

DS-ACH Toolholders



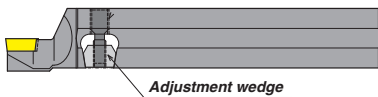
Features

- Adjust centerline height simply with a wrench

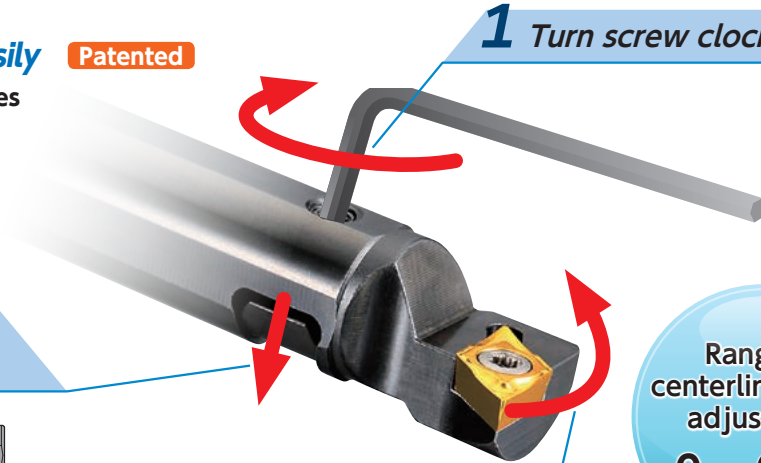
1 Adjust centerline height easily Patented

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

2 Adjustment wedge goes down



3 Insert edge moves up

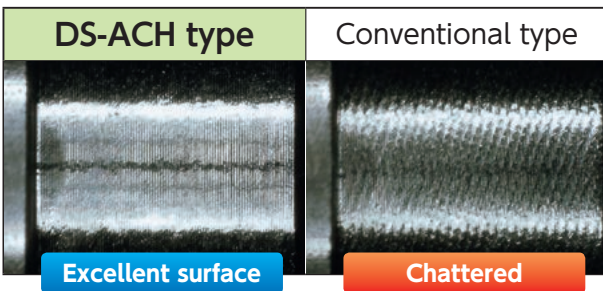


1 Turn screw clockwise

Range of centerline height adjustment
0 - .008"

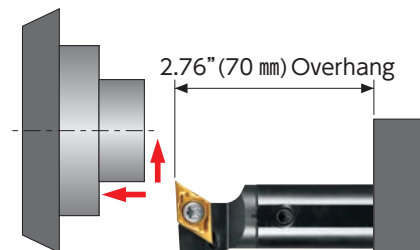
2 Optimized design reduces vibration

Improved chatter resistance.



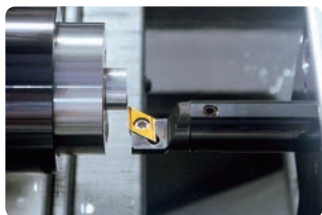
Tested cutting conditions (304 SS)

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

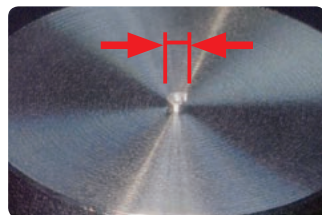


How to use

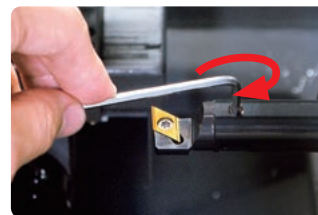
Insert moves in an upward direction only. (Loosen wedge screw before making any adjustment)



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