

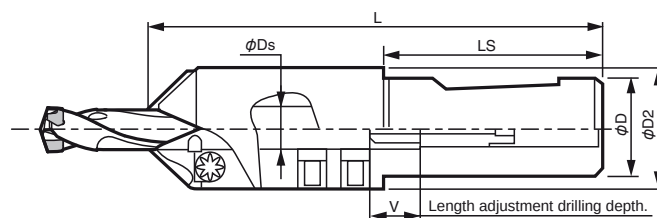
Chamfering attachment

- Drilling and chamfering simultaneously

By using the chamfering attachment, the SS-DRC type can perform drilling and chamfering in parallel.



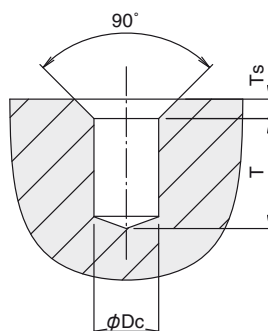
- Toolholder



Description	Std.	Applicable Drill Dia. ØDs	Dimension (mm)					Applicable Inserts
			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	

Note) Chamfering attachment is dedicated for Straight Shank SS-DRC type.
It cannot be used for Flanged Shank SF-DRC type.

- Drilling and chamfering depths



Cutting Dia. (mm)		Drilling depth (mm)						Chamfering dimension (mm)		Applicable Toolholders
øDc		T (3D Drill)		T (5D Drill)		T (8D Drill)		Ts		
min	max	min	max	min	max	min	max	Ts 100	Ts max	
ø7.94	ø8.49	11	19	21	37	47	63	2.5	5.0	S20-CH10
ø8.50	ø8.99	12	21	24	40	51	67			
ø9.00	ø9.49	12	23	27	43	56	72			
ø9.50	ø9.99	13	25	31	47	61	77			
ø10.00	ø10.49	13	26	28	49	60	81	3.5	7.0	S32-CH12
ø10.50	ø10.99	14	28	31	52	64	85			
ø11.00	ø11.49	14	30	34	55	69	90			
ø11.50	ø11.99	15	32	37	58	73	94			
ø12.00	ø12.49	15	30	41	56	79	94	4.0	8.0	S32-CH14
ø12.50	ø12.99	17	32	44	59	83	96			
ø13.00	ø13.49	19	34	47	62	88	103			
ø13.50	ø13.99	21	36	51	66	93	108			
ø14.00	ø14.49	19	37	50	68	94	112	4.0	8.0	S32-CH16
ø14.50	ø14.99	21	39	53	71	98	116			
ø15.00	ø15.99	25	43	59	77	107	125			
ø16.00	ø16.99	30	44	66	80	117	131			
ø17.00	ø17.99	35	49	73	87	127	141	4.0	8.0	S32-CH18

Ts 100: Max chamfering dimension at the full feed
Ts max: Max chamfering dimension at a 50% feed reduction
(Max chamfering dimension of machining possible without step feeding)

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)