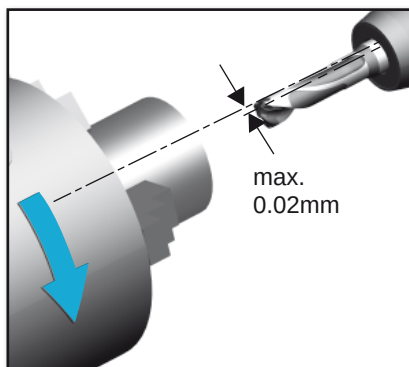


MagicDrill® DRC type

Precautions for use

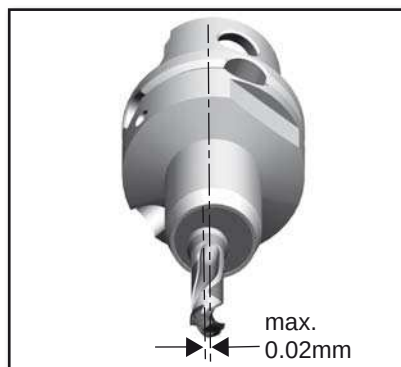
Core Deviation

1) If drill is stationary



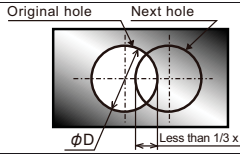
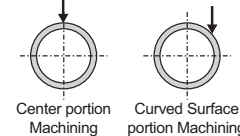
This is usable for boring sleeve (screw clamp) and coltachuck, please be sure to set deviation amount under 0.02mm between workpiece and drill.

2) If drill is rotating



Make sure to use arbor that is not deformed. Center of arbor deviation must be within 0.02mm.

Applicable workpiece

Application	Workpiece Shape	Caution for machining
Flat Surface		- Due to good chip control, step machining is not necessary for soft steel like SS400. - When machining SUS304, for hole depths of more than 2.5D, utilize the step machining process. - In order to have smooth chip removal, we recommend internal coolant.
Stacked Plates		Fix stacked plates securely to ensure they do not slip while machining.
Hole Expansion		If the overlap amount is less than $1/3 \times D$, machining is possible. 
Concave Surface		When machining concave holes, set the feed rates at half or less of continuous hole machining.
Pipe Material		- Hole machining above the centerline of the pipe is possible. - Do not machine on curved surface areas. 

Not recommended workpieces

Application	Workpiece Shape
Slanted Surface	

Application	Workpiece Shape
Half Cylindrical	

Application	Workpiece Shape
Cored Hole	