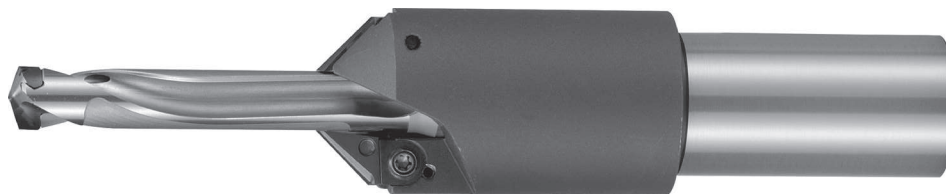


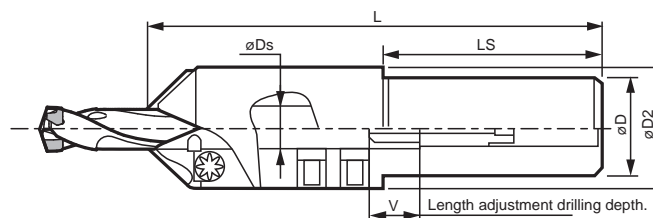
Chamfering attachment

● Drilling and chamfering simultaneously

By using the chamfering attachment, the SS-DRC type can drill and chamfer simultaneously.



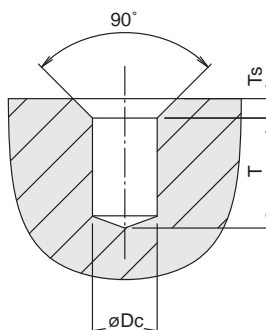
● Toolholder



Description	Std.	Applicable Drill Shank Dia. øDs	Dimensions (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)		Cutting 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	3.5	7.0	S32-CH12
ø10.00	ø10.49	13	26	28	49	60	81			
ø10.50	ø10.99	14	28	31	52	64	85			
ø11.00	ø11.49	14	30	34	55	69	90	4.0	8.0	S32-CH14
ø11.50	ø11.99	15	32	37	58	73	94			
ø12.00	ø12.49	15	30	41	56	79	94			
ø12.50	ø12.99	17	32	44	59	83	96	4.0	8.0	S32-CH16
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-CH18
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	4.0	8.0	S32-CH18
ø17.00	ø17.99	35	49	73	87	127	141			

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