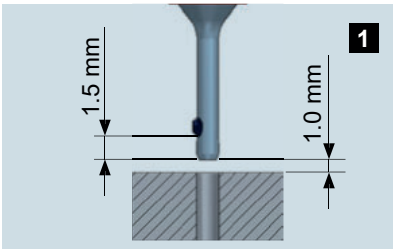
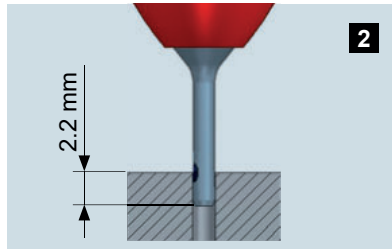


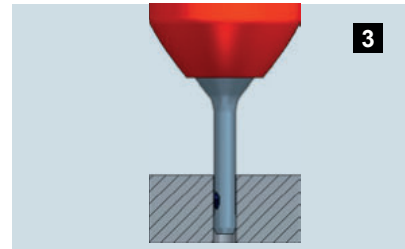
## Programming information



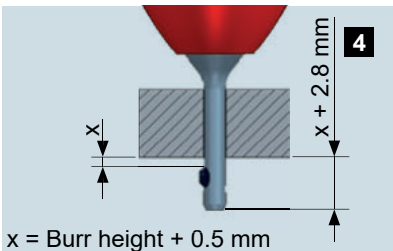
The DL2 tool must be used in **counter-clockwise rotation**. During the entire machining process, neither a change in the direction of rotation nor a stopping of the spindle is necessary. The tool cutting edge is positioned in rapid feed above the front of the hole to be deburred.



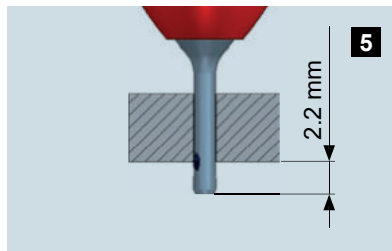
At working feed, the edge is deburred on the front edge of the hole until the blade has fully retracted.



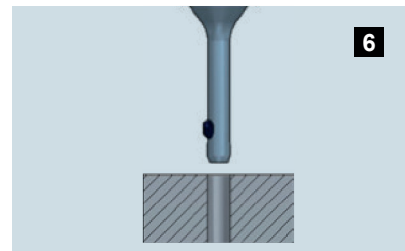
In rapid / increased feed, the tool passes through the workpiece without damaging the surface.



Position the blade 0.5 mm deeper than the existing burr to safely reach the new starting position.



In working feed, the hole on the underside of the workpiece is deburred. The blade should travel 0.5mm further than the deburring size.

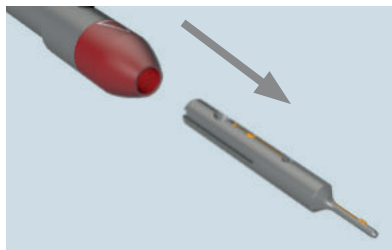


Move out of the workpiece in rapid feed and move to the next hole.

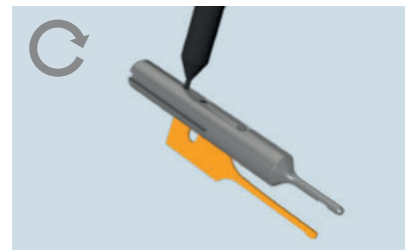
## Blade change



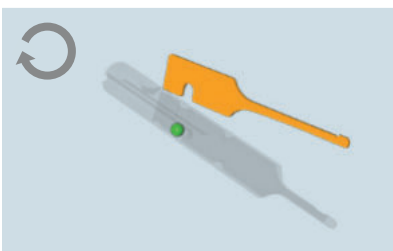
Loosen the clamping screw with the supplied Torx wrench.



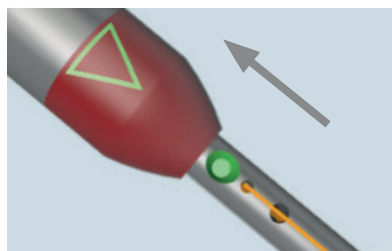
Carefully pull the blade housing out of the main body.



Insert a small pointed instrument through the hole on the underside of the blade housing. This lifts the blade out of its housing enabling easy removal.



Insert the new blade from above, paying attention to the positioning ball.



Slide the blade housing back into the tool body. The arrow on the coolant sleeve is aligned with the bore of the clamping screw.



To complete the blade change, tighten the clamping screw using the Torx wrench.