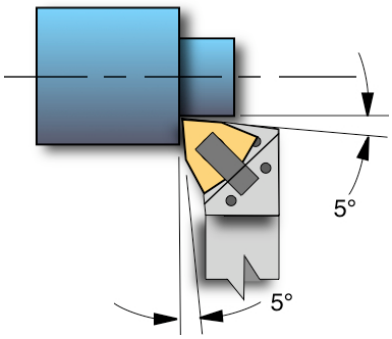
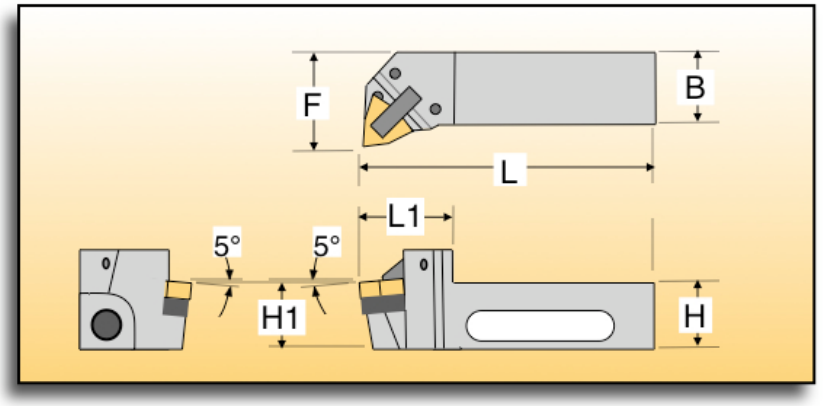
Click Change Lathe Tool Holders

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

DWLNR/L - WNMG, 80° Trigon

This tool is designed for primarily turning applications where facing operations if needed are relatively light.
Our GWLNR/L is recommended where heavy facing is required.





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	
DWLNR-2025K-08	■	DWLNL-2025K-08	■	WNMG 08 04 08	20.00	25.00	20.00	125.00	30.00	30.00	IWSN-433	CHM-1002	PLM-1002	
DWLNR-2525M-08	■	DWLNL-2525M-08	■	WNMG 08 04 08	25.00	25.00	25.00	150.00	32.00	32.00	IWSN-433	CHM-1002	PLM-1002	
DWLNR-3225P-08	■	DWLNL-3225P-08	■	WNMG 08 04 08	32.00	25.00	32.00	170.00	32.00	32.00	IWSN-433	CHM-1002	PLM-1002	

■ 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	
DWLNR-124B	☐	DWLNL-124B	☐	WNMG-432	0.750	0.750	0.750	4.50	1.188	1.188	IWSN-433	CHE-1002	PLE-1002	
DWLNR-124C	■	DWLNL-124C	■	WNMG-432	0.750	0.750	0.750	5.00	1.188	1.188	IWSN-433	CHE-1002	PLE-1002	
DWLNR-164B	■	DWLNL-164B	☐	WNMG-432	1.000	1.000	1.000	4.50	1.250	1.250	IWSN-433	CHE-1002	PLE-1002	
DWLNR-164C	■	DWLNL-164C	■	WNMG-432	1.000	1.000	1.000	5.00	1.250	1.250	IWSN-433	CHE-1002	PLE-1002	
DWLNR-164D	■	DWLNL-164D	■	WNMG-432	1.000	1.000	1.000	6.00	1.250	1.250	IWSN-433	CHE-1002	PLE-1002	
DWLNR-204D	■	DWLNL-204D	■	WNMG-432	1.250	1.250	1.250	6.00	1.500	1.250	IWSN-433	CHE-1002	PLE-1002	
DWLNR-244D	☐	DWLNL-244D	☐	WNMG-432	1.500	1.500	1.500	6.00	1.750	1.250	IWSN-433	CHE-1002	PLE-1002	

■ Normally Stocked ☐ Special Order

Revised 4/04/08

Click Change Test Data

DWLNR/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	1.00158	1.25051	5.00028
Std. Deviation	0.00004	0.00006	0.00004
Maximum Val	1.00165	1.25060	5.00035
Minimum Val	1.00150	1.25045	5.00020
Total Variation	0.00015	0.00015	0.00015

Insert Repeatability	<.0002"	<.005 mm.

Measurement Data (inches)

No.	Height	Width	Length
1	1.00150	1.25045	5.00025
2	1.00155	1.25050	5.00020
3	1.00155	1.25055	5.00030
4	1.00160	1.25045	5.00025
5	1.00160	1.25050	5.00030
6	1.00160	1.25060	5.00025
7	1.00160	1.25060	5.00030
8	1.00155	1.25045	5.00035
9	1.00160	1.25045	5.00030
10	1.00165	1.25055	5.00030

DWLNR/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	.100 in.	2.5 mm	.080 in.	2.0 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

Revised 8/22/08

Click Change **Price List**

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DWLNR/L WNMG - 80° Trigon

All prices are in US Dollars

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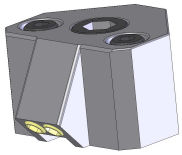

Metric Tool Holders

Tool Holder Catalog Number					
Right Hand	Left Hand	List Price	Weight (Lbs.)		
DWLNR-2025K-08	DWLNL-2025K-08	$375.50	0.92		
DWLNR-2525M-08	DWLNL-2525M-08	$389.50	1.85		
DWLNR-3225P-08	DWLNL-3225P-08	$419.50	2.3(est)		

Metric Parts

Accessories & Parts (Applies to all sizes)			
Description	Part Number	Price	
Coolant Head	CHM-1002	$124.00	
Shim Kit	SK-WNMG-4M	$23.50	
Clamp Kit (RH)	CK-WNMG-4RM	$54.50	
Clamp Kit (LH)	CK-WNMG-4LM	$54.50	
Cam Rod Kit	RK-1002	$19.95	

Inch Tool Holders

Tool Holder Catalog Number					
Right Hand	Left Hand	List Price	Weight (Lbs.)		
DWLNR-124B	DWLNL-124B	$375.50	0.84		
DWLNR-124C	DWLNL-124C	$375.50	0.94		
DWLNR-164B	DWLNL-164B	$389.50	1.34		
DWLNR-164C	DWLNL-164C	$389.50	1.51		
DWLNR-164D	DWLNL-164D	$389.50	1.79		
DWLNR-204D	DWLNL-204D	$419.50	2.68		
DWLNR-244D	DWLNL-244D	$449.50			

Inch Parts

Accessories & Parts (Applies to all sizes)			
Description	Part Number	Price	
Coolant Head	CHE-1002	$124.00	
Shim Kit	SK-WNMG-4	$23.50	
Clamp Kit (RH)	CK-WNMG-4R	$54.50	
Clamp Kit (LH)	CK-WNMG-4L	$54.50	
Cam Rod Kit	RK-1002	$19.95	

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DWLNR-164C	Height	Width	Length	
1	1.00385	1.24900	4.50205	
2	1.00380	1.24885	4.50230	
3	1.00380	1.24800	4.50245	
4	1.00385	1.24860	4.50250	
5	1.00385	1.24830	4.50225	
6	1.00380	1.24880	4.50245	
7	1.00390	1.24865	4.50250	
8	1.00380	1.24865	4.50250	
9	1.00385	1.24880	4.50250	
10	1.00385	1.24870	4.50250	
Variation	0.0000337474	0.0002903298	0.0001527525	
GWLNR-164C	Height	Width	Length	
1	0.99950	1.25295	4.99905	
2	0.99955	1.25310	4.99900	
3	0.99955	1.25305	4.99900	
4	0.99955	1.25310	4.99890	
5	0.99955	1.25305	4.99900	
6	0.99960	1.25290	4.99900	
7	0.99955	1.25305	4.99890	
8	0.99950	1.25305	4.99885	
9	0.99955	1.25310	4.99890	
10	0.99955	1.25325	4.99895	
Variation	0.0000283823	0.0000936898	0.0000643342	
DCLNR-164C	Height	Width	Length	
1	1.00150	1.25040	5.00025	
2	1.00155	1.25050	5.00020	
3	1.00155	1.25055	5.00030	
4	1.00160	1.25045	5.00025	
5	1.00160	1.25050	5.00030	
6	1.00160	1.25060	5.00025	
7	1.00160	1.25060	5.00030	
8	1.00155	1.25045	5.00035	
9	1.00160	1.25045	5.00030	
10	1.00165	1.25055	5.00030	
Variation	0.0000421637	0.000068516	0.0000421637	

DVJNR-163C	Height	Width	Length	
1	0.99905	1.24910	5.00105	
2	0.99905	1.24945	5.00100	
3	0.99915	1.24950	5.00085	
4	0.99915	1.24950	5.00090	
5	0.99915	1.24940	5.00100	
6	0.99915	1.24945	5.00090	
7	0.99915	1.24915	5.00095	
8	0.99915	1.24945	5.00095	
9	0.99920	1.24935	5.00100	
10	0.99915	1.24945	5.00085	
Variation	0.0000474342	0.0001418136	0.000068516	
DDJNR-164C	Height	Width	Length	
1	1.00065	1.20145	5.00335	
2	1.00070	1.20170	5.00335	
3	1.00065	1.20140	5.00330	
4	1.00070	1.20140	5.00335	
5	1.00075	1.20135	5.00340	
6	1.00075	1.20140	5.00345	
7	1.00075	1.20155	5.00355	
8	1.00075	1.20145	5.00340	
9	1.00075	1.20130	5.00345	
10	1.00075	1.20145	5.00345	
Variation	0.0000421637	0.0001116791	0.0000724569	