

Part-off Tool for Automatic Lathes ——ACD 1.5 series

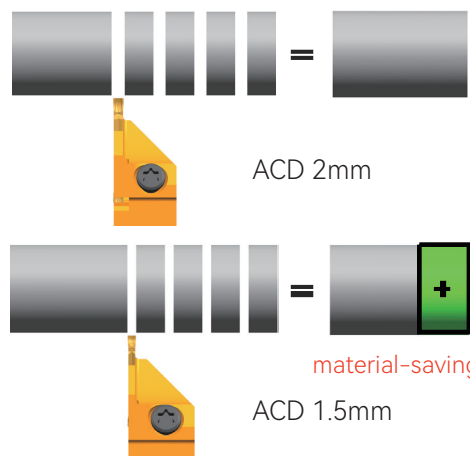
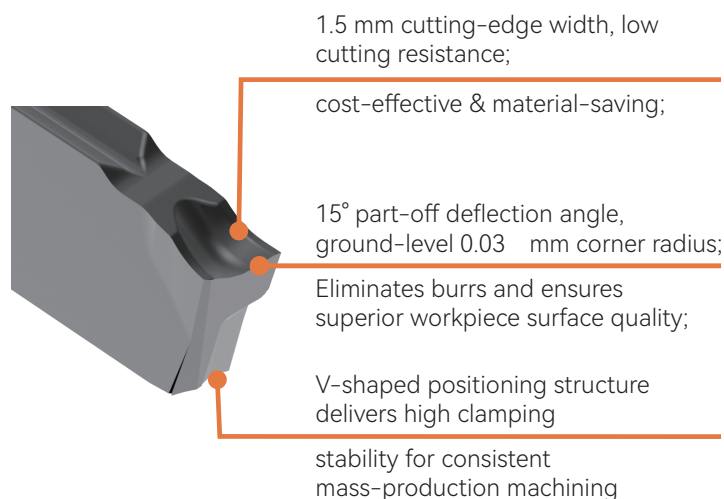


Economical, Stable &
High-efficiency Part-off Machining

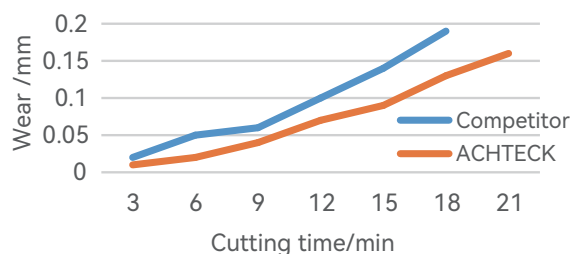
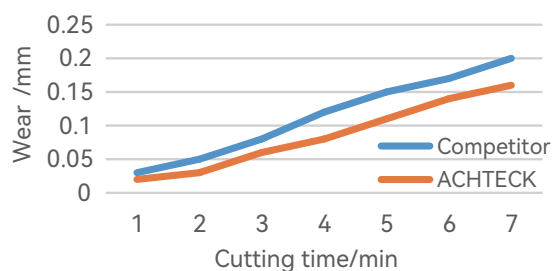


ACD 1.5 Series Part-Off Tools: Material-saving and cost-effective. Tool life increased by up to 50%, with per-piece cost directly reduced by 25%. It enables faster, more economical and more stable parting-off machining.

Product Features



Performance Test

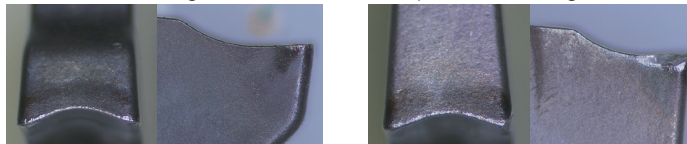


ACHTECK-Cutting time 35.2min Competitor-Cutting time 26.7min



Material: 4140
Insert: ACD 1.5015-CS AP301U
Parameters: $V_c=76\text{m/min}$, $f=0.05\text{mm/rev}$, $a_p=7\text{mm}$

ACHTECK-Cutting time 22.8min Competitor-Cutting time 18.6min

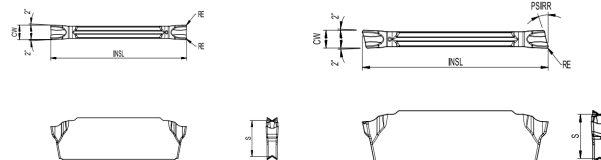


Material: SUS304
Insert: ACD 1.5015-CS AP301U
Parameters: $V_c=52\text{m/min}$, $f=0.04\text{mm/rev}$, $a_p=5.5\text{mm}$

Application & Cutting Parameters

Material	Steel					Stainless Steel				
Maching field	Finishing ← → Roughing					Finishing ← → Roughing				
ISO	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40
Application		AP301U					AP301U			
			AP330M					AP330M		

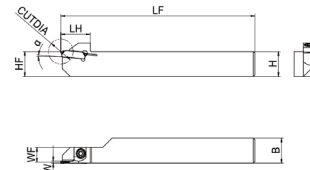
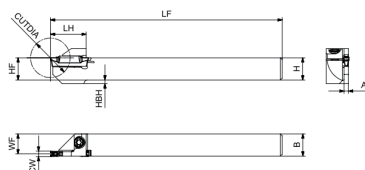
Insert List



Product code	Cutting Data Recommendation		Dimensions/mm					Grades	
	CDX	f (mm/rev)	CW	RE	INSL	S	PSIRR	AP301U	AP330M
ACD 1.5015-CS	16.0	0.02-0.10	1.5	0.15	16.70	3.7	-	●	●
ACD 1.5003-CS	16.0	0.01-0.09	1.5	0.03	16.45	3.7	-	●	●
ACD 1.5015-CS-15R	16.0	0.01-0.09	1.5	0.15	16.70	3.7	15°	●	●
ACD 1.5015-CS-15L	16.0	0.01-0.09	1.5	0.15	16.70	3.7	15°	●	●
ACD 1.5003-CS-15R	16.0	0.01-0.09	1.5	0.03	16.45	3.7	15°	●	●
ACD 1.5003-CS-15L	16.0	0.01-0.09	1.5	0.03	16.45	3.7	15°	●	●

● - Stock available ○ - Made to Order

Tool-holder List



Product code		Dimensions/mm							
		H	B	HF	A	LF	LH	WF	CUTDIA
ATSER/L	1010-1.5D16-SW	10	10	10	1.2	125	18	9.4	16
	1010-1.5D20-SW	10	10	10	1.2	125	18	9.4	20
	1212-1.5D16-SW	12	12	12	1.2	125	19	11.4	16
	1212-1.5D24-SW	12	12	12	1.2	125	19	11.4	24
	1616-1.5D16-SW-C (Sub-spindle)	16	16	16	1.2	125	27	9.4	16

Application Case

Product code	ACD 1.5015-CS AP330M
Mchined Parts	OA-shaft 
Material	SUS304
Cutting Speed	62.8 m/min
Feed Rate	0.03 mm/rev
Cutting Depth	4 mm
Coolant	Oil
Result	Competitor ACHTECK 0500010000 ACD 1.5 delivers stable machining, achieving an 40% increase in tool life.

Product code	ACD 1.5015-CS-15R AP301U
Mchined Parts	Shaft-type Component 
Material	304L
Cutting Speed	42 m/min
Feed Rate	0.03 mm/rev
Cutting Depth	1.5 mm
Coolant	Oil
Result	Competitor ACHTECK 020004000 ACD 1.5 delivers stable machining, achieving an 50% increase in tool life.

Product code	ACD 1.5015-CS AP301U
Mchined Parts	Automotive Transmission Shaft 
Material	20CrMnTi
Cutting Speed	115 m/min
Feed Rate	0.035 mm/rev
Cutting Depth	1.0 mm
Coolant	Oil
Result	Competitor ACHTECK 020004000 ACD 1.5 delivers stable machining, achieving an 30% increase in tool life.

Product code	ACD 1.5015-CS AP301U
Mchined Parts	Shaft-type Component 
Material	303、304
Cutting Speed	100 m/min
Feed Rate	0.015 mm/rev
Cutting Depth	10 mm
Coolant	Oil
Result	Competitor ACHTECK 0100020003000 ACD 1.5 delivers stable machining, with a 25% reduction in per-part cost at equivalent tool life.