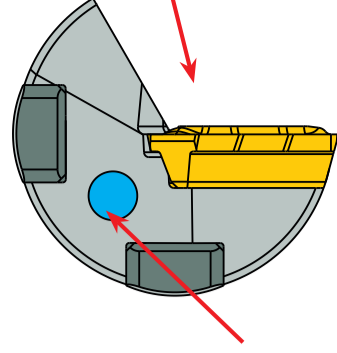


Wide Flute Angle

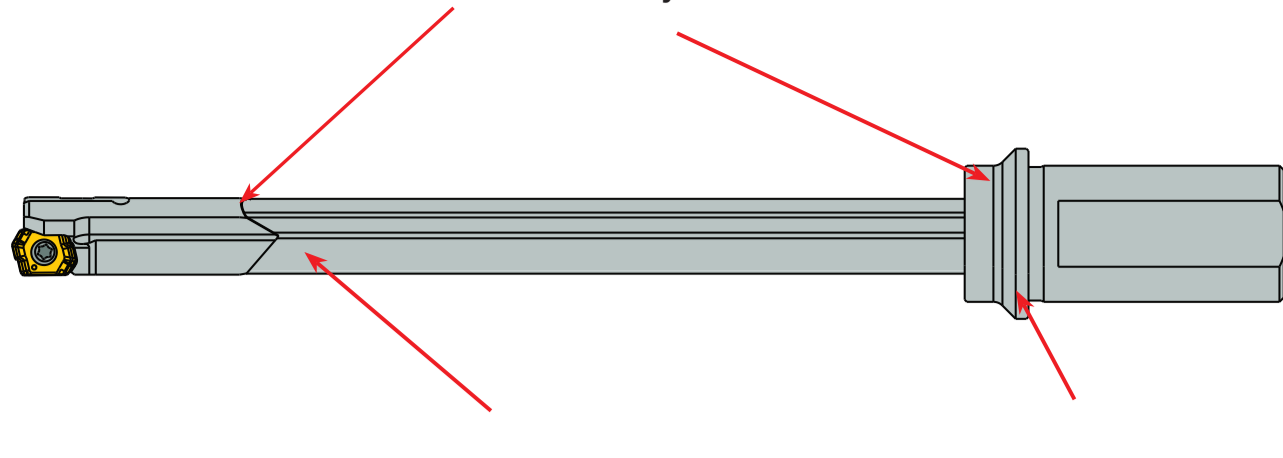
- Smooth chip evacuation



Large Cooling Hole

- Efficient lubrication
- Longer life of inserts and guide pads

Brazed Body



Steel Body

- Extremely high rigidity
- Simple direct mounting setup

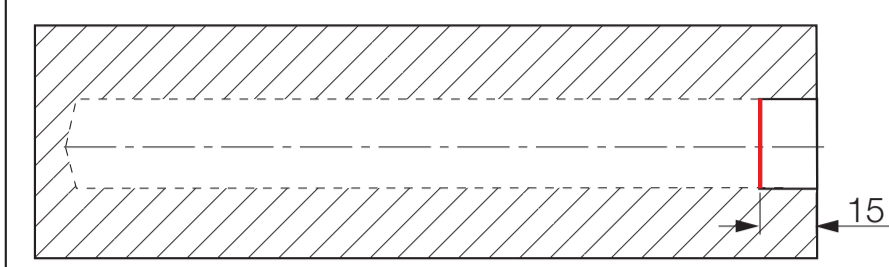
Flange

- Superior rigidity for higher speeds and feeds

Drilling Process on Machining Centers and Lathe Machines

- 1 Drill a 15 mm pilot hole $D_{+0.05}^{+0.03}$ flat bottom
- 2 Set the TRIDEEP drill into the pilot hole (10 mm depth). $V_c=5-10$ m/min $f=0.5-1.0$ mm/rev
- 3 Initial cutting at a 25 mm DOC (80% feed rate), verify activated coolant ($V_c=100\%$).
- 4 In case of through hole, drill the full hole to a depth of +5 mm.
- 5 Retract with slow rotation (5-10 m/min).

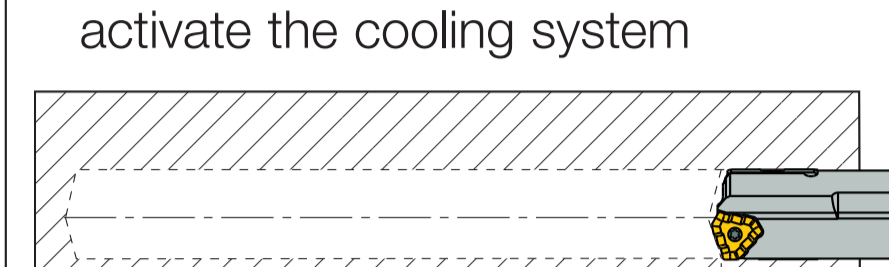
1 Drill a 15 mm pilot hole flat bottom



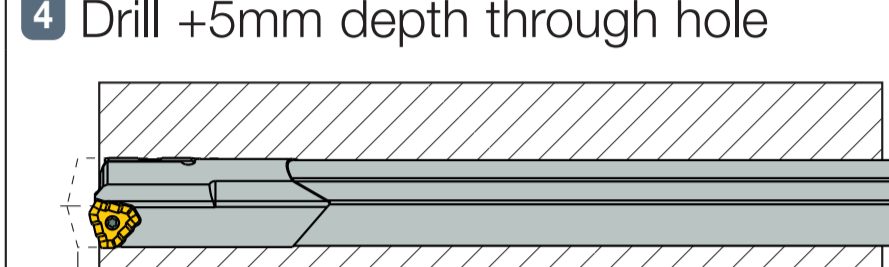
2 Slow rotation and feed while entering to the pre-hole



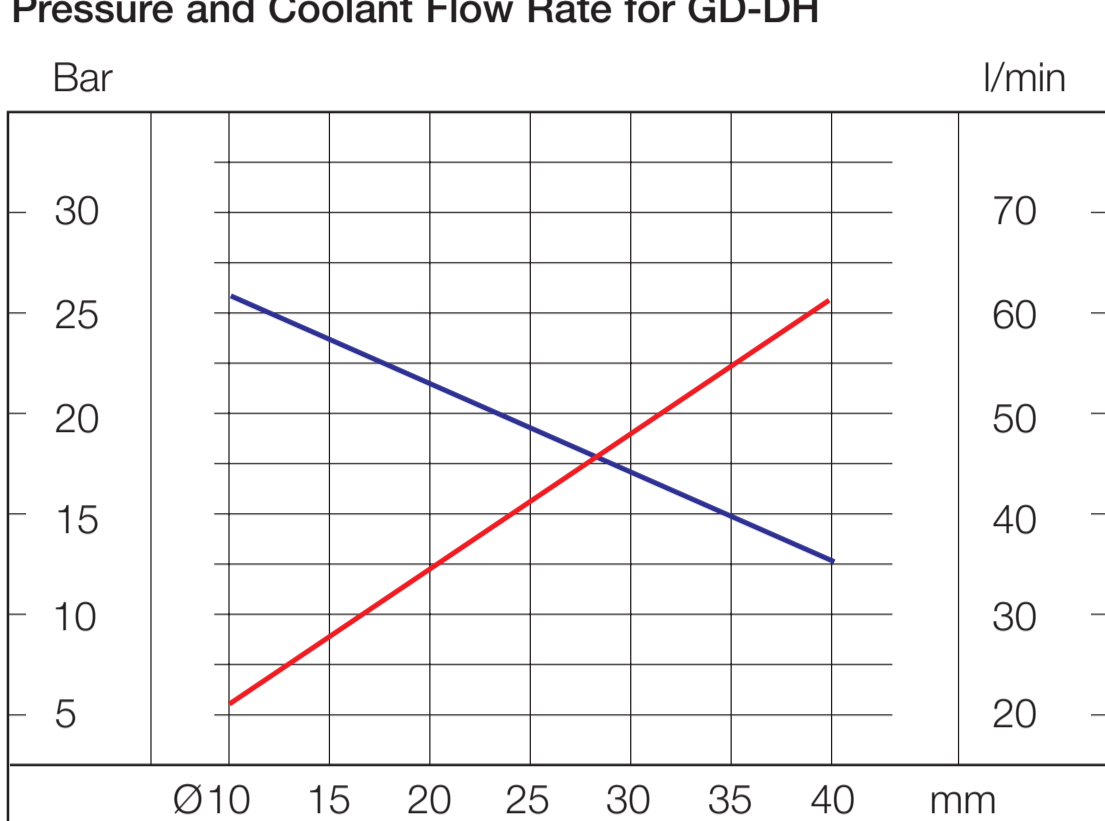
3 Maintain for 2-3 seconds and activate the cooling system



4 Drill +5mm depth through hole

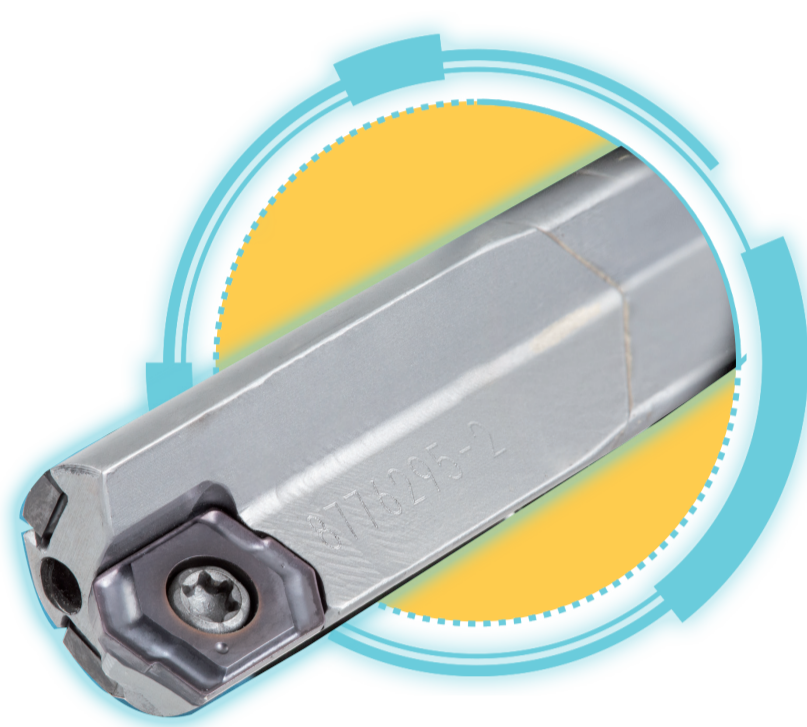


Pressure and Coolant Flow Rate for GD-DH

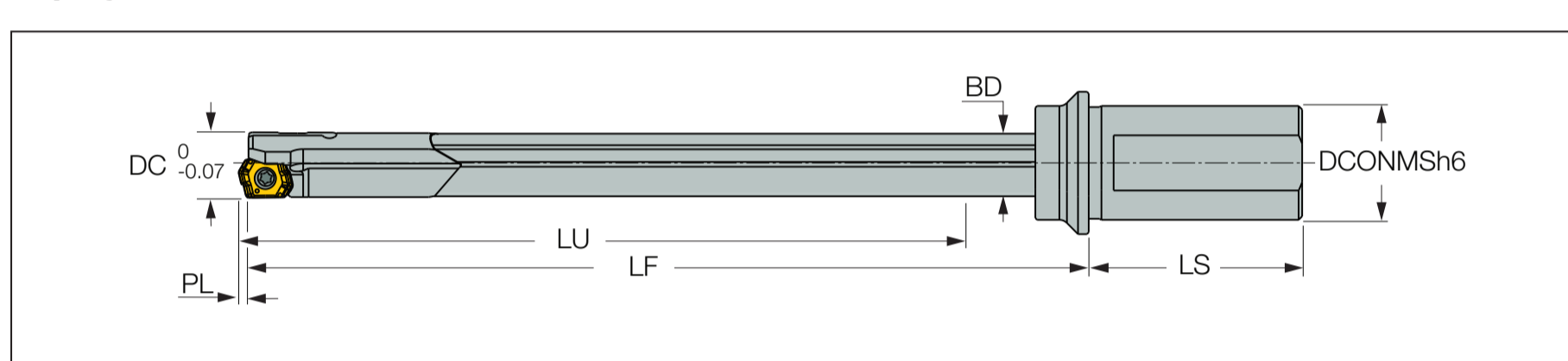


Q (l/min) P (bar)

Drilling Diameter



Inquiry Form



1. Tool

Quantity.....
Nominal diameter and tolerance
Please fill in dimensions on the sketch below.

Driver

Driver: for standard drivers please use codes
 Code No.
 Special, please attach sketch and specifications.

2. Workpiece

(If possible, attach a drawing)

2.1 Material

Material description (DIN material number or any other standard):
Hardness and Properties:

2.2 Hole Type

- Blind Hole Drilling into Pre-hole
 Angled Entry
 Drilling into Solid Boring Angled Exit
Drilling Depth inch Hole Tolerance

2.3 Application:

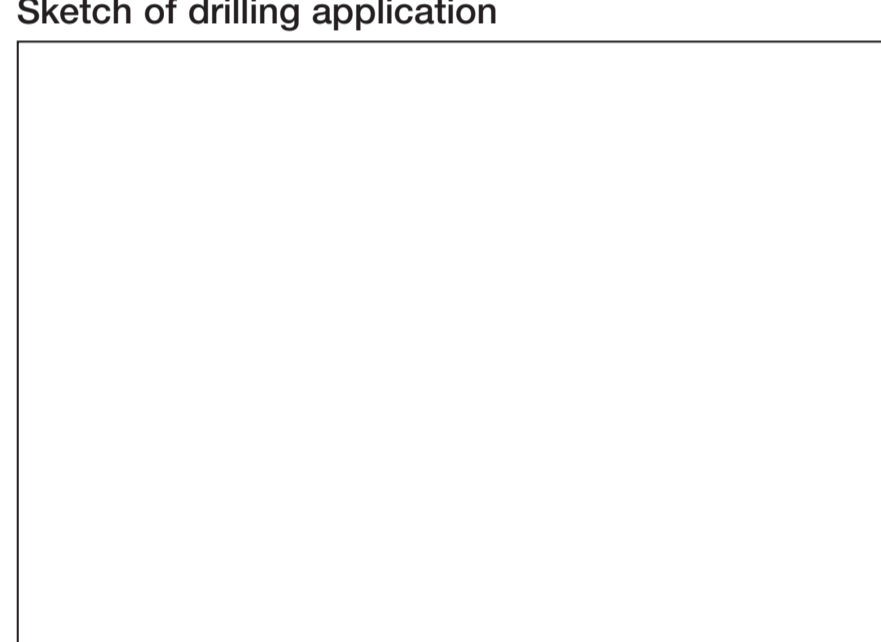
Workpiece: Stationary Rotating
Tool: Stationary Rotating

3. Machine

3.1 Technical Data

Machine Type.....
Power HP

Sketch of drilling application



Note: It may be necessary to change several of the parameters that you indicated, based on our experience with your application.

3.2 Cutting Data:

Cutting Speed V_c SFM
Revolutions N_{min} RPM, N_{max} RPM
Feed F_{min} in/rev,
 F_{max} in/rev.....
Feed Rate V_F in/min

Coolant:

Oil Soluble Oil Other
Coolant Pressure: PSI

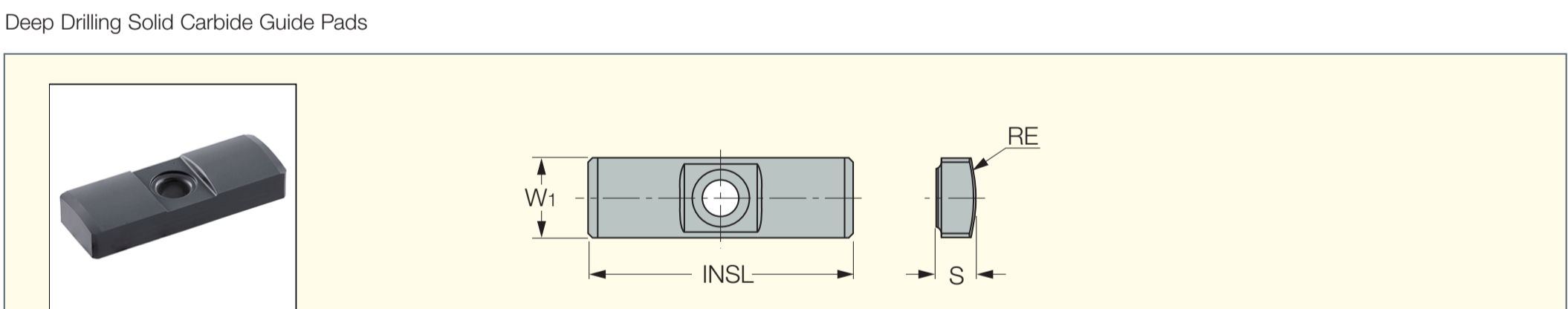
Specially Tailored TRIDEEP Code Key

GD - DH ##.## - #### - ##

Dia. Drilling Length Shank Type

GPS

Deep Drilling Solid Carbide Guide Pads



Metric

Designation	Dimensions				IC908
	W1	RE	INSL	S	
GPS-04-16-055	4.0	5.50	16.00	2.0	•

Inch

Designation	Dimensions				IC908
	W1	RE	INSL	S	
GPS-04-16-055	.157	.217	.630	.079	•

Spare Parts

Designation	Guide Pad Screw	Guide Pad Key
GPS-04-16-055	TS 20043/HG-P M2X0.4	Wrench IP-6/5

Standard Gundrill Drivers for Machining Centers, Lathes, etc.

Drivers

Drivers are available for dedicated and CNC machines, for any specified diameter and length. Below are the driver codes and technical data.

Driver Type	Drawing	øD x L	Driver Code
Cylindrical DIN1835A DIN6535HA		.75x2.03"	95
		20x50	10
		25x56	11
		1.00x2.28"	96
		1.25x2.28"	97
Weldon DIN1835B DIN6535HB		.75x2.03"	93
		20x50	22
		25x56	23
		1.00x2.28"	100
		1.25x2.28"	101
Whistle Notch DIN1835E		20x50	34
		25x56	35
		32x60	36
		40x70	37

Standard Drivers for Gundrill Machines

Driver Type	Drawing	øD x L	Driver Code
DIN228AK		CM1	45
		CM2	46
		CM3	47
		CM4	48
DIN228BK		CM1	49
		CM2	50
		CM3	51
		CM4	52
Central Clamping Surface 15°		.750x2.75"	56
		25x70	57
		1.00x2.75"	58
		1.25x2.75"	59
		1.50x2.75"	60
Frontal Clamping Surface 15°		16x50	61
Cylindrical with Thread		25x100 M16x1.5	66
		36x120 M24x1.5	67
VDI Design		25x112 M16x1.5	70
		36x135 M24x1.5	71
Central Clamping Hexagonal		25x70	72
		32x70	73
Central Clamping Tapered		.75x2.75"	76
		20x70	77
Frontal Clamping Surface 2°		1.00x2.75"	80
		1.00x3.94"	81
		1.25x2.75"	82
		1.25x3.94"	83
		1.50x2.75"	84
Trapezoidal Thread		28x126 Tr 28x2	88
		36x162 Tr 36x2	89
Spraymist Driver		25x50	91
		35x60	92