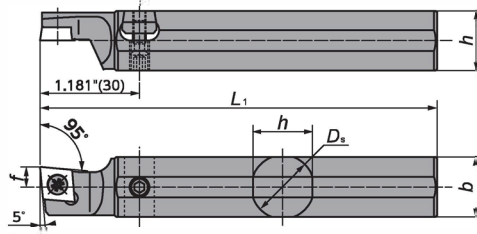
④ Re-machine the end face.

*Adjustment instructions are supplied in the tool case

DS-SCLL-ACH (Adjustable centerline height)

(Parts)

Shank	Wedge	Screw for Wedge
φ .630" (16)	ACH-W18 (5805601)	WS060415-003 (5795539)
φ 3/4" (19.05)		
φ .787" (20)		
φ .866" (22)	ACH-W24 (5805619)	WS060419-004 (5799226)
φ 1" (25.4)		




Left-Hand style shown
Takes Right-hand or Neutral insert

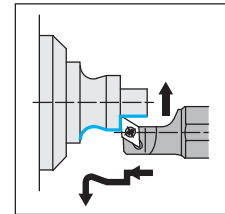
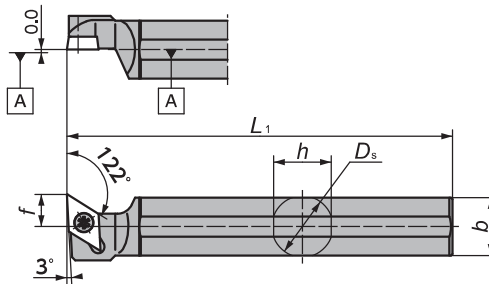
HOLDERS

Item #	D ₈		h		b		L ₁		f		List Price
	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	
DS-SCLL16F-09-ACH	.630	16.00	.610	15.5	.610	15.5	3.150	80	.236	6.0	\$XXX.XX
DS-SCLL22-09-ACH	.866	22.00	.827	21.0	.827	21.0	4.724	120	.236	6.0	\$XXX.XX

INSERTS

Shape	Item #	ISO Item #	IC	R	Coating	List Ea.
	CCGT 32.508 FNAM3		3/8	.008	QM3	\$XX.XX
	CCGT 32.51 FNAM3		3/8	.016	QM3	\$XX.XX
	CCGT32.52 FNAM3		3/8	.031	QM3	\$XX.XX

DS-SDU




Left-Hand style shown
Takes Right-hand or Neutral insert

HOLDERS

Item #	D ₈		h		b		L ₁		f		List Price
	Inch	mm	Inch	mm	Inch	mm	Inch	mm	Inch	mm	
DS-SDUL16F-11-ACH	.630	16.00	.610	15.5	.610	15.5	3.150	80	.394	10.0	\$XXX.XX
DS-SDUL22-11-ACH	.866	22.00	.827	21.0	.827	21.0	4.724	120	.394	10.0	\$XXX.XX

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