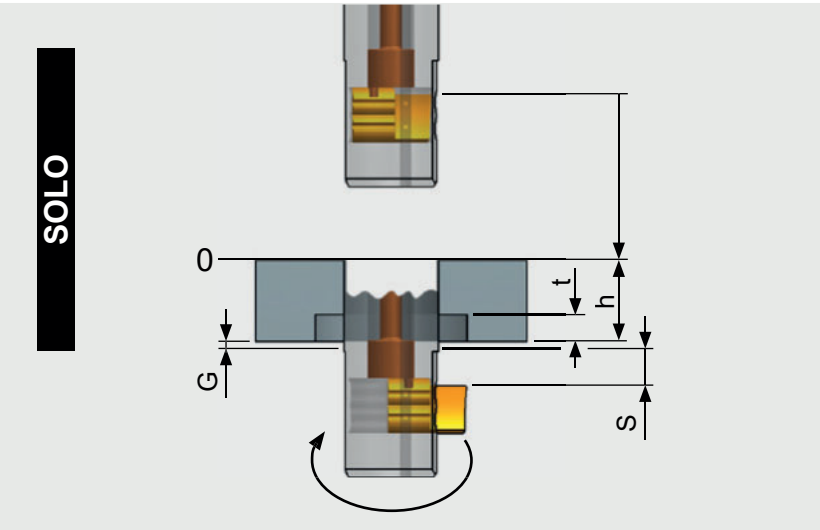


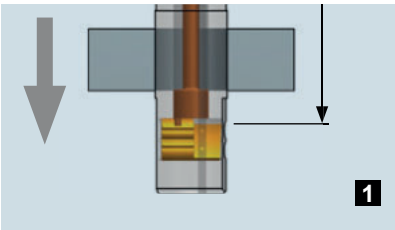
0 Zero line

G Burr height

h Workpiece thickness

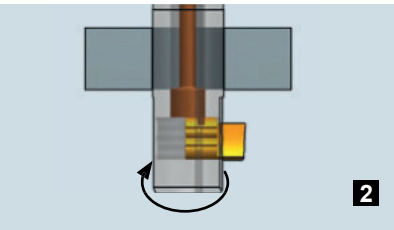
t C'sinking depth

S Clearance distance



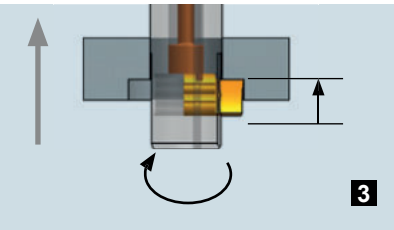
After spindle stop (Speed = 0, blade retracted), rapid traverse through the workpiece.

Position: h + G + S



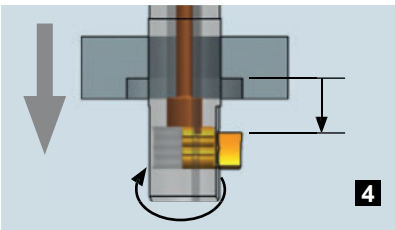
Activate spindle clockwise. Select correct activation speed to extend blade.

Attention: Dwell time 1 sec. at least. Increase speed to working speed. Switch coolant on.
Position: h + G + S



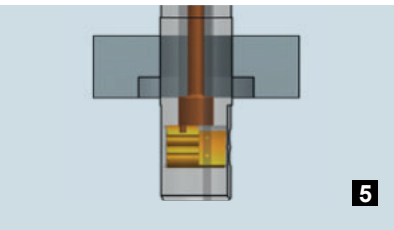
Machine workpiece backwards in working speed.

Position: h - t



Travel out of countersink in rapid traverse. Switch off coolant.

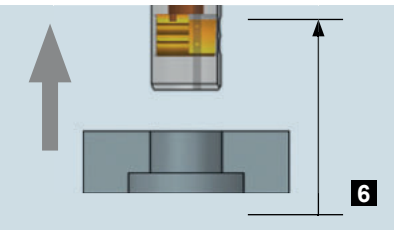
Position: h + G + S



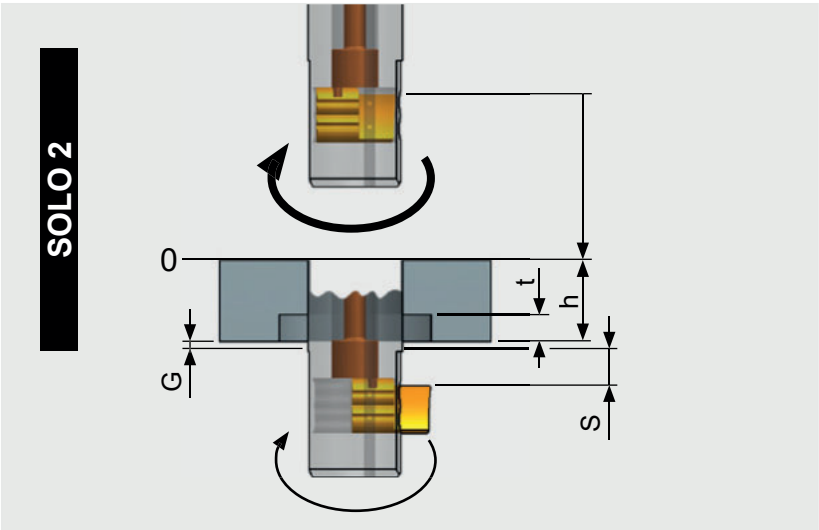
Stop the spindle. Select speed rate = 0 to retract blade.

Attention: Dwell time 1 sec. at least.

Position: h + G + S



With stopped spindle (speed rate = 0) and in rapid traverse withdraw the tool from the workpiece.



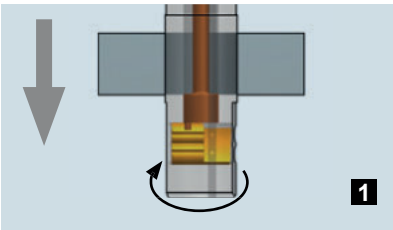
0 Zero line

G Burr height

h Workpiece thickness

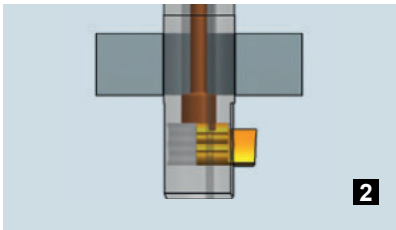
t C'sinking depth

S Clearance distance



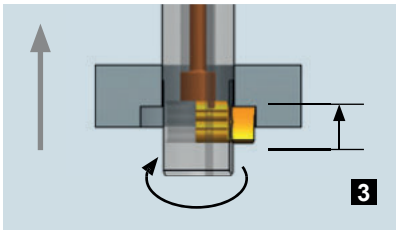
Activate spindle clockwise with retraction speed (speed = 1900 rev./min. minimum). The blade retracts. Travel through workpiece with rotating spindle and in rapid traverse.

Position: h + G + S



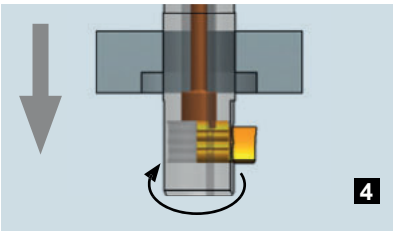
Stop the spindle. Dwell time 1 sec. at least. Switch on coolant. Set the speed to working speed.

Position: h + G + S



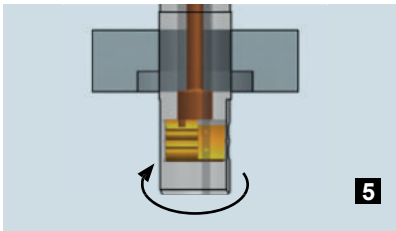
Machine the workpiece backwards in working speed and with working feed.

Position: h - t



Travel out of countersink in rapid traverse. Switch off coolant.

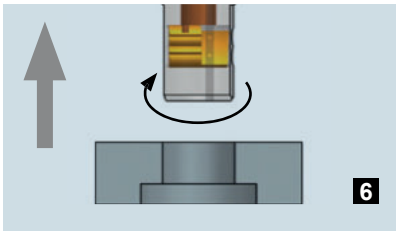
Position: h + G + S



Retract blade by increasing spindle speed to 1900 rev./min. minimum.

Attention: Dwell time 1 sec. at least.

Position: h + G + S



Travel through workpiece with retraction speed (Speed rate 1900 rev./min. minimum) and in rapid traverse and with retracted blade.