

DEEP HOLE DRILLING

include components for automatised production. In this case, the customer decided against an automatised solution due to cost reasons and commissioned us to install a manual device."

Frequently, the diameters of the coolant holes in a tool shank differ. For drilling from both sides, the user embraces the workpiece. A stop ensures exact positioning. A clamping screw fixes the cylindrical shanks, which are equipped with a milled groove for this purpose. In the shown variant the drilled hole with d1 proceeds inclined and outside of the middle axis. In the middle of the workpiece, it meets the drill hole with d2 which is also eccentrically positioned but parallel to the middle axis.

The slanted d1 drill hole must meet the d2 drill hole exactly at this position to prevent improper cross-sectional constriction.

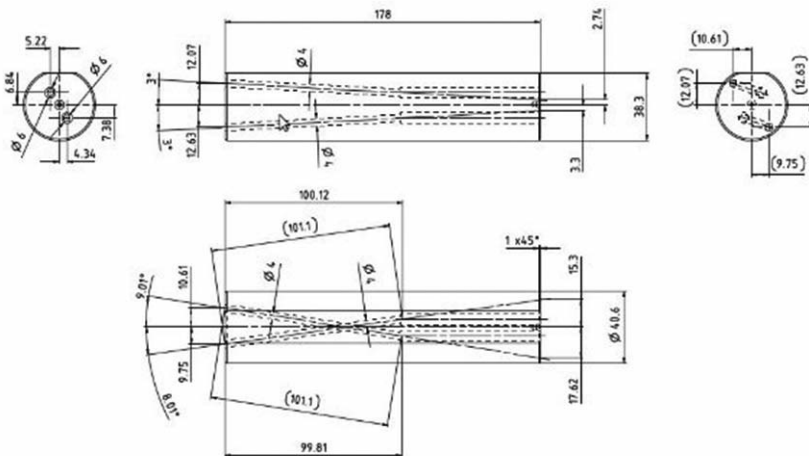
Due to significant varying drilling depths of the different workpiece variants, the manufacturer uses the drill bush carrier in two ways: for depths up to approx. 200 mm, immersion sleeves are used which realise the contacting movement of the drill bushes to the workpiece by using springs; for higher drilling depths, the user disassembles the

immersion sleeves and uses a sealing case. In this case, there is also the possibility of installing a tool steady for the support of the deep hole drilling tools.

Andreas Schlegel concludes: "Our solution includes a lot of ingenious details. All deflections can be adjusted quite simple and with the sufficient precision in using either scales or digital displays. Since even small angle deflections will cause a large transverse offset in long workpieces, the available space in the ML200 was initially a

hot topic of discussion. However, the engineers were able to combine all the requirements, quality and available space. The customer didn't have to invest in a larger machine, which was one of his main issues. Also, for all drilling processes, the standard safety guard can still be closed."

TBT UK Ltd
Tel: 01675 433250
Email: info@tbtuk.com
www.tbtuk.com



Expert deep hole drilling solutions from a single source



- Our machine sales range includes:
- Horizontal deep hole drilling/boring machines
 - Deep hole drilling/milling centres

Subcontract honing & turning



Subcontract deep hole drilling & boring



- Gun drilling
- Deep hole boring
- CNC turning up to 4 m in length
- CNC honing up to 4 m in length
- Small or large cylindrical or prismatic components
- Sales and service of gundrilling machines and tools
- Extensive range of gundrill diameters in stock
- Express turnaround available

