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DEEP DRILLING INSERTS

CEMENTED CARBIDE



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Production Capacity

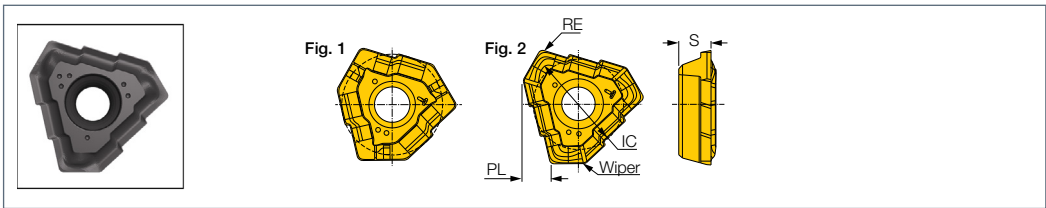
Weikeduo possesses high-precision mold production lines, automated and efficient inclinable ball mills and spray drying granulation system, fully automated TPA pressing and forming equipment, imported pressure sintering furnaces, as well as a constant temperature and humidity-controlled production environment. These highly specialized and automated production facilities fully ensure the stability of product quality and the efficiency of production.



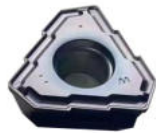


Deep Hole Drilling Inserts TOGT- DT

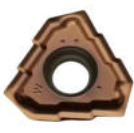
Deep Drilling Inserts with 3 Chip Splitting Cutting Edges, a Positive Rake Chipbreaker and a Wiper.



	Dimensions					VKD304/VKD301
Designation	IC	RE	PL	S	Fig.	
TOGT 070304-DT	7.69	0.40	1.95	2.30	1	
TOGT 080305-DT	8.55	0.50	2.20	2.80	1	
TOGT 090305-DT	8.32	0.50	3.00	3.00	2	
TOGT 100305-DT	9.23	0.50	3.20	3.30	2	
TOGT 110405-DT	10.40	0.50	3.40	3.80	2	
TOGT 120405-DT	11.59	0.50	3.60	4.30	2	
TOGT 130408-DT	12.85	0.80	4.57	4.76	2	



TOGT –DT - VKD304

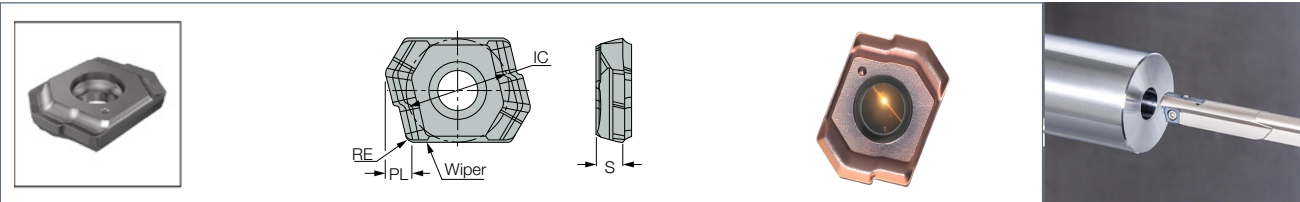


TOGT –DT - VKD301

Problem	Cause	Solution	
		Grade	Cutting Conditions / Other
1. Chipping, Fracture	- excessive vibration or impact - torn away built-up edge	use a tough grade	- reduce the feed rate - eliminate the vibration
2. Flaking	excessive vibration or impact	use a tough grade	- reduce the feed rate - eliminate the vibration
3. Flank Wear	- cutting speed too high - inadequate tool toughness	- use a grade with high wear resistance - use a coated grade	- reduce the cutting speed - reduce the feed rate - use coolant properly
4. Crater Wear	- cutting speed too high - feed rate too high - inadequate tool toughness	- use a grade with high wear resistance - use a coated grade	- reduce the cutting speed - reduce the feed rate - use coolant properly
5. Initial Chipping	- inappropriate guide bush or pilot hole - misalignment	use a tough grade	- adjust or change the guide bushing or pilot hole - reduce the feed rate - correct the misalignment

Deep Hole Drilling Inserts LOGT- DT

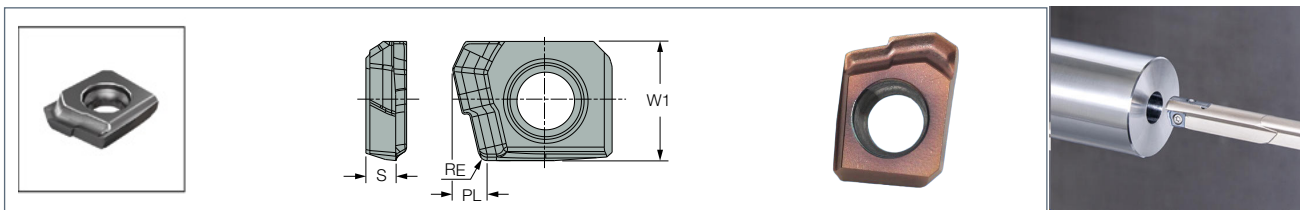
Deep Drilling Inserts with 2 Chip Splitting Cutting Edges, Positive Rake Chipbreaker and a Wiper.



	Dimensions			
Designation	IC	RE	PL	S
LOGT 060204R-DT	7.00	0.40	1.80	2.00

Deep Hole Drilling Inserts ZSGT- DT

Deep Drilling Inserts with Single Chip Splitting Cutting Edge and a Wiper.

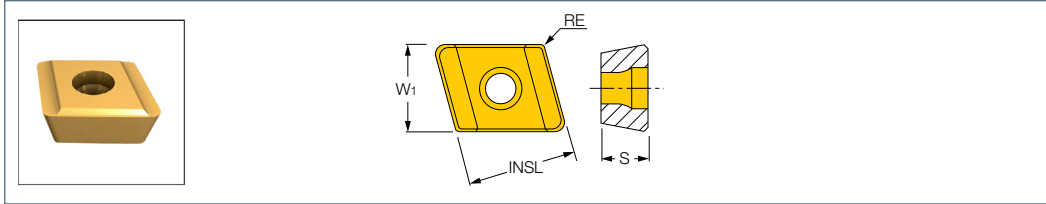


	Dimensions			
Designation	IC	RE	PL	S
LOGT 060204R-DT	7.00	0.40	1.80	2.00



Deep Hole Drilling Inserts NPHT- G

Peripheral Precision Inserts for Drilling Heads.

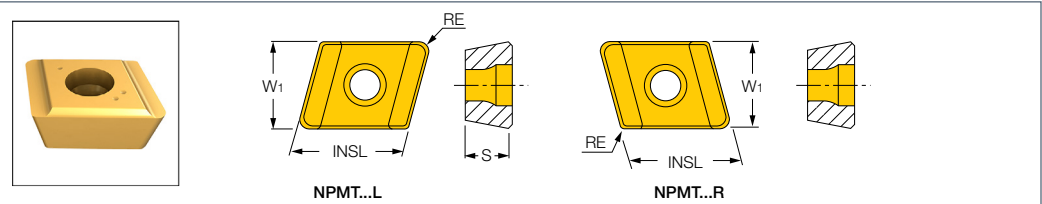


Dimensions				
Designation	W1	INSL	S	RE
NPHT 060308R-G-P	6.00	8.00	3.00	0.80
NPHT 070408R-G-P	7.50	10.00	4.00	0.80
NPHT 090408R-G-P	9.00	10.00	4.00	0.80
NPHT 110408R-G-P	11.00	10.00	4.00	0.80

Customized production is available upon request.

Deep Hole Drilling Inserts NPMT- G

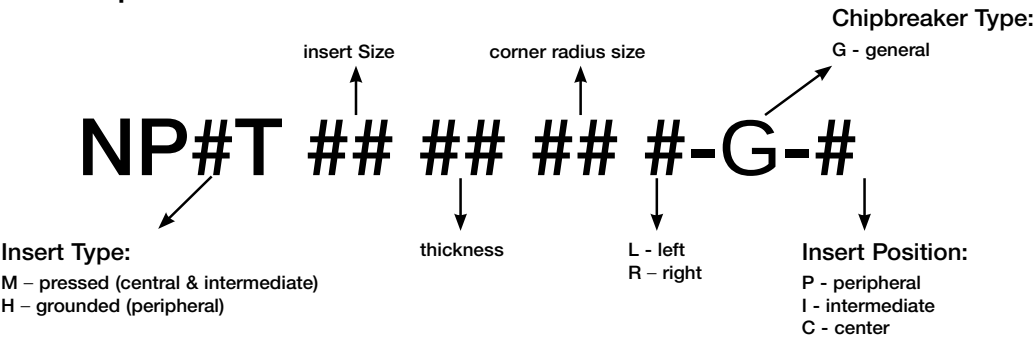
Internal and Central Inserts for Drilling Heads



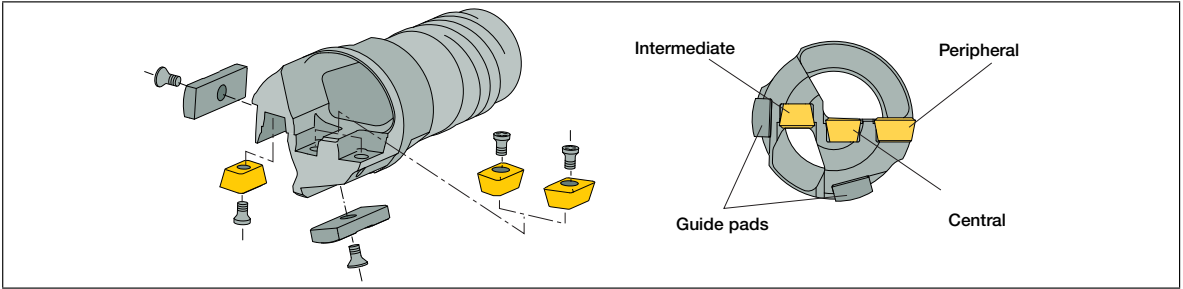
Dimensions				
Designation	W1	INSL	S	RE
NPMT 050304R-G-I	5.50	8.00	3.00	0.40
NPMT 060404R-G-I	6.50	10.00	4.00	0.40
NPMT 080404R-G-I	8.00	10.00	4.00	0.40
NPMT 090404R-G-I	9.50	10.00	4.00	0.40
NPMT 060408L-G-C	6.50	10.00	4.00	0.80
NPMT 080408L-G-C	8.00	10.00	4.00	0.80
NPMT 090408L-G-C	9.50	10.00	4.00	0.80
NPMT 120408L-G-C	12.50	10.00	4.00	0.80

Customized production is available upon request.

Insert Description:



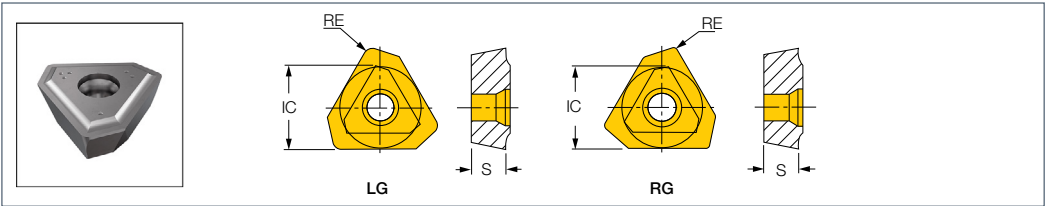
Spare Parts List



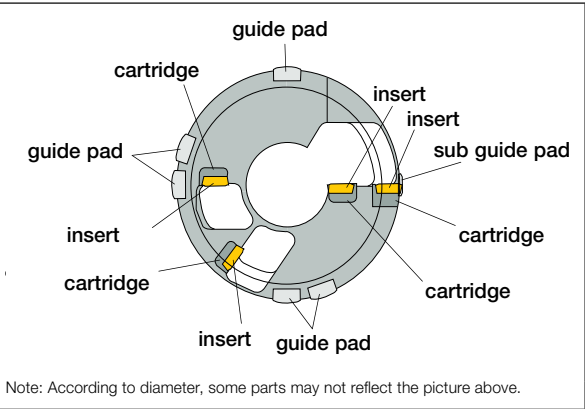
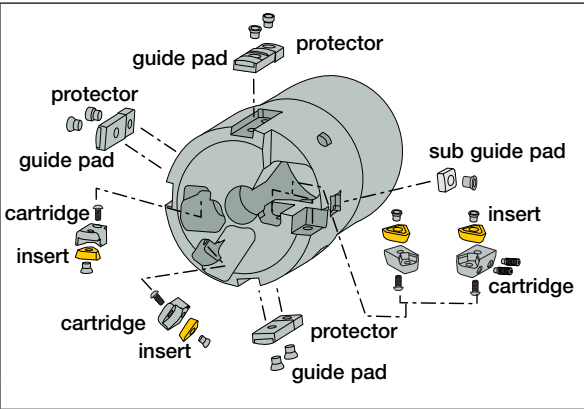


Deep Hole Drilling Inserts TPMX

Inserts for Drilling / Counterboring / Trepanning Tools



	Dimensions		
Designation	IC	S	RE
TPMX 090208R-B	7.55	2.75	0.80
TPMX 090208R-G	7.55	2.75	0.80
TPMX 140304R-B	8.45	3.50	0.40
TPMX 140304R-G	8.45	3.50	0.40
TPMX 140308R-B	8.45	3.50	0.80
TPMX 140308R-G	8.45	3.50	0.80
TPMX 170404R-B	10.30	4.00	0.40
TPMX 170408R-B	10.30	4.00	0.80
TPMX 170408R-G	10.30	4.00	0.80
TPMX 240504R-B	14.20	5.50	0.40
TPMX 240512R-B	14.20	5.50	1.20
TPMX 240512R-G	14.20	5.50	1.20
TPMX 280708R-B	17.00	7.50	0.80
TPMX 280716R-B	17.00	7.50	1.60
TPMX 280716R-G	17.00	7.50	1.60

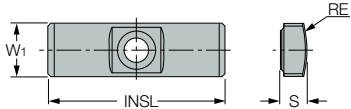


Note: According to diameter, some parts may not reflect the picture above.

G			B		
	versatile			good chip control for heat-resistant alloy	

Deep Hole Drilling GPS Guide Key

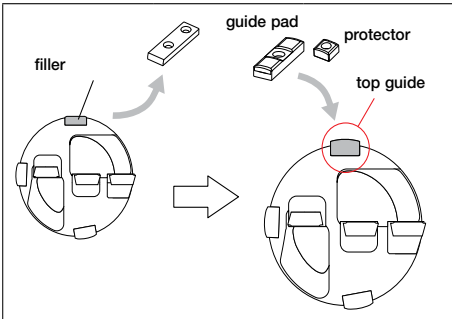
Deep Drilling Solid Carbide Guide Pads for ISCAR



	Dimensions			
Designation	W1	INSL	S	RE
GPS-04-16-045-DC	4.0	16.00	1.80	4.50
GPS-04-16-050-DC	4.0	16.00	1.80	5.00
GPS-04-16-055-DC	4.0	16.00	2.00	5.50
GPS-05-18-060-DC	5.0	18.00	2.50	6.00
GPS-05-18-075-DC	5.0	18.00	2.50	7.50
GPS-06-20-075-DC	6.0	20.00	3.00	7.50
GPS-06-20-075	6.0	20.00	3.00	7.50
GPS-06-20-085-DC	6.0	20.00	3.00	8.50
GPS-06-20-085	6.0	20.00	3.00	8.50
GPS-06-20-100-DC	6.0	20.00	3.00	10.00
GPS-06-20-100	6.0	20.00	3.00	10.00
GPS-06-20-120-DC	6.0	20.00	3.00	12.00
GPS-06-20-120	6.0	20.00	3.00	12.00
GPS-07-20-120-DC	7.0	20.00	3.50	12.00
GPS-07-20-120	7.0	20.00	3.50	12.00
GPS-08-25-155-DC	8.0	25.00	4.50	15.50
GPS-08-25-155	8.0	25.00	4.50	15.50
GPS-10-30-200-DC	10.0	30.00	4.50	20.00
GPS-10-30-200	10.0	30.00	4.50	20.00
GPS-10-35-200-DC	10.0	35.00	6.00	20.00
GPS-10-35-200	10.0	35.00	6.00	20.00
GPS-12-35-250-DC	12.0	35.00	5.50	25.00
GPS-12-35-250	12.0	35.00	5.50	25.00

Please replace the filler with the top guide pad when:

- High hole accuracy is required.
- L/D (hole length-to-diameter) ratio is greater than 50:1.
- Drilling a workpiece which has a tail stock hole.
- The DOC required is greater than the range of the peripheral insert for counterboring. *See chart below.



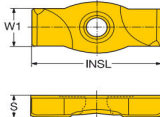
*Maximum DOC of peripheral insert.



Deep Hole Drilling GPS Guide Key

Deep Drilling Solid Carbide Guide Pads

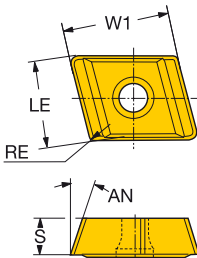
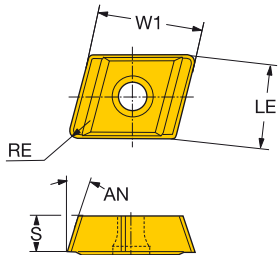
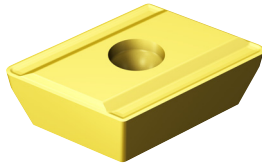


				
Type	INSL	W1	S	Range(mm)
800-06A	18	6	3	φ25-31
800-07A	20	7	3.5	φ31.01-39.6
800-08A	25	8	4.5	φ39.61-47
800-10A	30	10	4.5	φ47.01-54.99
800-12A	35	12	5.5	φ55.00-65.00
800-14D	35	14	7	φ63.5-74.99
800-16D	35	14	7	φ75.0-84.99
800-18D	35	14	7	φ85.0-99.99
800-20D	50	20	8.5	φ100-109.99
800-24D	50	20	8.5	φ120-129.99

Support pad	Shim set (8 pcs)	S
800-06A	5549 127-85	0.02
	5549 127-86	0.03
800-07A	5549 127-88	0.02
	5549 127-89	0.03
800-08A	5549 127-91	0.02
	5549 127-92	0.03
800-10A	5549 127-94	0.02
	5549 127-95	0.03
800-12A	5549 127-97	0.02
	5549 127-98	0.03

Note: Do not add more than 0.05 mm thickness of shims

Insert For Drilling

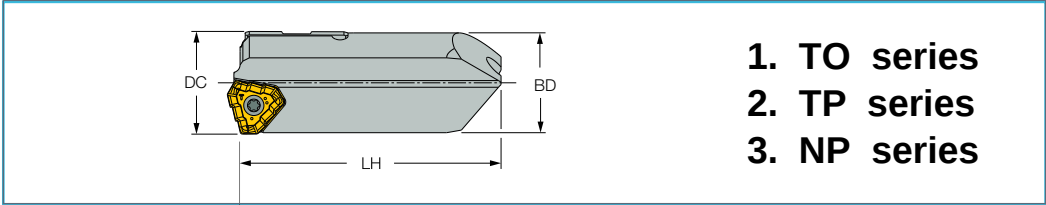
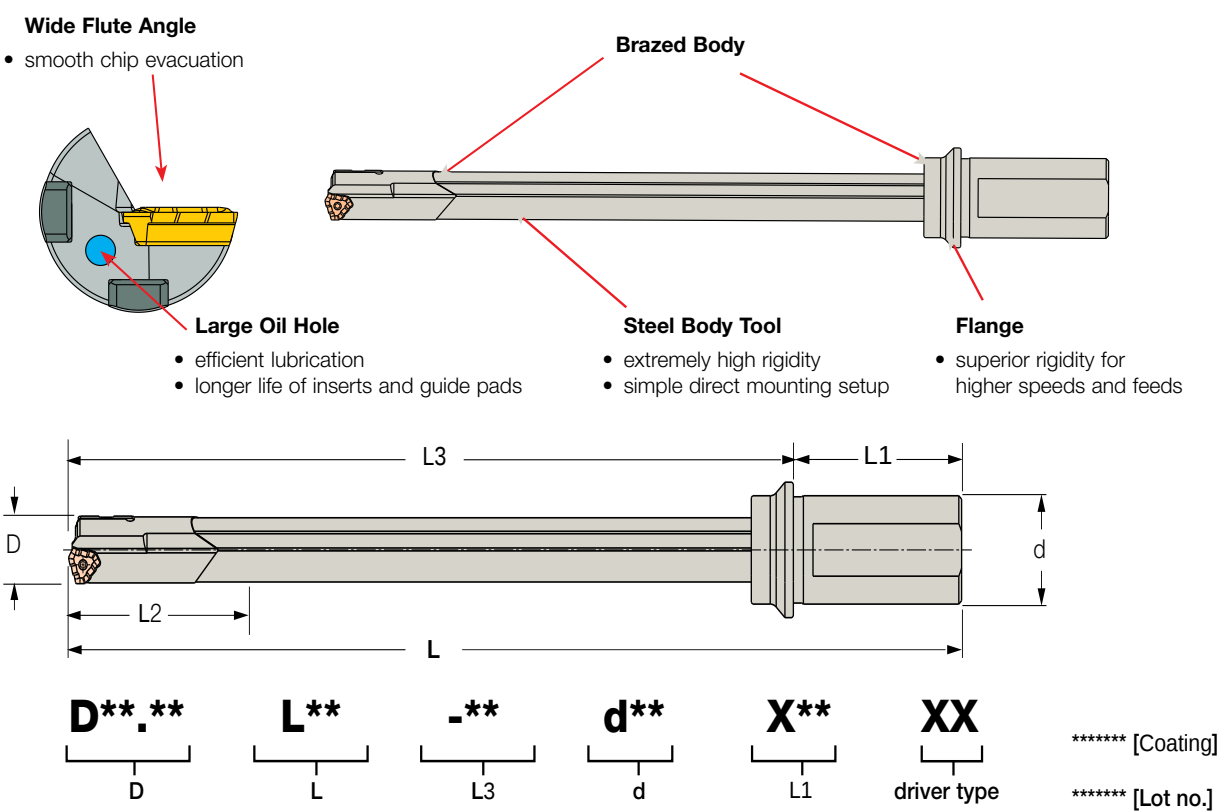


		Ordering code			Ordering code
	05	800-05 03 08M-C-G		05	800-05 03 08M-I-G
	06	800-06 T3 08M-C-G		06	800-06 T3 08M-I-G
	08	800-08 T3 08M-C-G		08	800-08 T3 08M-I-G
	10	800-10 T3 08M-C-G		12	800-12 T3 08M-I-G
	12	800-12 T3 08M-C-G		05	800-05 03 08M-I-L
	05	800-05 03 08M-C-L		06	800-06 T3 08M-I-L
	06	800-06 T3 08M-C-L		08	800-08 T3 08M-I-L
	08	800-08 T3 08M-C-L		12	800-12 T3 08M-I-L
	10	800-10 T3 08M-C-L			
	12	800-12 T3 08M-C-L			

Customized production is available upon request.



Universal Marking for Deep Drilling Tools



Insert:
1.ZSGT
2.LOGT
3.TOGT
4.TPMX
5.NPHT

Deep Hole Drilling Tools

Compare with brazed gundrills, indexable gundrills have good performance at chips removal, high feed rate, and easy to change inserts. But the indexable type gundrills have lower accurate, poor performance at cross holes, it also require machines with more stability. Normally indexable gundrills use on blind holes, tube sheet, shaft holes etc, no more accuracy requirement processing.

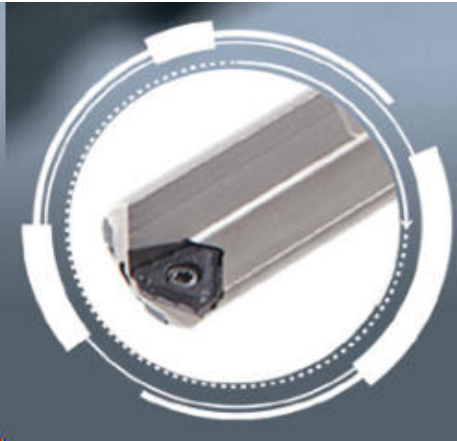
Indexable gun drills cutting parameters:

Material	Cutting Speed	Drill Bit Dia / Feed Rate mm/rev		
	Vc m/min	D12.00-22.00mm	D22.50-26.00mm	D26.50-35.00mm
Construction steel <700/mm	80-100	0.055-0.100	0.080-0.110	0.100-0.140
Case hardened steel <700/mm	80-100	0.055-0.100	0.080-0.110	0.100-0.140
Case hardened steel <1100/mm	70-80	0.070-0.100	0.080-0.110	0.100-0.130
Heat treated steel <700/mm	70-90	0.070-0.100	0.080-0.110	0.100-0.140
Heat treated steel <1100/mm	55-75	0.070-0.100	0.080-0.110	0.100-0.130
Nitriding steel <1100/mm	55-75	0.070-0.090	0.080-0.100	0.090-0.120
Ferritic steel <900/mm	60-80	0.070-0.100	0.080-0.110	0.100-0.140
Austenitic steel	60-80	0.070-0.090	0.080-0.100	0.100-0.120
Heat resisting steel / Tool steel	50-70	0.070-0.090	0.080-0.100	0.100-0.120
Steel castings <700/mm	60-80	0.070-0.100	0.080-0.100	0.100-0.140
Nodular cast iron <700/mm	65-80	0.090-0.120	0.100-0.130	0.120-0.150
Cast iron alloyed and unalloyed	70-100	0.090-0.120	0.100-0.130	0.120-0.150
Aluminum	100-120	0.080-0.110	0.090-0.120	0.100-0.140
Copper / Cu-content <99%	120-300	0.050-0.090	0.060-0.100	0.080-0.120

Parameters above are average values as a guide,the setting based on tool length,cooling lubricant, material,machine stability,workpiece clamping etc.

Recommended Support Guide Shape

A support guide may be needed to assure a stable drilling process. The use of a dedicated shaped guide bush is recommended.



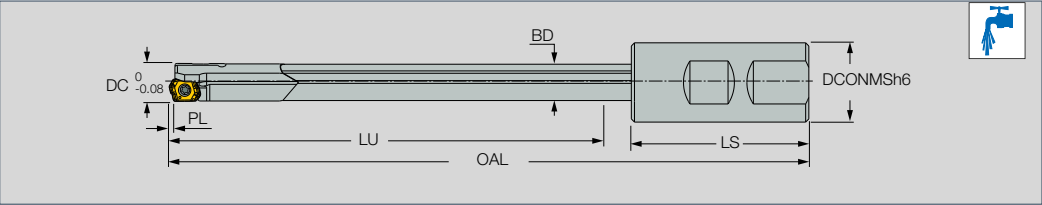
Indexable Gundrills (TO series)

Deep Drilling Tools

Accessories (Single Insert)

Dimensions					
					
Size	Insert	Guiding pad	Insert screw	Pad screw	Wrench
8.00 - 9.00					
9.50 - 10.50	ZSGT060204R	GP-04-045	M2.5x4	M2x3.5	T6/T7
11.00	ZSGT060204R	GP-04-050	M2.5x4	M2x3.5	T6/T7
11.50 - 12.00	LOGT060204R	GP-04-055	M2.5x4.5	M2x3.7	T6/T8
12.50 - 13.50	LOGT060204R	GP-04-055	M2.5x5	M2x3.7	T6/T8
14.00 - 15.50	LOGT070304R	GP-05-060	M2.5x5/6	M2.2x4.5	T7/T8
16.00 - 17.50	LOGT080305R	GP-05-075	M2.5x6	M2.2x4.5	T7/T8
18.00 - 19.50	LOGT090305R	GP-06-085	M2.5x6	M2.5x5/6	T8
20.00 - 20.50	LOGT100305R	GP-06-085	M3x7	M2.5x6	T8/T10
21.00 - 21.50	LOGT100305R	GP-06-100	M3x7	M2.5x6	T8/T10
22.00 - 24.50	LOGT110405R	GP-06-100	M3.5x9	M2.5x6	T8/T15
25.00 - 28.50	LOGT120405R	GP-06-120	M4x10	M2.5x6	T8/T15
29.00 - 29.50	LOGT130408R	GP-06-120	M5x11	M2.5x6	T8/T20
30.00 - 32.50	LOGT130408R	GP-07	M5x11	M3x6.5	T8/T20
33.00 - 33.50	LOGT140508R	GP-07	M5x13	M3x6.5	T8/T20

Gundrill diameter less than 33.5mm adapt 1 insert. bigger diameter gundrills adapt to 3 inserts.



* This image is for reference only.

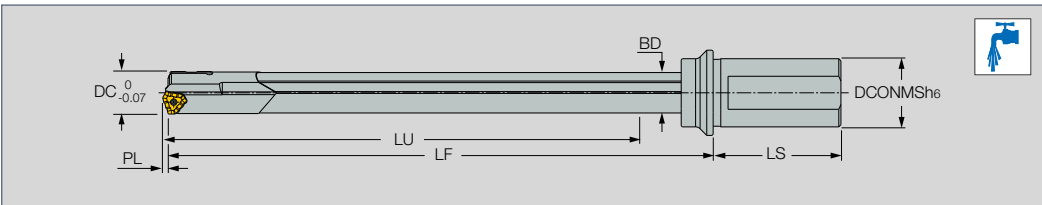
Indexable Gundrills (TP series)

Deep Drilling Tools

Accessories (Single Insert)

Dimensions					
					
Size	Insert	Guiding pad	Insert screw	Pad screw	Wrench
8.00 - 13.50					
14.00 - 15.50	TPMX100206	GP-05-060	M2.5x5/6	M2.2x4.5	T7/T8
16.00 - 17.50	TPMX100206	GP-05-075	M2.5x6	M2.2x4.5	T7/T8
18.00 - 18.50	TPMX1403RG	GP-06-085	M2.5x5.5	M2.5x5.5	T8
19.00 - 21.50	TPMX1403RG	GP-06-085	M2.5x6.5	M2.5x6	T8
22.00 - 22.50	TPMX1704RG	GP-06-100	M3.5x8.5	M2.5x6	T8/T15
23.00 - 24.50	TPMX1704RG	GP-06-100	M3.5x10	M2.5x6	T8/T15
25.00 - 25.50	TPMX1704RG	GP-06-120	M3.5x10	M2.5x6	T8/T15
26.00 - 29.50	TPMX2204RG	GP-06-120	M4x10	M2.5x6	T8/T15
30.00 - 35.50	TPMX2405RG	GP-07	M4x12	M3x6.5	T8/T15
36.00 - 38.50	TPMX2807RG	GP-07	M5x15	M3x6.5	T8/T20
39.00 - 40.50	TPMX2807RG	GP-08	M5x15	M3x8	T8/T20

Gundrill diameter less than 40.5mm adapt 1 insert. bigger diameter gundrills adapt to 3 inserts.



* This image is for reference only.



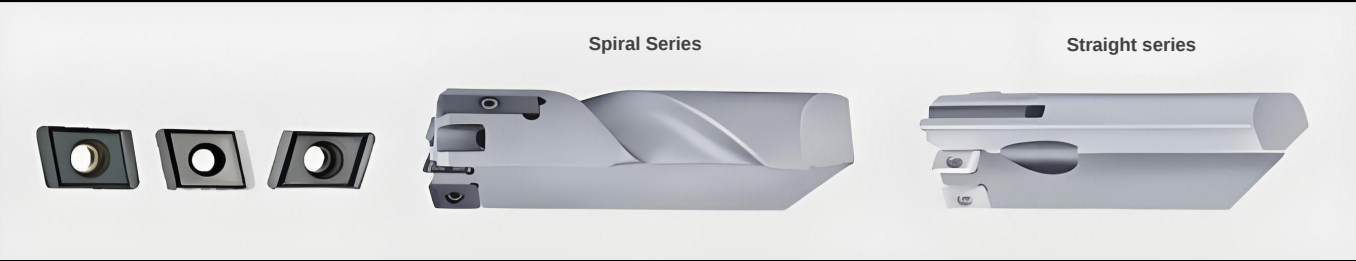
Indexable Gundrills

Deep Drilling Tools

Accessories (NP series Three inserts)

Size	- Inserts -			Dimensions		
	 Outer	 Inner	 Middle	 Guiding pad	 insert screw	 pad screw
30.00 - 34.00	NPHT070404R	NPMT060404R	NPMT060408L	GP-07	M2.5x6.5	M3x6.5
35.00 - 37.00	NPHT070404R	NPMT060404R	NPMT080408L	GP-07	M2.5x6.5	M3x6.5
38.00	NPHT090404R	NPMT060404R	NPMT080408L	GP-07	M2.5x6.5	M3x6.5
39.00 - 40.00	NPHT090404R	NPMT060404R	NPMT080408L	GP-08	M2.5x6.5	M3x8
41.00 - 43.00	NPHT090404R	NPMT080404R	NPMT080408L	GP-08	M2.5x6.5	M3x8
44.00	NPHT090404R	NPMT080404R	NPMT090408L	GP-08	M2.5x6.5	M3x8
45.00 - 46.00	NPHT090404R	NPMT080404R	NPMT090408L	GP-10	M2.5x6.5	M3.5x9
47.00 - 50.00	NPHT110404R	NPMT080404R	NPMT090408L	GP-10	M2.5x6.5	M3.5x9
51.00 - 53.00	NPHT110404R	NPMT090404R	NPMT090408L	GP-10	M2.5x6.5	M3.5x9
54.00 - 55.00	NPHT110404R	NPMT090404R	NPMT120408L	GP-10	M2.5x6.5	M3.5x9
56.00 - 59.00	NPHT110404R	NPMT090404R	NPMT120408L	GP-12	M2.5x6.5	M3.5x9
60.00 - 63.00	NPHT130404R	NPMT090404R	NPMT120408L	GP-12	M2.5x6.5	M3.5x9
64.00 - 65.00	NPHT130404R	NPMT120404R	NPMT120408L	GP-12	M2.5x6.5	M3.5x9

Non-standard customization can be carried out according to different processing requirements.



Drivers

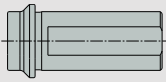
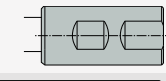
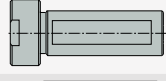
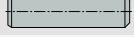
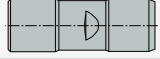
Deep Drilling Tools



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

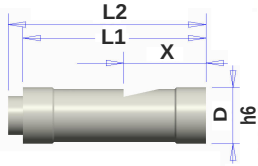
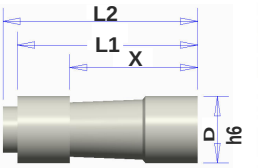
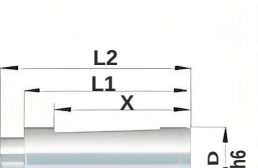
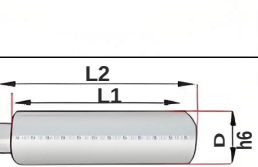
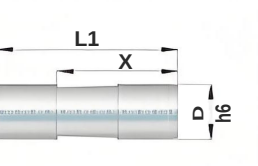
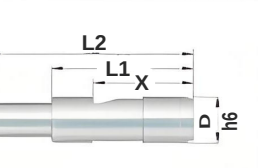
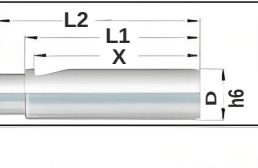
Accessories

Driver Type

M	machining	M20,M25,M32,M40,U19.05,U25.4,U31.75,U38.1,FM32,FM40,FU31.75,FU38.1	
WD	weldon	22,23,24,25,26,99	
WN	whistle notch	U03,U04,U05,U06,34,35,36	
F	flat	FD50C25,FD37C25,C25	
C	cylindrical	95	
CCL	cylindrical clamping	57	

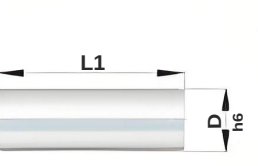
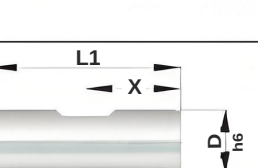
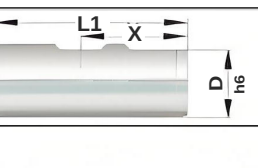
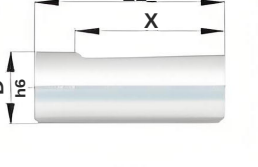
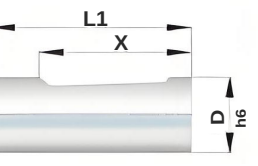
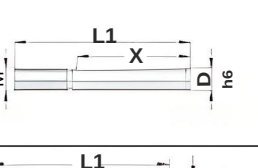
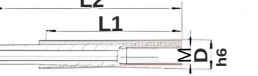
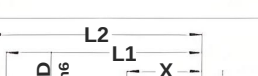
Drivers

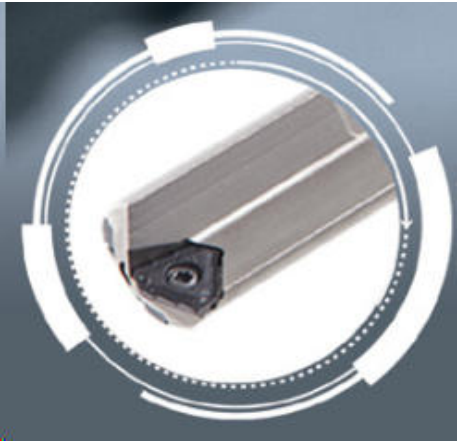
Deep Drilling Tools

Size	Diagram	L1	L2	X	Drill range	NO.
16 x 50		50	58	22	2.00–13.00	vk001
25 x 70		70	78	34	2.00–20.00	vk002
12.7 x 38.1		38.1	46.1	25.4	8.00–13.00	vk003
19.05 x 70		70	78	34	15.00–20.00	vk004
25 x 70		70	78	34	2.00–20.00	vk005
25.4 x 70		70	78	57.1	20.00–25.00	vk006
31.75 x 70		70	78	57.1	26.00–30.00	vk007
38.1 x 70		70	78	57.1	30.00–40.00	vk008
25 x 70		70	78	57.1	2.00–25.00	vk009
25 x 70		70	78		3.00–25.00	vk010
12.7 x 38.1		38.1		25.4	2.00–9.00	vk011
19.05 x 70		70		44.4	2.00–15.00	vk012
25 x 70		70		44.4	2.00–20.00	vk013
10 x 40		40	48	25	7.00–10.00	vk014
16 x 45		45	53	31	11.00–15.00	vk015
16 x 50		50	58	32	11.00–15.00	vk016
16 x 50		50	58	47.5	2.00–10.00	vk017
25.4 x 70		70		57.1	2.00–20.00	vk018
31.75 x 70		70		57.1	2.00–25.00	vk019
38.1 x 70		70		57.1	2.00–32.00	vk020
25 x 70		70		57.1	2.00–25.00	vk021

Drivers

Deep Drilling Tools

Size	Diagram	L1	L2	X	M	Drill range	NO.
10 x 50		50				2.00 – 12.00	vk022-1
12 x 45		45				2.00 – 12.00	vk022-2
16 x 48		48				2.00 – 12.00	vk022
20 x 50		50				2.00 – 15.00	vk023
25 x 70		70				2.00 – 20.00	vk024
32 x 60		60				2.00– 26.00	vk025
10 x 40		40		20		2.00 – 7.00	vk026
12 x 45		45		22.5		2.00– 8.00	vk027
16 x 48		48		24		2.00 – 12.00	vk028
20 x 70		50		25		2.00 – 15.00	vk029
25 x 56		56		32		2.00 – 20.00	vk030
32 x 60		60		36		2.00 – 26.00	vk031
40 x 70		70		40		2.00 – 30.00	vk032
10 x 40		40		28		2.00 – 7.00	vk033
12 x 45		45		33		2.00 – 8.00	vk034
16 x 48		48		36		2.00 – 12.00	vk035
20 x 70		70		38		2.00 – 15.00	vk036
25 x 56		56		44		2.00 – 20.00	vk037
32 x 60		60		48		2.00 – 26.00	vk038
10 x 40		40		28		2.00 – 7.00	vk039
12 x 45		45		33		2.00 – 8.00	vk040
16 x 48		48		36		2.00 – 12.00	vk041
20 x 50		50		38		2.00 – 15.00	vk042
25 x 56		56		44		2.00 – 20.00	vk043
16 x 112		112		72	TR16x1.5	2.00 – 12.00	vk044
20 x 126		126		81	TR20x2	2.00 – 15.00	vk045
28 x 126		126		24	TR28x2	2.00 – 24.00	vk046
36 x 162		162		25	TR36x2	2.00 – 27.00	vk047
10 x 60		60			M6x0.5	2.00 – 7.00	vk048
16 x 80		80			M10x1	2.00 – 12.00	vk049
25 x 100		100			M16x1.5	2.00 – 20.00	vk050
16 x 80		80	100		M10x1	12.00 – 15.00	vk050
25 x 100		100	140		M16x1.5	20.00 – 25.00	vk050
10 x 68		68		35	M6 x 0.5	2.00 – 7.00	vk050
16 x 90		90		37	M10 x 1	2.00 – 12.00	vk050
25 x 112		112		45	M16 x 1.5	2.00 – 19.00	vk050
10 x 68		68	81	35	M6 x 0.5	7.00 – 10.00	vk050
16 x 90		90	110	37	M10 x 1	12.00 – 15.00	vk050
25 x 112		112	142	45	M16 x 1.5	20.00 – 25.00	vk050



BTA Tools

Deep Drilling Tools

Indexable Type

BTA deep hole drill is a special drill that focuses on high efficiency and is suitable for processing larger diameter holes. The cutting fluid is discharged from the outside of the cutter head under high pressure, and the iron chips are discharged from the inside of the cutter bar. Because there is no iron chip scraping against the wall of the processed hole during processing, the surface finish of the processed hole is high and the processing efficiency is high. Suitable cutter bodies and matching cutter grains can be designed according to different processed materials and processing equipment. The cutter grain guide strip is easy to replace and is widely used in large-scale machinery and equipment, petroleum, military industry, manufacturing industry and other fields.

Brazed Insert Type

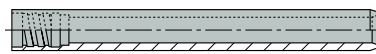
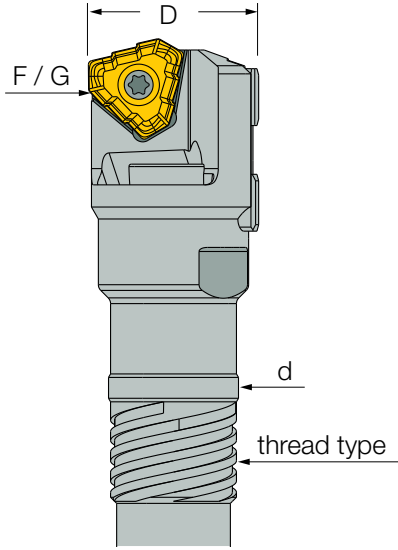
Brazed Insert BTA deep hole drill focuses on applications with stricter hole diameter tolerances. Because the blade body, blade and guide strip are welded into a whole and then finished by fine grinding, the dimensional accuracy is much higher than that of the machine-clamped BTA drill. It is generally used in subdivided fields with strict dimensional accuracy requirements. Because the blade guide strip cannot be reused after being worn, the cost is relatively high, and it is generally used for processing small holes.

- D- Tool Diameter**
Metric - DXX.XX
Inch - D.XXX
- d- Pilot diameter**
Metric - DXX.X
Inch - D.XXX

- Tool Style**
F- Fixed pocket 3-5 cutting edges
G- Fixed pocket single cutting edge

- Thread Type**
4ST- Four-start thread single tube
1ST- Single-start thread single tube
4DT- Four-start thread double tube

Universal Marking for Deep Drilling Tools



Connection Outer Tubes

BTA Tools

Deep Drilling Tools

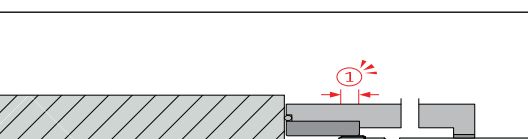
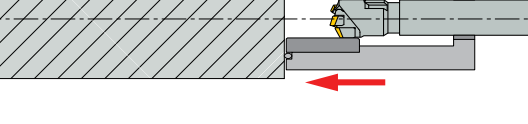
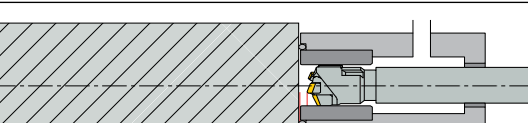
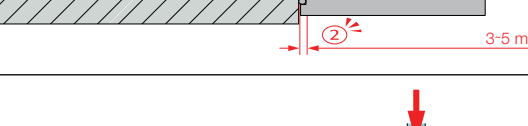
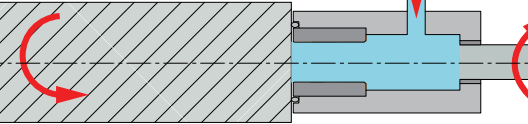
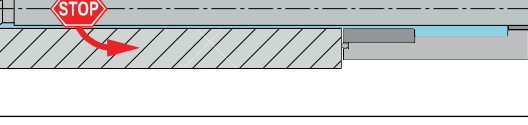
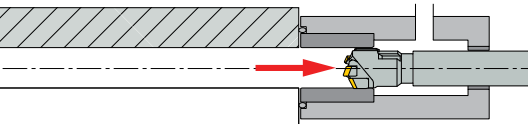
BTA TOOLS HEAD/TUBE/INSERT/PAD MATCHING TABLE

Dimensions									
BAT head	Tube OD	Tube ID	 Outer Insert	 Inner Insert	 Middle Insert	 Guiding Pad	 Insert Screw	 Pad Screw	 Wrench
25.00-26.00	22	14	TOGT120405R	TOGT120405R	TOGT120405R	GP-06	M4x10	M2.5x6	T7/T8
27.00-28.00	24	14	TOGT120405R	TOGT120405R	TOGT120405R	GP-06	M4x10	M2.5x6	T7/T8
29.00	26	17	TOGT130408R	TOGT130408R	TOGT130408R	GP-06	M5x11	M2.5x6	T7/T8
30.00	26	17	TOGT130408R	TOGT130408R	TOGT130408R	GP-07	M5x11	M3x6.5	T8/T10
31.00-32.00	28	18	TOGT130408R	TOGT130408R	TOGT130408R	GP-07	M5x11	M3x6.5	T8/T10
33.00	28	18	NPHT070404R	NPMT060404R	NPMT060408L	GP-07	M2.5x8	M3x8	T8/T10
34.00-36.00	30	19.5	NPHT070404R	NPMT060404R	NPMT080408L	GP-07	M2.5x8	M3x8	T8/T10
37.00	33	23	NPHT070404R	NPMT060404R	NPMT080408L	GP-07	M2.5x8	M3x8	T8/T10
38.00	33	23	NPHT090404R	NPMT060404R	NPMT080408L	GP-07	M2.5x8	M3x8	T8/T10
39.00	33	23	NPHT090404R	NPMT060404R	NPMT080408L	GP-08	M2.5x8	M3.5x8	T8/T10
40.00	36	25	NPHT090404R	NPMT060404R	NPMT080408L	GP-08	M2.5x8	M3.5x8	T8/T10
41.00-42.00	36	25	NPHT090404R	NPMT080404R	NPMT080408L	GP-08	M2.5x8	M3.5x8	T8/T10
43.00	39	28	NPHT090404R	NPMT080404R	NPMT080408L	GP-08	M2.5x8	M3.5x8	T8/T10
44.00	39	28	NPHT090404R	NPMT080404R	NPMT090408L	GP-08	M2.5x8	M3.5x8	T8/T10
45.00-46.00	39	28	NPHT090404R	NPMT080404R	NPMT090408L	GP-10	M2.5x8	M3.5x8	T8/T15
47.00-50.00	43	31	NPHT110404R	NPMT080404R	NPMT090408L	GP-10	M2.5x8	M3.5x8	T8/T15
51.00	43	31	NPHT110404R	NPMT090404R	NPMT090408L	GP-10	M2.5x8	M3.5x8	T8/T15
52.00-53.00	47	35	NPHT110404R	NPMT090404R	NPMT090408L	GP-10	M2.5x8	M3.5x8	T8/T15
54.00-56.00	47	35	NPHT110404R	NPMT090404R	NPMT120408L	GP-10	M2.5x8	M3.5x8	T8/T15
57.00-59.00	51	39	NPHT110404R	NPMT090404R	NPMT120408L	GP-12	M2.5x8	M3.5x8	T8/T15
60.00-63.00	51	39	NPHT130404R	NPMT090404R	NPMT120408L	GP-12	M2.5x8	M3.5x8	T8/T15
64.00	51	39	NPHT130404R	NPMT120404R	NPMT120408L	GP-12	M2.5x8	M3.5x8	T8/T15
65.00	56	42.9	NPHT130404R	NPMT120404R	NPMT120408L	GP-12	M2.5x8	M3.5x8	T8/T15

Non standard clamping methods can be set for gun drill pipe sizes smaller than 25mm and larger than 65mm based on actual processing conditions.
25-32mm Customizable 3-inserts gun drill styles.

Technical Information - NC Cycle

Use the NC cycle as instructed below to optimize tool performance more safely.

	1. Start NC operation cycle
	2. Oil pressure head moves until it touches the workpiece ① Set the starting point of the main axis of the tool so that the guide pad remains inside the guide bush when the oil pressure head moves forward
	3. Move tool workpiece ② Move the tool 3 to 5 mm from the edge of the workpiece If the available NC machine can support this approach, the operation process may start from this point
	4. Start cutting • Start coolant supply • Start rotating (tool / workpiece / tool & workpiece) • Start feeding
	5. Stop cutting • Stop feeding • Stop rotating (tool / workpiece / tool & workpiece) • Stop coolant supply ③ Stop rotation when the outer tip is at the edge of the workpiece
	6. Tool main axis back to starting point
	7. Oil pressure head back to starting point

Deep Hole Drilling Systems

Problem	Possible Cause	Solution
The drill breaks or insert chips	- chip evacuation problems - center misalignment of drill to workpiece	- check that the coolant passages are clear and that the venturi slots are not damaged - check center alignment of drill to workpiece - check workpiece and drill clamping rigidity
Poor surface finish	- workpiece or drill clamping rigidity problem - inadequate coolant oil - cutting speed too low	- improve workpiece or drill clamping - check the coolant oil and replace if necessary - increase the cutting speed
Excessive leakage of the coolant	- chips block the fluid passages - the drill was incorrectly assembled, or the venturi slots of the internal tube are located in the wrong direction	- clear the chips - check all connections and the direction of the internal tube
Insufficient coolant flow at the cutting zone, despite correct fluid supply	- chips block the fluid passages - worn bushing or sealing device - venturi slots are too wide (worn) - internal tube shorter than the external tube	- clear the chips - check the bushing and seal and replace if necessary - replace the internal tube - replace the internal tube to one with a correct length
Chips jam in the front end of the drill	insufficient coolant flow	adjust the fluid flow by raising the pressure; check the filter and fluid quality