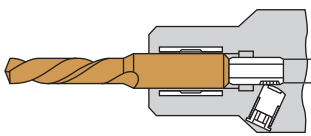
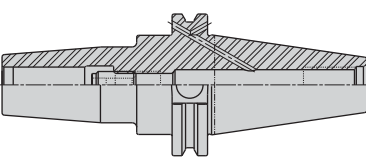
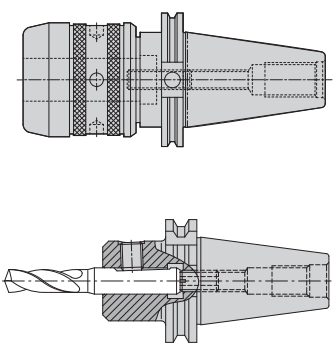
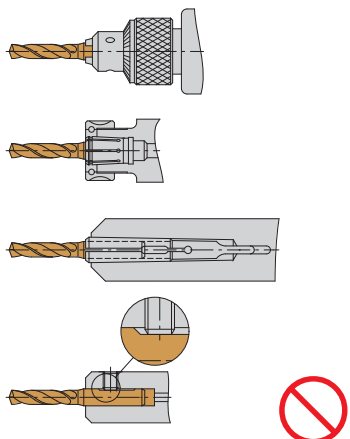
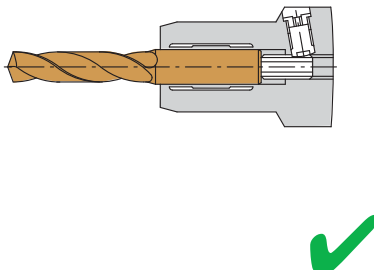
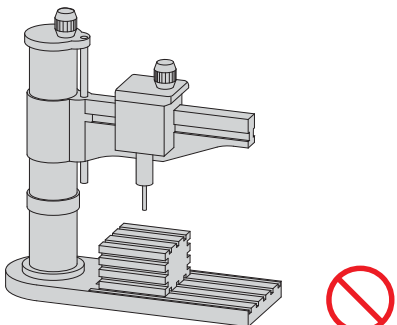
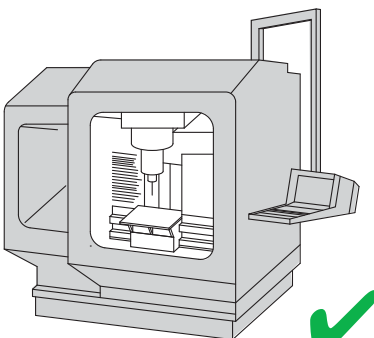


Toolholding Systems

As with any drilling system, components of the entire system contribute to the quality of the machined hole, not just the drill itself. For maximum efficiency and accuracy, the following toolholding systems are your best choices:

First Choice Hydraulic chucks 	Second Choice Shrink Fit 	Third Choice High-performance milling chucks with reduction sleeves 
Not Recommended 	Clamping Chuck Use of all-purpose drilling chuck collets, clamping sleeves, and Weldon® clamping chucks should be avoided because they do not absorb cutting forces reliably and provide insufficient precision of concentricity.	Highly Recommended Hydraulic chucks ensure a secure torque transmission with excellent concentricity. 
Not Recommended 	Machine Solid carbide drills have a much higher rigidity than conventional high-speed steel drills. This enables the machining of close-tolerance holes with a position accuracy of $\pm 0.025\text{mm}$. However, it also means that drills require rigid machine tools with good spindles.	Rigid Machine Tool Recommended 

(continued)