

Coolant pressure gauging-kit for machining centres 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.

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 pressure can be checked directly at the tool.



For machining centres:

Spindle adaptor for collet chuck ER-32 with cylindrical shaft Ø 16.0 (h5) mm / Ø 20.0 (h5) mm / Ø 25.0 (h5) mm, incl. nut for sealing disc assembly	1 pc.	1*
Collet chucks ER-32 (4/6/8/10/12/16/20 mm)	7 pcs.	2
Sealing discs (4/6/8/10/12/16/20 mm)	7 pcs.	3
Dummies for tool simulation	14 pcs.	4
Open end wrench for adaptor	1 pc.	5
Wrench for nut	1 pc.	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 pc.	7*
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Smaller lathe and machining centres:

Dummy adaptor Ø 10.0 mm / Ø 45.0 mm incl. 4 dummies	adaptor and 4 dummies	8*
Allen key, size 8	1 pc.	9
Aluminium case	1 pc.	

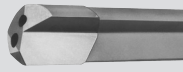

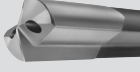


* Manometers with "drag-indicator" are available for an additional charge. (This device can be used when no line of sight is possible during the actual measurement.)

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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	Dummy no.
						
1		0.50 - 1.55		coolant hole \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

