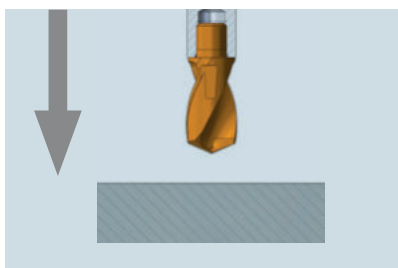
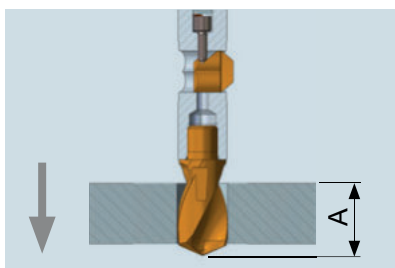


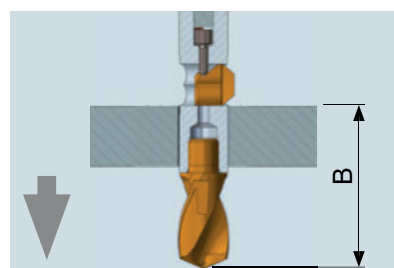
It is not necessary to change the direction of rotation or to stop the spindle during the full process.



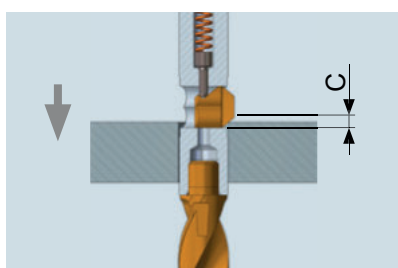
Rapid traverse of the tool to just above the top of the workpiece.  
Pay attention to the clearance distance.



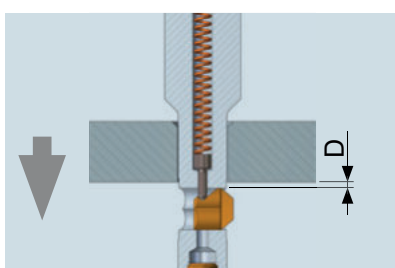
In forward linear feed the bore is produced. Continue in linear feed until the drill insert is completely clear of the bore.



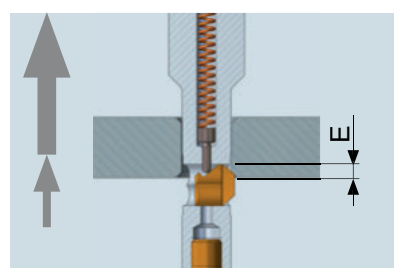
Position tool with SNAP blade in rapid feed, forward slightly above the top material surface of bore or burr.



In linear feed forward, the chamfer is generated. Continue in linear feed until the blade is completely retracted into the tool.



The tool can be passed through the hole in rapid feed forward until the SNAP blade is clear of the hole and fully extended.



The back chamfer is machined by linear feed backward (no change of spindle direction). As soon as the SNAP blade is completely retracted into the tool, the tool can travel out of the hole in rapid feed backward.

### Dimension Table to Programming Information

Bore depth	A		B		C		D		E	
	1xd	2xd	1xd	2xd	1xd	2xd	1xd	2xd	1xd	2xd
<b>Tool type</b>										
Series B 5.0 <sup>1)</sup>	5.5	11.0	17.9	23.7	21.9	27.7	25.4	31.2	21.9	27.7
Series B 5.5 <sup>1)</sup>	6.0	12.0	18.8	25.1	22.8	29.1	26.3	32.6	22.8	29.1
Series C 6.0	6.5	13.0	19.6	26.3	23.6	30.3	27.1	33.8	23.6	30.3
Series C 6.5	7.0	14.0	20.6	27.9	24.6	31.9	28.1	35.4	24.6	31.9
Series D 7.0	7.5	15.0	22.8	30.7	26.8	34.7	30.3	38.1	26.8	34.7
Series D 7.5	8.0	16.0	23.6	31.9	27.6	35.9	31.1	39.4	27.6	35.9
Series D 8.0	8.5	17.0	24.4	33.2	28.4	37.2	31.9	40.7	28.4	37.2
Series E 8.5	9.0	18.0	25.6	34.9	29.6	38.9	33.1	42.4	29.6	38.9
Series E 9.0	9.5	19.0	26.4	36.2	30.4	40.2	33.9	43.7	30.4	40.2
Series E 9.5	10.0	20.0	27.3	37.6	31.3	41.6	34.8	45.5	31.3	41.6
Series E 10.0	10.5	21.0	28.1	38.9	32.1	42.9	35.6	46.4	32.1	42.9
Series E 10.5	11.0	22.0	29.1	40.2	33.1	44.2	36.6	47.7	33.1	44.2
Series F 11.0	11.5	23.0	29.9	41.5	33.9	45.5	37.4	49.0	33.9	45.5

<sup>1)</sup> Available only without internal cooling. VEX with internal cooling starts from bore-Ø 6.00 mm.