

DRILLING (INDEXABLE TYPE)

CARBIDE

JUST FIT SLEEVE [JFS]

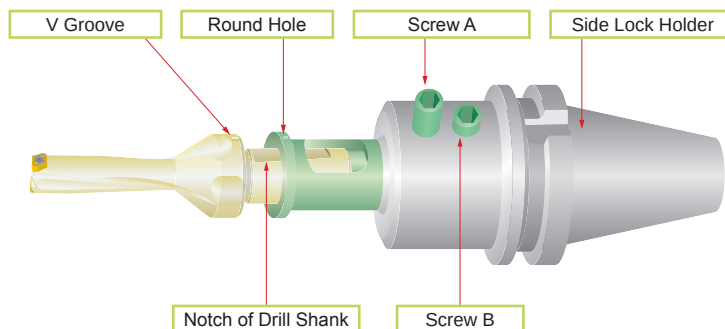
APPLICATION OF THE JUST FIT SLEEVE

1 When inserting the drill into the side lock holder, align the V groove on the outer peripheral edge of the drill flange, the round holes of the outer peripheral edge of the sleeve flange and the screws of the side lock holder for fixing the drill. (If the drill does not have a V groove, align the notch of the drill shank with the round holes of the sleeve.)

2 Insert screws A of the side lock holder directly through the open window of the sleeve to clamp the drill. Tighten screw B only to a degree that does not damage the sleeve.

(Note)

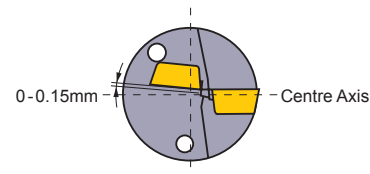
- Fine adjustments cannot be made for the diameter of the sleeve.
- Cannot be used with collect chuck type holders.



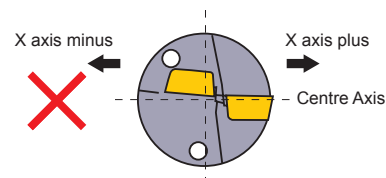
APPLICATION OF MVX TYPE DRILL

●Use on a Lathe

- (1) The outer insert and machine X axis must be set parallel. The drill is designed that the centre of the inner insert is 0-0.15mm lower when matching the drill centre and the machine spindle centre.
- ★The inner insert may fracture if the centre height of the inner insert is higher than the machine X axis.



- (2) To adjust the hole diameter by off-setting the drill, please adjust to the X axis plus direction (expanding direction of the hole diameter). Please refer to the holder dimension list for the maximum adjustment rate of each holder.
- ★It is not recommended to adjust to the X axis minus direction (direction of reducing the hole diameter) as the holder may interfere with the hole.



- (3) When through hole drilling on a lathe, the disc produced by the drill exiting the workpiece may be expelled at high velocity. To reduce the danger of injury or damage a cover guard is highly recommended.

