GD-DH

Gundrills for machining centers and gundrill machines, carrying the TOGT inserts, feature 3 chip splitting cutting edges and a wiper for high hole surface quality and high feed. The drills are available in the diameter range of 14 to 28 mm and in 10, 15 and 25 drilling length to diameter ratios.
Longer gundrills in the diameter range of 14 to 28 mm diameters can be supplied with up to 2400 mm length on request.

TRIDEEP Spare Parts List

Spare Parts

Diameter Range	Insert	Insert Clamping Screw	Key	N*m	Solid Carbide Guide Pad	Guide Pad Clamping Screw	Key
14.00-15.99	TOGT 070304-DT/SF	SR 14-060/S M2.5/0.45	T-6/5	1.2	GPS-05-18/90-DC	SR-34-508 M2.2/0.45	T-7/5
16.00-18.00	TOGT 080305-DT/SF		T-6/5	1.2	GPS-05-18-075-DC		
18.01-20.00	TOGT 090305-DT/SF		T-6/5	1.2	GPS-05-20-090-DC		
20.01-21.00	TOGT 100305-DT/SF	SR 34-508 M3/0.5	T-9/5	2.0	GPS-05-20-095-DC		
21.01-21.99	TOGT 100305-DT/SF				GPS-06-20-100-DC		
22.00-25.00	TOGT 110405-DT/SF	SR 14-070/S M3.5/0.6	T-15/5	4.8	GPS-06-20-100-DC		
25.01-28.00	TOGT 120405-DT/SF	SR 14-090 M4/0.7	T-15/5	4.8	GPS-06-20-100-DC		
28.01-29.99	TOGT 130408-DT/SF	SR 18-212/LS M5/0.8	T20/5	10	GPS-06-20-120-DC	SR 34-508 M2.2/0.45	T-7/5
30.00-32.00	TOGT 130408-DT/SF				GPS-07-20-120-DC	SR 1100/T20-6	T-9/5

USER GUIDE

Wide Flute Angle
- Smooth chip evacuation

Brazed Body

Flange
- Superior rigidity for higher speeds and feeds

Steel Body Tool
- Extremely high rigidity
- Simple direct mounting setup

Large Oil Hole
- Efficient lubrication
- Longer life of inserts and guide pads

TRIDEEP – Chip Formation

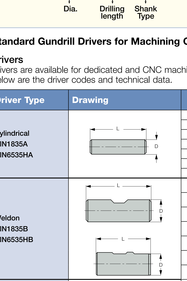
Workpiece material: AISI 1055
Drill diameter: Ø20.5 mm

Vc (m/min) \ f (mm/rev)	0.1	0.15	0.2	0.25
140				
120				
100				
80				

Drilling Process on Machining Centers and Lathe Machines

1. Drill a 15 mm pilot hole to ⌀20.5 flat bottom
2. Set the TRIDEEP drill into the pilot hole (10 mm depth). V_c=5-10 m/min f=0.5-1.0 mm/rev
3. Initial cutting at a 25 mm DOC (80% feed rate), verify activated coolant (V_c=100%).
4. In case of through hole, drill the full hole to a depth of +5 mm.
5. Retract with slow rotation (5-10 m/min)

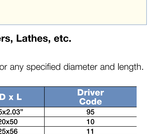
Pressure and Coolant Flow Rate for GD-DH



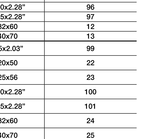
1 Drill a 15 mm pilot hole flat bottom

2 Slow rotation and feed while entering to the pre-hole

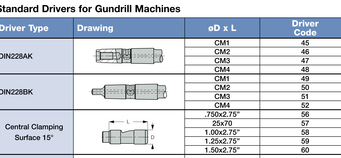
3 Maintain for 2-3 seconds and activate the cooling system



4 Drill +5mm depth through hole



Inquiry Form



1. Tool
Quantity.....
Nominal diameter and tolerance .....
Please fill in dimensions on the sketch below.

Driver
Driver: for standard drivers please use codes from pages 16-17.....
□ Code No.
□ Special, please attach sketch and specifications.

2. Workpiece
If possible, please attach a drawing)
2.1 Material
Material description (DIN material number or any other standard):
.....
Hardness and Properties:
.....

2.2 Hole Type
□ Blind Hole □ Drilling into Pre-hole □ Angled Entry
□ Drilling into Solid □ Boring □ Angled Exit
Drilling Depth mm Hole Tolerance

2.3 Application:
Workpiece: Stationary : Rotating
Tool : Stationary : Rotating

3. Machine

Sketch of drilling application

Note: It may be necessary to change several of the parameters that you indicated, based on our experience with your application.

3.1 Technical Data
Machine Type.....
Power: ..... kW .....

3.2 Cutting Data:
Cutting Speed Vc: ..... m/min .....
Revolutions N/min ..... RPM, N/max ..... RPM
Feed F/min..... mm/rev,
F/max..... mm/rev.....
Feed Rate **VF** ..... mm/min .....

Coolant:
□ Oil □ Soluble Oil : Other
Coolant Pressure: ..... Bar .....

Specially Tailored TRIDEEP Code Key

GD - DH ##.## - #### - ##

Dia.	Drilling length	Shank Type

Standard Gundrill Drivers for Machining Centers, Lathes, etc.

Drivers

Drivers are available for dedicated and CNC machines, for any specified diameter and length. Below are the driver codes and technical data.

Driver Type	Drawing	øD x L	Driver Code
Cylindrical DIN1835A DIN6535HA		.75x2.03"	95
		20x50	10
		25x56	11
		1.00x2.28"	96
		1.25x2.28"	97
		32x60	12
		40x70	13
Weldon DIN1835B DIN6535HB		.75x2.03"	99
		20x50	22
		25x56	23
		1.00x2.28"	100
		1.25x2.28"	101
		32x60	24
		40x70	25
Whistle Notch DIN1835E		20x50	34
		25x56	35
		32x60	36
		40x70	37

Standard Drivers for Gundrill Machines

Driver Type	Drawing	øD x L	Driver Code
DIN228AK		CM1	45
		CM2	46
		CM3	47
		CM4	48
DIN228BK		CM1	49
		CM2	50
		CM3	51
		CM4	52
Central Clamping Surface 15°		.750x2.75"	56
		25x70	57
		1.00x2.75"	58
		1.25x2.75"	59
		1.50x2.75"	60
Frontal Clamping Surface 15°		16x50	61
Cylindrical with Thread		25x100 M16x1.5	66
		36x120 M24x1.5	67
VDI Design		25x112 M16x1.5	70
		36x135 M24x1.5	71
Central Clamping Hexagonal		25x70	72
		32x70	73
Central Clamping Tapered		.75x2.75"	76
		20x70	77
Frontal Clamping Surface 2°		1.00x2.75"	80
		1.00x3.94"	81
		1.25x2.75"	82
		1.25x3.94"	83
		1.50x2.75"	84
		1.50x3.94"	85
Trapezoidal Thread		28x126 Tr 28x2	88
		36x162 Tr 36x2	89
Spraymist Driver		25x50	91
		35x60	92

Universal Marking for Deep Drilling Tools

Driver Type

M	machining	M20,M25,M32,M40,U19.05,U25.4,U31.75,U38.1,FM32,FM40,FU31.75,FU38.1	
WD	weldon	22,23,24,25,26,99	
WN	whistle notch	U03,U04,U05,U06,34,35,36	
F	flat	FD50C25,FD37C25,C25	
C	cylindrical	95	
CCL	cylindrical clamping	57	

Example:
Metric: D14.00 L/D15 d20X06M
Inch: D0.551 L/D15 d0.984X2.205M
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