



The operation and installation of taper shank twist drill

(1) Determining the feed rate: Feed rate is generally depend on people's experience, the value is general 0.08-0.12mm / rotation or 0.6-1.0mm / sec, feed speed is a more critical element in drilling, different amount feed can form different iron, different chip will change the performance of iron.

(2) Location: in order to ensure the accuracy of the drilling locations, you needs to hit a chisel drilling anchor point or draw a "ten" line with alloy pin in a central location .Note that when you play with a center anchor point chisel, make sure the center of the chisel perpendicular on the surface of the workpiece, so as not to affect the discharge of cutting material cores.

(3) Start drilling: Please adjust the speed with a good shift, make sure the bottom of magnetic be clean, open magnetic switch and meanwhile open the motor switch, run the motor at the same time open the coolant switch, when the drill contact the steel, at first slowly feed, after drill about 1-2mm, then speed the feed normally.

(4) The end of drilling : turn off the motor shaft, determining the feed rat. Feed rate is generally depend on experience. In terms of the value, it's generally 0.08-0.12mm / rotation or 0.6-1.0mm / sec, the feed rate is in comparison of key elements, different feed amount of iron can form different drilling, different chip will change the performance of iron.

(5) Lifting the drill cassette a bit Slowly, and putting the four cassette drill legs into the four holes, choosing the appropriate size drill box core board according to drill's standards, lifting the drill bit into the drill core sheet cassette box body, then letting the drill grooves be corresponded with the drill core plates spur box which need to be installed, and make the drill into the box drill, drill bit and drill core is placed on the turntable card. Then followed by the coupling nut screwed on the drill bit.

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