1. Before using the drills make sure the machine has the necessary equipment to do proper deep hole drilling. The machine should have suitable guarding for protection from cutting chips and coolant for operation. Check with machine builder!

2. Improper use or handling of deep hole drilling tools can cause serious injuries, e.g. skin cuts from the cutting edge.

3. Deep hole drilling tools are not self-centering and can be unbalanced. Therefore the drills must be guided during the start of the drilling cycle by means of a following long drill bush or pilot hole.

4. Tools support: unsupported drill length should never exceed the dimensions as shown on table (vertical page). Do not exceed the dimensions as shown on page (horizontal page). If the unsupported drill length is exceeded the tool might cause injury. Check with machine builder!

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6. The gundrill is fed into the pilot hole or drill bush slowly at < 50 RPM. Then the coolant and the machine spindle should be started.

7. After reaching the drilling depth switch off the coolant and retract with the spindle stopped or slowly rotated at < 50 RPM.

8. Grinding of carbide produces dust (cobalt, etc.) that may be potentially hazardous. Use adequate ventilation and safety glasses during grinding.

Guidelines:

The values specified in this catalogue are guide values only and can vary depending on your application.

Please note that all application notes and values contained herein are intended as guidelines only. We do not accept any liability for damages caused by improper handling of botek deep hole drilling tools, operations errors, unsuitable machinery or misuse when using our tools.

Do you have any further queries? Please call us at +49-(0)-71 23-38 08-0. We will be pleased to offer you advice.

Safety information:

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Suitable coolant, i.e. deep hole drilling oil or emulsion (min. 10-12% concentration, with additives) min. clearance

Drill diameter range 1.000 – 26.000 mm
Two flute spiral tool, coolant fed or not coolant fed

ISO tolerance F8 is possible under specific conditions. To avoid chipping of the cutting edge, a chamfered pilot hole (F)
For precise holes we recommend to use the ISO tolerance G6. The dimensions specified in the table are guide values.

The quality of the pilot hole affects the drilling performance (tool life, entrance deviation, etc.)

The drill is a single-edged tool without self-centering. After piercing the drill, the tool must be guided through a drilled hole (a guide hole).

The type of coating is aligned due to processed material, coolant and drilling situation.

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