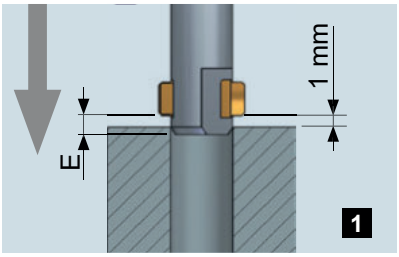
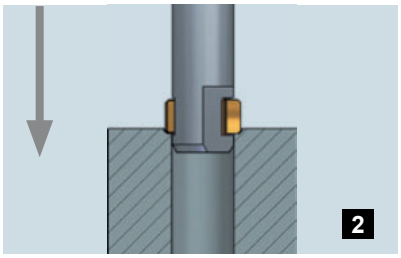
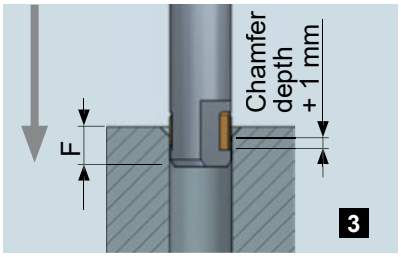
Programming Information DEFA



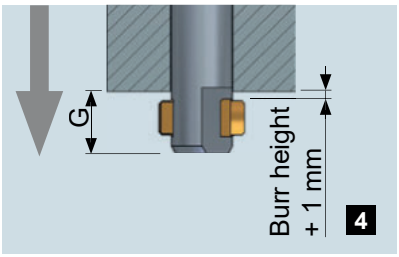
It is not necessary to change the sense of rotation nor to stop the spindle during the whole process. First, rapid traverse of the tool blade above the top material surface of bore or burr.



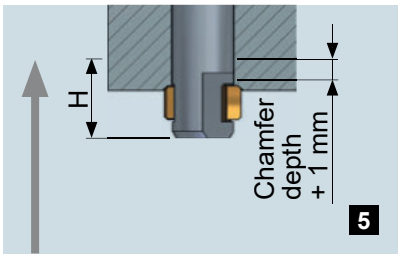
First, the burr of the front bore edge is being removed in working feed. Then, continue in working feed to apply the requested chamfer.



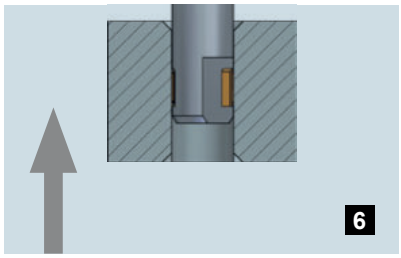
Continue in working feed 1.0 mm farther than the chamfer until the blade is fully retracted.



In rapid traverse and without stopping the spindle, you can travel through the hole without damaging its surface. Travel with the blade 1.0 mm behind the back bore edge and possible burrs.



In back working feed the backward chamfer is executed. Proceed with the blade 1.0 mm farther than the planned chamfering depth.



Once the blades are fully retracted, exit in rapid traverse to the next bore.

Dimension Table to Programming Information

Tool	E	F	G	H
DEFA 4-6	0.8	3.4	6.0	3.4
DEFA 6-10	0.8	1.8+(0.5B)	1.8+B+1.0	1.8+(0.5B)
DEFA 9-24	2.0	3.0+(0.5B)	3.0+B+1.0	1.8+(0.5B)