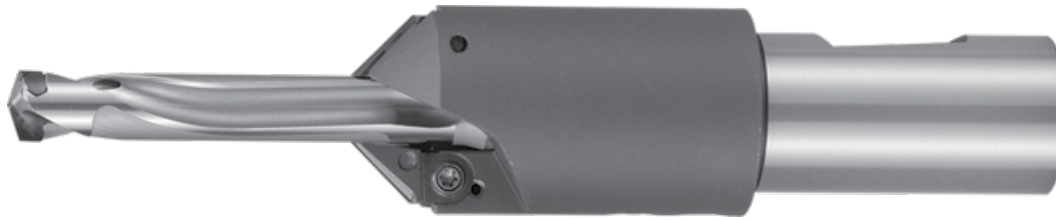


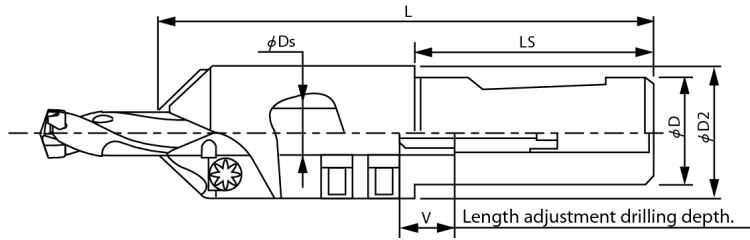
### Chamfering Attachment

● Drilling and chamfering simultaneously

By using the chamfering attachment, the SS-DRC can perform drilling and chamfering in one set up.

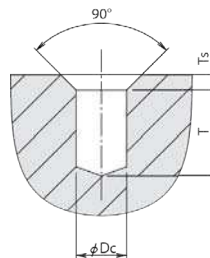


● Toolholder



Description	stock	Applicable Drill Dia.Ds	Dimensions(mm)					Applicable Insert
			ØD	ØD2	L	LS	V	
S20-CH10	○	10	20	29	122	52	17	CT08T2-45A
S32-CH12	○	12	32	38	133	62	21	CT12T3-45A
S32-CH14	○	14		40	137		16	
S32-CH16	○	16		42	141		19	
S32-CH18	○	18		47	144		15	

● Drilling and chamfering depths



● : Stock Standard  
○ : World Express

Cutting Dia.(inch)		Drilling depth(inch)						Chamfering dimension(inch)		Applicable Toolholder
ØDc		T(3×D)		T(5×D)		T(8×D)		Ts		
min	max	min	max	min	max	min	max	Ts 100	Ts max	
.3125	.3343	0.433	0.748	0.827	1.457	1.850	2.480	.0984	.1969	S20-CH10
.3346	.3539	0.472	0.827	0.945	1.575	2.008	2.638			
.3543	.3736	0.472	0.906	1.063	1.693	2.205	2.835			
.3740	.3933	0.512	0.984	1.220	1.850	2.402	3.031	.1378	.2756	S32-CH12
.3937	.4130	0.512	1.024	1.102	1.929	2.362	3.189			
.4134	.4327	0.551	1.102	1.220	2.047	2.520	3.346			
.4331	.4524	0.551	1.181	1.339	2.165	2.717	3.543	.1575	.3150	S32-CH14
.4528	.4720	0.591	1.260	1.457	2.283	2.874	3.701			
.4724	.4917	0.591	1.181	1.614	2.205	3.110	3.701			
.4921	.5114	0.669	1.260	1.732	2.323	3.268	3.780	.1575	.3150	S32-CH16
.5118	.5311	0.748	1.339	1.850	2.441	3.465	4.055			
.5315	.5508	0.827	1.417	2.008	2.598	3.661	4.252			
.5512	.5705	0.748	1.457	1.969	2.677	3.701	4.409	.1575	.3150	S32-CH18
.5709	.5902	0.827	1.535	2.087	2.795	3.858	4.567			
.5906	.6295	0.984	1.693	2.323	3.031	4.213	4.921			
.6300	.6689	1.181	1.732	2.598	3.150	4.606	5.157	.1575	.3150	S32-CH18
.6692	.7083	1.378	1.929	2.874	3.425	5.000	5.551			

Ts 100 : Max chamfering dimension at the full feed.  
Ts max : Max chamfering dimension at a 50% feed reduction.



Magic Drill DRC

Drilling