

# The Ultimate Solution for Turning

**Better  
Hole Diameter**

**Better Surface  
Roughness**

**Extend Tool Life**

**HOW TO ADJUST**

**Required Tools**

Adjustment Wrench  
9ZF1 (Optional)

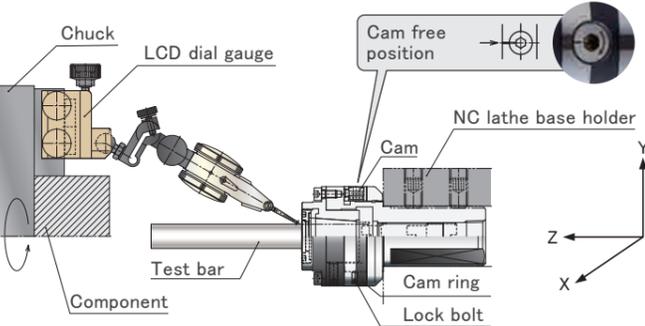
Tightening Spanner  
SKL-16S-P (Optional)

Dial Gauge  
LCD (Optional)



**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.

**Y AXIS**

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.

**X AXIS**

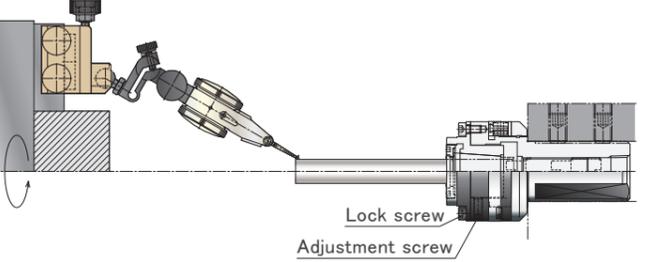
If the run-out at that location is positive, adjust by rotating +X side cam in the clockwise direction.

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.

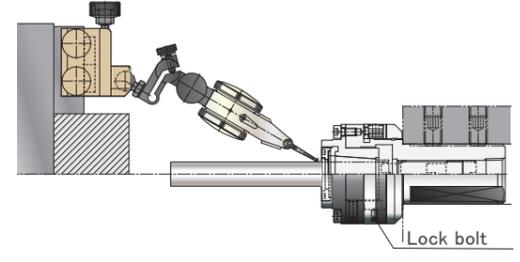
**Misalignment** can be adjusted to "ZERO" by simply tightening 4 screws.

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.

# ZERO-ZERO HOLDER FOR TURNING MACHINE

Ideal for Ultra Deep Drilling and Precise Reaming

**NEW**

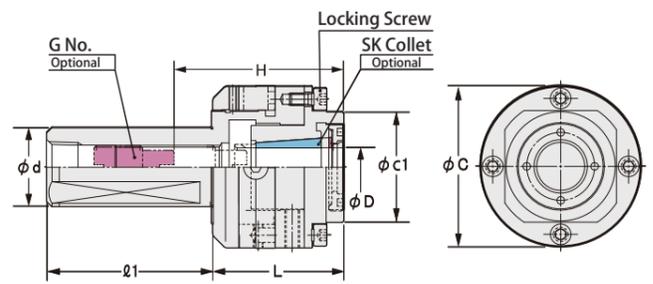


**Run-out adjustment to "ZERO"**  
**Misalignment adjustment to "ZERO"**

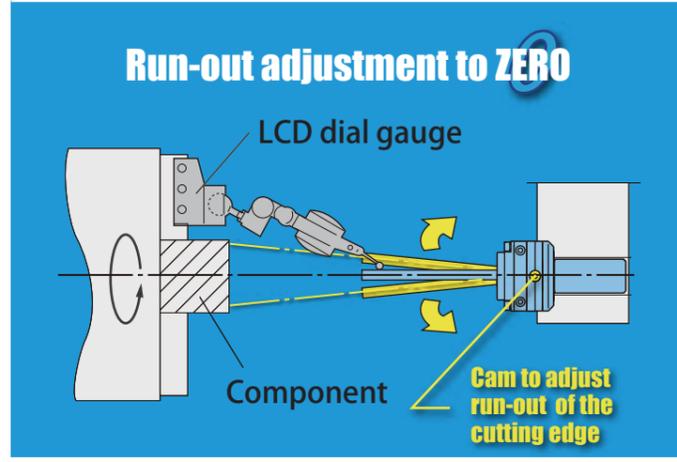
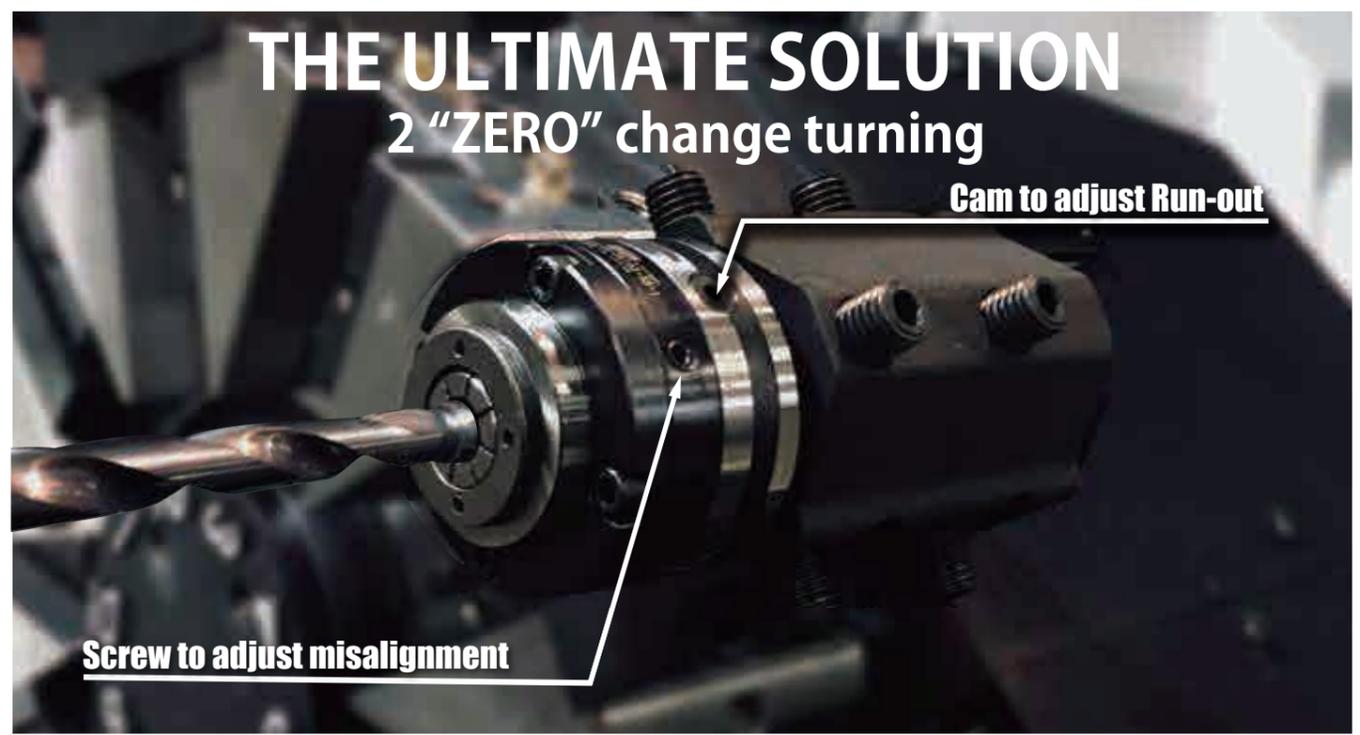
# NEW ZERO-ZERO HOLDER FOR TURNING MACHINE



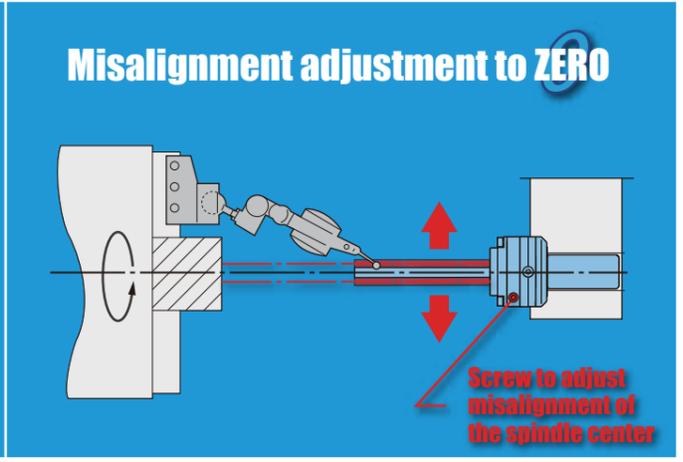
LCH40-SZF16S-55



Code.No.	D	d	L	ρ1	H	C	c1	G NO. (Optional)	SK Collet (Optional)	Spanner (Optional)
LCH32-SZF16S-55	2.75 ~ 16	32	54.3	68	70	66	45	SKG-18L	SK 16	SKL-16S-P
LCH40-SZF16S-55		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

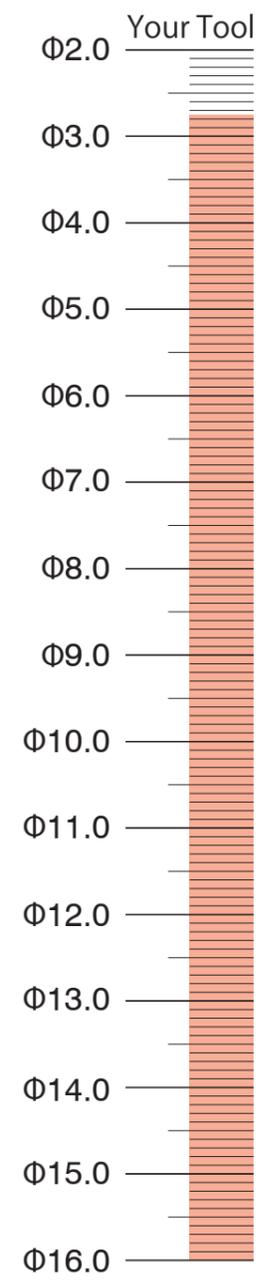
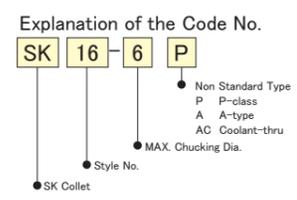
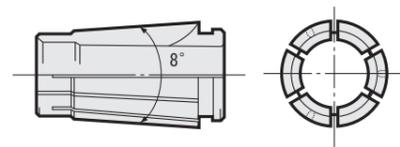
# COLLETS FOR ZERO-ZERO HOLDER



SK Collet

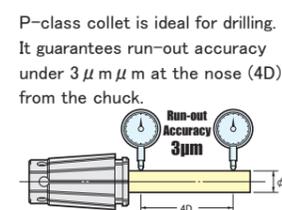


Perfect seal, ideal for coolant-thru tools  
SK Coolant Collet



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

Nut	SKN-16SB		SKN-16SB-9L (Optional)	
Tightening Spanner	SKL-16S-P (Optional)			



☆ The standard nut : SKN-16SB comes with every ZERO-ZERO HOLDER.  
☆ A-type collet needs the optional nut : KN-16SB-9L. The acceptable shank tolerance is h8.