

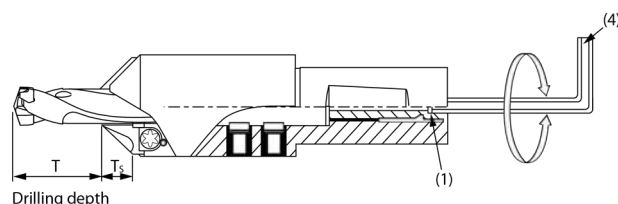
● Applicable Chamfering Insert

Shape		Description	Dimensions (mm)		PVD Coated	Applicable Toolholder
			W1	T	PR0315	
		CT08T2-45A	8	2.83	○	S20-CH10
		CT12T3-45A	12	3.98	○	S32-CH12 ~ S32-CH18

● : Stock Standard
○ : World Express

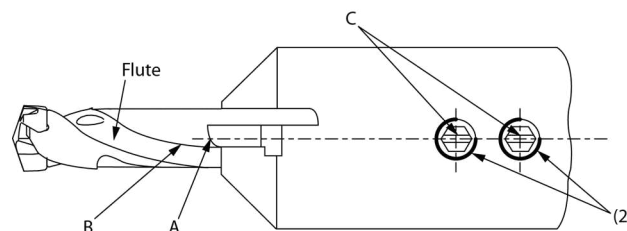
● Method to use DRC chamfering attachment

1. Drilling depth adjustment



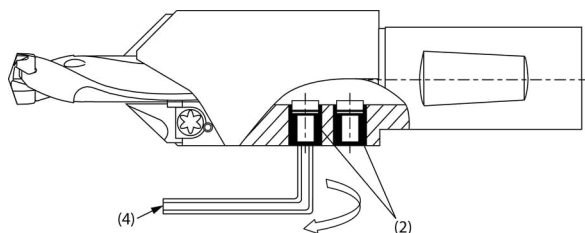
- Insert drill into chamfering attachment.
- Next, temporarily attach the chamfering insert A.
- Turn the adjusting screw (1) with the hexagon wrench (4) to set the drilling depth T.

2. Drill location check



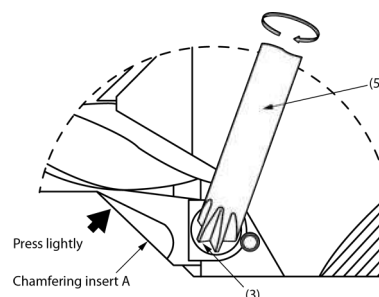
- Rotate the drill so that the lower end of the chamfering insert A is aligned with the body clearance B of the drill.
- Set it so that slot C and the drill fitting screws (2) are lined up as shown in the figure above.

3. Fix the drill



- Tighten the drill fitting screws (2) with the hexagon wrench (4). (In the case of using a torque wrench, then please refer to the table below.)

4. Installation of the chamfering insert



- Press the chamfering insert A lightly into the drill and tighten the insert mounting screw (3) with wrench (5).

Chamfering Attachment	Torque [Nm]	Adjusting Screw	Drill Fitting Screw	Insert Mounting Screw	Hexagon Wrench	Wrench
S20-CH10	10	AJ-6X38	FS-10	MT-3	LW-3	DT-9
S32-CH12	15	AJ-8X44-9.5	FS-12	MT-4		LW-4
S32-CH14	20	AJ-10X46	FS-14			
S32-CH16	30		FS-16			
S32-CH18	45		FS-18			



Magic Drill DRC

Drilling