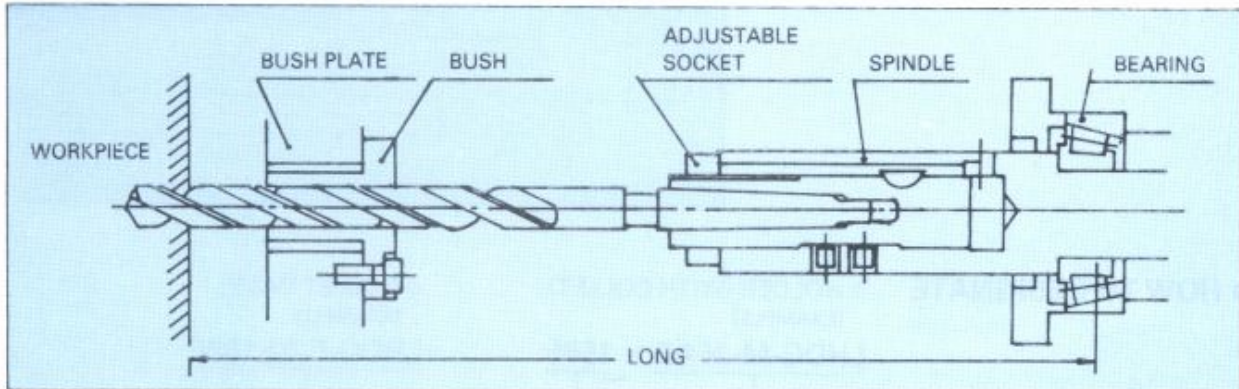




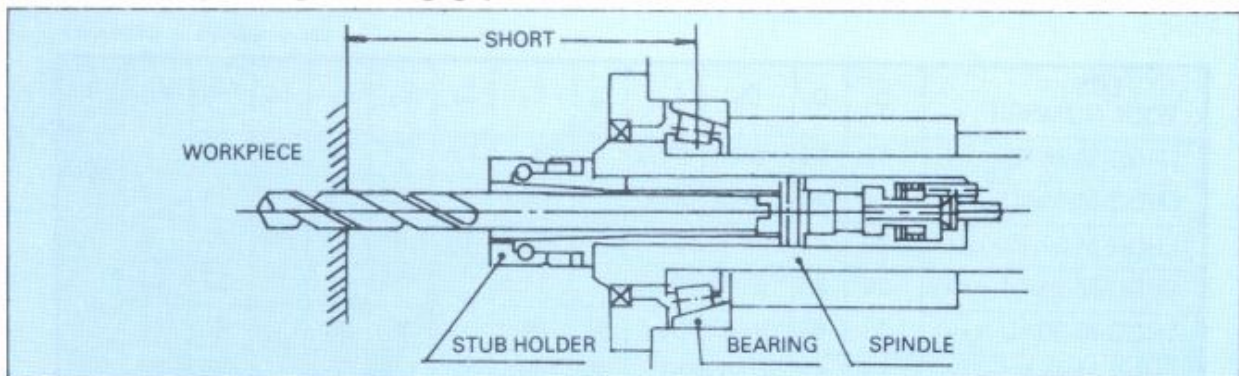
RAPID CHANGE STUB HOLDER

(FUJI SEIKO TYPE)

CONVENTIONAL TOOLING LAYOUT



STUB TOOLING LAYOUT



ADVANTAGES OF STUB TOOLING

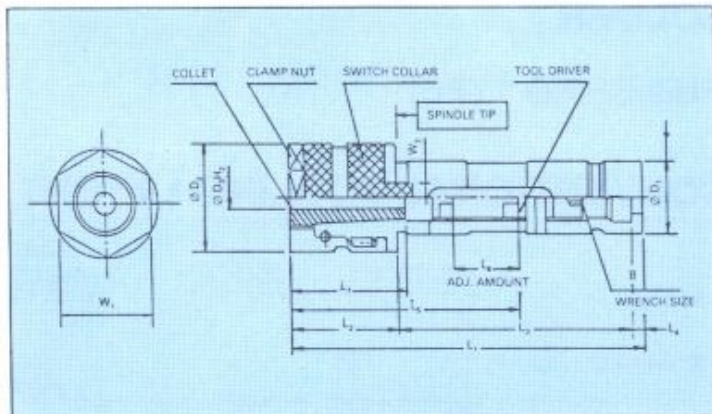
1. Since the flute length is set at the necessary minimum (depth of hole + length for regrinding), rigidity of drill is extremely high.
2. The distance between spindle tip and drill tip is also set at the necessary minimum (depth of hole + chip pocket + projection of Stub Holder) to lessen the whipping of drill and to make bushing unnecessary.
3. Having no bush, there is no need for the alignment between spindle center and bush.
4. Without bush, the removal of metal chips will be smooth.
5. The stroke of spindle unit will be the necessary minimum (depth of hole + length of Stub Holder + allowance).
6. Since there is no bush and the stroke of spindle unit is small, the machine is made smaller and space is utilized efficiently.
7. Since there is no need to have bush, designing of machine and tooling can be simplified.



RAPID CHANGE STUB HOLDER

(FUJI SEIKO TYPE)

LHDG STUB HOLDER



■ HOW TO DESIGNATE

○ HOLDER (WITH COLLET):
(EXAMPLE)

LHDG-M-26AD × 1595

STUB HOLDER CODE COLLET I.D. (D3)

○ COLLET ONLY:
(EXAMPLE)

LHDG-C-26 1595

COLLET CODE COLLET I.D. (D3)

(All dimensions in millimeter.)

LCS TOOL NUMBER	D ₁	D ₂	D ₃	L ₁	L ₂	L ₃	L ₄	L ₅	L ₆	L ₇	W ₁	W ₂	B	
LHDG-M-16AD****	16	24	5~8	80.5	28	50	2.5	51	20	25	21	6	4	
LHDG-M-19AD****	19	28	5~9	91.5		60.5	3	59	25			24		7
LHDG-M-22AD****	22	32	5~12	97		65.5	3.5	64	28	30		27		8
LHDG-M-26AD****	26	36	5~16	106.5	32	74.5	4	71	33	50	32	10	6	
LHDG-M-35AD****	35	46	8~22	130.5		94.5		89	35			41		14
LHDG-M-48AD****	48	62	20~32	152		38	109	5	105		50	55		18

Note: **** shows the I.D. of collet. (two digits below zero)

Example: $\varnothing 15.50$ 1550
 $\varnothing 8$ 0800

