4TEX™ Drill *Eccentric Sleeves*

For Cutting Diameter / Center Height Adjustment
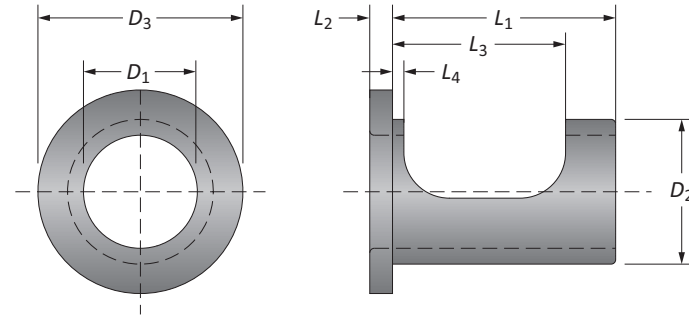

Sleeve Dimensions								Adjustment Range	
D_1	D_2	D_3	L_2	L_3	L_4	L_1	Part No.	Diameter*	Center Height
0.750	1.000	1.614	0.157	1.417	0.118	1.536	SLEEVE-075F	+0.0157 to -0.0079	+0.0079 to -0.0059
1.000	1.250	1.929	0.236	1.496	0.098	1.890	SLEEVE-100F	+0.0157 to -0.0079	+0.0079 to -0.0059
1.250	1.500	2.283	0.236	1.693	0.098	2.087	SLEEVE-125F	+0.0157 to -0.0079	+0.0079 to -0.0059
1.500	2.000	2.913	0.236	1.929	0.118	2.481	SLEEVE-150F	+0.0236 to -0.0079	+0.0079 to -0.0079
20.00	25.00	41.00	4.00	36.00	3.00	43.00	SLEEVE-20FM	+0.40 to -0.20	+0.20 to -0.15
25.00	32.00	49.00	6.00	38.00	2.50	48.00	SLEEVE-25FM	+0.40 to -0.20	+0.20 to -0.15
32.00	40.00	58.00	6.00	43.00	2.50	53.00	SLEEVE-32FM	+0.40 to -0.20	+0.20 to -0.15
40.00	50.00	74.00	6.00	49.00	3.00	63.00	SLEEVE-40FM	+0.40 to -0.20	+0.20 to -0.20

*Diameter adjustment range refers to the cutting diameter.
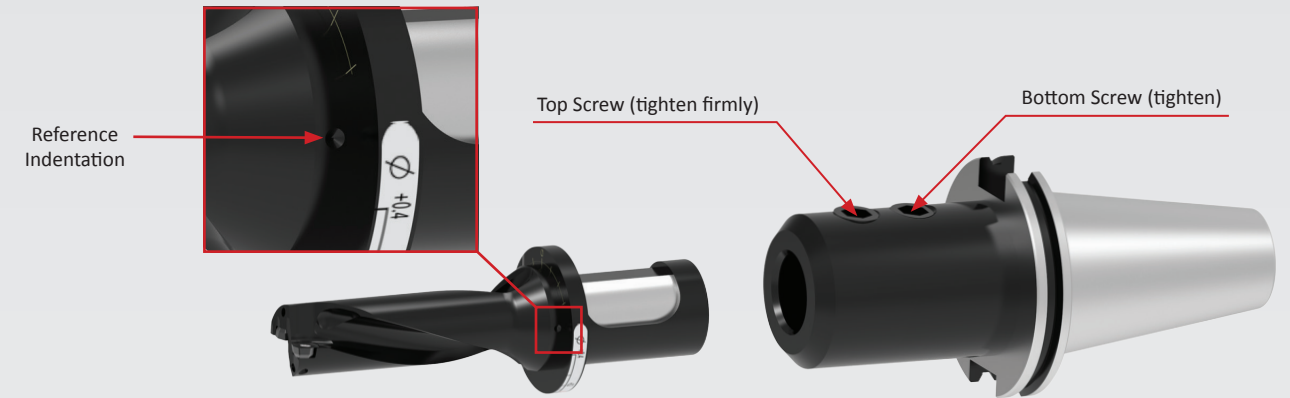
ⓘ = Imperial (in)
ⓜ = Metric (mm)
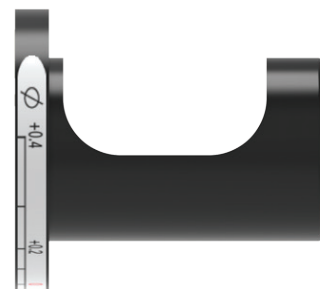
Milling Applications
Peripheral Adjustment Position
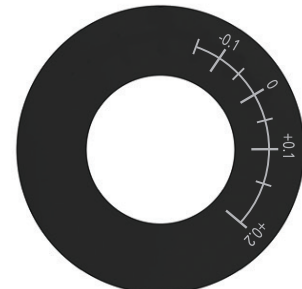
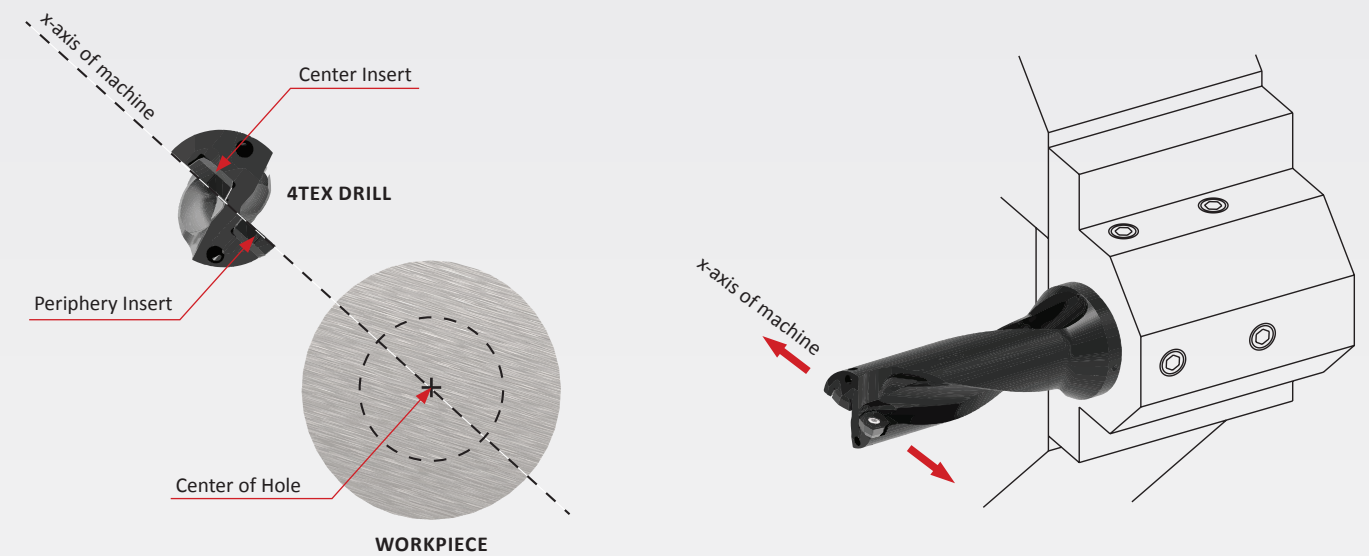**Lathe Applications**
Front Adjustment Position

Diameter Adjustment
Milling and Lathe Applications

Reference Indentation

Top Screw (tighten firmly)

Bottom Screw (tighten)

For Milling Applications

1. Assemble the 4TEX Drill, eccentric sleeve, and tool holder. Do not tighten the tool holder set screws.

2. Using the peripheral marks for milling machines, align the reference indentation on the holder with the 0 (zero) mark on the eccentric sleeve to have no offset.

3. Rotate the sleeve in the (+) or (-) direction to increase or decrease the nominal diameter.

4. Once the drill has arrived at the desired diameter, firmly tighten the top set screw first and then tighten the bottom set screw.

NOTICE: Eccentric sleeves are to be used with side-locking tool holders only. Damage may result with other styles of tool holders.

x-axis of machine

Center Insert

4TEX DRILL

Periphery Insert

Center of Hole

WORKPIECE

x-axis of machine

For Lathe Applications

1. Assemble the 4TEX Drill into the lathe turret with the top face of the inserts parallel to the x-axis of the machine. This will allow for the diameter offsets to be made using the lathe's x-axis.

2. To increase the nominal diameter, offset the x-axis so the periphery insert moves away from the center of the hole.

3. To decrease the nominal diameter, offset the x-axis so the periphery insert moves toward the center of the hole.

NOTE: Eccentric sleeve is not required when adjusting the diameter of the hole on a lathe.