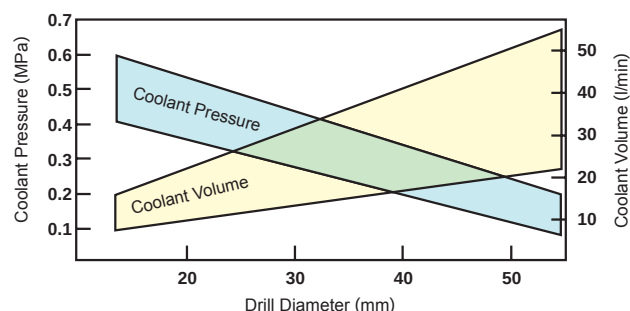


APPLICATION OF TAF TYPE DRILL

- Please ensure the highest rigidity possible exists in both machine set up and workholding.
- Refer to the following graph for coolant pressure and volume. Coolant is an important factor in the efficient use of these drills.
- Cannot be used for stack drilling.
In common with many indexable insert drills, these drills produce a round disc on exit which unless evacuated may cause the drill to fracture.



- Use on a Lathe
- (1) The inner cutting edge must be positioned between 0-0.2mm over center.
0-0.2mm
 - (2) To adjust the hole diameter by off-setting the drill, the outer cutting edge and machine axis must be set parallel.
 - (3) When producing an oversize hole.
The drill offset should be no more than 2% of the diameter. It is not possible to produce an undersized hole.
 - (4) 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.

