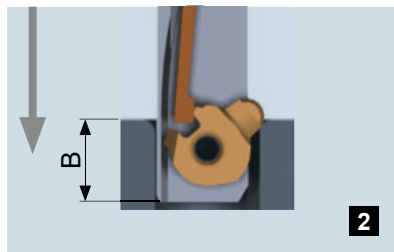
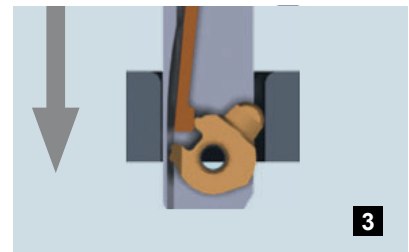


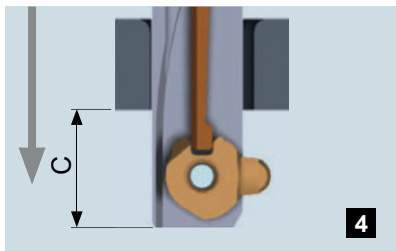
Rapid traverse of the cutting unit of the tool above the top material surface of hole or burr. Referencing the front edge of the cutting blade **A**.



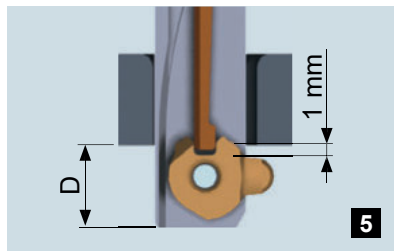
In forward working feed machine the top surface of the hole to position **B**.



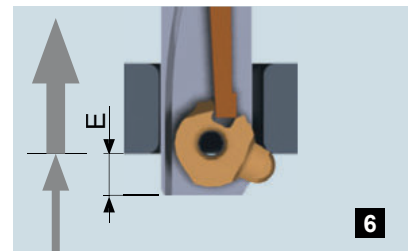
Rapid traverse through the hole. The surface of the hole cannot be damaged.



In order to make the blade snap out again, the tool has to be positioned beyond the rear bore edge of the hole or the burr by measurement **C**.



Travel the tool back in rapid feed below the rear material surface of the hole or the burr **D**.



In back working feed the backward deburring is executed until position **E**. Then exit in rapid traverse.

Dimension Table to Programming Information

Tool	A	B	C	D	E
COFA C2	1.7	4.5	4.5	4.3	1.5
COFA C3	2.5	6.0	6.0	5.5	2.0
COFA 4M	2.0	5.5	5.5	5.3	1.8
COFA 5M	2.8	7.0	6.9	6.4	2.2
COFA C6 Medium	1.1	6.3	6.5	4.9	-0.3
COFA C6 Large	1.1	6.8	6.8	4.9	-0.8
COFA C8 Medium	1.9	8.0	8.1	6.1	0
COFA C8 Large	1.9	8.8	8.5	6.1	-0.4
COFA C12 Medium	3.4	11.6	11.6	8.6	0.4
COFA C12 Large	3.4	13.0	12.5	8.6	-1.0

**NOTE**

Important - Please pay attention to irregular surfaces! Please consider unevenness when programming the distances. See also the explanations on page 59.