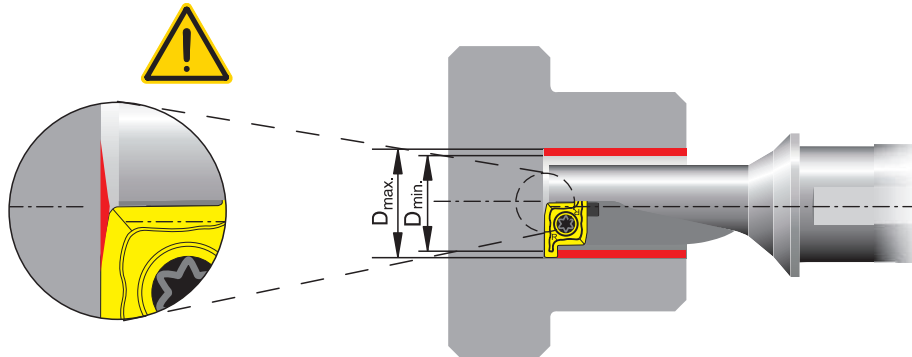


### Off-centre drilling



Due to the special construction of ProfileMaster tools and inserts off-centre drilling is possible. Thus desired deviations from the tool's nominal diameter can be obtained (see table below).

| Type of tool  | Nominal tool diameter | Drilling diameter (work piece) |                       |
|---------------|-----------------------|--------------------------------|-----------------------|
|               | D [mm]                | D <sub>min</sub> [mm]          | D <sub>max</sub> [mm] |
| PMC 10R/L ... | 10                    | 9,85                           | 12                    |
| PMC 12R/L ... | 12                    | 11,85                          | 15                    |
| PMC 16R/L ... | 16                    | 15,85                          | 19                    |
| PMC 20R/L ... | 20                    | 19,80                          | 24                    |
| PMC 25R/L ... | 25                    | 24,80                          | 29                    |
| PMC 32R/L ... | 32                    | 31,80                          | 38                    |

### Machining across centre line

**Situation:**

In case of insufficient movement of the machine across the centre line the external diameter can not be machined with the same tool.

**Solution:**

Use a right-hand ProfileMaster tool.

