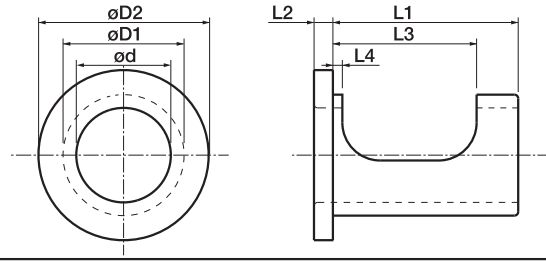
для заказа - kyocera@kyocera-tools.ru

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

SHE



Sleeve Dimensions

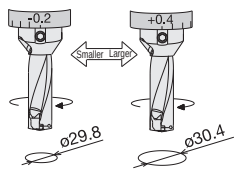
Description	Std.	Dimension (mm)							* Cutting Dia. Adjustable Range	Center Height Adjustable Range
		ød	øD1	øD2	L1	L2	L3	L4		
SHE 2025-43	●	20	25	41	43	4	36	3.0	+0.4~-0.2	+0.2~-0.15
2532-48	●	25	32	49	48	6	38	2.5	+0.4~-0.2	+0.2~-0.15
3240-53	●	32	40	58	53	6	43	2.5	+0.4~-0.2	+0.2~-0.15
4050-63	●	40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

1. Diameter Adjustment ~For Machining Center~

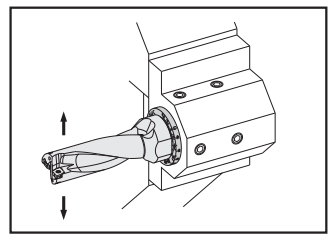
e.g.) ø30mm Drill



● Diameter Adjustment Range (mm)

Shank Dia.	Adjustment Range
ø20	+0.4~-0.2
ø25	
ø32	
ø40	+0.6~-0.2

2. Center Height Adjustment ~Fewer problems owing to height adjustment for lathes~



● Center Height Adjustment Range (mm)

Shank Dia.	Adjustment Range
ø20	+0.2~-0.15
ø25	
ø32	
ø40	+0.3~-0.2

How to use the Adjustable Sleeve

1. Hole Diameter Adjustment when Drilling

① Adjust the scale at the flange periphery of the sleeve to the center of the coolant plug of the drill. (Fig.1)
② When making the hole diameter bigger, rotate the sleeve in (+) direction and to make it smaller, rotate the sleeve in (-) direction.
③ When rotating the sleeve, insert the wrench supplied with the drill into the hole on the flange periphery to rotate the sleeve.
④ Using the bottom screw of the side-lock arbor, firmly tignten 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
- Scale on the sleeve is the reference value.
Check the actual cutting diameter after adjusting.

DRX

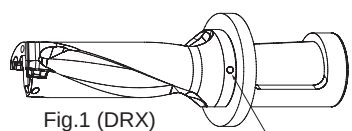


Fig.1 (DRX)

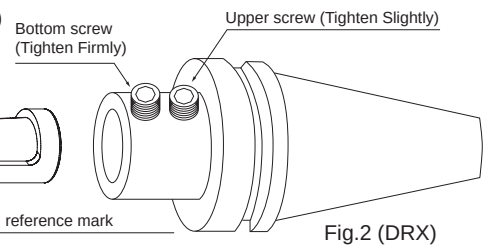


Fig.2 (DRX)

DRZ

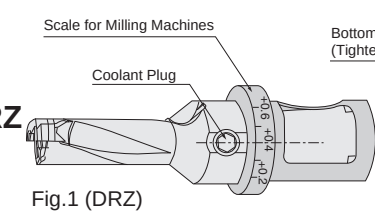


Fig.1 (DRZ)

(Example of Adjusting the Hole Dia. +0.4mm)

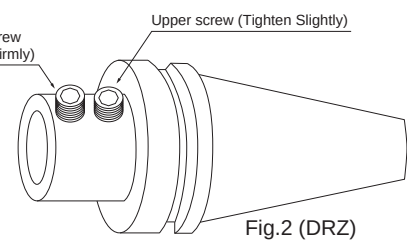


Fig.2 (DRZ)

2. Center-Height Adjustment for Lathes

Most Lathe problems occur due to Center Height Deviation.
The Center Height is appropriate if a core approximatately 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

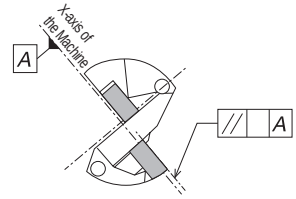


Fig.4

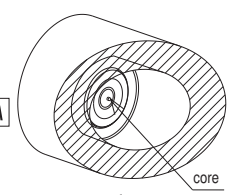


Fig.3

① Align the drill with the outer insert face parallel to the X-axis of the tool turret. (Fig.4)
② Align the scale (for the lathe) on the flange face of the sleeve to the center of the drill coolant plug.
③ 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.
④ When rotating the sleeve, insert the wrench supplied with the drill into the hole of the flange and then rotate the sleeve.
⑤ 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.

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