

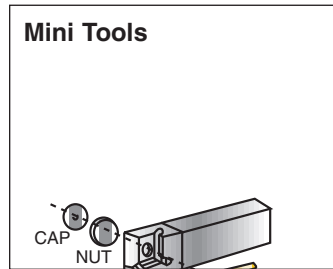
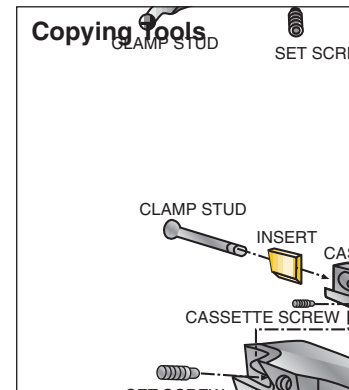
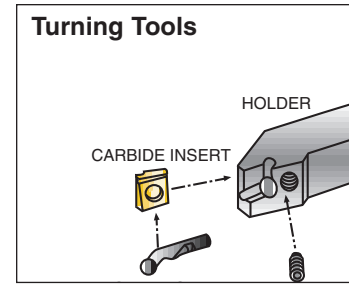
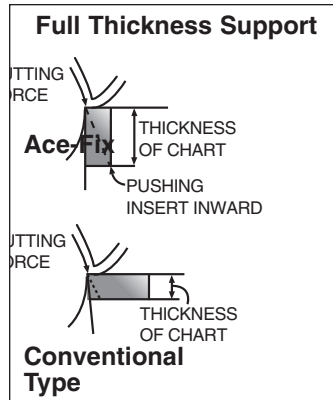
## Ace-Fix System

### FEATURES

Ace-Fix turning and profiling holders feature inserts which are clamped in the vertical position, providing the full depth of the insert for support. This eliminates the need for carbide support shims and utilizes the full strength of the insert.

Positive rake geometry and the lack of surface obstacles result in smooth chip flow. Eight cutting edges available on each insert reduce insert costs.

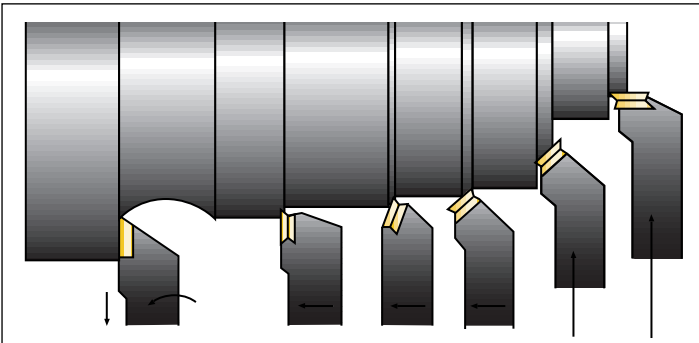
The "bent pin" insert locking Clamp Stud forces the insert back and into the insert pocket, virtually eliminating insert movement even when cutting forces are variable.



### MAXIMUM CUTTING CONDITIONS

The following graphs represent the feed rate and depth of cut ratio for Ace-Fix tooling. The graphs show max. Depth of Cut (D.O.C.) and max. feed rate, therefore optimum cutting conditions are within these ranges.

### TOOLING

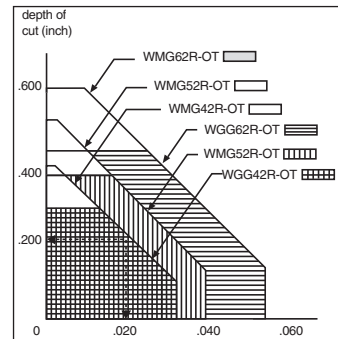


\*Note: Right hand tools shown.

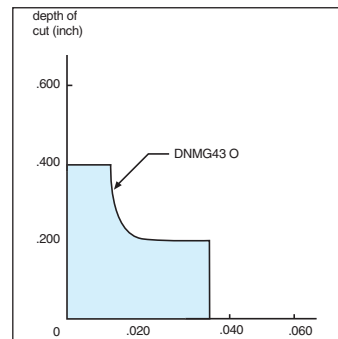
● Tool Holder	MDJNR164D	W21R W22R	W11R	W12R	W12R	W25R
● Insert	DNMG430	WGG○○○ (O.D. Turning)	WGG○○○ (O.D. Turning)	WGG○○○ (Facing)	WGG○○○ (Facing)	WGG○○○ (Facing)
		WMG○○○ (O.D. Turning)	WMG○○○ (O.D. Turning)	WMG○○○ (Facing • O.D. Turning)	WMG○○○ (Facing)	WMG○○○ (Facing)

- NOTE: 1) WGG style has 8 cutting edges, WMG style 4 cutting edges.  
 2) When using holders W12R/L, right hand holder takes left hand insert and left hand holder takes right hand insert.  
 3) When using holder W12R/L, WGG style inserts are used only for facing applications, while WMG style inserts are used for facing and O.D. turning applications.  
 4) When using holder W12R/L for facing applications, maximum insert nose radius is 1/64.

### TURNING



### COPYING



### GRADES

Inserts are stocked in five grades:  
 Coated: AC720, AC325  
 Uncoated: ST20E, A30, G10E

General Info

Negative Inserts

Positive Inserts

Ace-Fix Inserts

Threading, Grooving, & Cut-Off Inserts

Ceramic Inserts

PCBN & PCD Inserts

Toolholders

Swiss Toolholders

Boring Bars

Technical Info

ALMT