

HOLEMAKING

ACCESSORIES

Chamfering Rings & Eccentric Sleeves

HOLEMAKING

Chamfering Rings &
Eccentric Sleeves



CHAMFERING RINGS

Designed for streamlined workflows, these chamfering rings facilitate the simultaneous drilling and chamfering of workpieces. This dual-operation capability minimizes cycle times and lowers the tooling inventory required for hole preparation, contributing to improved efficiency and reduced machine downtime associated with tool changes.

FEATURES

- **Integrated on Drill:** simultaneous hole drilling and chamfering in one operation
- **VBMT insert:** the chipbreaker and grade should be specifically engineered to match the insert being used within the chamfering ring to ensure suitable workpiece machining
- **Versatility:** compatible across all range of jet drills program

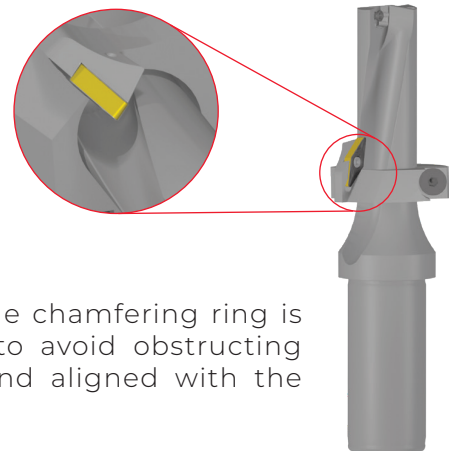


MOUNTING PROCEDURE

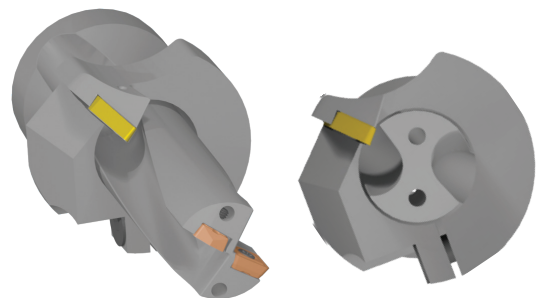
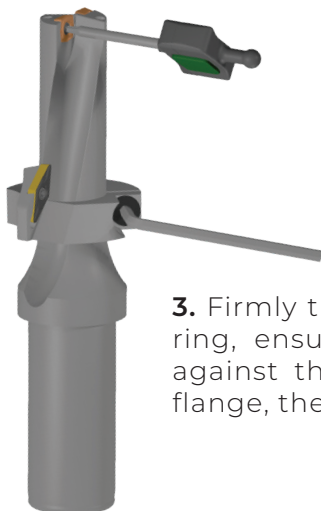
1. Slide the chamfering ring into the drill body and position it along the beginning of flute.



2. Ensure the chamfering ring is positioned to avoid obstructing chip flow and aligned with the flute.



3. Firmly tighten the chamfering ring, ensuring it is fully seated against the contour of the drill flange, then place the drill insert.



Correct instalation of the ring



Check the QrCode for more information

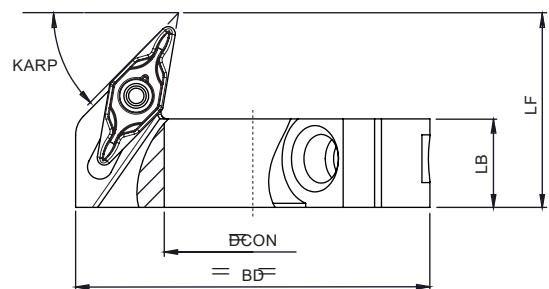
CHAMFERING RINGS

Drill and Chamfer System: Two Operations, One Setup

RINGS



KAPR=45°



Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Insert	Stock
		DC DRILL	DCON	BD	LB	LF		
184349800	CHR 130 VB1103	13,0	12,5	32,5	10,0	22,0	VB.. 1103	○
184346300	CHR 135 VB1103	13,5	13,0	33,0	10,0	22,0	VB.. 1103	⊗
184346400	CHR 140 VB1103	14,0	13,5	33,5	10,0	22,0	VB.. 1103	○
184346500	CHR 145 VB1103	14,5	14,0	34,0	10,0	22,0	VB.. 1103	⊗
184346600	CHR 150 VB1103	15,0	14,5	34,5	10,0	22,0	VB.. 1103	○
184346700	CHR 160 VB1103	15,5-16	15,0	35,0	10,0	22,0	VB.. 1103	⊗
184346800	CHR 165 VB1103	16,5	15,5	35,5	10,0	22,0	VB.. 1103	○
184346900	CHR 170 VB1103	17,0	16,0	36,0	10,0	22,0	VB.. 1103	⊗
184347000	CHR 175 VB1103	17,5	16,5	36,5	10,0	22,0	VB.. 1103	○
184347100	CHR 180 VB1103	18,0	17,0	37,0	10,0	22,0	VB.. 1103	⊗
184347200	CHR 185 VB1103	18,5	17,5	37,5	10,0	22,0	VB.. 1103	○
184347300	CHR 190 VB1103	19,0	18,0	38,0	10,0	22,0	VB.. 1103	⊗
184347400	CHR 195 VB1103	19,5	18,5	38,5	10,0	22,0	VB.. 1103	○
184347500	CHR 200 VB1103	20,0	19,0	39,0	10,0	22,0	VB.. 1103	⊗
184347600	CHR 205 VB1103	20,5	19,5	39,5	10,0	22,0	VB.. 1103	○
184347700	CHR 210 VB1103	21,0	20,0	40,0	10,0	22,0	VB.. 1103	⊗
184347800	CHR 215 VB1103	21,5	20,5	40,5	10,0	22,0	VB.. 1103	○
184347900	CHR 220 VB1103	22,0	21,0	41,0	10,0	22,0	VB.. 1103	⊗
184348000	CHR 225 VB1103	22,5	21,5	41,5	10,0	22,0	VB.. 1103	○
184348100	CHR 230 VB1103	23,0	22,0	42,0	10,0	22,0	VB.. 1103	⊗
184348200	CHR 235 VB1103	23,5	22,5	42,5	10,0	22,0	VB.. 1103	○
184348300	CHR 240 VB1103	24,0	23,0	43,0	10,0	22,0	VB.. 1103	⊗
184348400	CHR 245 VB1103	24,5	23,5	43,5	10,0	22,0	VB.. 1103	○
184348500	CHR 250 VB1103	25,0	24,0	44,0	10,0	22,0	VB.. 1103	⊗
184348600	CHR 255 VB1103	25,5	24,5	44,5	10,0	22,0	VB.. 1103	○
184348700	CHR 260 VB1103	26,0	25,0	45,0	10,0	22,0	VB.. 1103	⊗
184348800	CHR 265 VB1103	26,5	25,5	45,5	10,0	22,0	VB.. 1103	○
184348900	CHR 270 VB1103	27,0	26,0	46,0	10,0	22,0	VB.. 1103	⊗
184349000	CHR 275 VB1103	27,5	26,5	46,5	10,0	22,0	VB.. 1103	○
184349100	CHR 280 VB1103	28,0	27,0	47,0	10,0	22,0	VB.. 1103	⊗
184349200	CHR 285 VB1103	28,5	27,5	47,5	10,0	22,0	VB.. 1103	○
184349300	CHR 290 VB1103	29,0	28,0	48,0	10,0	22,0	VB.. 1103	⊗
184349400	CHR 295 VB1103	29,5	28,5	48,5	10,0	22,0	VB.. 1103	○
184349500	CHR 300 VB1103	30,0	29,0	49,0	10,0	22,0	VB.. 1103	⊗
184349600	CHR 305 VB1103	30,5	29,5	49,5	10,0	22,0	VB.. 1103	○
184349700	CHR 310 VB1103	31,0	30,0	50,0	10,0	22,0	VB.. 1103	⊗

⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

ECCENTRIC SLEEVES

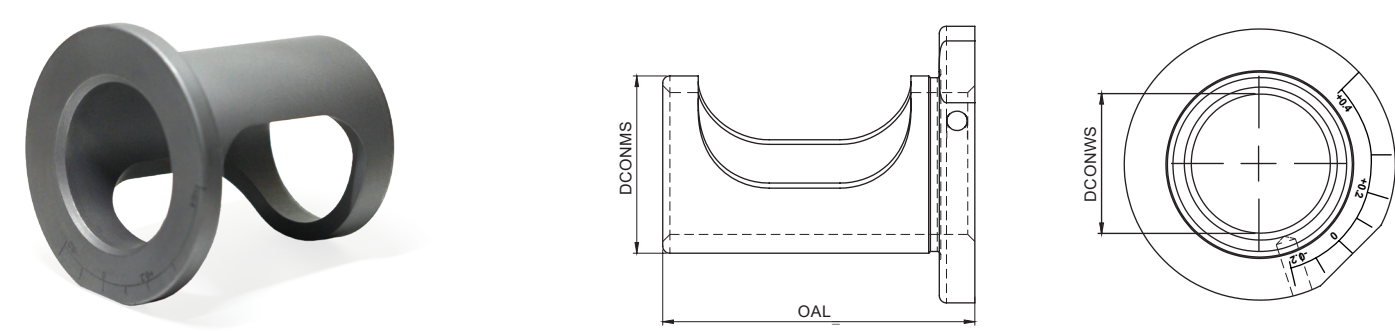
Palbit eccentric sleeves: a user-friendly system that provides a versatile and effective solution accurate hole decentring and adjustable positioning. Their ingenious off-centre bore design allows precise micro-adjustment of drill positions, easily adapting to different requirements and tolerances.

This cost-effective approach reduces the need for numerous fixed-size parts by allowing adjustments for different effective diameters and minor misalignments , during drilling processes.

FEATURES

- Fine diameter adjustment:** slight drill axis shift for precise sizing
- Adjustable hole decentring:** enables fine-tuning of the bore's offset from the intended center
- MaxPro Drill:** eccentric sleeve integration for offset capabilities

ECCENTRIC SLEEVES



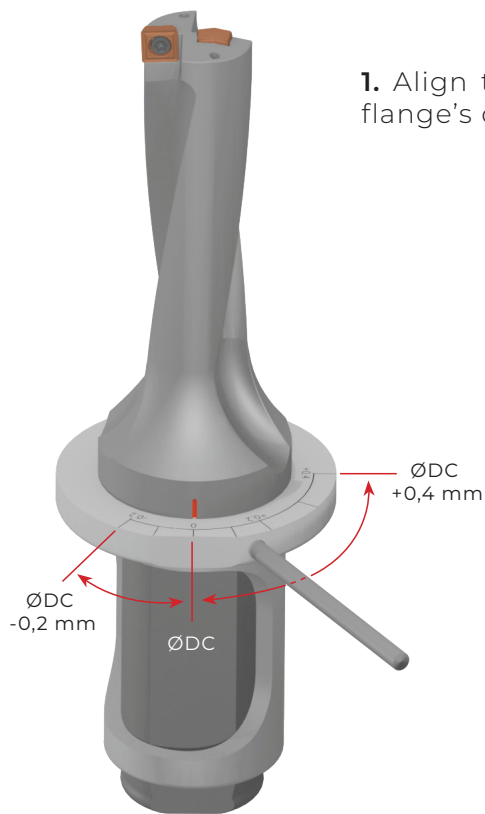
Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)			Stock
		DCONWS	DCONMS	OAL	
214345100	2025-L44	20	25	44	Ⓢ
214345200	2532-L46	25	32	46	Ⓢ
214345300	3240-L55	32	40	55	Ⓢ
214345400	4050-L62	40	50	62	Ⓢ

Ⓢ Stock item | Produto de stock | Itens de stock
 ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

ECCENTRIC SLEEVES

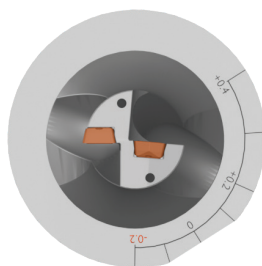
Precision Offset and Diameter Control

MOUNTING PROCEDURE

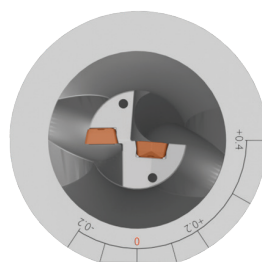


1. Align the adjustment markings perpendicular to the flat on the drill flange's circumference.

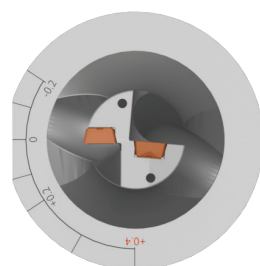
2. Rotation of the sleeve is achieved through the hole on the eccentric flange.



$\text{ØDC} - 0,2 \text{ mm}$



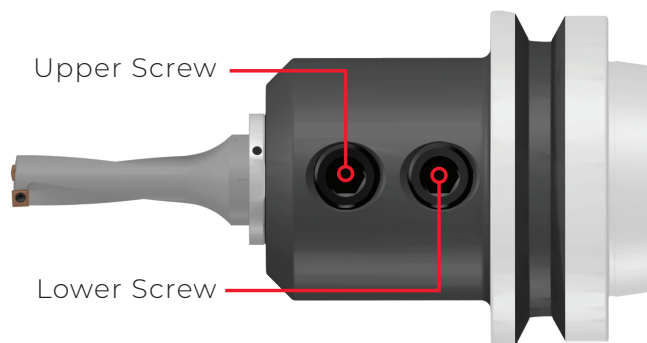
ØDC



$\text{ØDC} + 0,4 \text{ mm}$

3. Ensure the upper screw on the chuck is firmly tightened against the Weldon flat of the drill.

4. Tighten the lower screw on the chuck just enough to contact the drill.



NOTES: Reduce the feed rate by approximately 20% for 2D and 3D drills, and by 30% for 4D and 5D drills.
Designed for use with DIN 1835.
Not for use with lathe tools.



Check the QrCode for more information

HOLEMAKING

ACCESSORIES

Chamfering Rings & Eccentric Sleeves



HEADQUARTERS

PALBIT. S.A.

T (+351) 234 540 300 | F (+351) 234 540 301

palbit@palbit.pt | www.palbit.pt

Branch office

PALBIT México, S de RL de CV

T (+52) 5555 454 543 | F (+52) 5552 509 190

info@palbit.com.mx | www.palbit.pt/mx

Branch office

PALBIT Brasil

T (+55) 011 25 343 648

palbit@palbit.com.br | www.palbit.pt/br