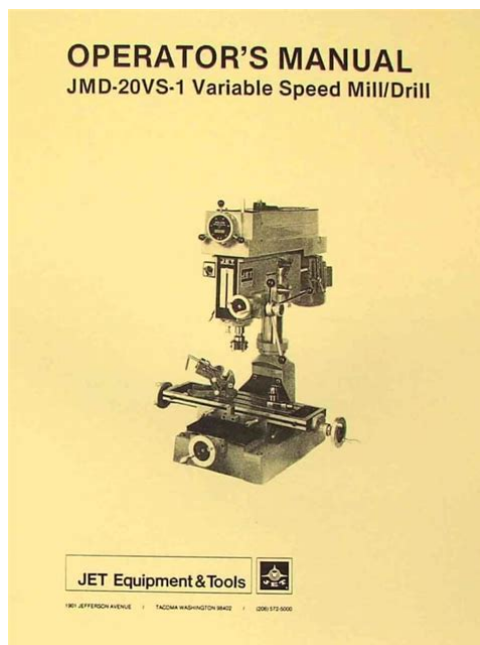


## Drill Machine Operation Manual



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Field and maintenance shop drilling operations allow for some tolerance, but oversizing must be kept to the minimum by the machine operator. The material to be drilled, the size of that material, and the size of the drilled hole must all be considered when selecting the drill. Also, the drill must have the proper lip angles and lip clearances for the job. The drill must be clean and free of any burrs or chips. The shank of the drill must also be clean and free of burrs to fit into the chuck. Most drills wear on the outer edges and on the chisel point, so these areas must be checked, and resharpened if needed, before drilling can begin. If the twist drill appears to be excessively worn, replace it. Use a small file inside the socket to remove any tough burrs. Slip the tang of the drill or geared drill chuck into the sleeve and align the tang into the keyway slot Figure 630. Another method used to seat the drill into the sleeve is to place a block of wood on the machine table and force the drill down onto the block. For drilling, the spindle should rotate at a set speed that is selected for the material being drilled. Correct speeds are essential for satisfactory drilling. The speed at which a drill turns and cuts is called the peripheral speed. Peripheral speed is the speed of a drill at its circumference expressed in surface feet per minute SFPM. This speed is related to the distance a drill would travel if rolled on its side. For example, a peripheral speed of 30 feet per minute means the drill would roll 30 feet in 1 minute if rolled on its side. It is best to use the machine speed that is closest to the recommended RPM. When using the metric system of measurement, a different formula must be used to find RPM. It is expressed in thousandths of an inch or in millimeters. Handfeed drilling machines have the feed regulated by the hand pressure of the operator; thus, the skill of the operator will determine the best feeds for drilling.

Power feed drilling machines have the ability to feed the drill into the work at a preset depth of cut per spindle revolution, so the best feeding rate can be determined see Table 44 in Appendix A. Feed should increase as the size of the drill increases. After starting the drill into the workpiece by hand, a lever on the powerfeed drilling machine can be activated, which will then feed the drill into the work until stopped or disengaged. Too much feed will cause the drill to split; too little feed will cause chatter, dull the drill, and possibly harden the workpiece so it becomes more difficult to drill. Some drilling operations may not require a precise alignment of the drill to the work, so alignment can be done by lining up the drill by hand and eye alone. If a greater precision in centering alignment is required, then more preparation is needed before starting to drill. Set the drilling machine speed for the diameter of the tip of the center drill, start the machine, and gently lower the center drill into contact with the work, using hand and eye coordination. The revolving center drill will find the center punched mark on the workpiece and properly align the hole for drilling. The depth of the centerdrilled hole should be no deeper than two third the length of the tapered portion of the center drill. To draw the twist drill back to the position desired Figure 631, a sharp chisel is used to make one or more nicks or grooves on the side toward which the drill is to be drawn. The chisel marks will draw the drill over because of the tendency of the drill to follow the line of least resistance. After the chisel mark is made, the drill is again handfed into the work and checked for being on center. This operation must be completed before the drill point has enlarged the hole to full diameter or the surface of the workpiece will be marred by a double hole impression. The cutting fluid to use will depend on what material is being machined see Table 43 in Appendix A.

<https://www.becompta.be/emploi/dyson-dc02-absolute-manual-0>

Use the cutting fluids freely. A slight increasing speed and decrease in feed is often used to give the chips a greater freedom of movement. In deep hole drilling, the flutes of the smaller drills will clog up very quickly and cause the drill to drag in the hole, causing the diameter of the hole to become larger than the drill diameter. The larger drills have larger flutes which carry away chips easier. The chisel edge of drill does not have a sharp cutting action, scraping rather than cutting occurs. In larger drills, this creates a considerable strain on the machine. To eliminate this strain when drilling a large hole, a pilot hole is drilled first Figure 634 and then followed with the larger drill. A drill

whose diameter is wider than the web thickness of the large drill is used for the pilot hole. This hole should be drilled accurately as the larger drill will follow the small hole. Avoid making the pilot drilled hole much wider than the web of the larger drill. Too wide of a pilot drilled hole may cause the larger drill cutting lips to grab and snag which may cause excessive chatter or an outofround hole. The depth stop is designed to be used whenever a number of holes of the same depth are to be drilled, or when drilling holes deep into the workpiece blind holes. Make sure that drills are chucked tightly to avoid slipping and changing the depth setting. Most depth stops have away to measure the distance that the drill travels. Some may have a fractional gage on the depth stop rod, and some may have a micrometer dial located on the depth stop for very precise measurements. Do not measure from the bottom point of the hole Figure 636. A thin depth gage is inserted into the hole, along the side, and the measurement taken. If the hole is too small for the gage to fit down into it then a twist drill of the same size as the hole can be inserted into the hole upside down, then removed and measured with a rule.

Clean all chips and coolant from the holes before attempting any depth measurement. Use Vblocks to hold the round stock for center punching and drilling. Align the center of the round stock with a square or by lining the workpiece up with the twist drill point. Another method to drill round stock is to use a Vblock drill jig that automatically centers the work for drilling. Allowing a drill to run on in the hole will cause the hole to be oversized. At any time during the drilling process, a problem could occur. If so, it should be fixed as soon as possible to avoid any damage or injury. Operators must observe the drilling machine for any excessive vibration or wobble, overheating of the electric motor, and unusual noises coming from the machine. A high pitched squeal coming from the drill itself may indicate a dull drill. A groaning or rumbling sound may indicate that the drill is overloaded and the feed needs to be reduced. A chattering sound may indicate an offcenter drill or a poorly sharpened drill. These or other noises could also be caused by internal parts of the machine. Consult the operators manual and correct all problems before attempting to continue drilling. Product Details Packing shipping For machine usually by sea; For documents by international express, eg. DHL, TNT or EMS. For packing Free fumigation plywood packaging steel base our service 1. A Please tell me your specifications, we can choose the best model for you, or you can choose the exact model You can also send us the products drawing, we will choose the most suitable machines for you. 2 What's your main products of your company. A We specialized in all kinds of machines, such as CNC Lathe Machine, CNC Milling Machine, Vertical Machining Center, Lathe Machines, Drilling Machine, Radial Drilling Machine, Sawing Machine, Shaper machine and so on. 3 Where is our factory located. How can I visit there. A Our factory is located in Tengzhou City, Shandong Province, 277500 China.

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BT6 Line Boring Machine Manual. From Un Learn More TECHNICAL REVIEW BOREHOLE DRILLING AND BOREHOLE DRILLING AND REHABILITATION. Figure 2 A mud rotary machine working in eastern Zimbabwe. Figure 17 A testpumping rig in operation. A drill press is a machine that turns and advances a rotary tool into a workpiece. The drill press is used primarily for drilling holes, but when used with the Learn More Parts Types tpu.ru Drilling machine A Drilling machine at a construction site with a concrete pump and a barely visible concrete mixer. The tops of foundation columns with reinforcing iron rods sticking out, are visible at the Learn More Operators manual Pentrunder MDU and Drill Rig 4.3.

9 Drilling with a. The operator's manual should be kept where the machine. In the following text, the "machine", "drill motor" or. Learn More Metal Shaper Literature and Sources of Information Metal Shaper Literature. Learn More Types of Drilling Machines Bright Hub Engineering Upright Drilling Machine. The upright drilling machine uses a geared drive spindle head. In comparison to the previous type, the manner of feeding this machine into the workpiece can be done by hand or automatically. Learn More PDF Technical Review Borehole Drilling and Rehabilitation Under the field of borehole drilling and rehabilitation. The Advanced Text Tools let you access True Type or Open Type fonts on your PC to create text outlines for your design. Haas CNC Mill Programming Manual Page 7 Machine. Learn More FRACINO BAMBINO INSTALLATION INSTRUCTIONS MANUAL Pdf Download View and Download Fracino Bambino installation instructions manual online. Bambino Coffee Maker pdf manual download. Also for Classic, Contempo, Romano. Initial setup Before you can generate Gcode SheetCam needs to know certain facts about your specific machine and unit preferences in. Learn More DRILLING METHODS This continuing education unit reviews This continuing education unit reviews drilling methods common to drillers, with an emphasis on water well. The drilling motion of the cable tool drilling machine Learn More manual text of drilling machine pdf aigafoundation.org International Journal of Engineering Research and General. International Journal of Engineering Research. Design of low Cost CNC Drilling Machine. Learn More MILLING MACHINE OPERATIONS MILLING MACHINE OPERATIONS. Within a selfstudy environment and given the subcourse text, without. Learn More These days we focus on inhouse refurbished continuous mining roadheaders as well as new machine offerings.

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