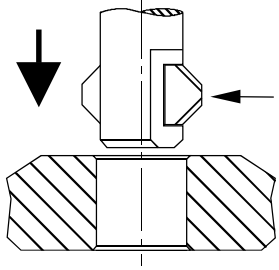
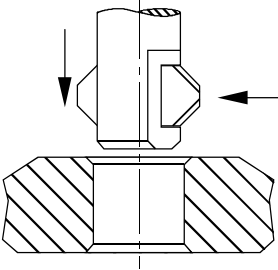
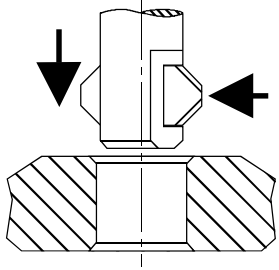
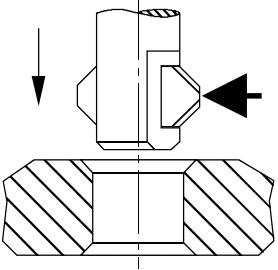


Getting the right chamfer with GH-S

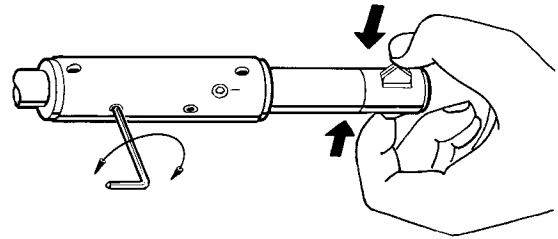
How to adjust the Chamfer Size

When working with the GH-S tool it is important to know that the chamfer size is affected by the material being machined, the feed rate, and the adjustable blade force. If the chamfer is too large or too small, the feed rate or blade tension can be adjusted to change the chamfer size.

	
<p>Small Chamfer</p> <ul style="list-style-type: none"> • small blade tension • high feed rate 	<p>Medium Chamfer</p> <ul style="list-style-type: none"> • small blade tension • low feed rate
	
<p>Medium Chamfer</p> <ul style="list-style-type: none"> • large blade tension • high feed rate 	<p>Large Chamfer</p> <ul style="list-style-type: none"> • large blade tension • low feed rate

How to adjust the Blade Tension

The blade tension is the force necessary to push the blades into the tool body. This force can be felt by hand when pushing on the blades. Increasing or decreasing the blade tension will change the chamfer size accordingly.



- Increase the chamfer size and the blade tension by turning the “**tension adjusting set screw**” clockwise.
- Decrease the chamfer size and the blade tension by turning the “**tension adjusting set screw**” counter-clockwise.

Adjusting the ØD2

The measurement across the blades does not effect the chamfer size and **must not be changed**.

- Do Not Adjust the ØD2
- Adjusting the ØD2 can result in tool or part damage.

See pages 17 & 18 for more information on setting up the tool.