



Hydro Base Holder

for CNC lathes

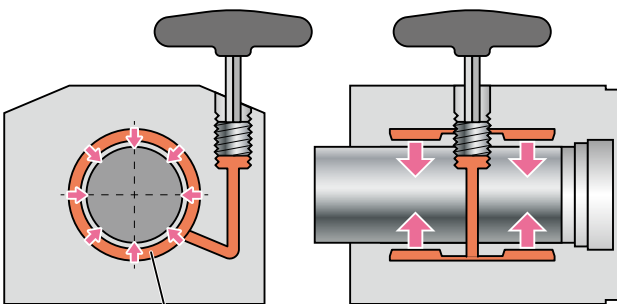


A high-precision holder that maximizes machining quality and tool life on CNC lathes.

- Achieving high-precision hole machining
- Reducing tool abnormal wear
- Damping chatter during boring machining

Hydraulic chucking with high precision and vibration damping effect!

■ : Oil Chamber



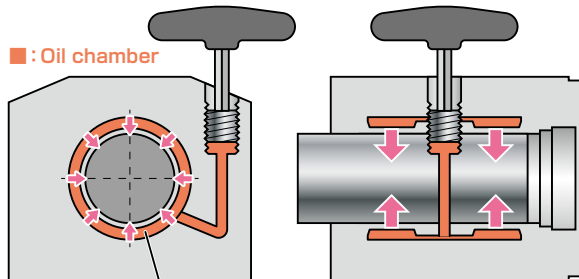
The entire inner diameter contracts to grip the cutting tool tightly, ensuring no misalignment!



Features of Hydro Base Holder

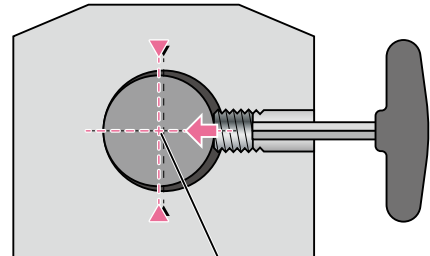
- Repetitive mounting precision: less than $2\mu\text{m}$
- No misalignment in tool mounting *High precision processing is possible.

Hydro Base Holder



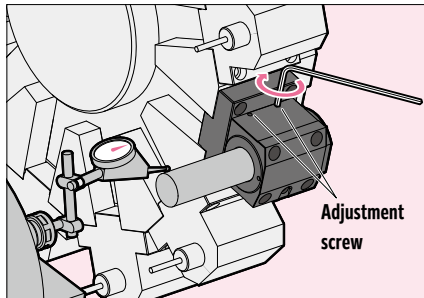
The entire inner diameter contracts to grip the cutting tool tightly, ensuring no misalignment!

Conventional side lock

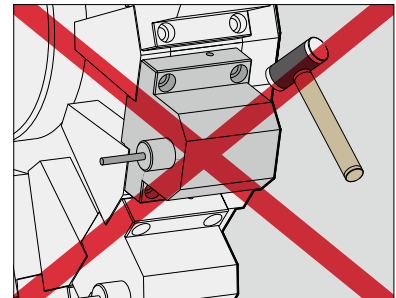
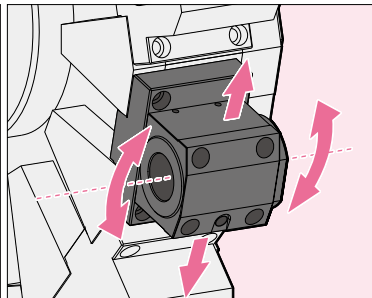


Pushing from the side causes the blade to misalign.

- Core alignment with just one wrench! ~Adjustable core misalignment and y-axis tilt to less than 0.01mm ~



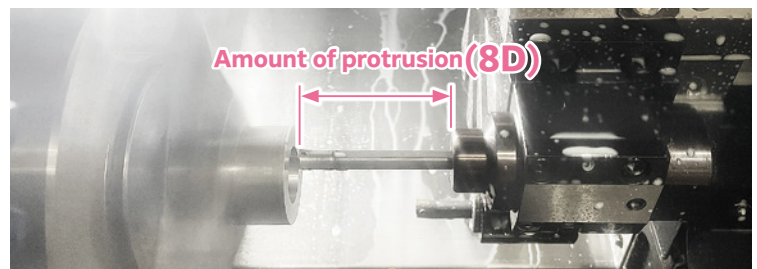
By simply adjusting the adjustment screw on the side of the body, you can correct the alignment and tilt in the Y-axis direction!



You no longer need to strike the cutting tool holder with a hammer to align the core!

Achieve machining with boring bar protrusions of up to 8D! (Vibration-proof effect)

Work material	S45C
Tool	Carbide $\phi 10$ boring bar
Machining diameter	$\phi 23\text{mm}$
Cut depth	0.5mm
Feed rate	0.1mm/rev
Cutting speed	150m/min
Coolant	Exterior application (water-soluble)

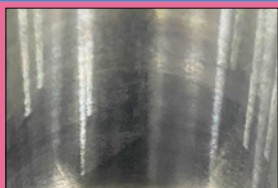


Cutting surface comparison

Hydro Base Holder

Protrusion amount

L/D=8



Boring Holder

Protrusion amount

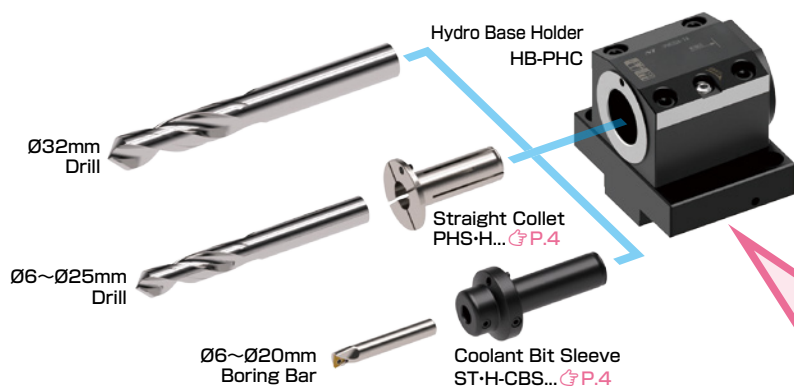
L/D=5



Boring bar protrusion amount L/D

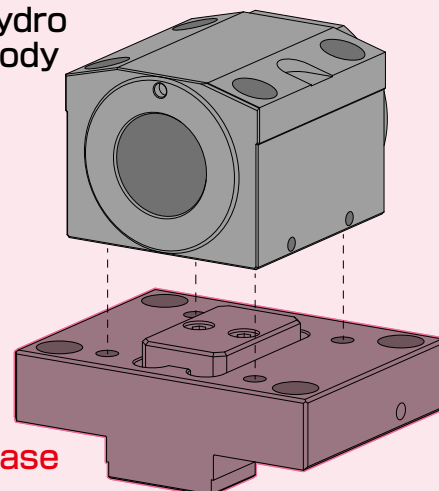
4	5	6	7	8	9	10
✓	✓	✓	✓	✓	* A little rough	✗
✓	✗	✗	✗	✗	✗	✗

List of cutter and accessory combinations



Base unit is sold separately.

Hydro
Body



Base

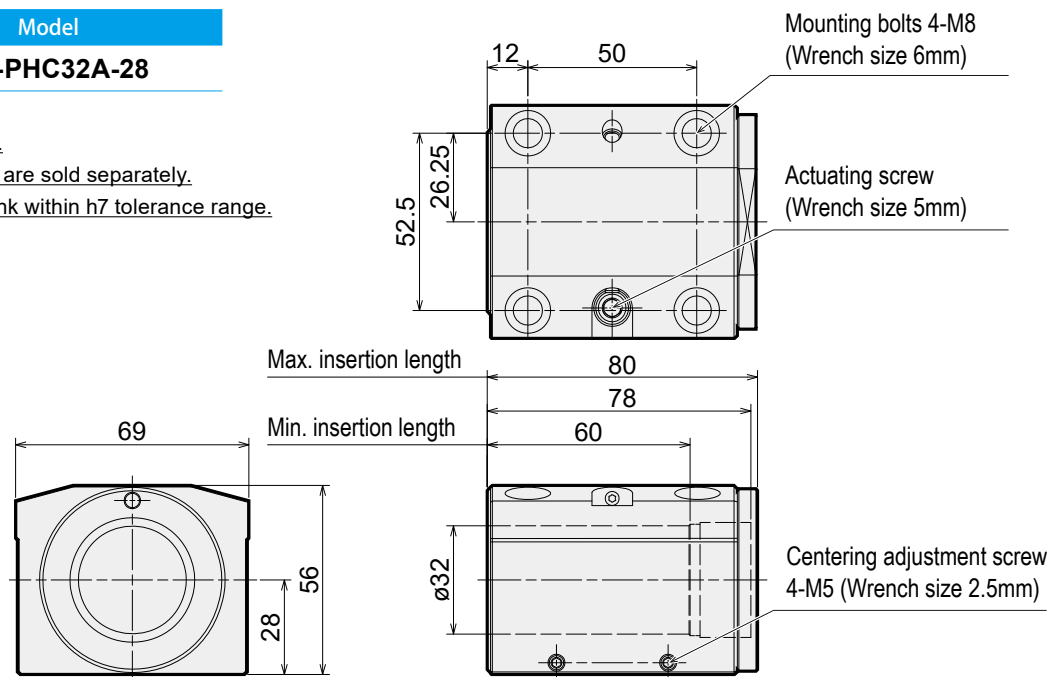
Base unit must be designed to match the machine.

Please prepare the detailed drawing for the machine side base installation and contact NT TOOL.

HB-PHC Holder Body

Code	Model
6670 00032028	HB-PHC32A-28

- Mounting bolts are included.
- Base and various wrenches are sold separately.
- Please use cutters with shank within h7 tolerance range.



Torque Check Gauge TG

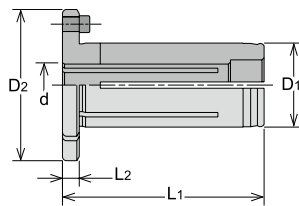
Code	Model	Supported holder model
2584 70000032	TG-PHC32H	HB-PHC32A-28



If the Torque check gauge can't be rotated with your fingers, there is no loss of gripping force.

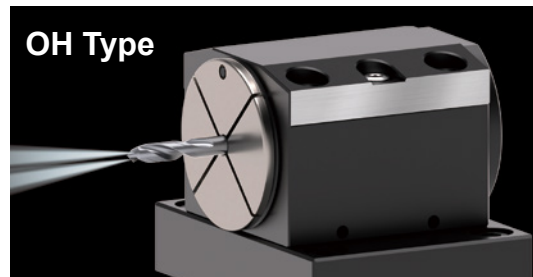
Collet with stopper pin for PHS·H

Coolant compatible collets.



OH type : For cutter with oil hole

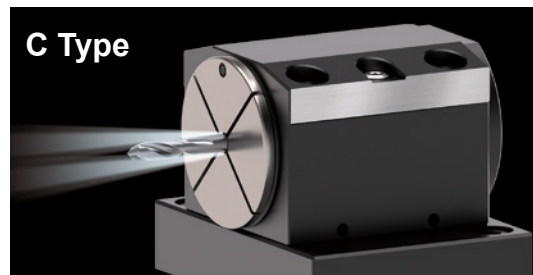
Code	Model	D1	D2	L1	L2	d
2584 300532※※	PHS32H - d - OH	32	55	72	4	6, 8, 10, 12, 16, 20, 25



C type : For collet through coolant

Code	Model	D1	D2	L1	L2	d
2584 300632※※	PHS32H - d - C	32	55	72	4	6, 8, 10, 12, 16, 20, 25

- Specify the inner diameter size in the **d** part of the model number. (No need to align the digits.)
- The ※※ in the code is followed by the inner diameter size in two digits.

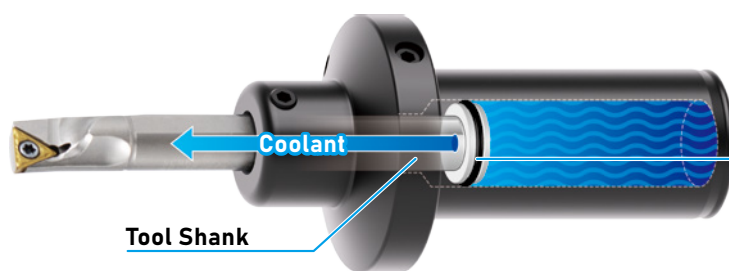


Min. Clamping length of cutter						
Collet I.D. d	6, 8	10, 12	16	20	25	
Min. Clamping length	29	40	45	50	55	

Ordering Example

PHS32H - 6 - OH
Shank size I.D. Type

Coolant Bit Sleeve ST·H-CBS



Seal stopper (PAT.P)

Pushed by coolant pressure and adheres to the tool shank end face to prevent coolant leakage from the tool shank flat!

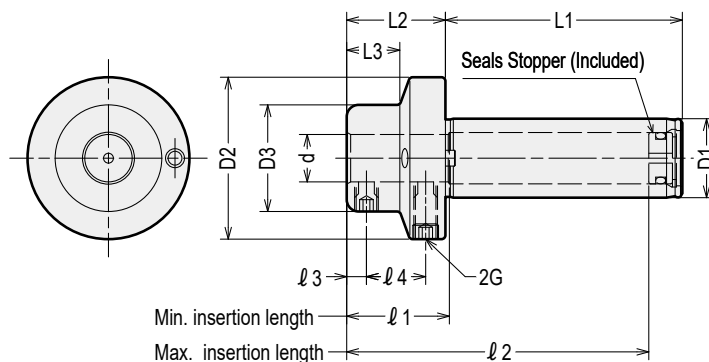
Comparison Video



Prevents coolant leakage from tool shank! Efficient coolant supply to I.D. of the workpiece!



- No decrease in coolant pressure at cutting edge
- Improved chip removal



- Maximum coolant pressure: 0.5~7MPa
- Cutters must be inserted at least the minimum insertion length. If the minimum insertion length is not met, the seal stopper will not function and coolant will leak.

商品コード	型式	d	D1	D2	D3	L1	L2	L3	l1	l2	l3	l4	G
6674 03206000	ST32H - CBS06R	6	32	55	27	70	25	10.9	26	86	5	15	M5
6674 03208000	ST32H - CBS08R	8	32	55	27	70	30	14.9	30	91	5	20	M6
6674 03210000	ST32H - CBS10R	10	32	55	27	70	30	14.9	30	91	5	20	M6
6674 03212000	ST32H - CBS12R	12	32	55	27	70	35	19.9	35	96	5	25	M6
6674 03216000	ST32H - CBS16R	16	32	55	34	70	40	26.2	40	101	5	30	M6
6674 03220000	ST32H - CBS20R	20	32	55	40	70	40	25.3	40	97	6	28	M8

Ordering Example

ST32H - CBS06R
Shank size I.D.

NT TOOL CORPORATION

CV202505

TECHNO MAIL technomail@nttool.co.jp For technical question, please contact us by technomail.

NT TOOL CORPORATION (HEAD OFFICE) : en.nttool.com
NT USA CORPORATION (OFFICE) : www.nttoolusa.com

NT TOOL EUROPE GmbH (OFFICE) : www.nttooleurope.com
NT TOOL THAI CO., LTD. (OFFICE) : nttoolthai.com

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