

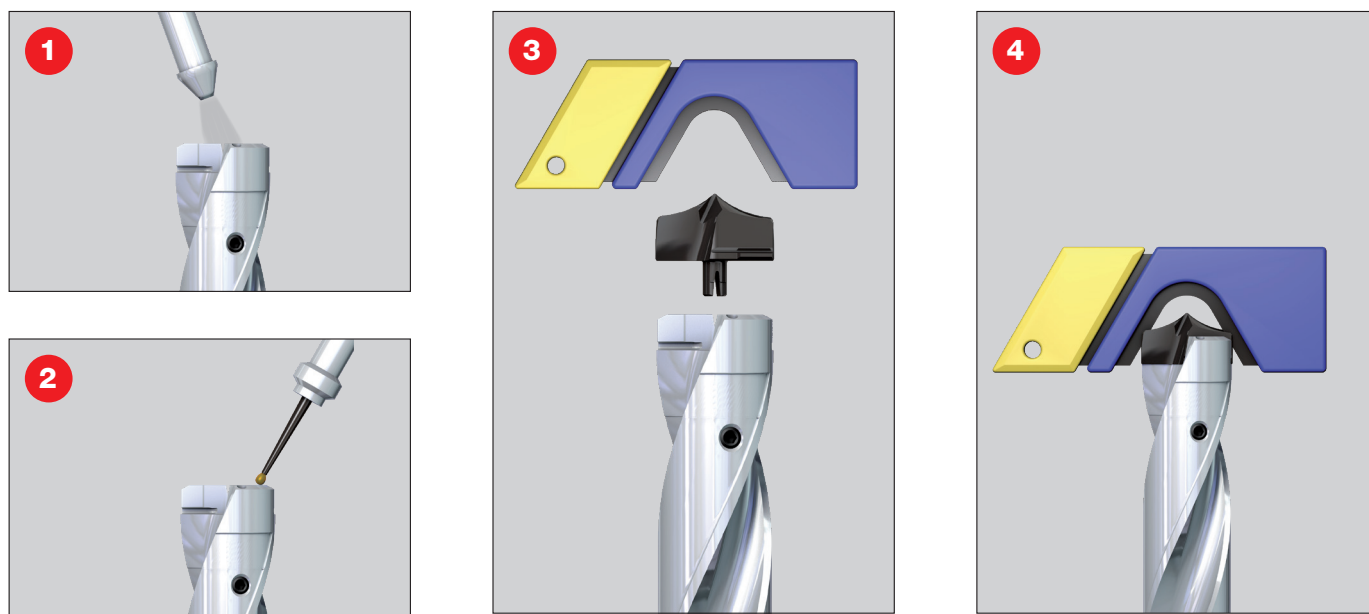
MODUDRILL

MODULAR HEADS

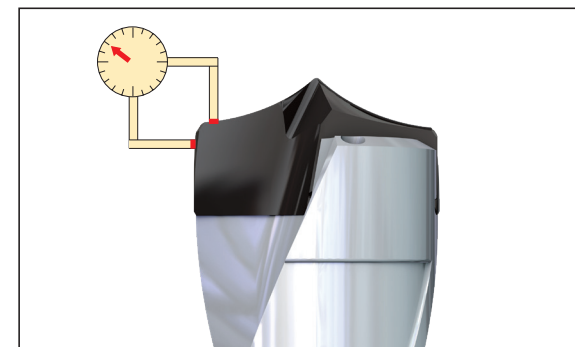
Head and Body Assembly



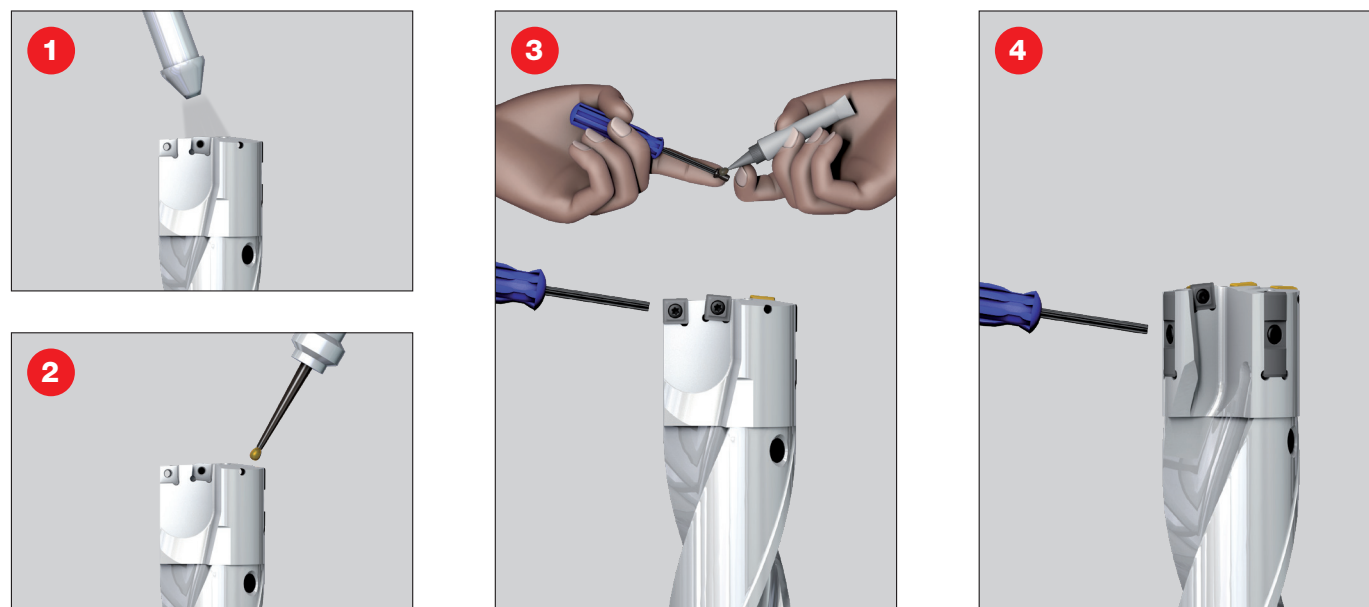
MD-DFN Head Assembly



For MD-DFN Head
Max allowed $\Delta = 0.04$ mm
Axial runout & Radial runout



MD-DR-DH Inserts Assembly

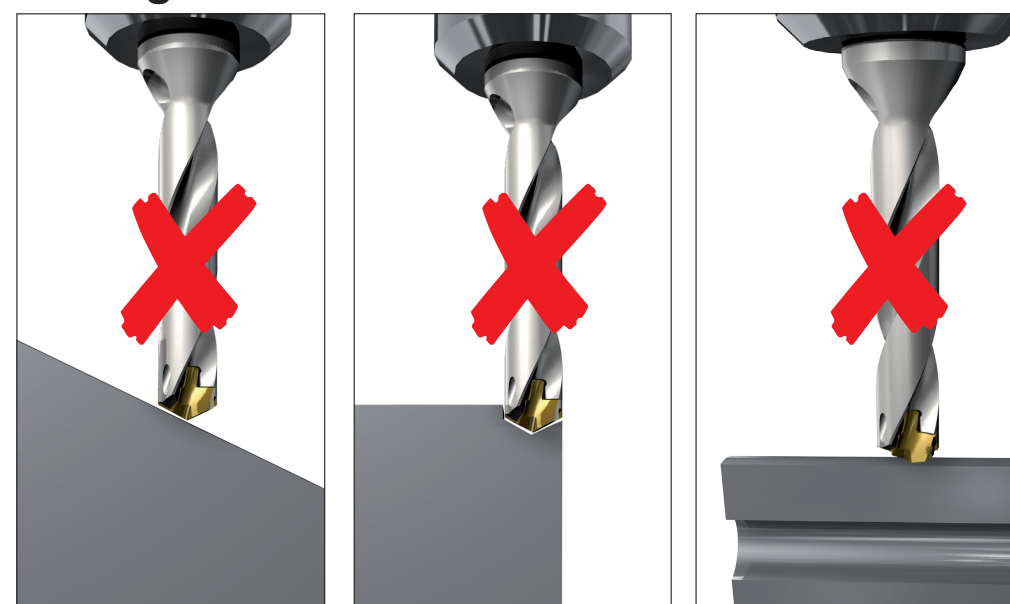


Important:

For MD-DR-DH Head

- A short pre-hole 1xD deep minimum with H8 hole tolerance and **FLAT BOTTOM MUST** be prepared to guide the long drill (an endmill can be used)
- Use HD chip breaker for internal insert
- When using the MD-EXTENSION, a short pre-hole of 1xD deep minimum with H8 hole tolerance and **FLAT BOTTOM MUST** be prepared to guide the long drill (an endmill can be used) **for all drilling head types**

Drilling Limitations



Flow Rate vs. Pressure & Drill Diameter

Drill Diameter (mm)	Pressure (bar)	Flow Rate (liter/min)
33	20	60
34	20	60
35	20	60
36	20	60
37	20	60
38	20	70
39	20	70
40	20	70

• Internal coolant supply only