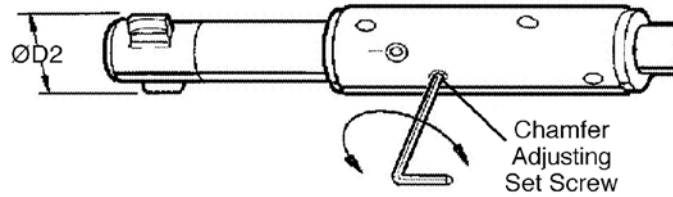


## The D2 Dimension

### Setting ØD2

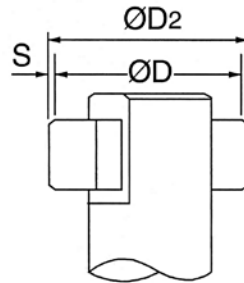
The ØD2 is the measurement across the outer edge of the DEFA blades. The ØD2 can be adjusted by changing the position of the chamfer adjusting “Set Screw.” Use a pre-setter or calipers to measure across the outer edges of the blades when installed in the tool holder and adjust the “Set Screw” to get the proper dimension for ØD2.



### Calculating ØD2

ØD2 is the measurement across the outer sliding edge of the cutting blades when they are installed in the tool holder. ØD2 is based on the desired chamfer diameter, ØD, and the projected length of the non-cutting guiding edge, 's'.

$$\text{ØD2} = \text{ØD} + 2(\text{S})$$



$$\text{ØD2} = \text{Chamfer Dia. (ØD)} + [2 \times \text{'s'}]$$

Values for 's'		
Series	Old Series	's'
02 thru 09	4 thru 8	0.3mm .012"
10 thru 13	8 thru 13	0.4mm .016"
14 thru 17	12 thru 19	0.5mm .020"
18 thru 32	17 thru 42	1.0mm .040"

### Adjusting ØD2

- Remove the red sealant from the chamfer adjusting set screw.
- To increase the ØD2 dimension, turn the set screw counter-clockwise.
- To decrease the ØD2 dimension, turn the set screw clockwise.
- Reapply screw sealant to the set screw to prevent unintentional changes.

**Hint:** When setting the ØD2, increase the blade tension to ensure maximum extension of the blades against the calipers.