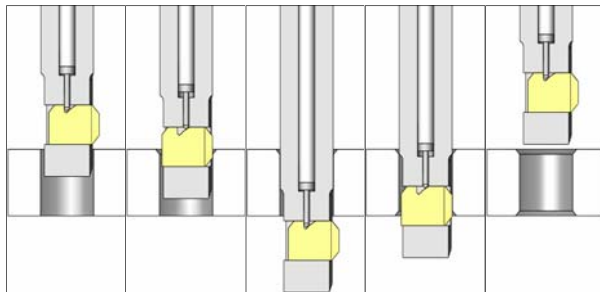
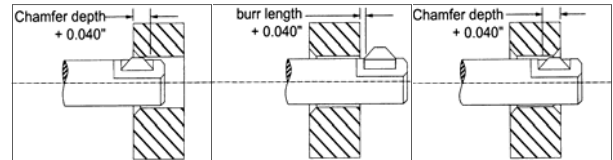


Programming Information:



- As the rotating tool is fed into the hole, the front cutting edge deburrs the top of the hole by cutting a 45° chamfer. As the tool feeds into the part the blade is forced into the body and slides in the blade window.
- When the blade is in the hole, only the ground gliding surface touches the surface protecting it from damage while the tool is fed through the part. There is no need to stop or reverse the spindle.
- When the blade reaches the back of the part the coiled spring acts with the control bolt to push it back out into cutting position. The back edge is deburred and chamfered as the tool is withdrawn. When the blade is again in the hole, the tool can be rapid fed out and on to the next hole.



Programming Information			
Typical Material	bhn	IPR	SFM
aluminum	30-180	0.006-0.012	210-400
iron	180	0.004-0.008	150-220
low carbon steel	100-200	0.004-0.008	150-210
med carbon steel	125-250	0.004-0.009	130-180
stainless steel	140-250	0.002-0.005	90-140
cast steel	200	0.003-0.007	100-150
titanium		0.001-0.003	20-50
free machining alloys		0.004-0.006	100-160

NOTE: When using a DEFA Geometry cutting blade, use .003 IPR MAX.

NOTE: Do NOT exceed 6000 RPM. Tool must be modified.