

For Front & Back Deburring		For Back Only Deburring
<p><b>Step 1:</b> Referencing the front of the tool. Rapid traverse the tool the distance "A" into the hole. This will give .040"(1) clearance from the cutter.</p>		<p>For back deburring only, the COFA tool can rapid traverse through the top hole without damage to your hole surface.</p>
<p><b>Step 2:</b> In forward working feed machine the top surface of the hole by moving to distance "B". (Ref. the front of the tool)</p>		
<p><b>Step 3:</b> Rapid traverse through the hole. The hole will not be damaged.</p>		<p><b>Step 1:</b> Rapid traverse through the hole. The hole cannot be damaged.</p>
<p><b>Step 4:</b> In order to make the blade pop out again, the tool has to be positioned beyond the rear bore edge by the distance "C". (Ref. the front of the tool)</p>		<p><b>Step 2:</b> In order to make the blade pop out again, the tool has to be positioned beyond the rear bore edge by the distance "C". (Ref. the front of the tool)</p>
<p><b>Step 5: (optional)</b> Travel the tool in back rapid feed below the rear material surface of the hole or burr to reduce cycle time. Move to distance "D". (Ref. the front of the tool)</p>		<p><b>Step 3: (optional)</b> Travel the tool in back rapid feed below the rear material surface of the hole or burr to reduce cycle time. Move to distance "D". (Ref. the front of the tool)</p>
<p><b>Step 6:</b> In back working feed, move to distance "E" to machine the rear surface. (Ref. the front of the tool) Rapid out.</p>		<p><b>Step 4:</b> In back working feed, move to distance "E" to machine the rear surface. (Ref. the front of the tool) Rapid out.</p>

Tool Type	A	B-Flat	B-Irregular	C*	D*	E-Flat*	E-Irregular*
<b>C6</b>	.043" (1.1)	.268" (6.8)	.306" (7.8)	.268" (6.8)	.193" (4.9)	-.03" (-0.8)	-.071" (-1.8)
<b>C8</b>	.075" (1.9)	.347" (8.8)	.392" (10.0)	.335" (8.5)	.240" (6.1)	-.016" (-0.4)	-.063" (-1.6)
<b>C12</b>	.134" (3.4)	.512" (13.0)	.584" (14.9)	.492" (12.5)	.339" (8.6)	-.039" (-1.0)	-.118" (-3.0)

\* Values above based on either med or lrg blade. Plus Material Thickness