

MVR STOCKS

MVR Gundrill

MVR Gundrill is developed as a Machining Center and NC Lathe etc.

STOCK GUN DRILLS LIST (for 20D)

Dia. (φD)m/m	Length (L)m/m	Dia. (φD)m/m	Length (L)m/m
5	250	10.3	350
5.1	250	10.4	350
5.2	250	10.5	350
5.3	250	11	350
5.4	250	11.1	350
5.5	250	11.2	350
6	250	11.3	350
6.1	250	11.4	350
6.2	250	11.5	350
6.3	250	12	420
6.4	250	12.1	420
6.5	250	12.2	420
7	300	12.3	420
7.1	300	12.4	420
7.2	300	12.5	420
7.3	300	13	420
7.4	300	13.1	420
7.5	300	13.2	420
8	300	13.3	420
8.1	300	13.4	420
8.2	300	13.5	420
8.3	300	14	500
8.4	300	14.1	500
8.5	300	14.2	500
9	350	14.3	500
9.1	350	14.4	500
9.2	350	14.5	500
9.3	350	15	500
9.4	350	15.1	500
9.5	350	15.2	500
10	350	15.3	500
10.1	350	15.4	500
10.2	350	15.5	500

The above stock gun drills are featured with breaker.

Driver Dimension

φD	φd	l1	l2
5~13.5	20	50	38
14~15.5	25	55	43

φD Specification of Oil hole

5~6 Kidney	
6.1~15.5 Two hole	

WORK MATERIAL

Materials such as high & medium carbon steel, alloy steel, cast iron, aluminum and light alloy can be drilled.

RANGE OF DRILLING DIAMETER

Standard drilling diameters are φ5 - φ25 and drilling depth is L / D = 5 ~ 25.

DRILLING CONDITIONS

Work Material	Cutting Speed (m/min)	Feed(mm/rev)	
		φ5~φ12	φ12~φ25
Medium/High Carbon Steel Alloy Steel	50~90	0.04~0.08	0.06~0.10
Cast Iron	50~80	0.05~0.09	0.07~0.12
Aluminum Light Alloy	90~170	0.05~0.09	0.07~0.12

DRILLING PROCEDURE

1 Make predrilled hole
"Predrilled hole with hole depth of 2-3 times larger than diameter is required."*

2 Fix gun drill
Picture shows "Drilling is suspended"

3 Feed gun drill, supplying cutting oil from front side of work surface, and insert it at predrilled hole. Feed is 300 mm/min. Stop the feed of gun drill at about few mm from bottom of predrilled hole.

4 Rotate gun drill
It is dangerous to rotate gun drill outside predrilled hole.

5 Feed gun drill

6 Completion of cutting

7 Rapid traverse

8 Stop gun drill at the point of

9 Stop rotation of gun drill and supplement of oil

10 Remove gun drill from work and return to zero point

*:Keep predrilled hole about + 50μm (+10~30μm if possible) to diameter of gun drill and in case of precision cutting, keep about +3~10μm.