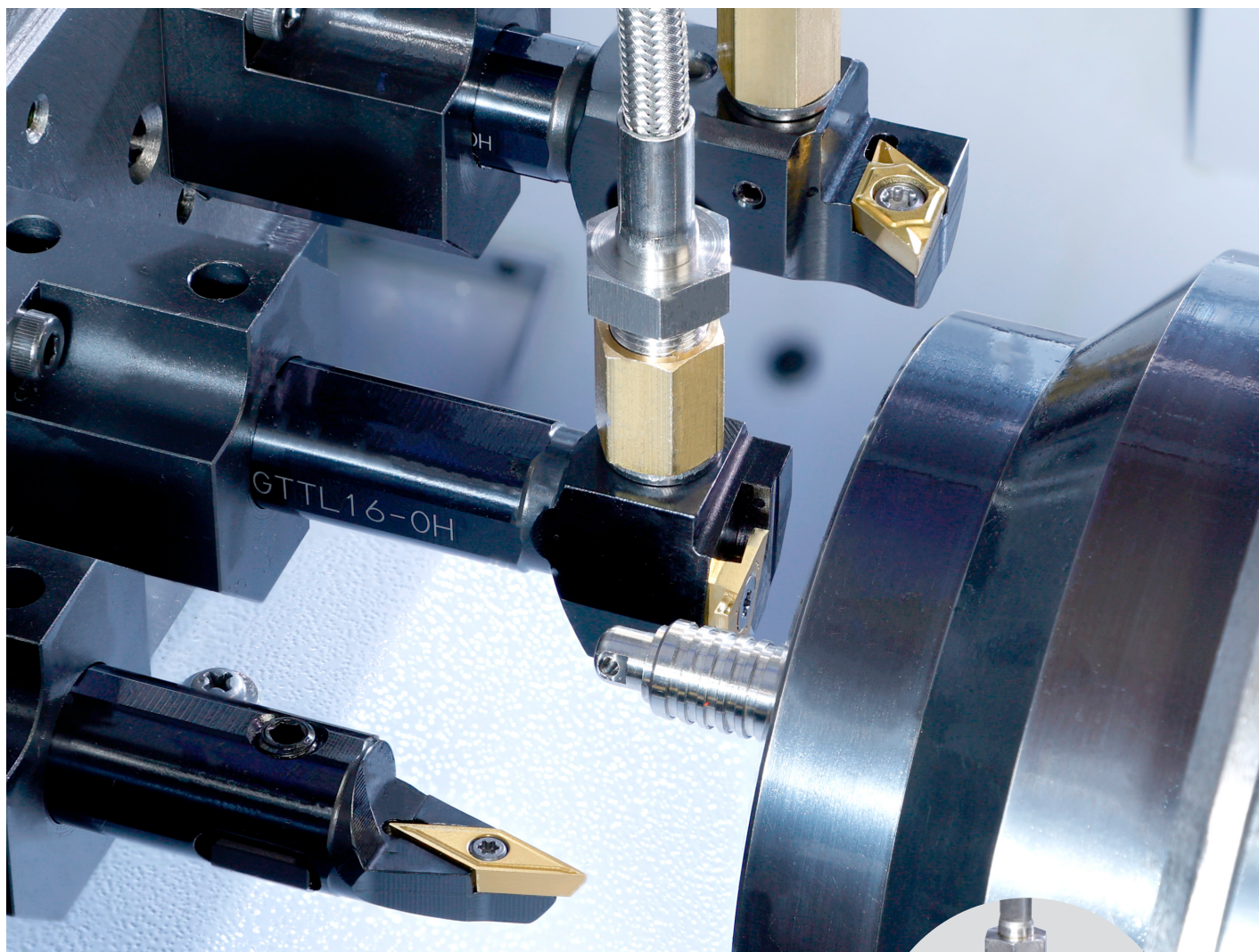


DS Holder Series

For Grooving and Back Turning operations | CNC automatic lathes



Capable of using inverted toolholder

Coolant-through grooving and back turning holder added to the DS holder series.

💧 The internal coolant supply improves tool wear resistance and chip control.

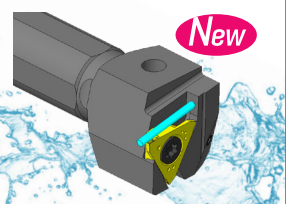
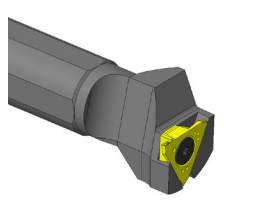
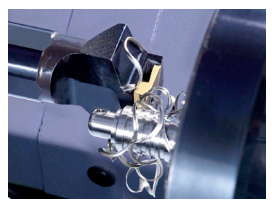
CERtainly | but not only | **CERamics**
Outstanding solutions for demanding applications



Coolant-through type is now available for the DS grooving and back turning holder.

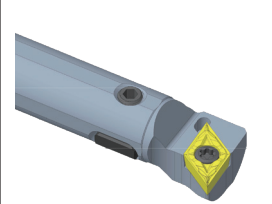
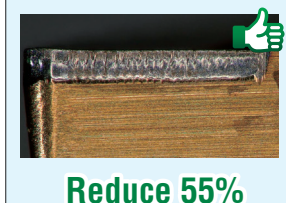
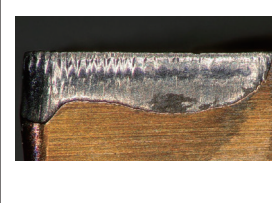
| Feature 1.

Improves chip control.

	Coolant-through + External	External coolant only
Holder type		
Chips		

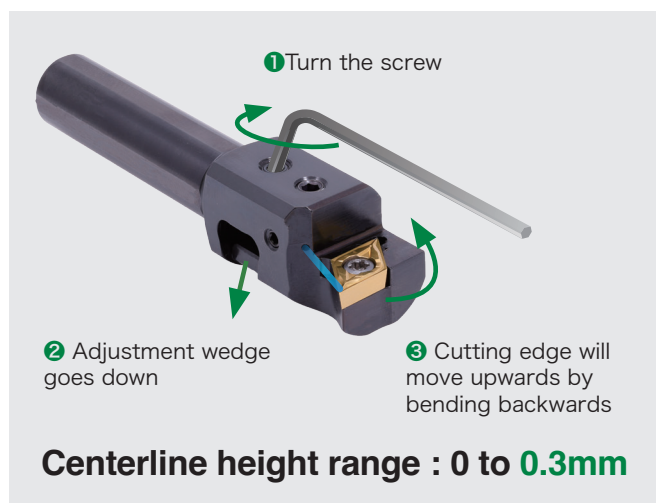
| Feature 2.

Reduces insert wear.

	Coolant-through + External	External coolant only
Holder type		
Lateral relief surface		

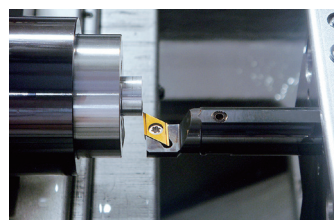
| Feature 3.

Centerline height can be easily adjusted with a wrench reducing setup time.

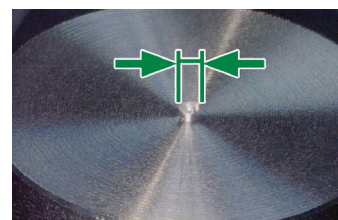


| How to use

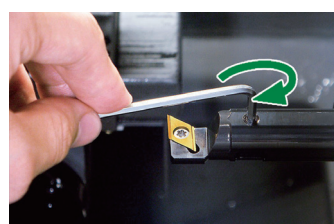
* The insert moves in an upward direction only.
(Loosen wedge screw before making any adjustments)



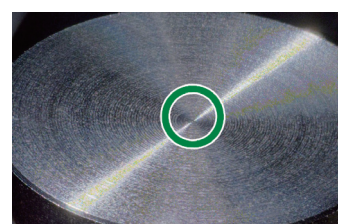
① Set the holder slightly below centerline and process the end face.



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



③ Raise the centerline height by half of the diameter.

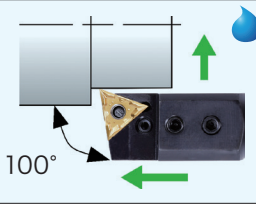
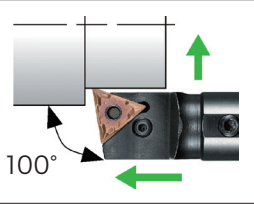
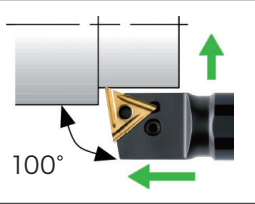
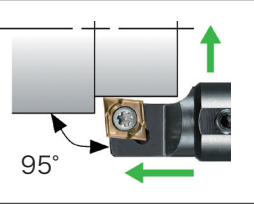
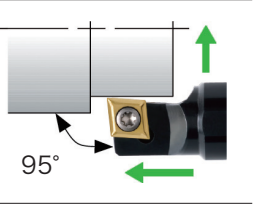
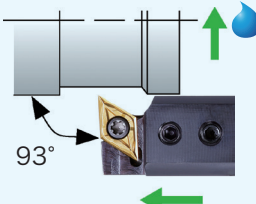
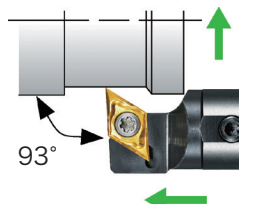
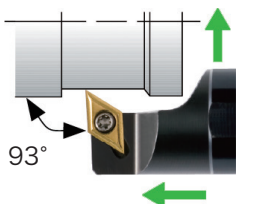
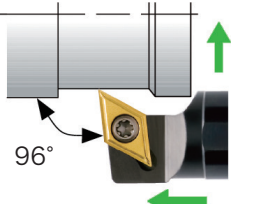
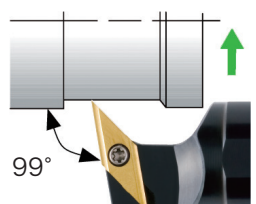
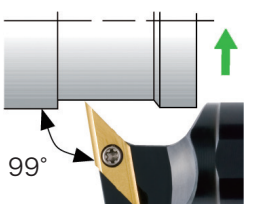
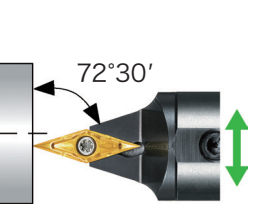
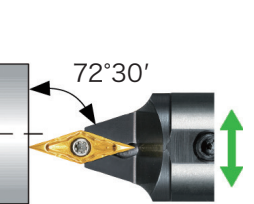


④ Re-machine the end face.

Lineup

Front Turning

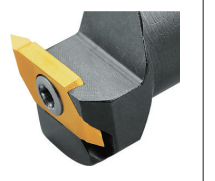
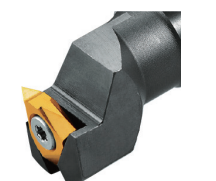
DS-...-OH	Coolant-through	DS-...-ACH...	Adjustable Centerline Height
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DS-PTX-ACH-OH  →Next page	DS-PTX-ACH  →Q54	DS-PTX  →Q54	DS-SCL-ACH  →Q15	DS-SCL  →Q16
DS-SDU-ACH-OH  →Next page	DS-SDU-ACH  →Q27	DS-SDU  →Q28	DS-SDX  →Q30	
DS-SVX  →Q42	DS-SVXP  →Q46	DS-SVVPN-ACH  →Q47	DS-SVVPN  →Q48	

Grooving

DS-GTT-OH  New →Next page	DS-GTT  →T16	DS-FGV  →T35
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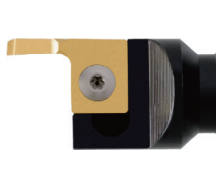
Threading

DS-TTP  →U19	DS-STT  →U22
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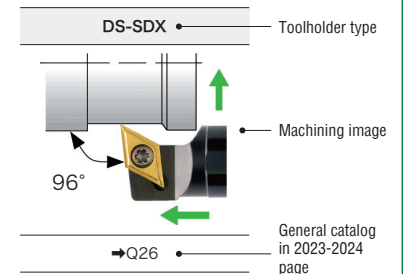
Back Turning

DS-TBP  →R13	DS-GTT-OH  New →Next page	DS-GTT  →R28
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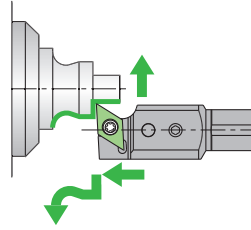
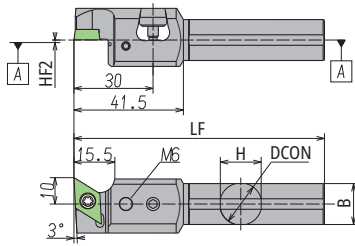
Boring

DS-LBMB  →V7

Example



DS-SDU-ACH-OH Adjustable Centerline Height DS toolholder (Coolant-through type)



Spare Parts

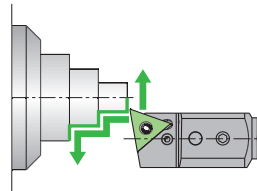
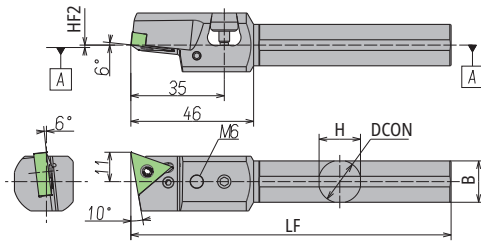
Screw (for clamping)	LRIS-4*10
Screw (for wedge)	WS060419-004
Wedge	ACH-W18
Wrench (for clamping)	LLR-25S-20*65
Wrench (for wedge)	LW-3

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	Adjustable Centerline Height TypeA(0~+0.2)	DC..11T3.. DC..11T3..WP
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 (Coolant-through 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 wedge)	LW-3

This figure shows the left hand (L).

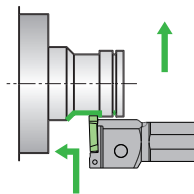
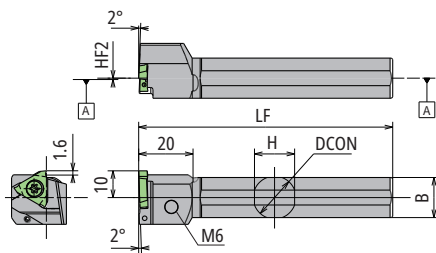
Note: Use the Right (R) or Non-hand (N) insert

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	Adjustable Centerline Height 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-PTXL25-33-MET-ACH-OH	L	25.00	24	24	150		
DS-PTXL25-33-ACH-OH	L	25.40	24	24	150		

DS-GTT-OH (Coolant-through type)



New



Spare Parts

Screw (for clamping)	LR-S-4*9
Wrench (for clamping)	RLR-20S

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-GTTL16-OH	L	16.00	15	15	95	0	TBMH32.. GT..32...
DS-GTTL19-OH	L	19.05	18	18	120		
DS-GTTL20-OH	L	20.00	19	19	120		
DS-GTTL22-OH	L	22.00	21	21	120		
DS-GTTL25-MET-OH	L	25.00	24	24	150		
DS-GTTL25-OH	L	25.40	24	24	150		



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