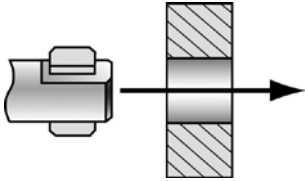
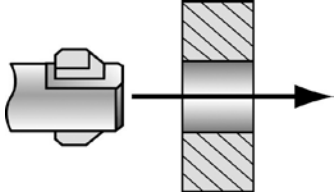
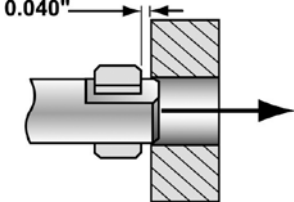
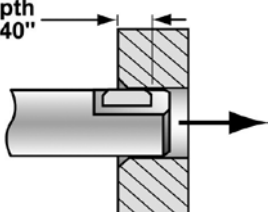
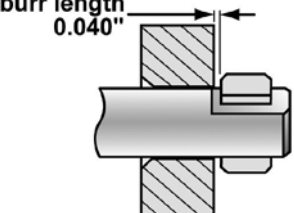
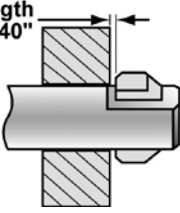
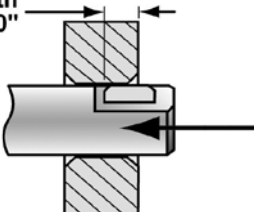
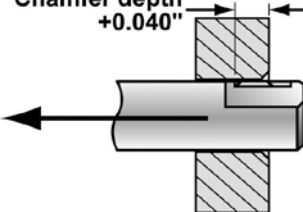
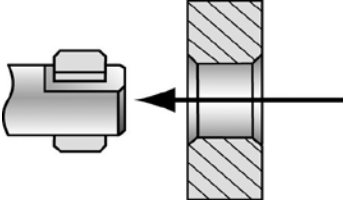
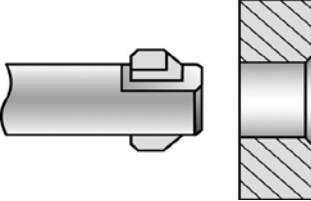


Programming Information

For Front & Back Chamfer		Back Chamfer Only
	<p>Step 1: See Feed and Speed chart on next page for proper parameters.</p>	
 <p>0.040"</p>	<p>Step 2: (Rapid into position) Move the tool with rapid feed into position with the front of the cutting blade 0.040" above the part.</p>	<p>N/A</p>
 <p>Chamfer depth 0.040"</p>	<p>Step 3: (Cut front chamfer) Machine the part with cutting feed (cf) and speed (cs). Feed into the part the chamfer depth +0.040" to ensure the blade has finished cutting.</p>	<p>N/A</p>
 <p>burr length 0.040"</p>	<p>Step 4: (Rapid to back) Move the tool through the part with rapid feed (rf) so the blade is 0.040" beyond the burr. The blade will not mark nor damage the through hole.</p>	 <p>burr length +0.040"</p>
 <p>Chamfer depth 0.040"</p>	<p>Step 5: (Cut back chamfer) Machine the part with back cutting feed (cf) and speed (cs). Feed into part the chamfer depth +0.040" to ensure the blade has finished cutting the back chamfer.</p>	 <p>Chamfer depth +0.040"</p>
	<p>Step 6: (Remove from the part) Remove the tool from the hole with rapid feed and proceed to the next hole. The blade will not mark nor damage the through hole.</p>	

While the DEFA tool is designed to handle almost any size of breakout burr, poor machining procedures may result in an excessively large, extruded burr which are extremely hard and difficult to machine. Timely replacement of dull drills and reamers as well as sufficient coolant supply can help control the burr size extending the life of the chamfer tool and improve chamfer quality.