



Proper use of carbide drills,cermet drills

Because Carbide quite valuable, the proper use of the drill so the proper use of cermet drill is most important, and is the responsibility of each practitioner's responsibility. Proper use of carbide drills, cermet drills, and cermet drills including the following aspects:

1. Choosing the right CNC machine tool, the CNC machining centers, power, good steel, and should ensure that the tip beating TIR < 0.02. Otherwise The rocker drilling, universal milling machine is small power, precision spindle poor, easily lead to the collapse of carbide drill early losses, should be avoided.

2. Choosing the right shank collet, lateral pressure handle, hydraulic handle, Shrinkfit holders, etc. All can be used, but due to the quick change drill chuck clamping force is not enough and slip easily lead to drill failure, can't be used.

3. Proper Cooling

(1) Should pay attention to the combination of external cooling cooling direction, The formation of the upper and lower echelon, and to minimize the angle between the tool.

(2) cooling the drill should be noted that the pressure and flow rate, and should prevent coolant leaks affect the cooling effect.

4. The correct drilling process

(1) When the diamond surface inclination > 8-10 ° , can't not drilling .when < 8-10 ° , the feed should be reduced to the normal 1 / 2-1 / 3;

(2) when the drill surface inclination > 5 ° , the feed should be reduced to the normal 1 / 2-1 / 3;

(3) When the drill holes intersecting (orthogonal or oblique bore hole), the feed should be reduced to the normal 1 / 2-1 / 3;

(4) 2 edge drill can not reaming.