

NIKKEN

ZERO-ZERO HOLDER FOR TURNING MACHINE

Ideal for Ultra Deep Drilling and Precise Reaming

NEW



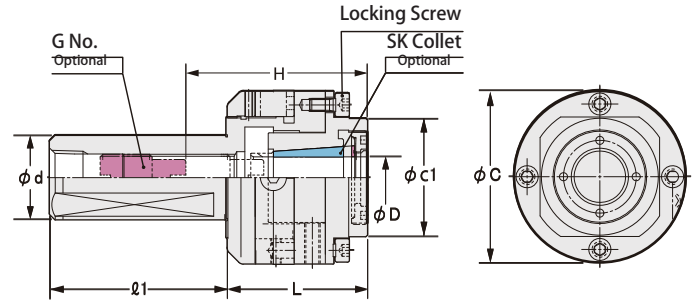
Run-out adjustment to "ZERO"
Misalignment adjustment to "ZERO"

NEW ZERO-ZERO HOLDER FOR TURNING MACHINE

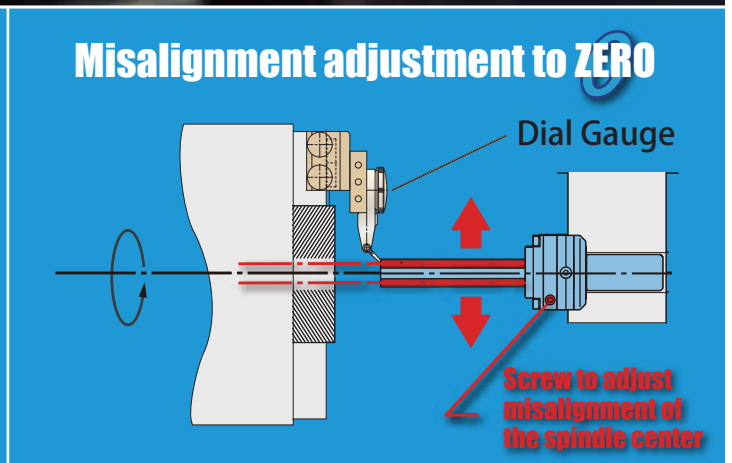
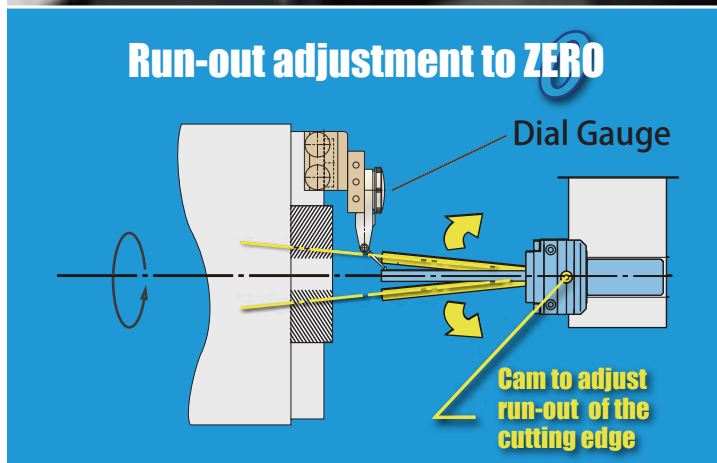
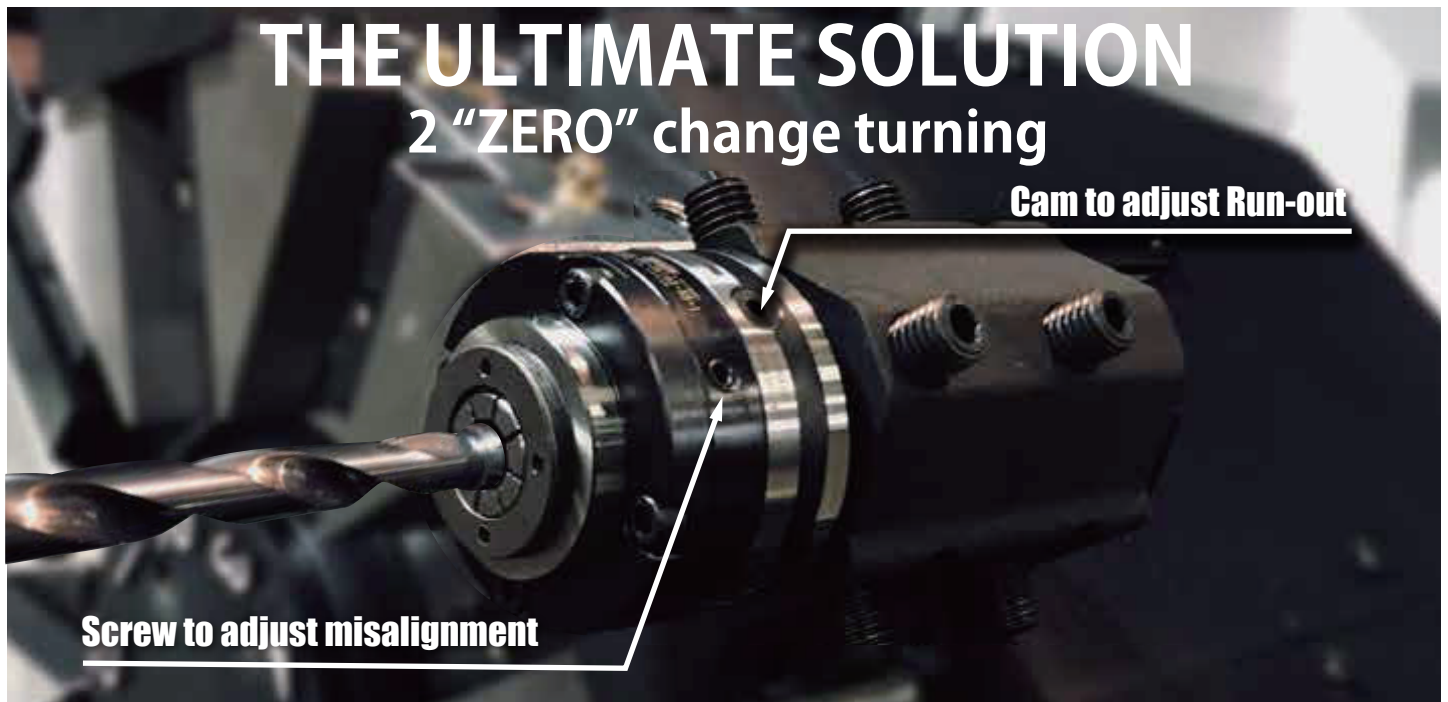
PAT.P



LCH40-SZF16S-55



Code.No.	D	d	L	l1	H	G	c1	G NO. (Optional)	Nut	SK Collet (Optional)	Spanner (Optional)
LCH32-SZF10S-52	1.75 ~ 10	32	52.1	68	50	66	35	SKG-18-SZF10S	SKN-10SB	SK10	SKL-10S-P
LCH40-SZF10S-52		40								SK10-P	
LCH32-SZF10S-52-A		32							SKN-10SB-11L	SK10-AC	
LCH40-SZF10S-52-A		40									
LCH32-SZF16S-55	2.75 ~ 16	32	54.3	70	70	66	45	SKG-18L	SKN-16SB	SK16	SKL-16S-P
LCH40-SZF16S-55		40								SK16-P	
LCH32-SZF16S-55-A		32							SKN-16SB-9L	SK16-AC	
LCH40-SZF16S-55-A		40									



Run-out adjustment range at the tip of 100mm test bar : 0.05mm
(Cam ring indication : ϕ 0.1mm)

Misalignment adjustment range : 0.5mm/diameter

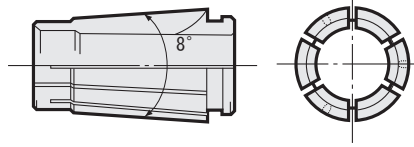
COLLETS FOR ZERO-ZERO HOLDER



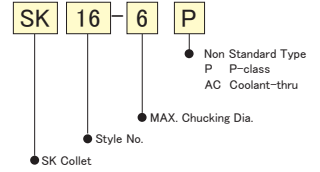
SK Collet



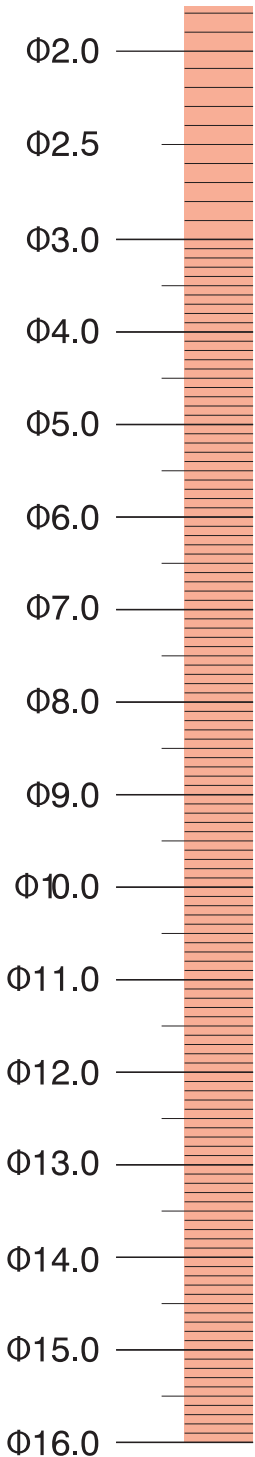
Perfect seal, ideal for coolant-thru tools
SK Coolant Collet



Explanation of the Code No.

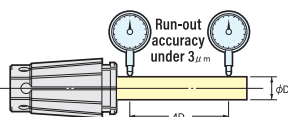


Your Tool



D	Standard Type		for Drilling		for Coolant-thru Tools	
	SK Collet		P-class Collet		SK Coolant Collet	
1.75~ 2.0	SK10- 2.0		SK10- 2.0P			
2.0 ~ 2.25	- 2.25		- 2.25P			
2.25~ 2.5	- 2.5		- 2.5P			
2.5 ~ 2.75	- 2.75		- 2.75P			
2.75~ 3.0	- 3	SK16- 3	- 3P	SK16- 3P	SK10- 3AC	
3.0 ~ 3.5	- 3.5	- 3.5	- 3.5P	- 3.5P		
3.5 ~ 4.0	- 4	- 4	- 4P	- 4P	- 4AC	
4.0 ~ 4.5	- 4.5	- 4.5	- 4.5P	- 4.5P		
4.5 ~ 5.0	- 5	- 5	- 5P	- 5P	- 5AC	
5.0 ~ 5.5	- 5.5	- 5.5	- 5.5P	- 5.5P		
5.5 ~ 6.0	- 6	- 6	- 6P	- 6P	- 6AC	SK16- 6AC
6.0 ~ 6.5	- 6.5	- 6.5	- 6.5P	- 6.5P		
6.5 ~ 7.0	- 7	- 7	- 7P	- 7P	- 7AC	- 7AC
7.0 ~ 7.5	- 7.5	- 7.5	- 7.5P	- 7.5P		
7.5 ~ 8.0	- 8	- 8	- 8P	- 8P	- 8AC	- 8AC
8.0 ~ 8.5	- 8.5	- 8.5	- 8.5P	- 8.5P		
8.5 ~ 9.0	- 9	- 9	- 9P	- 9P	- 9AC	- 9AC
9.0 ~ 9.5	- 9.5	- 9.5	- 9.5P	- 9.5P		
9.5 ~10.0	-10	-10	-10P	-10P	-10AC	-10AC
10.0 ~10.5		-10.5		-10.5P		
10.5 ~11.0		-11		-11P		-11AC
11.0 ~11.5		-11.5		-11.5P		
11.5 ~12.0		-12		-12P		-12AC
12.0 ~12.5		-12.5		-12.5P		
12.5 ~13.0		-13		-13P		-13AC
13.0 ~13.5		-13.5		-13.5P		
13.5 ~14.0		-14		-14P		-14AC
14.0 ~14.5		-14.5		-14.5P		
14.5 ~15.0		-15		-15P		-15AC
15.0 ~15.5		-15.5		-15.5P		
15.5 ~16.0		-16		-16P		-16AC

P-class collet is ideal for drilling. It guarantees run-out accuracy under 3 μm at the nose (4D) from the chuck.



☆ The standard nut for SK Collet / P-class Collet : SKN-10SB comes with LCH32-SZF10S-52 / LCH40-SZF10S-52, SKN-16SB comes with LCH32-SZF16S-55 / LCH40-SZF16S-55.

☆ The nut for SK Coolant Collet : SKN-10SB-11L comes with LCH32-SZF10S-52-A / LCH40-SZF10S-52-A, SKN-16SB-9L comes with LCH32-SZF16S-55-A / LCH40-SZF16S-55-A.

The Ultimate Solution for Turning

**Better
Hole Diameter**

**Better Surface
Roughness**

Extend Tool Life

HOW TO ADJUST

Required Tools

Adjustment Wrench
9ZFL (Optional)



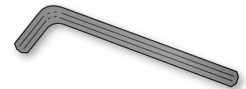
Tightening Spanner
SKL-16S-P (Optional)
SKL-10S-P (Optional)



Dial Gauge
LCD-Z (Optional)

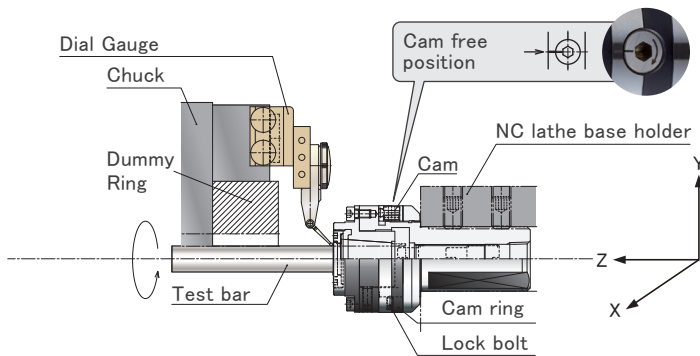


Hexagonal wrench to adjust 3mm
(commercial product)
Hexagonal wrench to lock screw 4mm
(commercial product)



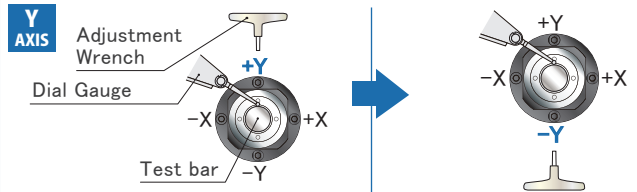
Run-out can be adjusted to "ZERO" by simply tightening 4 cams.

Set dial gauge at the base of the test bar.



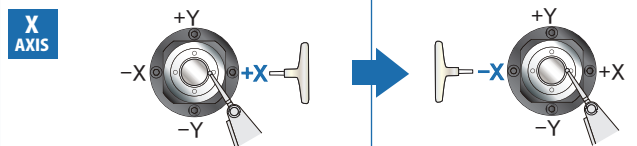
- Loosen the two lock bolts, move the cam to free position, and then rotate the cam ring to move the cam to +Y side of the test bar.
- Set the dial gauge to the +Y side of the test bar.
- Operate the handle of the machine to move Z axis and check the run-out.

Set dial gauge at the tip of the test bar.



If the run-out at that location is positive, adjust by rotating +Y side cam in the clockwise direction.

If the run-out at that location is negative, adjust by rotating -Y side cam in the clockwise direction.



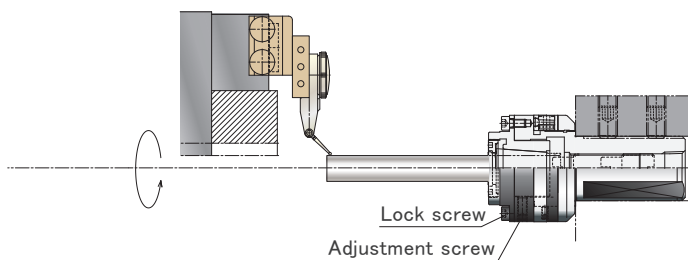
If the run-out at that location is positive, adjust by rotating +X side cam in the clockwise direction.

If the run-out at that location is negative, adjust by rotating -X side cam in the clockwise direction.

Repeat above operations until the inclination is zero, and then tighten the two lock bolts.

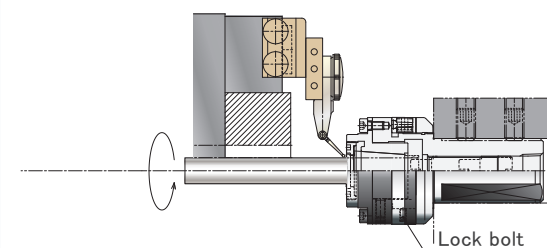
Misalignment can be adjusted to "ZERO" by simply tightening 4 screws.

Set dial gauge at the tip of the test bar.



- Loosen the four lock screws, and then use the adjust screw to adjust the run-out while rotating the dial gauge at the tip of the test bar.

Set dial gauge at the base of the test bar.



- Check the run-out at the base of the test bar, and then tighten the four lock screws.
- Replace with the actual tool to be used after adjustment.

- ☆ Must read instruction before starting to use.
- ☆ Always perform adjustments within the respective range. If the range are exceeded, the cam may not return easily.
- ☆ Test bar is not included.