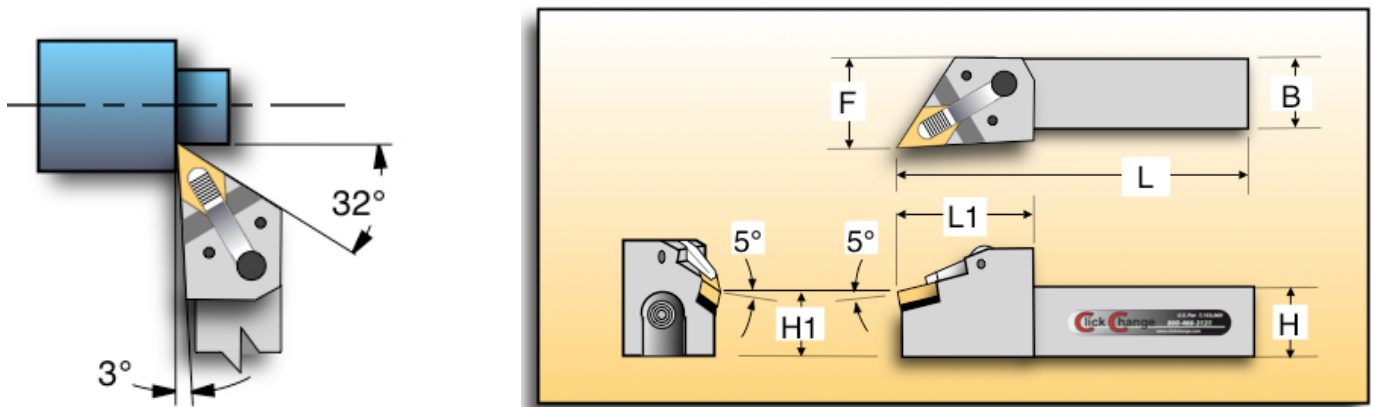


DDJNR/L - DNMG, 55° Diamond



Metric Sizes				Dimensions in Millimeters									
Catalog Number		Gage Insert		H	B	H1	L	F	L1	Shim	Options		
Right Hand	Left Hand			Shank Height ±.10	Shank Width ±.15	Insert Height ±.08	Overall Length ±.08	Tip Offset ±.08	Head Length ±.15		Coolant Head	Parts List	
DDJNR-2020J-15 <input type="checkbox"/>	DDJNL-2020J-15 <input type="checkbox"/>	DDJNR-2020K-15 <input checked="" type="checkbox"/>	DDJNL-2020K-15 <input checked="" type="checkbox"/>	DNMG 15 04 08	20.00	20.00	20.00	110.00	30.00	46.00	IDSN-433	CHM-1006	PLM-1006
DDJNR-2525K-15 <input type="checkbox"/>	DDJNL-2525K-15 <input type="checkbox"/>	DDJNR-2525M-15 <input checked="" type="checkbox"/>	DDJNL-2525M-15 <input checked="" type="checkbox"/>	DNMG 15 04 08	25.00	25.00	25.00	125.00	30.00	46.00	IDSN-433	CHM-1006	PLM-1006
DDJNR-3225P-15 <input checked="" type="checkbox"/>	DDJNL-3225P-15 <input checked="" type="checkbox"/>			DNMG 15 04 08	32.00	25.00	32.00	170.00	30.00	46.00	IDSN-433	CHM-1006	PLM-1006

■ Normally Stocked □ Special Order

Inch Sizes				Dimensions in Inches									
Catalog Number		Gage Insert		H	B	H1	L	F	L1	Shim	Options		
Right Hand	Left Hand			Shank Height ±.004	Shank Width ±.006	Insert Height ±.003	Overall Length ±.003	Tip Offset ±.003	Head Length ±.006		Coolant Head	Parts List	
DDJNR-124B <input type="checkbox"/>	DDJNL-124B <input type="checkbox"/>	DDJNR-124C <input checked="" type="checkbox"/>	DDJNL-124C <input checked="" type="checkbox"/>	DNMG-432	0.750	0.750	0.750	4.50	1.200	1.865	IDSN-433	CHE-1006	PLE-1006
DDJNR-164C <input type="checkbox"/>	DDJNL-164C <input type="checkbox"/>	DDJNR-164D <input checked="" type="checkbox"/>	DDJNL-164D <input checked="" type="checkbox"/>	DNMG-432	1.000	1.000	1.000	5.00	1.200	1.865	IDSN-433	CHE-1006	PLE-1006
DDJNR-204D <input checked="" type="checkbox"/>	DDJNL-204D <input checked="" type="checkbox"/>			DNMG-432	1.250	1.250	1.250	6.00	1.460	1.865	IDSN-433	CHE-1006	PLE-1006
DDJNR-244D <input type="checkbox"/>	DDJNL-244D <input type="checkbox"/>			DNMG-432	1.500	1.500	1.500	6.00	1.750	1.865	IDSN-433	CHE-1006	PLE-1006

■ Normally Stocked □ Special Order

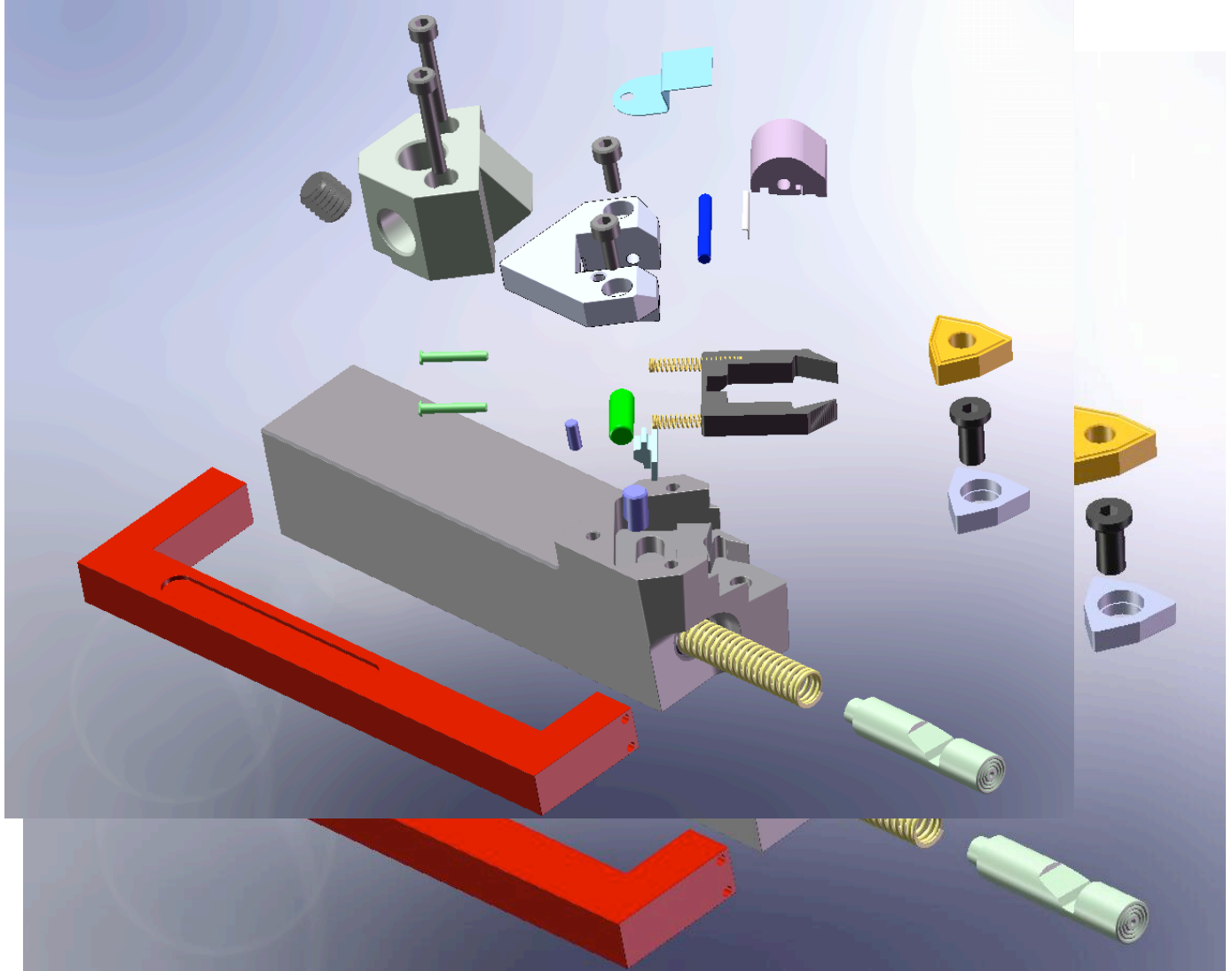
Revised 4/04/08

Click Change **Disassembly & Assembly Instructions**

U.S. Patent 7153069 other US & foreign patents pending
Specifications are subject to change without notice

DDJNR/L Tool Holder Disassembly

Follow Steps 1 through 6.



DDJNR/L Insert Repeatability

This test shows the insert repeatability of the Click Change tool holder. The test is performed using a standard gauge insert in a metrology environment. The insert is manually removed and manually replaced for each reading using the same insert tip. Each measurement is recorded in the table below for each of the three axes. A standard production Click Change tool holder is used for the test, and similar results may be expected using any production tool. Measurements are taken with a Mititoyo Digimatic Indicator model ID-F, and recorded to a resolution of .00005". The gauge R&R error is +/- .00005.

Repeatability Test Results (inches)

	Height	Width	Length
Avg. Value	1.00317	1.20456	5.01808
Std. Deviation	0.00003	0.00005	0.00007
Maximum Val	1.00320	1.20460	5.01815
Minimum Val	1.00310	1.20445	5.01800
Total Variation	0.00010	0.00015	0.00015

Measurement Data (inches)

No.	Height	Width	Length
1	1.00310	1.20445	5.01800
2	1.00320	1.20455	5.01815
3	1.00315	1.20460	5.01800
4	1.00315	1.20460	5.01815
5	1.00320	1.20455	5.01815
6	1.00320	1.20450	5.01810
7	1.00315	1.20460	5.01810
8	1.00315	1.20455	5.01800
9	1.00315	1.20455	5.01815
10	1.00320	1.20460	5.01800

Insert Repeatability <.00015" <.004 mm.

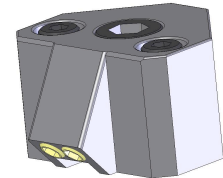
DDJNR/L Machining Test Cuts

These examples show some actual test cutting conditions for the Click Change Tool Holder. They are not intended to show the limits of the tool. The important measurements here are the depth of cut, the feed rate, and the material being cut. These three parameters determine the cutting forces that the tool holder will see. Increasing the cutting speed, will require more horsepower, but has little or no effect on the forces seen by the insert or the tool holder. In general, it is the machine rigidity, the insert composition and coating, and the coolant type and delivery method that limit the metal removal rate. The tool holder is not usually the "Weak Link".

	Test 1		Test 2	
Material	347 Stainless		Inconel 625	
Feed Rate	.010 in.	0.26 mm	.010 in.	0.26 mm
Depth of Cut	.150 in.	3.8 mm	.100 in.	2.5 mm
Diameter	1.0 in.	25.4 mm	1.25 in.	31.75 mm
Speed	450 SF/M	135 M/M	225 SF/M	67.5 M/M
RPM	1720	1720	685	685

DDJNR/L - DNMG, 55° Diamond

All prices are in US Dollars



Metric Tool Holders					
Tool Holder Catalog Number					
Right Hand	Left Hand	List Price	Weight (Lbs.)		
DDJNR-2020J-15	DDJNL-2020J-15	\$389.50	0.96		
DDJNR-2020K-15	DDJNL-2020K-15	\$389.50	0.96		
DDJNR-2525K-15	DDJNL-2525K-15	\$399.50	1.89		
DDJNR-2525M-15	DDJNL-2525M-15	\$399.50	1.89		
DDJNR-3225P-15	DDJNL-3225P-15	\$429.50	2.45		

Metric Parts		
Accessories & Parts (Applies to all sizes)		
Description	Part Number	Price
Coolant Head	CHM-1006	\$124.00
Shim Kit	SK-1006M	\$15.50
Clamp Kit	CK-1006M	\$74.50
Cam Rod Kit	RK-1006	\$22.50

Inch Tool Holders					
Tool Holder Catalog Number					
Right Hand	Left Hand	List Price	Weight (Lbs.)		
DDJNR-124B	DDJNL-124B	\$389.50	0.88		
DDJNR-124C	DDJNL-124C	\$389.50	0.98		
DDJNR-164C	DDJNL-164C	\$399.50	1.55		
DDJNR-164D	DDJNL-164D	\$399.50	1.83		
DDJNR-204D	DDJNL-204D	\$429.50	2.75		
DDJNR-244D	DDJNL-244D	\$469.50			

Inch Parts		
Accessories & Parts (Applies to all sizes)		
Description	Part Number	Price
Coolant Head	CHE-1006	\$124.00
Shim Kit	SK-1006	\$15.50
Clamp Kit	CK-1006	\$74.50
Cam Rod Kit	RK-1006	\$22.50

DDJNR/L Individual Parts Price List

Part Number	Qty/ Tool	Description	Price Each																
AT-1006	0	Assembly Tool	\$34.50																
AX-1002	1	Axle	\$5.50																
BD-1006-xxx	1	Body (specify size)	\$235.70																
CL-1006	1	Clamp	\$54.30																
CR-1006	1	Cam Rod	\$25.60																
CS-1006	2	Clamp Spring	\$13.75																
DS-1002	1	Drive Spring	\$13.80																
FS-1006	1	Front Shield	\$9.10																
LB-1001	1	Adhesive Label	\$4.50																
LR-1006	1	Lock Roller	\$9.80																
PS-1006	1	Piston	\$7.30																
RS-1006	1	Rear Shield	\$18.60																
SHCS-M3x8	3	Socket Head Cap Screw (M3 x 8)	\$4.00																
HSSE-6X.125	2	Socket Head Set Screw (M3 x 4)	\$4.00																
SP-1006	2	Spring Pin	\$6.50																
SR-1006	1	Shim Retainer	\$15.50																
IDSN-432	1	Carbide Shim	\$8.50																
Coolant Head Parts																			
CH-1006	1	Coolant Head	\$120.00																
HSSM-3x20	2	Attachment Screws	\$8.00																
NZ-1006	2	Nozzle																	

