cenye
成 业

深圳市成业深孔刀具有限公司
Shenzhen Chengye Deep Hole Tool Co., Ltd.



成业枪钻
GUNDRILL







COMPANY PROFILE
公司简介

深圳市成业深孔刀具有限公司成立于2009年3月，坐落于美丽的深圳市光明区公明办事处李松蔚第一工业区。是一家专业研发、生产、销售高精密深孔枪钻的企业。主要产品有：整体硬质合金枪钻、焊接式硬质合金枪钻、枪钻钻杆、刀粒式枪钻、BTA枪钻等其它枪钻附件。

公司三大主要产品：整体硬质合金枪钻、焊接式硬质合金枪钻、枪钻钻杆，都是成业自主研发、独立车间、统一管理，一条龙生产。

成业有一支高素质、高层次、经验丰富的专业研发团队及国际先进的多轴联动刀具生产设备和检测仪器。我们深熟国内外枪钻行业的需求标准及技术要求，紧跟国际国内市场需要、适应市场需求。经过十多年的研发、开拓与沉淀，公司产品远销中国各地及东南亚和欧美市场。

本着“效率创造效益、质量赢得市场”的经营理念，公司对生产设备、工艺革新、人力资源、原材料供应等高效管理，持续保持和提高各环节的品质控制。

为客户创造价值、为企业和员工创造财富，为行业和社会创造贡献是公司一贯坚持的企业文化！

Founded in March 2009, Shenzhen Chengye Deep Hole Tool Co., Ltd. is located in the first industrial zone of Lisonglang, Gongming Office, Guangming District, Shenzhen City. This company is professional in research and development, production and sales of high-precision deep hole gun drills. The main products include solid carbide gun drill, welded carbide gun drill, gun drill pipe, blade-type gun drill, BTA gun drill and other gun drill accessories.

These three major products of this company is solid carbide gun drill, welded carbide gun drill and gun drill pipe. These products are all independent research and development. In addition, they are produced in independent workshops, under unified management and one-stop production.

The company has a professional R&D team with high-quality, high-level and rich experience and international advanced production equipment and detection equipment of multi-axis tool. We are very familiar with the demand standards and technical requirements of gun drill industry both at home and abroad. We are keeping up with the needs of the international and domestic markets and adapting to market demand. Through more than ten years of research and development, exploitation and accumulation, the products of our company has been exported to all over China, Southeast Asia and Euramerican market

Based on the business philosophy of “to create benefit through efficiency and to win the market through quality”, the company manages production equipment, process innovation, human resources and raw material supply with high efficiency, continuously maintains and improves quality control in all aspects. To create value for customers, to create wealth for company and its employees, and to create contributions for this industry and our society is our corporate culture!

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焊接式双刃硬质合金枪钻 **07-09**
Welded Double-Blade Carbide Gun Drill



刀片、导条式单刃枪钻 **10**
Blade, Single-Blade Gun Drill of Conducting Bar Type



BTA枪钻
BTA Gun Drill



枪钻附件
Gun Drill Accessories



整体硬质合金枪钻 Solid Carbide Gun Drill

适合加工各类材料
孔径范围Ø 0.500-12.001mm
排屑槽可达 350mm



Suitable for processing all kinds of materials
Aperture range Ø 0.500-12.001mm
Chip Groove 350mm

整体硬质合金枪钻的优点：

直线度高、刚性强、较低的扭曲振动使刀具寿命长、效率快、稳定性好！

Advantages of Solid Carbide Gun Drill:

It has high straightness, strong rigidity and low twisting vibration, which make the tool long life, efficient and stable!

我们不承担由于不当使用、错误操作、不良机床状态等引起的刀具失效责任。
为了您的利益，请正确遵循使用说明和安全操作规则！我们很乐意为您提供各类解决方案

We are not responsible for tool failure due to such reasons as improper use, incorrect operation, poor machine conditions and so on. For your benefit, please follow the instruction and safety operation rules correctly! We are willing to provide you with a variety of solutions.

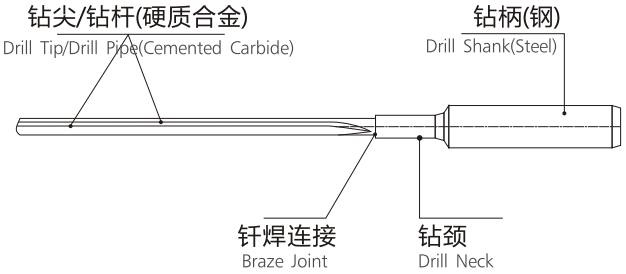
整体硬质合金单刃枪钻——刀具设计
Solid Single-Blade Carbide Gun Drill——Tool Design

机构分为二种

一、钻尖、钻杆、钻柄由整支硬质合金通过多道特殊工序根据不同的部位尺寸要求整体加工而成
二、钻尖、钻杆由整支硬质合金通过多道特殊工序整体加工而成、再与钻经过热处理和精磨过的特殊钢制钻柄钎焊组成

It is divided into two types:

1.The drill tip, drill pipe and drill shank are integrally processed from solid carbide through a number of special processes in terms of size requirements of different parts.
2.The drill tip and the drill pipe are integrally processed by solid carbide through a number of special processes.
And then it is brazed with a special steel drill which has been heat treated and accurate grinding.



整体硬质合金枪钻刀头刃磨角度及外形轮廓
Drill Tip Sharpening Angle and Contour Profile of Solid Carbide Gun Drill

枪头的刃磨几何形状对孔的公差、切屑的形成、冷却压力及流量和刀具寿命、中心线偏斜、表面质量都有直接影响。
多年来，成业针对不同的材质已成功的试验并研制成多种不同的几何形状，我们开发出的标准枪头刃磨几何形状适用于大多数的加工需求对于长切屑及难加工材料，成业可提供特殊的枪头刃磨形状及断屑槽

The sharpening geometry of the gun drill tip has a direct impact on hole tolerance, chip formation, cooling pressure and flow and tool life, centerline deflection, and surface quality.
Over the years, our company has successfully tested and developed a variety of different geometries for different materials. The sharpening geometry of standard gun drill tip that we invented is suitable for most processing needs for long chips and materials which is difficult to process. Our company can provide special sharpening shapes of gun drill tip and chip breakers.

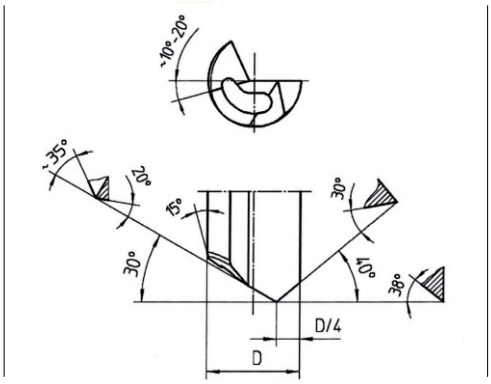


图1 适用于钻孔范围0.500-4.00mm
Fig. 1 Suitable for drill hole range of 0.500-4.00mm

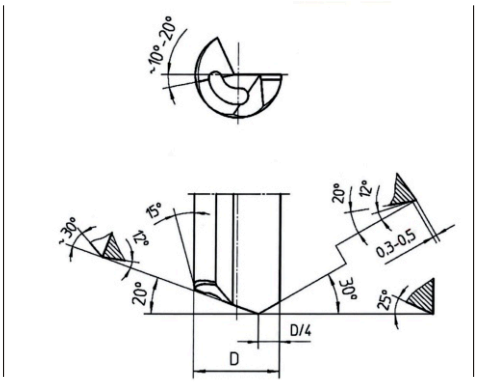
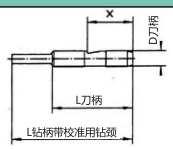
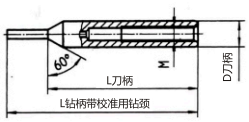
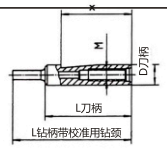
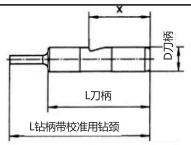
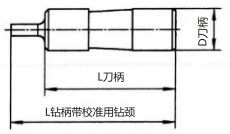
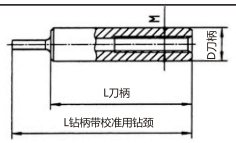
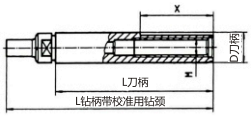
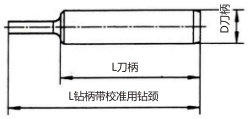
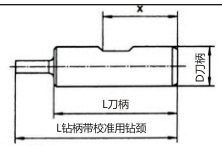
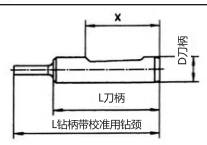


图2 适用于钻孔范围4.001-12.001mm
Fig. 2 Suitable for drill hole range of 4.001-12.001mm

成业根据多年经验优化了枪头的外形轮廓以满足和提高客户加工不同材质的需求
Our company has optimized the contour profiles of the gun tips to meet and improve customers requirements for the processing of different materials according to years of experience.

钻头设计 Drill Tip Design	整体硬质合金式设计 Solid Carbide Design	
图示 Icon		
钻孔范围 The range of drill hole	Ø 0.500-12.001	
枪钻长度 The length of gun drill	可提供100倍直径长、最长排屑槽300mm Suitable for 100 times diameter and longest chip groove of 300mm	
冷却孔设计 Cooling hole design	 腰形冷却孔 Waist cooling hole	
优越性 Advantages	可加工非常小直径的深孔 整体硬质合金设计保证刚性强、降低振动及加工中的扭曲 较高的进给量、比焊接式枪钻效率快 同心度高、确保最低的孔线偏斜度	Be able to process very small diameter deep holes Solid carbide design ensures rigidity, vibration reduction and distortion in the course of processing Higher feed rate, more efficient than welded gun drill High concentricity, ensuring the lowest hole skewness
外形轮廓与适应加工 提示：EA和G型为直径不可直接测试的非对称型 Contour profile and Adaptive Processing Tip: EA and G are asymmetric types whose diameter cannot be directly tested	 适用于几乎所有材料、高尺寸精度、最低的扭曲变形 Suitable for almost all materials, high dimensional accuracy、lowest distortion	 不锈钢材料、难加工材料、建议使用水溶性冷却液 Stainless steel materials, refractory materials Recommend to use water soluble coolant
	 铜、铝 尺寸精度高 Copper, aluminum With high dimensional accuracy	 铸铁及可锻材质、交叉孔、可从斜面钻入并钻出 Cast iron and wrought materials, cross holes can be drilled into and drilled out of inclined plane.
特殊轮廓 Special contour profile	可按特殊要求提供特殊轮廓 Special contour profiles are available on special request	
涂层 Coating	可按需求提供特殊涂层 Provide special coating based on requirements	

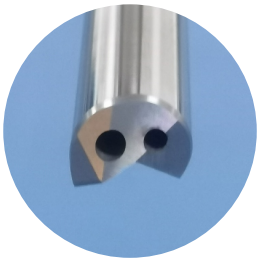
整体硬质合金枪钻的标准钻柄
The Standard Drill Shank Solid Carbide Gun Drill

编号 Number	直径	图例 Legend	刀具长度计算 The Calculation of Tool length			X=削边位置 X=Sharpened position	M=螺纹规格 M=Thread specification
			钻头直径范围 The range of drill diameter	L钻柄=夹紧区域 L drill shank= Clamping area	L钻柄带钻颈 L drill shank with drill neck		
CY101	6		0.500-4.649	30	45	17	
CY102	10		0.500-6.349	55	70		M6x0.5
CY103	10		0.500-6.349	40	55	32.7	M6x0.5
CY104	10		0.500-6.349	40	55	24	
CY105	12.7		0.500-6.349	38	48	25.4	
CY106	12.7		0.500-6.349	51	65		M6x0.5
CY107	16		0.500-10.000	80	105	37	M10x1
CY108	4		0.500-5.149	34	46		
CY109	6		0.500-4.649	36	50		
CY110	10		0.500-6.349	40	55		
CY111	12		0.500-6.349	45	60		
CY112	16		0.500-10.000	48	63		
CY113	6		0.500-4.649	36	50	20	
CY114	10		0.500-6.349	40	55	23.5	
CY115	12		0.500-6.349	45	60	26.5	
CY116	16		0.500-10.000	48	63	29	
CY117	6		0.500-4.649	36	50	25	
CY118	10		0.500-6.349	40	55	28	
CY119	12		0.500-6.349	45	60	33	
CY120	16		0.500-10.000	48	63	36	

焊接式合金枪钻 Welding type alloy gun drill

直径范围2.0-50.0mm, 全长可达6000mm

Therangeofitsdiameteris2.0−50.0mm,anditsoveralllengthcanreach6000mm

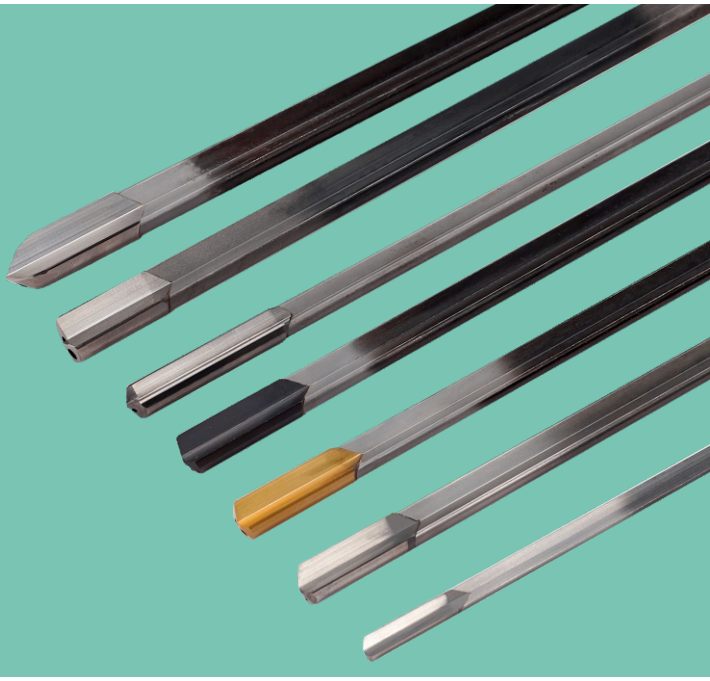


焊接式枪钻分为：

Weldedgundrillcanbedividedintoseveraltypes:

焊接式单刃合金枪钻、焊接式双刃合金枪钻、焊接式刀片枪钻

Welding single edged alloy gun drill, welding double edged alloy gun drill, welding blade gun drill



焊接式枪钻的优点

1.钻孔直径范围大、长度深、钻深可达6000mm

2.效率快、光洁度好、直线度高

3.钻杆可重复使用、多次焊接新枪头、节约成本

Advantages of Welded gun drill

1. The diameter range of drill hole is large, its length is deep, and the depth of drill can reach 6000mm

2. High efficiency, good fineness and high straightness

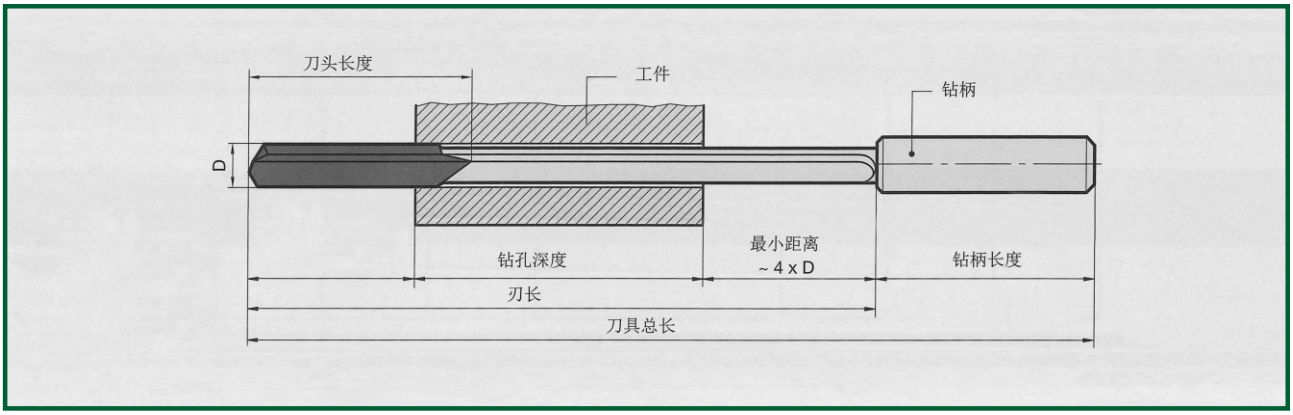
3. The drill pipe can be reused, welding gun tip for multiple times and saving cost

刀具设计

此类枪钻分为枪头、枪杆、枪柄三部分组成、枪头部分与经过特殊热处理的枪杆钎焊在一起
枪杆再与径淬硬和精磨过的钢制枪柄钎焊在一起而成为一个整体

Tool Design

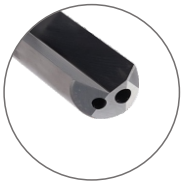
This kind of gun drill is divided into three types: the gun tip, the gun pipe and the gun shank. The gun tip part is brazed with the specially heat-treated gun pipe.
The gun pipe is then brazed together with a hardened and finely grinding steel gun shank.



焊接式单刃枪钻

单刃通用型标准枪钻
Single-blade universal standard gun drill

适合于绝大部分产品加工
Suitable for most products processing





单刃式台阶型枪钻
Single-blade stepped gun drill

可一次性加工出同一个孔内的不同孔径，可以满足于阶梯加工的同轴及同心度要求
Be able to process different apertures in the same hole at one time, which can meet the coaxial and concentricity requirements of step processing





单刃式球形枪钻
Single-blade spherical gun drill

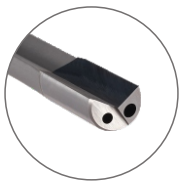
钻出的孔底部是球形状的 适合孔底有球形要求的
The bottom of the drill hole is in the shape of a ball.which is situable for the ball -shapoe drill hole





单刃式平底枪钻
Single-edged flat-bottomed drill

钻出的孔底部是平的、适合孔底有平底要求的
The bottom of the drilled hole is flat which suitable for the bottom of the flat dri hole.





成业可以根据您不同的产品加工要求和底部形状做出成熟的解决方案和相应的涂层方式。
Our company can adopt experienced solutions and corresponding coating methods according to your different product processing requirements and bottom shape.

我们不承担不当使用、错误操作、不良机床状态引起的刀具失效或损坏责任。
为了您的利益、请遵循合理正确的枪钻使用方式, 我们乐意为您提供枪钻使用及加工方面的帮助

We are not responsible for tool failure or damage caused by improper use, incorrect operation, or poor machine conditions. For your benefit, please follow the reasonable and correct way to use the gun drill. We are willing to provide you with the assistance of gun drill and processing.

焊接式单刃枪钻钻头刃磨形状及外形轮廓
The sharpening shape and contour profile of welded single-blade gun drill

枪头的刃磨几何形状对孔的公差、切屑的形成、冷却压力及流量和刀具寿命、中心线偏斜、表面质量都有直接影响。
多年来，成业针对不同的材质已成功的试验并研制成多种不同的几何形状，我们开发出的标准枪头刃磨几何形状适用于大多数的加工需求，对于长切屑及难加工材料，成业可提供特殊的枪头刃磨形状及断屑槽

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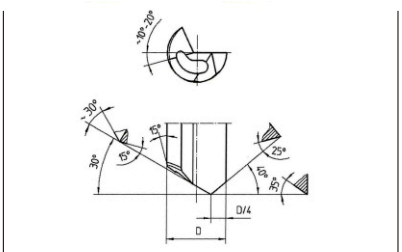


图1 用于钻孔范围：1.850-4.000 mm
Figure1. use for the range of drill hole 1.850-4.000 mm

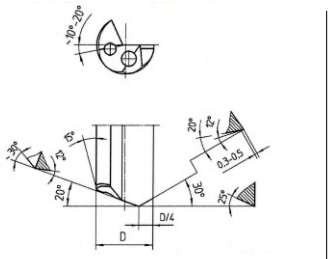


图2 用于钻孔范围：4.001-20.000 mm
Figure2. use for the range of drill hole 4.001-20.000 mm

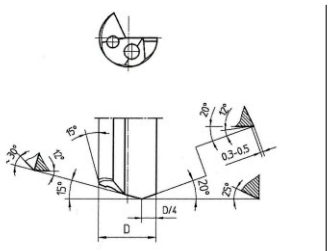
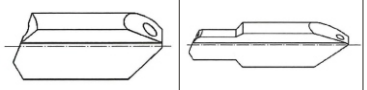
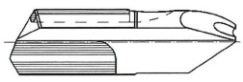
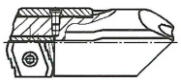
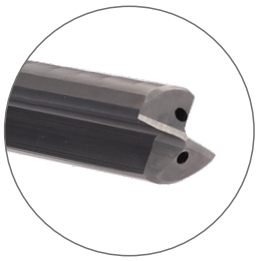


图3 用于钻孔范围：20.001-... mm
Figure3. use for the range of drill hole20.001-... mm

成业根据多年经验优化了枪头的外形轮廓以满足和提高客户加工不同材质的需求
Our company has optimized the contour profiles of the gun tips to meet and improve customers requirements for the processing of different materials according to years of experience.

钻头设计 Drill Tip Design	整体硬质合金刀头 Solid carbide tool head	焊接硬质合金切削刃寄支撑导条 Welded carbide cutting edge supporting guide bar	可换刀片切削刃及导条 Replaceable blade cutting edge and guide bar
图示 Icon			
钻孔范围 The range of drill hole	1.850-50.00	5.8-65.002	12.000-45.000
枪钻长度 The length of gun drill	按直径 最长6000mm According to diameter, the longest is 6000mm		
冷却孔设计 Cooling hole design			
优越性 Advantages	按加工需要有不同的外形轮廓可供选择 可以重复修磨，不同的冷却孔优化了冷却液的流动性 Different contours are available according to processing needs Can repeat grinding different cooling holes in order to optimize fluidity of the coolant	按特定的加工要求切削刃可以与导向条 材料不同，可以重复修磨 Cutting edge can be guided with guide bar according to specific processing requirements Different materials can be repeatedly repaired	适用于大批量加工、速度快、经济性非常好，可更换刀片及导向条，交叉孔加工可用加长或双导向条 Suitable for replaceable blade with high-volume processing, fast speed, good economic, and guide strips for cross-hole processing can adopt extended or double guide strips
外形轮廓与适应加工 提示：EA、G、E型为直径不可直接测试的非对称型 Contour profile and Adaptive Processing Tip: EA and G are asymmetric types whose diameter cannot be directly tested	G（标准） 适用于几乎所有材料高尺寸精度、最低的扭曲变形 Suitable for almost all materials, high dimensional accuracy、lowest distortion C 不锈钢材料 难加工材料 建议使用水溶性冷却液 Stainless steel materials, refractory materials. Recommend to use water soluble coolant A 铜、铝 高尺寸精度场合 Copper, aluminum high-precision occasions D 铸铁及球墨铸铁 Cast iron and ductile iron	EA 钢、铝 交叉孔加工、从斜面钻入及钻出 Steel and aluminum cross hole machining, drilling and drilling from slope S 钢 高尺寸精度场合完好的表面质量 适合加工短孔 Steel with high dimensional accuracy, good surface quality which is suitable for processing short holes	
特殊轮廓 Special contour profile	可按特殊要求提供特殊轮廓、也可提供所需特殊涂层 Special contour profiles are available on special request and also can provide special coating based on requirements		

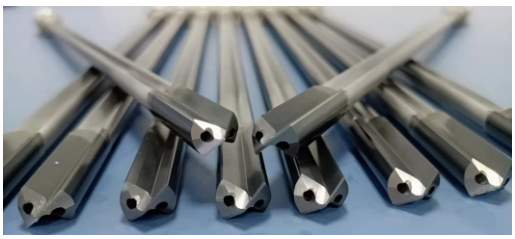
双刃枪钻
Double edged gun drill



直径范围4.0-32.0 全长3000mm
The range of diameter is 4.0-32.0 Its overall length is3000mm

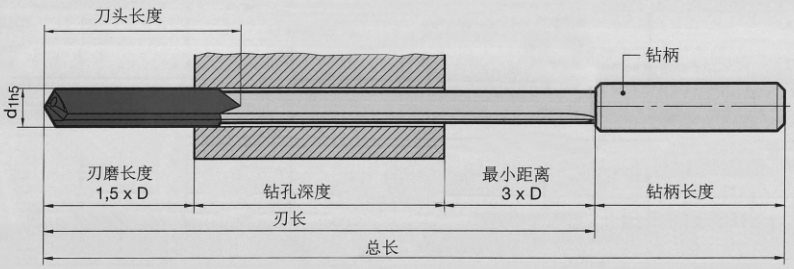
适合加工铸铁、铜、铝等软金属材料
Suitable for processing soft metal materials such as cast iron, copper, aluminum, etc



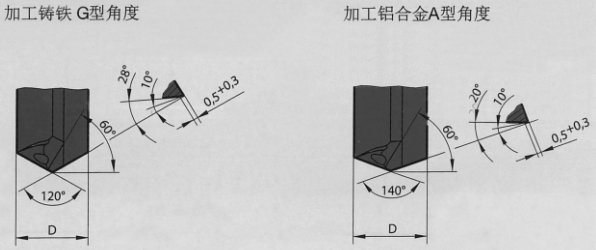


- 双刃枪钻可分为焊接式和整体硬质合金式，双刃枪钻有两个排屑槽、与单刃枪钻相比，双刃枪钻能达到更快的速度，极大提高了钻孔的效率。
- 另一方面，由于双刃枪钻有两条对称的切削刃，导向条没有足够的挤压压力，对内孔表面不能产生充分的挤压效果, 因此不能达到单刃枪钻的表面加工精度。
- The double-blade gun drill can be divided into welded type and solid carbide type. The double-blade gun drill has two chip grooves. Compared with the single-blade gun drill, the double-blade gun drill can be faster speed and greatly improve the efficiency of drilling hole.
- On the other hand, because double-blade gun drill has two symmetrical cutting edges and the guide bar does not have sufficient pressing pressure, the surface of the inner hole cannot be sufficiently squeezed. Therefore, the surface processing accuracy of the single-blade gun drill cannot be achieved.

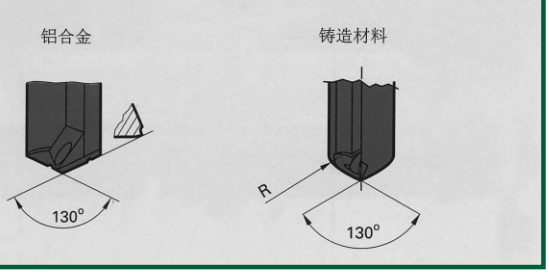
使用普通机床时必须计算行程长度



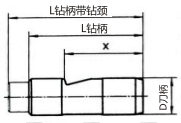
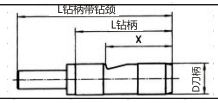
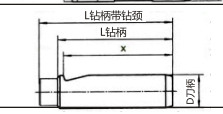
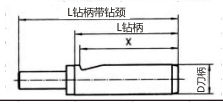
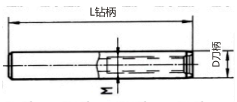
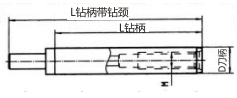
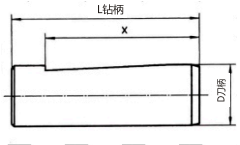
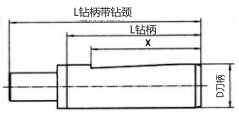
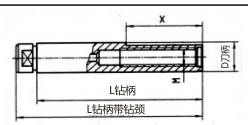
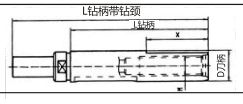
标准刀头角度



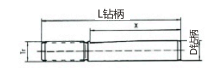
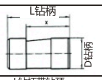
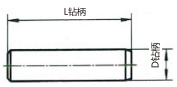
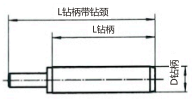
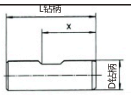
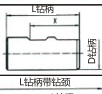
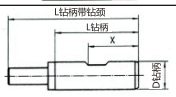
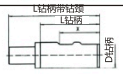
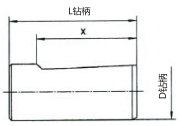
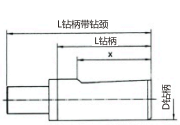
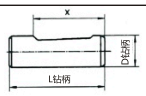
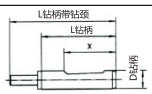
特殊刀头角度



钎焊刀头式枪钻标准钻柄的各种类型
All kinds of standard drill shank for single-blade gun drill

编号 Number	直径	图例 Legend	刀具长度计算 The Calculation of Tool length			X=削边位置 X=Sharpened position	M=螺纹规格 M=Thread specification
			钻头直径范围 The range of drill diameter	L钻柄=夹紧区域 L drill shank= Clamping area	L钻柄带钻颈 L drill shank with drill neck		
CY201	10		1.850-7.299	40		24.0	
CY202	16		1.850-12.399	45	53	31.0	
CY203	25		7.300-19.509	70	78	34.0	
CY204	10		7.300->	40	57	24.0	
CY205	16		12.400->	45	72	31.0	
CY206	25		19.510->	70	105	34.0	
CY207	16		1.85-12.399	50	58	47.5	
CY208	16		12.400-20.500	50	77	47.5	
CY209	10		1.850-7.299	60			M6x0.5
CY210	16		1.850-12.399	80			M10x1
CY211	25		7.300-19.509	100			M16x1.5
CY212	10		7.300->	60	77		M6x0.5
CY213	16		12.400->	80	105		M10x1
CY214	25		19.510->	100	140		M16x1.5
CY215	12. 7		1.850-9.699	38.1		25.4	
CY216	19. 05		3.960-14.899	70		45.0	
CY217	25. 4		6.000-19.509	70		57.5	
CY218	31. 7		9.700-25.609	70		57.5	
CY219	38. 1		9.700-32.609	70		57.5	
CY220	19. 05		14.900->	70	97	45.0	
CY221	25. 4		19.510->	70	100	57.5	
CY222	31. 7		25.610->	70	110	57.5	
CY223	38. 1		32.610->	70	110	57.5	
CY224	10		1.850-6.749	60	68	35	M6x0.5
CY225	16		1.850-10.799	80	90	37	M10x1
CY226	25		6.000-19.509	100	112	45	M16x1.5
CY227	16		10.800->	80	110	37	M10x1
CY229	25		19.510->	100	142	45	M16x1.5

钎焊刀头式枪钻标准钻柄的各种类型
All kinds of standard drill shank for single-blade gun drill

编号 Number	直径	图例 Legend	刀具长度计算			X=削边位置 X=Sharpened position	M=螺纹规格 M=Thread specification
			钻头直径范围 Therange of drill diameter	L钻柄=尖紧区域 L drill shank= Clamping area	钻柄钻颈 L drill shank with drill neck		
CY230	16		1.850-12.559	112		73.0	TR16x1.5
CY231	20		1.850-14.899	126		82.0	TR20x2
CY232	28		6.000-21.509	126		82.0	TR28x2
CY233	36		8.700-28.609	162		109.0	TR36x2
CY234	16		1.850-12.399	40		28.0	
CY235	25		7.300-19.509	50		35.0	
CY236	35		9.700-28.609	60		40.0	
CY237	16		12.400->	40	67	28.0	
CY238	25		19.510->	50	77	35.0	
CY239	35		28.610->	60	100	40.0	
CY240	10		1.850-7.299	40			
CY241	12		1.850-8.999	45			
CY242	16		1.850-12.399	48			
CY243	20		1.850-15.899	50			
CY244	25		7.300-19.509	56			
CY245	32		9.700-25.609	60			
CY246	40		9.700-32.609	70			
CY247	10		7.300->	40	57		
CY248	12		9.000->	45	62		
CY249	16		12.400->	48	75		
CY250	20		15.900->	50	77		
CY251	25		19.510->	56	86		
CY252	32		25.610->	60	100		
CY253	40		32.610->	70	110		
CY254	10		1.850-7.299	40		23.5	
CY255	12		1.850-8.999	45		26.5	
CY256	16		1.850-12.399	48		29.0	
CY257	20		1.850-15 899	50		30.5	
CY258	25		7.300-19.509	56		38.0	
CY259	32		9.700-25.609	60		43.0	
CY260	40		9.700-32.609	70		47.0	
CY261	10		7.300->	40	57	23.5	
CY262	12		9.000->	45	62	26.5	
CY263	16		12.400->	48	75	29.0	
CY264	20		15.900->	50	77	30.5	
CY265	25		19.510->	56	86	38.0	
CY266	32		25.610->	60	100	43.0	
CY267	40		32.610->	70	110	47.0	
CY268	10		1.850-7.299	40		28.0	
CY269	12		1.850-8.999	45		33.0	
CY270	16		1.850-12.399	48		36.0	
CY271	20		1.850-15.899	50		38.0	
CY272	25		7.300-19.509	56		44.0	
CY273	32		9.700-25.609	60		48.0	
CY274	40		9.700-32.609	70		66.0	
CY275	10		7.300->	40	57	28.0	
CY276	12		9.000->	45	62	33.0	
CY277	16		12.400->	48	75	36.0	
CY278	20		15.900->	50	77	38.0	
CY279	25		19.510->	56	86	44.0	
CY280	32		25.610->	60	100	48.0	
CY281	40		32.610->	70	110	66.0	
CY282	10		1.850-7.299	40		28.0	
CY283	12		1.850-8.999	45		33.0	
CY284	16		1.850-12.399	48		36.0	
CY285	20		1.850-15.899	50		38.0	
CY286	10		7.300->	40	57	28.0	
CY287	12		9.000->	45	62	33.0	
CY288	16		12.400->	48	75	36.0	
CY289	20		15.900->	50	77	38.0	

刀片、导条式单刃枪钻
Blade, bar type single-blade gun drill

直径范围10-80 长度可达6000mm
The range of diameter is 10-80 Its overall length is6000mm

此种枪钻枪头是特殊钢体、刀片和导向条是硬质合金，刀片切削、导条导向支撑。适用于大批量生产、速度快、经济效益好，不需要修磨、直接更换刀粒和导条就行了、在难加工材料和加硬材料上优势明显。

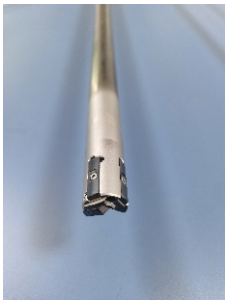
The gun drill tip is a special steel material, the blade and the guide strip are carbide, the blade is used to cut, and the guide bar is used to support. It is suitable for mass production, fast speed and good economic benefit. It does not need to be repaired, directly replaces the knives and guide bars, and has obvious advantages in difficult materials and hardened materials.













BTA系统钻头
BTA Drill Tip

直径范围14-200 长度可达16000mm
The range of diameter is 14-200 Its overall length is16000mm

适合大孔径加工 专用机械使用
Suitable for large aperture processing Available for special machinery

- BTA钻头钻杆是由圆形的特殊钢体精磨而成、钻头是用特殊合金钢经七轴复合铣制作而成，刀片和导向条通过焊接或者螺丝固定组成，钻杆和钻头通过螺丝锁紧在一起, 长度可自由调控，高压冷却油有外部供给，铁屑从枪杆内部排出，孔径范围大, 加工效率快。

- BTA钻头分为焊接式刀片导向条、可换式刀片导向条，焊接式BTA适合14-60以内的小孔，刚性强、直径可以控制、效率快 、一次性使用、成本高。可换刀片式BTA 直径控制差、效率快、节约成本、适合孔径要求不高的大孔。

- The BTA drill bit drill rod is finely ground from a circular special steel body, and the drill bit is made of special alloy steel through seven axis composite milling. The blade and guide bar are composed of welding or fixed with screws. The drill rod and drill bit are locked together by screws, and the length can be freely adjusted. High pressure cooling oil is supplied externally, and iron filings are discharged from the inside of the gun shaft, with a large aperture range and fast processing efficiency.

- BTA drill bits are divided into welded blade guide bars and replaceable blade guide bars. Welded BTA is suitable for small holes within 14-60, with strong rigidity, controllable diameter, fast efficiency, one-time use, and high cost. The replaceable blade type BTA has poor diameter control, fast efficiency, cost savings, and is suitable for large holes with low aperture requirements.















枪钻配套用的各类附件
All Kinds of Accessories for Gun Drills

导向套 Guide Sleeve

导向套分为钢制热处理导向套、钢制镶合金导向套、整体合金导向套，导向套起枪钻定心作用、导向套和引导孔的精度直接影响到钻孔的精度和枪钻的使用寿命。

The guide sleeve is divided into a steel heat treatment guide sleeve, a steel alloy guide sleeve, an solid carbide guide sleeve. The guide sleeve has centering function for gun drill. The precision of the guide sleeve and the guide hole can have directly impact on the accuracy of the drill hole and the use life of the gun drill.



橡胶套 Rubber sleeve

橡胶套、装在枪杆中间不同位置、起减震缓冲作用，把枪杆抖动控制在一定程度，如跟枪杆配合不好会导致钻孔直线度和孔径变差、甚至甲断枪杆。

The rubber sleeve is installed in different positions in the middle of the gun, and acts as a shock absorbing buffer to control the vibration of the gun to a certain extent. If the gun is not well matched, the straightness and the hole diameter of the gun may be deteriorated, and the gun may be broken.



延长杆 Extension rod

帮助枪钻增加长度和刚性，可以短枪长用，钻深孔时枪钻不够长可以使用。缩短小枪钻的枪杆长度，借用延长杆就可以达到想要钻孔的深度、刚性强、出油量大、速度快。

It can help the gun drill to increase its length and rigidity. It can be used for short guns. When drilling deep holes, the gun drill can not be used long enough to shorten the length of the gun drill. By using the extension rod, the depth, rigidity and oil output can be achieved with large amount of oil and fast speed.



砂轮 Grinding wheel

砂轮的质量和颗粒度直接影响到刀具修磨的效果、我们可以提供成业专用砂轮。

The quality and graininess of the grinding wheel directly affects the grinding effect of the tool. We can provide a special grinding wheel of our company.



磨刀夹具 Sharpening fixture

枪钻刃磨夹具 夹装枪钻、可以随意调整修磨角度、灵活性强，可以装在普通磨床上使用

The sharpening fixture of gun drill, clip-type gun drill, can adjust the grinding angle and its flexibility freely. It can be used on ordinary grinding machines.



磨刀机 Grinding machine

枪钻专用磨刀机、专为修磨枪钻用、简单实用，灵活方便

The special grinding machine is used for grinding and grinding.
It is simple and practical, flexible and convenient.



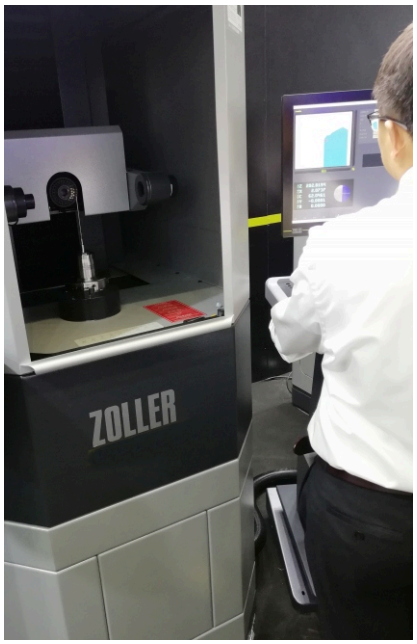
车间 Workshop



自动化车间
Automation workshop



检测仪器
Detection Equipment



对刀仪
Tool Checking Instrument



五轴数控磨
Five-Axis CNC Grinder



仓库
warehouse



行业领先的**枪钻制造商**

As the leading gun drill manufacturers in the Industry



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