

Method to change DRC type MagicDrill inserts

How to attach inserts



- ① Fix drill holder on arbor. For insert exchange, fix arbor on the machine of set on toolpresetter.
- ② Remove dust using air blow.



- 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.



(Improper alignment shown)



Slot for wrench



- ⑦ Turn the wrench in a slow counterclockwise 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.)



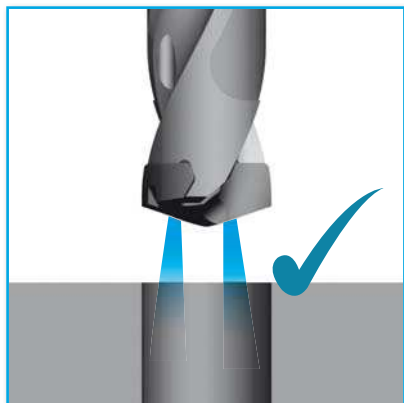
- ⑥ Remove insert.
(Use gloves to protect your hand from any danger.)

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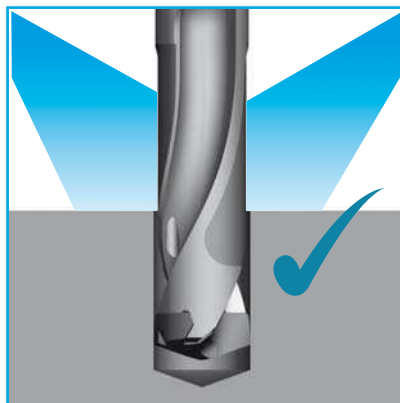


Drilling

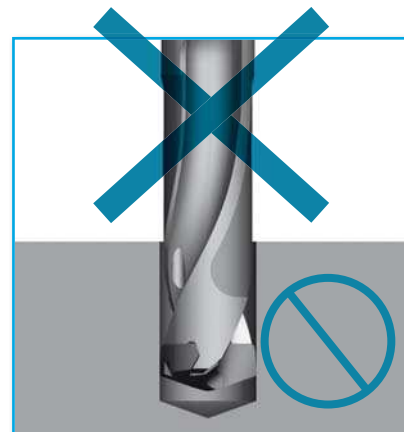
Coolant



- ① Internal coolant is recommended.



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



- ③ Dry cutting is not recommended.