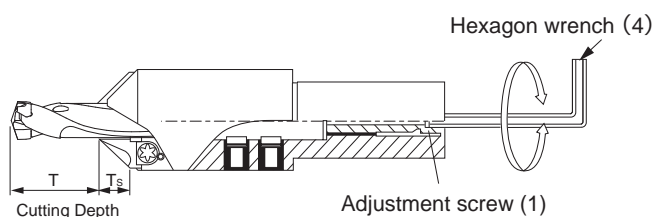


● Applicable chamfering Inserts

Insert		Description	Dimensions (mm)		PVD Coated Carbide PR0315	Applicable Toolholders
			W1	T		
		CT08T2-45A	8	2.83	●	S20-CH10
		CT12T3-45A	12	3.98	●	S32-CH12 S32-CH18

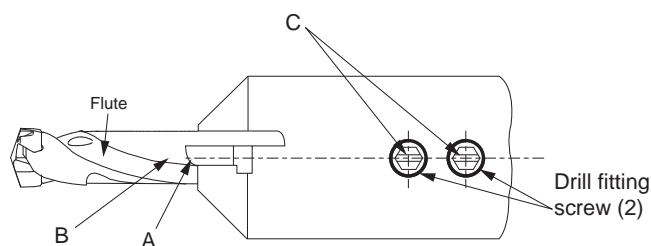
● Method to use DRC chamfering attachment

I. Drilling depth adjustment



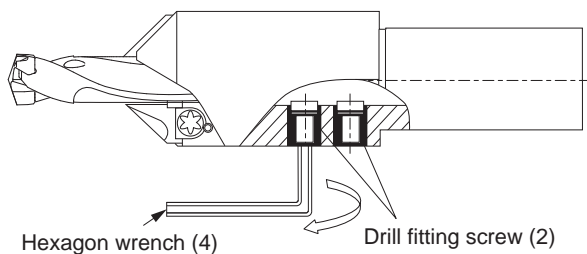
Insert drill into chamfering attachment.
Next, temporarily attach the chamfering insert A.
Turn the adjusting screw (1) with the hexagon wrench (4) to set the drilling depth T.

II. Drill location check



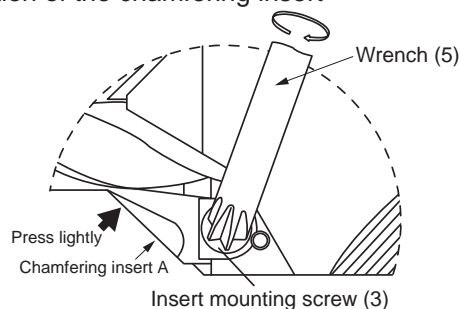
Rotate the drill so that the lower end of the chamfering insert A is aligned with the body clearance B of the drill.
Set it so that slot C and the drill fitting screws (2) are lined up as shown in the figure above.

III. Fix the drill



Tighten the drill fitting screws (2) with the hexagon wrench (4).
(In the case of using a torque wrench, then please refer to the table below)

IV. Installation of the chamfering insert



Press the chamfering insert A lightly into the drill and tighten the insert mounting screw (3) with wrench (5).

Chamfering attachment	Tightening Torque [Nm]	Adjusting screw (1)	Drill fitting screw (2)	Insert mounting screw (3)	Hexagon wrench (4)	Wrench (5)
S20-CH10	10	AJ-6x38	FS-10	MT-3	LW-3	DT-9
S32-CH12	15	AJ-8x44-9.5	FS-12	MT-4		LW-4
S32-CH14	20	AJ-10x46	FS-14			
S32-CH16	30		FS-16			
S32-CH18	45		FS-18			

● : Std. Item □ : Check Availability