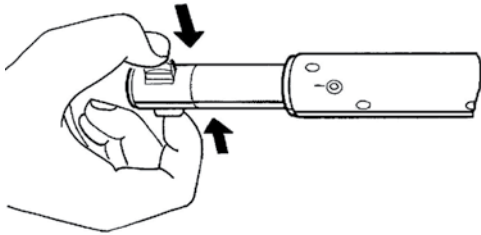


## Setting Blade Force

### How much Blade Force is enough?

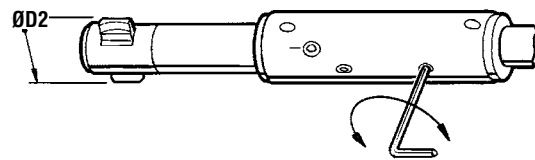
The blade force does not affect the chamfer size. The blade force merely ensures that the blades open to their full diameter after passing through the hole. It should be possible to press the blades into the tool easily with the fingers. When released, the blades should snap out to the diameter set as the ØD2.



### How to adjust the Blade Force

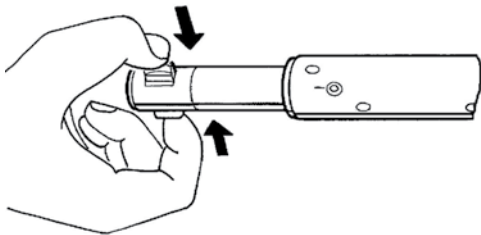
The tool body has a “tension screw” which can be used to adjust the force behind the blades. By turning this screw, the force will be increased or decreased.

- To increase the blade force, turn the “tension screw” clockwise.
- To decrease the blade force, turn the “tension screw” counter-clockwise.



### How to check the Blade Force

If the DEFA tools are being setup by various operators and consistency in setting the blade force is desired, the HEULE DPM3 Force Caliper Gage is recommended.



The HEULE DPM3 Force Caliper Gage is battery operated and uses a digital readout to display the force required to push the blades into the tool.

Using the DPM3 assures consistency in tool setup when several operators are using the same tooling.

When measuring with the DPM3, the recommended force is 8-12 newtons for the DEFA tools.



**DPM3 Order Number:**  
DPM3-US

### What do the screws do?

- 1) Clamping Screw (Blade Housing) – Holds the blade housing to the tool body. It must seat at the tapered pocket in the housing for maximum holding force.
- 2) Eccentric Cam – Disengages and engages the blade control pins from the blades making it possible to exchange the blades easily.
- 3) Set Screw (Chamfer adjusting) – Adjusts ØD2 setting and chamfer ØD. Turn clockwise to decrease chamfer, counter-clockwise to increase chamfer.
- 4) Tension Screw – Adjusts the force behind the blades. Turn clockwise to increase tension, counter-clockwise to decrease tension.
- 5) Clamping Screw (Shank) – Holds the shank to the tool body. It must seat in the tapered pocket in the shank for maximum holding force.

