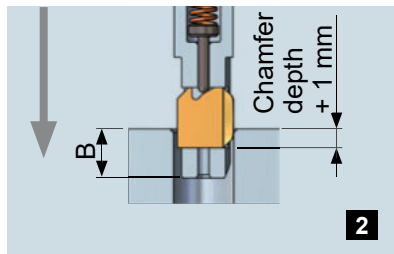
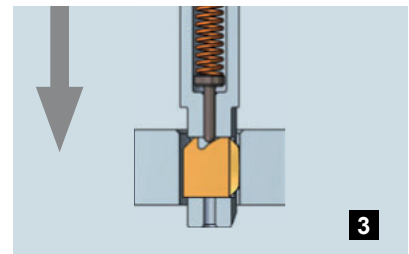


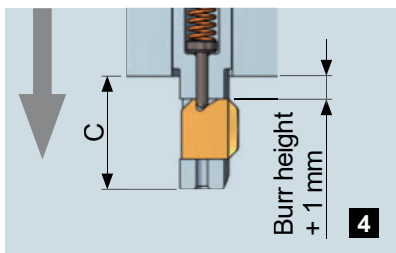
It is not necessary at all to change the sense of rotation or to stop the spindle during the whole process. First, rapid traverse of the tool blade above the top material surface of bore or burr.



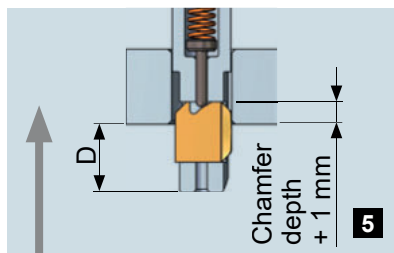
To generate the front chamfer continue in working feed until the blade is completely retracted into the tool.



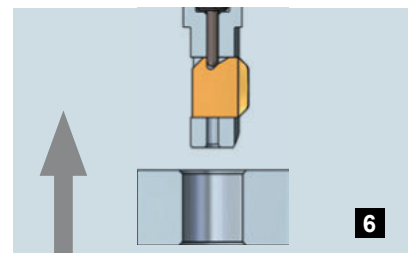
Rapid traverse through the hole. The surface of the hole cannot be damaged.



Go 1.0 mm beyond the existing burr in order to reach a safe initial position for the back chamfering.



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



Then exit in rapid traverse to the next bore.

Dimension Table to Programming Information

Tool	A	B	C	D
SNAP2	1.0	3.0	5.0	3.0
SNAP3	1.0	3.5	6.0	3.5
SNAP4	1.0	4.0	7.0	4.0
SNAP5	2.0	6.0	9.5	6.0
SNAP8	3.0	8.0	13.0	8.0
SNAP12	5.5	10.5	15.5	10.5
SNAP20	6.0	12.0	18.0	12.0

WARNING NOTICE - Cutting Data SNAP

All listed cutting data are standard values only! The cutting values depend on the amount of slope of the uneven bore edge. (i.e. high slope ► low cutting value). The feed also depends on the sloping ratio. In case of hard to machine materials or uneven bore edges, we recommend to apply cutting speeds that are at the lower end of the range for uneven bore edges. Cast materials should always be machined using coolant.