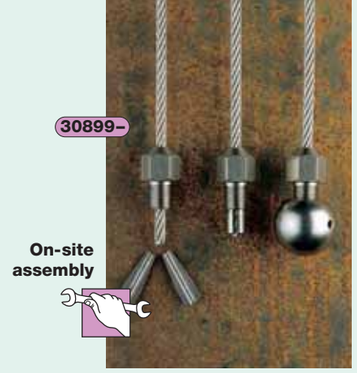
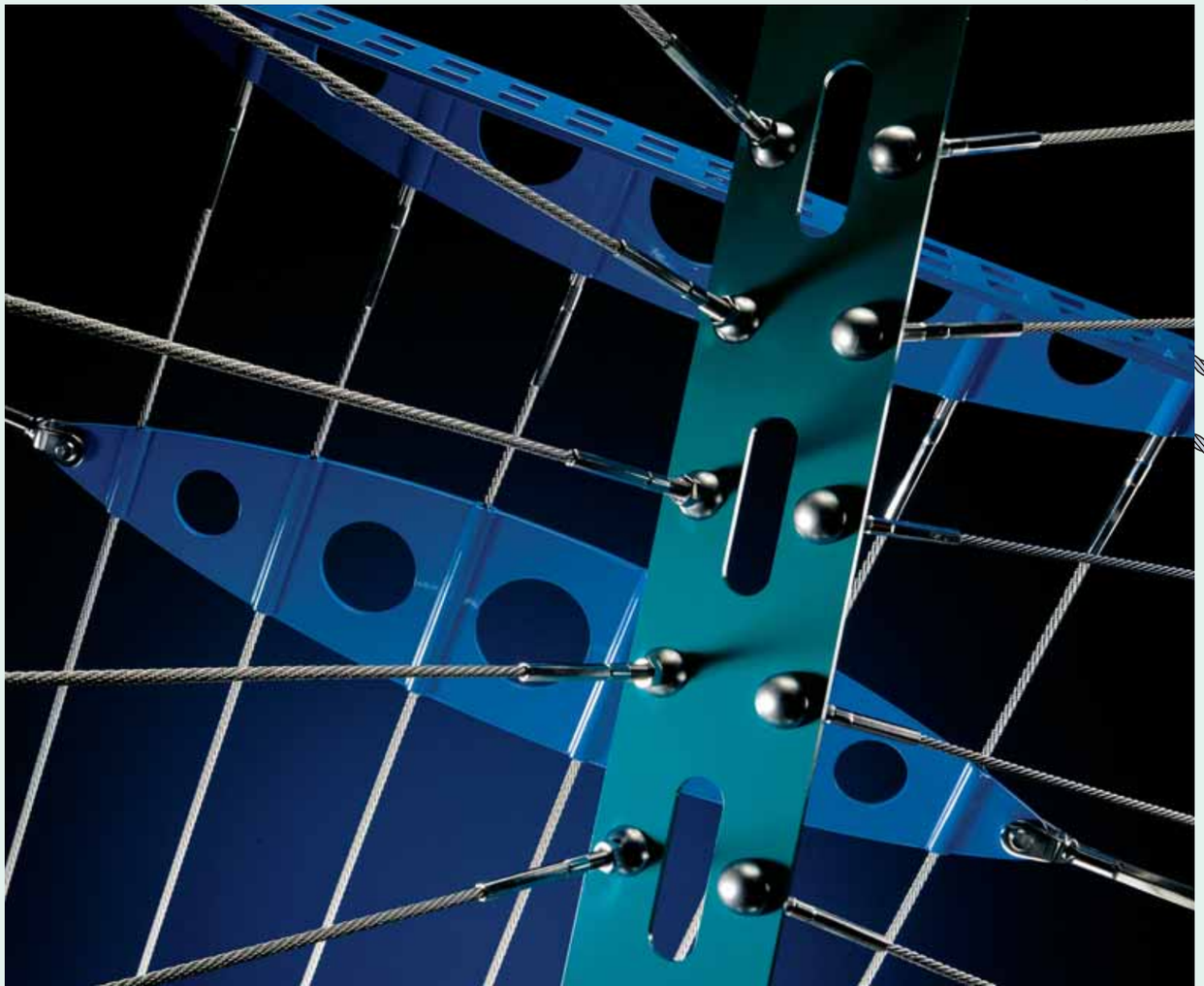
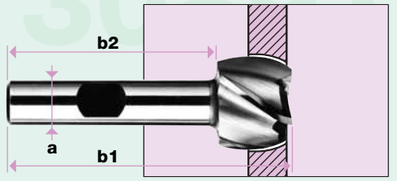
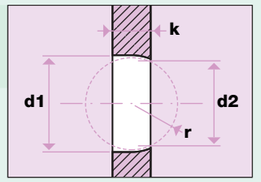


58.A

58.B







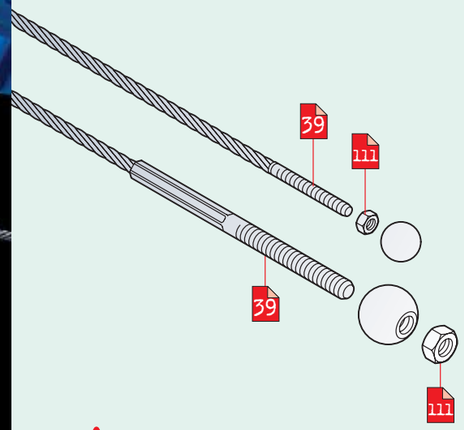
A bench drill with a depth stop is needed to professionally drill and shape the hole for the ***VARIBALL***® end stop.

The ***VARIBALL***® is designed to be retained in flat sections. A special milling tool is required to produce the matching hole.

VARIBALL® types Mk**I** to Mk**III** accept wire ropes with swaged or welded external threads; type Mk**IV** has a special compression fitting for cut wire rope ends.

Within the cone defined by the deflection angle, the longitudinal axis of the tensioned wire rope can point in any direction.

The deflection angle α applies to the permissible longitudinal axis of the wire rope.
The maximum deflection angle **α max.** defines the envelope of the cone. The α max. values are listed in the product tables for Mk**I** to Mk**IV** on page 57.



The use of *JAKOB* ***VARIBALL***® fittings calls for careful planning and execution!

VARIBALL® *COUNTERSINK MILL*

HSS-Co5

Only for bench drills with depth stops

mm

30891–	for ***VARIBALL***® ø	Diameter ø **d1**	Radius **r**	Total length **b1**	Shaft **a** x **b2**
1200	12	12,5	6	65	12 x 50
1600	16	16,5	8	65	16 x 50
2000	20	20,5	10	65	12 x 50
2400	24	24,5	12	75	12 x 55

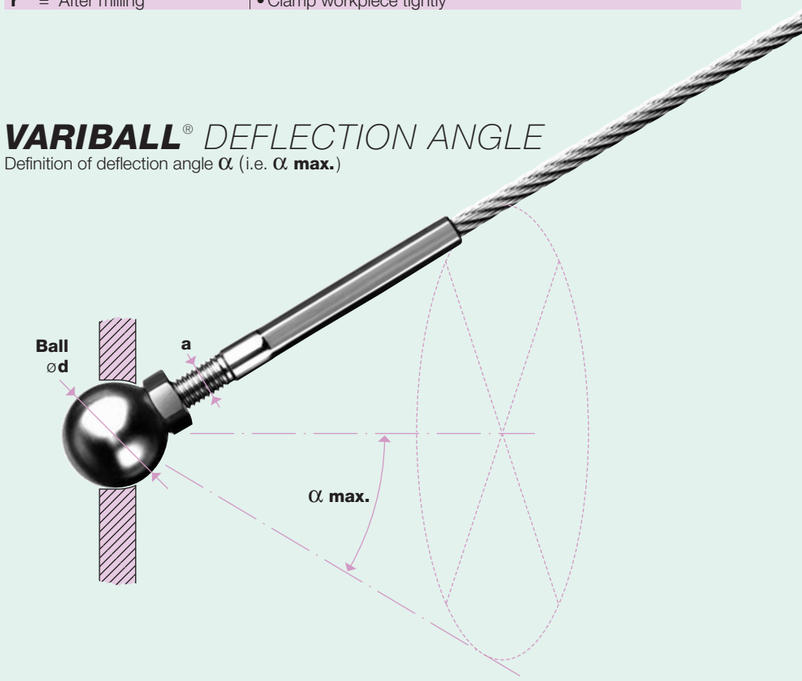
VARIBALL® *TEMPLATE*

Only for bench drills with depth stops

Sketch	Drilling procedure
d1 = After milling	• Predrill (about 2 mm less than rated ø)
d2 = Ball ø – 1 mm	• Finish with ***VARIBALL***® *COUNTERSUNK MILL*
k = Wall thickness	• Accurately set depth stop
r = After milling	• Clamp workpiece tightly

VARIBALL® *DEFLECTION ANGLE*

Definition of deflection angle α (i.e. **α max.**)



Measure assembly lengths like this: