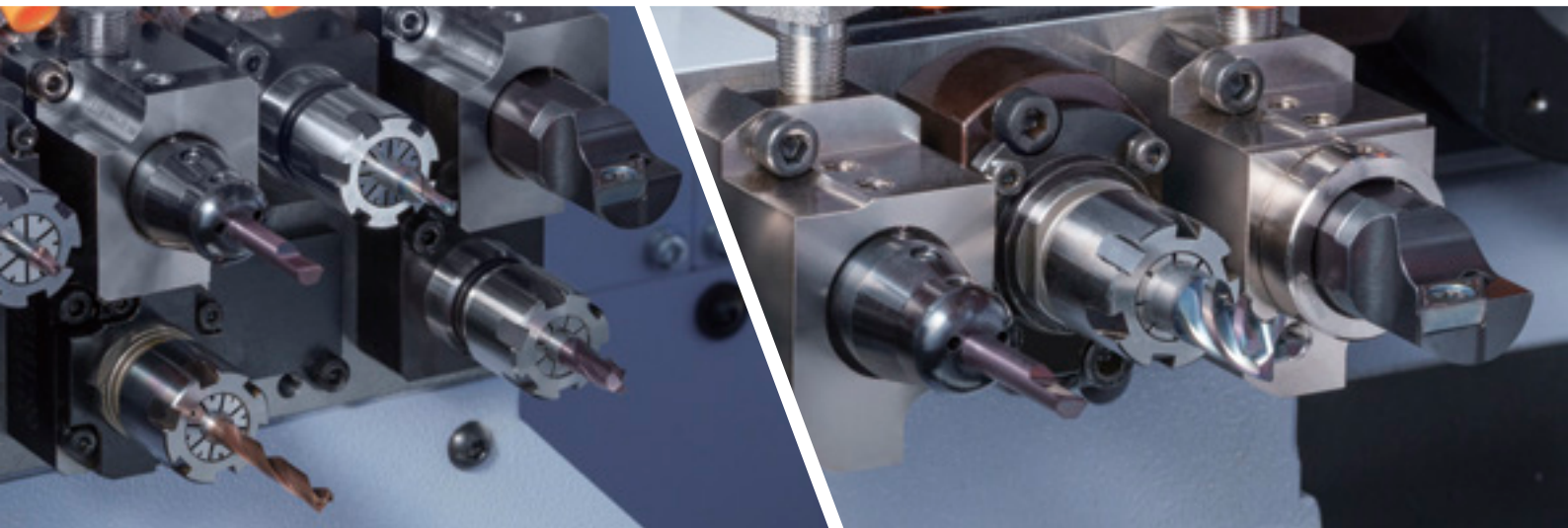


Sub-spindle holders

**NEW**

New sub-spindle holders for back side machining

New sub-spindle holders provide high rigidity and accuracy

4A-HA type for 4-spindle tool post with unique centre height adjustment mechanism

Easy adjustment by simply rotating the adjustable sleeve with excellent adjustment accuracy

Suppresses vibration by increasing rigidity

Supports internal coolant.



For Star Micronics Co., Ltd. Machines

**KEEPS YOU
AHEAD**



Back machining tool for Star Micronics Co., Ltd.'s machines

Sub-spindle holders

Highly rigid and supports internal coolant
Holders with a centre height adjustment mechanism are available

1 Line-up: Holders for 4- and 8-spindle tool post styles

For 4-spindle tool post

For 8-spindle tool post



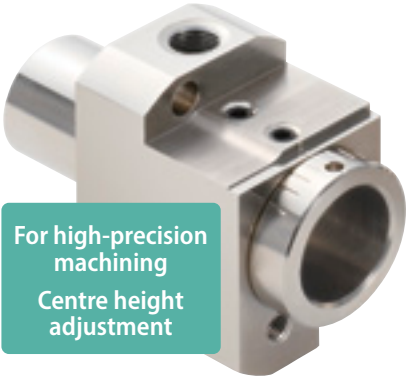
4A-HA type



4A type



8A type



2 Features

Feature 1

*Only the 4A-HA type for 4-spindle tool post supports the center height adjustment mechanism.

Adjustable sleeve enables easy adjustment of the center height.

Provides superior adjustment accuracy.

Feature 2

Supports internal coolant.

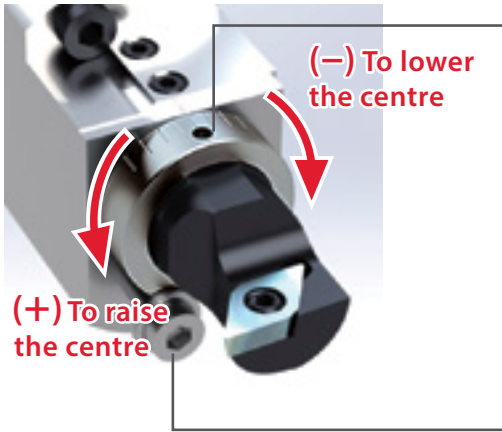
Feature 3

For large shank diameter tools.
High rigidity enhances chattering resistance and provides stable machining.

Easy and accurate centre height adjustment

Adjustable sleeve makes it easy to adjust the center height
Easy to operate with excellent adjustment accuracy

Centre height adjustment per scale
(Internal evaluation)

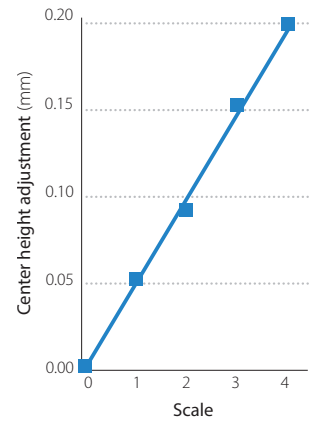


Scale of adjustable sleeve



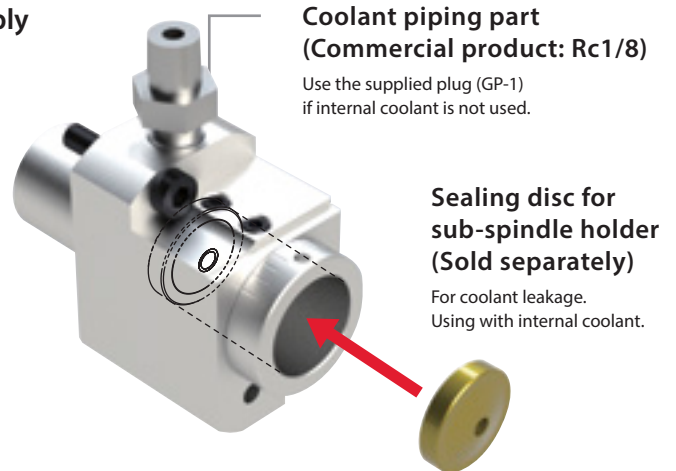
Adjust the scale of the adjustable sleeve to the reference position of the body
(Centre height adjustment range : $\pm 0.2\text{mm}$)
Please check the machining diameter after adjusting the center height.

Screw for temporarily fixing adjustable sleeve
• Temporarily fix after adjusting centre height
• Remove before machining



Supports internal coolant

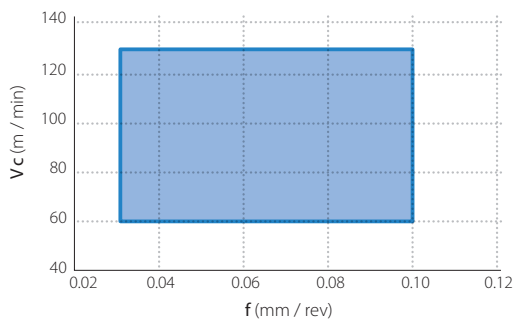
Accelerates chip evacuation and supports extended tool life
Special sealing discs provide more stable coolant supply



High rigidity enhances chatter resistance

Increased rigidity for tools with large shank diameter
Suppresses chattering and provides stable machining under a wide range of cutting conditions

Cutting condition range for stable machining (No chattering)

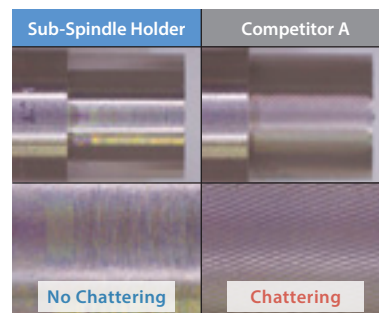


Cutting conditions: $V_c = 60 \sim 130 \text{ m/min}$, $f = 0.03 \sim 0.10 \text{ mm/rev}$, $a_p = 2.0 \text{ mm}$,
Wet, SUS304 SF22H-SH20-4A-HA S20K-SDUCL11 DCGT11T302MFP-SK

No chattering and good machining sound in a wide range of cutting conditions.

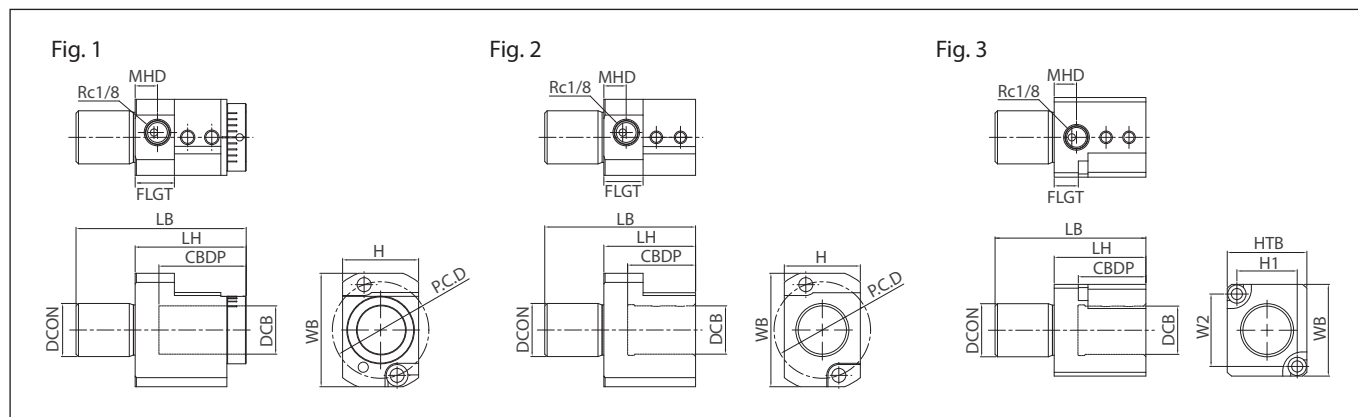
Work surface after machining was also good.

Chattering Resistance Comparison (Internal Evaluation)



Cutting conditions: $V_c = 100 \text{ m/min}$, $f = 0.05 \text{ mm/rev}$, $a_p = 2.0 \text{ mm}$
Wet, SUS304

Tool holders



Description	Availability	Tool post type	Centre height adjustment	Dimensions (mm)													Shape
				CBDP	DCB	DCON	FLGT	H	H1	HTB	LB	LH	WB	W2	P.C.D	MHD	
SF22F-SH20-4A-HA	●	4-spindle tool post	Yes	36.2	20	22	16.3	31.5	-	-	70.5	46	47	-	40	9.3	Fig. 1
SF22F-SH20-4A	●		-	28.2							62.5	38					Fig. 2
SF22F-SH20-8A	●	8-spindle tool post	-	28.2	20	22	10	-	25	33	62.5	38	38	30	-	9.3	Fig. 3

● : Available

Parts

Description	Parts								
	Holder body	Adjustable sleeve	Screw	Screw	Wrench	Plug	Screw	Wrench	Disc
SF22F-SH20-4A-HA									
SF22F-SH20-4A	-	-	-						
SF22F-SH20-8A	-	-	-	-	-	-			-

Sub-spindle holders compatible machines Referenced the general catalogue of Star Micronics Co., Ltd.

(4-spindle tool post) SP-20, SR-20JII(A) / 10J(C) / SB-16III, SB-12/16/20Rseries, SR-32JIII(A)

(8-spindle tool post) SV-20R, SW-20 / 12RII, SD-26(S / C / E / G), SR-38(B) / 20RIV(A / B), SR-32JIII(B)/20JII(B), SL-10

Precautions! 1: Be careful not to interfere with nearby tools. 2: Depending on the shape of the workpiece, special chucks may be required. 3: You may need to change the limits (soft limits) on the machine. 4: A short wrench is required for close proximity. 5: When the sub-spindle holders for 8-spindle tool post are mounted up and down on the tool post, the internal coolant cannot be used at the lower part. 6: When the sub-spindle holders for 4-spindle tool post is attached to the upper part of 8-spindle tool post, other tools cannot be attached to the lower part.

