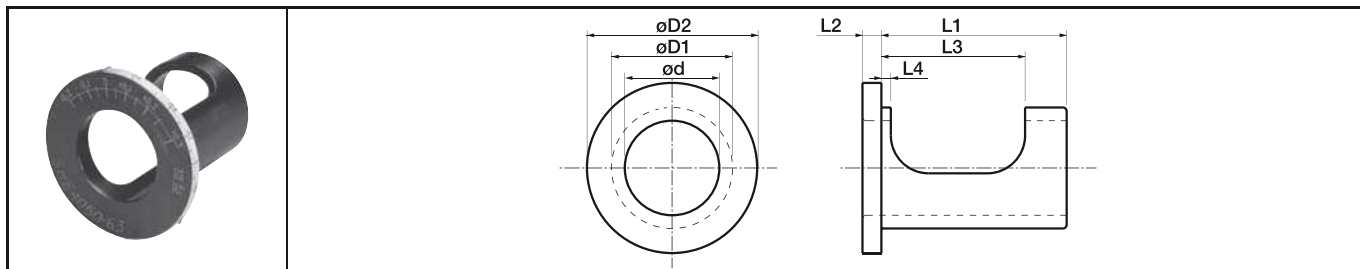


Adjustable Sleeve [DRX type / DRZ type for cutting dia. / center height adjustment]

kyocera@kyocera-tools.ru
www.kyocera-tools.ru

SHE



Sleeve Dimensions

Description	Std.	Dimension (mm)							* Cutting Dia. Adjustable Range	Center Height Adjustable Range
		ød	øD1	øD2	L1	L2	L3	L4		
SHE 2025-43	●	20	25	41	43	4	36	3.0	+0.4~-0.2	+0.2~-0.15
2532-48	●	25	32	49	48	6	38	2.5	+0.4~-0.2	+0.2~-0.15
3240-53	●	32	40	58	53	6	43	2.5	+0.4~-0.2	+0.2~-0.15
4050-63	●	40	50	74	63	6	49	3.0	+0.6~-0.2	+0.2~-0.2

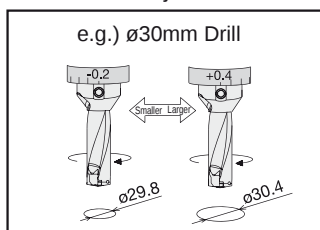
● Diameter Adjustment Range adjusts the cutting diameter.

● SHE type is for MagicDrill **DRX** / **DRZ**. It is not suitable for MagicDrill **DRS** type, because large correction amount is required.

● : Std. Stock

○ : Check Availability

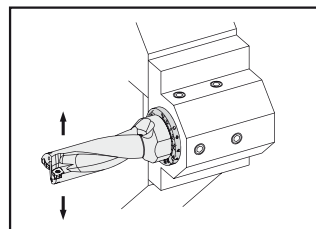
1. Diameter Adjustment ~For Machining Center~



● Diameter Adjustment Range (mm)

Shank Dia.	Adjustment Range
$\phi 20$	+0.4~-0.2
$\phi 25$	
$\phi 32$	
$\phi 40$	+0.6~-0.2

2. Center Height Adjustment ~Relief trouble by height adjustment at lathes~



● Center Height Adjustment Range (mm)

Shank Dia.	Adjustment Range
$\phi 20$	+0.2~-0.15
$\phi 25$	
$\phi 32$	
$\phi 40$	+0.3~-0.2

◆ How to use the Adjustable Sleeve

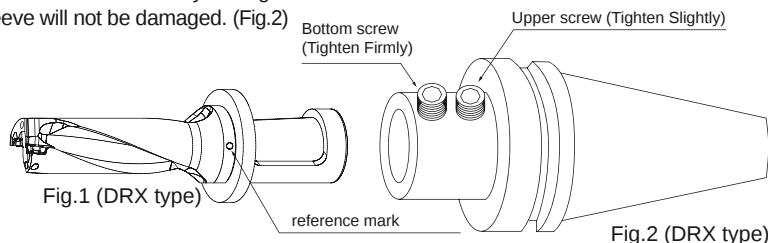
1. Hole Diameter Adjustment when Drilling

- Adjust the scale at the flange periphery of the sleeve to the center of the coolant plug of the drill. (Fig.1)
- When making the hole diameter bigger, rotate the sleeve in (+) direction and to make it smaller, rotate the sleeve in (-) direction.
- When rotating the sleeve, insert the wrench supplied with the drill into the hole on the flange periphery to rotate the sleeve.
- Using the bottom screw of the side-lock arbor, firmly tighten on the drill directly through the sleeve's window.

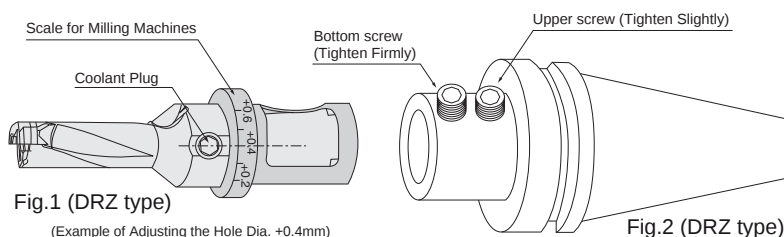
The upper screw should be tightened slightly so that the sleeve will not be damaged. (Fig.2)

Caution:

- Not applicable for Collet Chuck-type arbor **DRX type**
 - Scale on the sleeve is the reference value.
- Check the actual cutting diameter after adjusting.



DRZ type



2. Center-Height Adjustment for Lathes

Most Lathe problem occur with Center Height Deviation.

The Center Height is appropriate if a core approximately 0.5mm diameter remains at the center of the end face. (Fig.3)

Center-height adjustment is necessary for the case as follows:

- ◆ No core remains
- ◆ Core diameter is more than 1mm

- Align the drill with the outer insert face parallel to the X-axis of the tool turret. (Fig.4)
- Align the scale (for the lathe) on the flange face of the sleeve to the center of the drill coolant plug.
- When no core remains, rotate the sleeve to (+) direction to make the core larger, and when the core diameter is more than 1mm, rotate the sleeve to (-) direction to make the core smaller.
- When rotating the sleeve, insert the wrench supplied with the drill into the hole at the flange periphery and rotate the sleeve.
- After Completing the adjustment, tighten the drill directly through the window on the sleeve.

Note : Depending on amount of the center height adjustment, the hole diameter may change. It is recommended that the hole diameter is checked after the center height adjustment.

