

botek[®]

DEEP HOLE DRILLING SYSTEMS
SOLID CARBIDE TOOLS

Coolant pressure

gauging-kit

botek



Machining centres (BAZ) and deep hole drilling machines

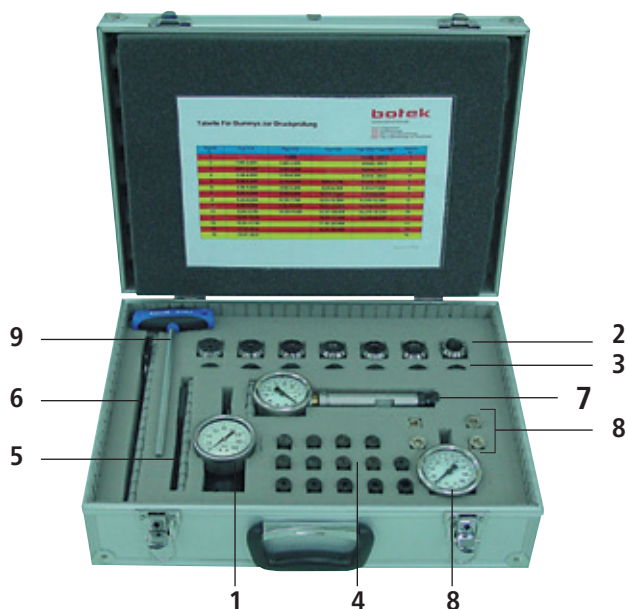
Quite often the set value at the pressure gauge is not reflecting the value that actually reaches the tool. Numerous sources for errors such as leaking valve parts, faulty rotating connectors or snapped hose lines are not visible on first sight. Leading to a decreased coolant pressure, this could influence the drilling result negatively.

**The gauging-kit developed by botek measures the real pressure – directly at the spindle/tool (up to a max. of 160 bar).
Taken measurements consider different coolant channel sizes.**

Big gauging-kit for coolant pressure testing on machining centres (BAZ) and deep hole drilling machines

For machining centre (BAZ) and deep hole drilling machine

Order No. 792 000 200



The following methods are available:

1. Measurement of the machine pump performance:

By means of a tool dummy a tool-independent check can be carried out – a big advantage.

2. Measurement with the tool:

The tool dummy is replaced by the actual drill.
The coolant pressure at the actual tool can then be checked.

For machining centres		
Spindle adaptor for collet chuck ER-32 with cylindrical shaft \varnothing 16.0 (h5) mm / \varnothing 20.0 (h5) mm / \varnothing 25.0 (h5) mm, incl. nut for sealing disc assembly	1 piece	1*
Collet chucks ER-32 (4 / 6 / 8 / 10 / 12 / 16 / 20 mm)	7 piece	2
Sealing discs (4 / 6 / 8 / 10 / 12 / 16 / 20 mm)	7 piece	3
Dummies for tool simulation	14 piece	4
Open end wrench for adaptor	1 piece	5
Wrench for nut	1 piece	6
For deep hole drilling machine		
Special adaptor for driver 25x100/112 mm as per VDI 3208 (ZH25-34)*. The adaptor can be modified to suit different drivers, if required.	1 piece	7*
Smaller lathe and machining centres		
Dummy adaptor \varnothing 10.0 mm / \varnothing 45.0 mm incl. 4 dummies	adaptor and 4 dummies	8*
Allen key, size 8	1 piece	9
Aluminium case	1 piece	

Small gauging-kit for coolant pressure testing on machining centres (BAZ) or deep hole drilling machines

For machining centre

Order No. 792 000 237



Allen key with T-handle AF8 (1 pc.)

Dummy holder Ø10/12/16 (1 pc.)

Dummies for tool simulation (8 pcs.)
Diameter range by arrangement

The following methods are available:

1. Measurement of the machine pump performance:

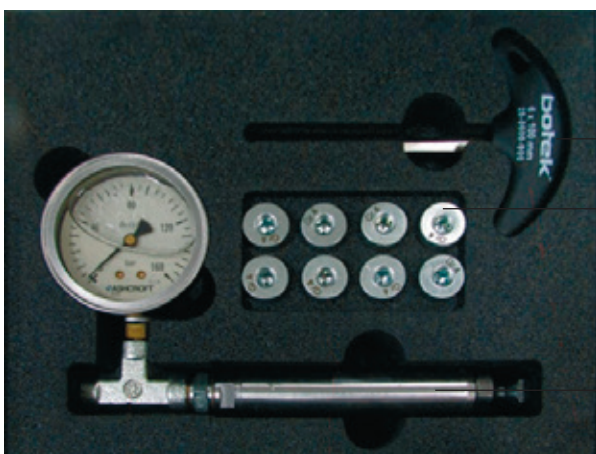
By means of a tool dummy a tool-independent check can be carried out – a big advantage.

2. Measurement with the tool:

The tool dummy is replaced by the actual drill. The coolant pressure measurement directly at the tool is only possible with the large coolant pressure gauging-kit. (Ordernumber 792 000 200).

For deep hole drilling machine

Order No. 792 000 238



Allen key with T-handle AF8 (1 pc.)

Dummies for tool simulation (8 pcs.)
Diameter range by arrangement

Special holder for driver 25x100/112
according to VDI 3208 (ZH25-34). (1 pc.)
(If required, the holder can be adapted
to a different driver).

The following methods are available:






1. Measurement of the machine pump performance:

By means of a tool dummy a tool-independent check can be carried out – a big advantage.

2. Measurement with the tool:

The tool dummy is replaced by the actual drill. The coolant pressure measurement directly at the tool is only possible with the large coolant pressure gauging-kit. (Ordernumber 792 000 200).

List of matching dummies

Dummy no.	Type 110 Single flute gundrill with brazed solid carbide tip	Type 113 Solid carbide gundrill	Type 120 Twin fluted drills with solid carbide head	Type 123 Solid carbide 2-fluted drill	Type 158 Solid carbide twist drill coolant fed	Dummy no.
						
1		0.50 - 1.55		coolant hole $\lt; \varnothing 0.5$		1
2	1.85 - 2.60	1.60 - 2.59		coolant hole $\varnothing 0.5$		2
3	2.61 - 3.35	2.60 - 3.24		coolant hole $\varnothing 0.7$		3
4	3.36 - 4.05	3.25 - 4.14		coolant hole $\varnothing 0.9$		4
5	4.06 - 4.55	4.15 - 4.84	4.51 - 5.30	coolant hole $\varnothing 1.0$		5
6	4.56 - 5.65	4.85 - 5.34	5.31 - 6.20	5.51 - 7.20		6
7	5.66 - 6.55	5.35 - 6.34	6.21 - 8.50	7.21 - 9.20		7
8	6.56 - 8.05	6.35 - 7.74	8.51 - 10.00	9.21 - 12.20		8
9	8.06 - 9.55	7.75 - 10.04	10.01 - 12.00	12.21 - 16.20		9
10	9.56 - 12.50	10.05 - 12.00	12.01 - 14.00	16.21 - 18.20		10
11	12.51 - 15.00		14.01 - 17.00	18.21 - 20.20		11
12	15.01 - 17.50		17.01 - 22.00			12
13	17.51 - 20.00		22.01 - 26.50			13
14	20.01 - 30.00					14

- Please see our application notes, www.botek.de
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