

Method to change DRC Type Magic Drill Inserts

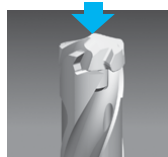
How to Attach Inserts



- 1) Fix drill holder on arbor. For insert exchange, fix arbor on the machine or set on tool presetter.
- 2) Remove dust using air blower.



- 3) Install insert onto holder.
(Use gloves to protect your hand from any danger.)



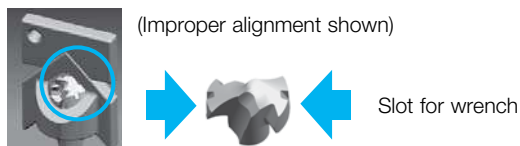
- 4) Turn lightly in a clockwise direction.
(Use gloves to protect your hand from any danger.)



- 5) Align the wrench properly with the insert.



- 6) Make sure the wrench is aligned with the wrench slots on the insert.



- 7) Turn the wrench in a slow clockwise direction.
- 8) Completed.

How to Detach Inserts



- 1) Remove dust from insert using air blower.
- 2) Align the wrench properly with the insert.



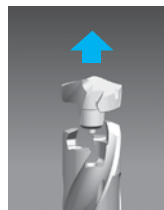
- 3) Make sure the wrench is aligned with the wrench slots on the insert.



- 4) Turn the wrench in a counterclockwise direction.

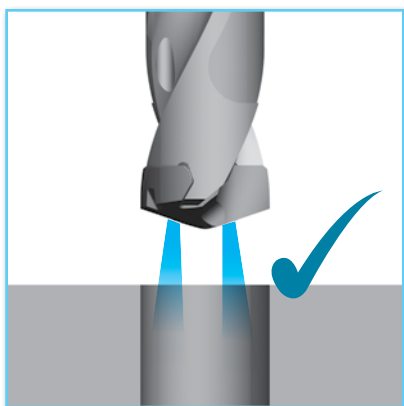


- 5) Once lock is released, insert can be turned by fingers.
(Use gloves to protect your hand from any danger.)



- 6) Remove insert.
(Use gloves to protect your hand from any danger.)

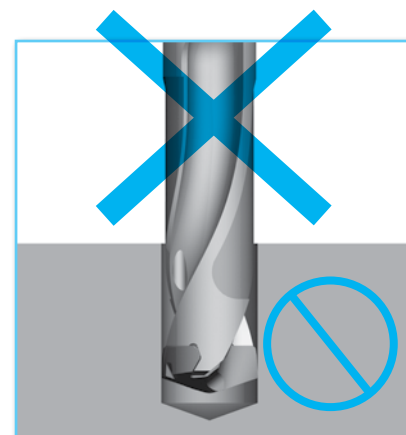
Coolant



- 1) Internal coolant is recommended.



- 2) In case of external coolant
Cutting depth must be 3xD or less.



- 3) Dry cutting is not recommended.



Magic Drill DRC

Drilling