

Thank you for purchasing the YAMAWA Shank Extension.

When the Shank Extension is equipped with the Single-Ended Coated Drills AUCES, AUCDS, AUPEQ or AUPES, you can use it as long shank drills.

Please read this manual for using the Shank Extension correctly and safely.

Please keep this manual in a safe place.

1 How to install?



1 Remove oil or dusts on the drill's shank and the hole of the Shank Extension. Insert a coated drill deeply into the Shank Extension.

2 Alternately, tighten the 2 set screws for a balanced fastening. In order to prevent misalignment and a weakened connection, do not tighten just one of the 2 set screws.

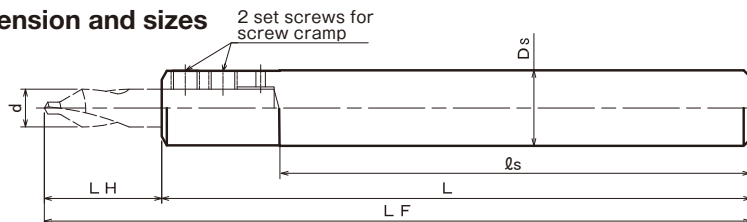
3 Be sure to use the Shank Extension with a milling chuck for drilling.

<Caution>

-Do not use for side feed machining such as channel cutting or corner chamfering.

-Create a notch on the shank of the drill or lower the feed rate if the drill slips.

2 Dimension and sizes



Unit mm

Size D × D _s × LF	Product Code	d	D _s	L	LF	LH	l _s	Drills
6 × 16 × 150	SE0616M	6	16	128	150	22	105	AUCES/AUCDS AUPEQ/AUPES
8 × 16 × 150	SE0816M	8	16	125	150	25	100	
10 × 20 × 150	SE1020M	10	20	123	150	27	95	

3 Warning

- ◆ Tools may shatter. Wear cover or eye glasses to avoid injury during machining.
- ◆ Tools may shatter. Use tools under the proper machining condition.
- ◆ Never wear gloves during machining operations as the gloves may get caught with the tools.
- ◆ Wear safety shoes to avoid injuring yourself by the falling tools.
- ◆ On attaching tools to the machine, fasten firmly to avoid chattering and run-out.
- ◆ Fasten the work pieces firmly so that they never move during operation. Never use worn tools or damaged tools with chipping.
- ◆ Take a special care to fire trouble. High temperature during machining may cause fire.

Note : Specifications may change without prior notice.