

DRILL-FIX Indexable Drills

Application Guidelines — DRILL-FIX Series



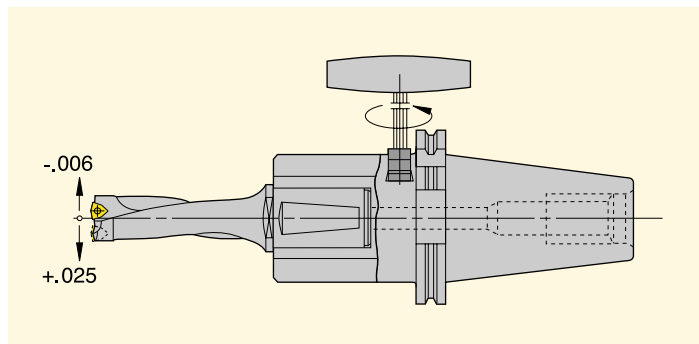
X-Adjustment Application Examples



Stationary Tool

For this example, the turret of the turning machine is offset along the X-axis.

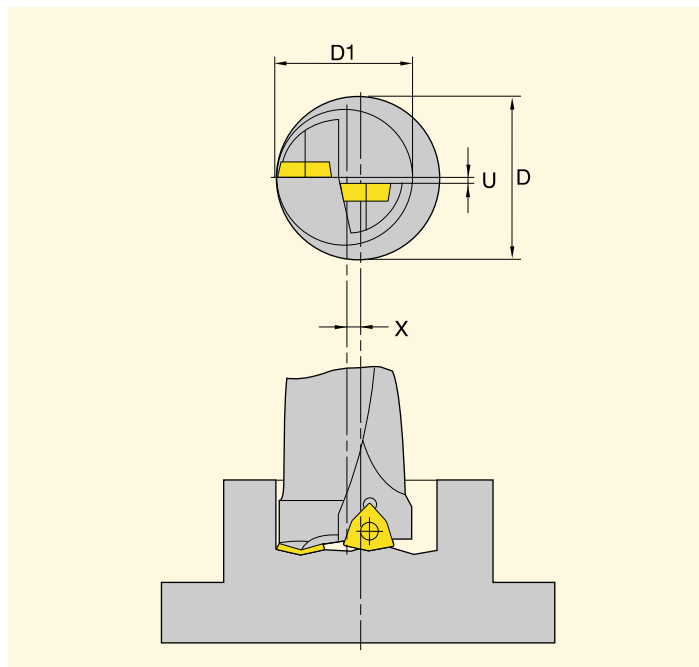
- The X-adjustment must be made at the outer cutting edge, parallel to the surface of the outer insert.



Rotating Tool — Straight Shank

For this example, a rotating tool on a machining center is shown.

- An adjustable eccentric chuck with a steep taper is used to help offset the drill along the X-axis.
- See page H210-211 for product ordering information.



X-Adjustment Description

Different diameter holes can be drilled using the same DRILL-FIX drill. Holes with a diameter greater than the nominal diameter can be drilled directly into a solid. Intermediate dimensions are produced by means of the X-adjustment:

Benefits:

- Eliminates the need for special tools for intermediate dimensions.
- Just a few drills cover a wide application range.
- Once precise adjustment of the desired diameter is made, tolerances of $\pm .002$ are achieved.

Solid Carbide Drills

Combination Tools

Modular Drills

Indexable Drills

OPV Drills

Twist Drills/Taps & Dies

Counterboring Tools

Rotating Boring Tools

Holemaking Tech Data

Special Tooling/Adapters

Toolholding Systems

Index