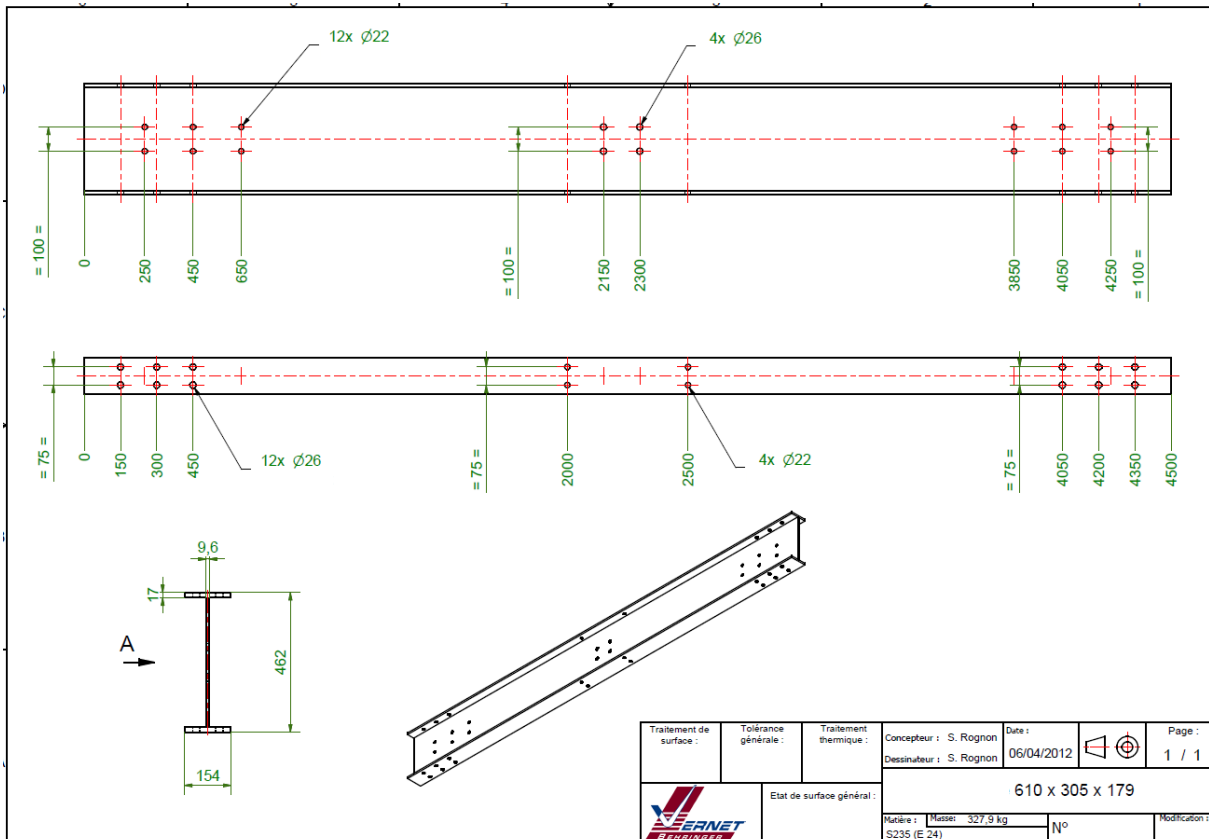


# DRILLING TIME COMPARISON

## HD vs. HD-X



⇒ Drilling time with HD machine (carbide drill): **240 s**

Cutting parameters:  $\phi$  22 mm -  $V_c= 100$  m/min,  $a=0.28$ ,  $\phi$  26 mm -  $V_c= 100$  m/min,  $a=0.32$

➔ **x3 faster than HSS!**

⇒ Drilling time with HD-X machine (carbide drill): **150 s**

Cutting parameters:  $\phi$  22 mm -  $V_c= 100$  m/min,  $a=0.28$ ,  $\phi$  26 mm -  $V_c= 100$  m/min,  $a=0.32$

➔ **60% faster than HD!**

## HD drilling machine

- Framework design ensuring vibration less carbide drilling
- Drilling speed: up to 3500 RPM
- Ultra stable and robust
- For beams up to 1800 x 600 mm



## HD-X drilling machine

HD architecture with **additional motion on x-axes (500 mm stroke) on the 3 spindles:**

- **Very high productivity:** holes drilled in hidden time, no carriage motions within 500 mm window
- **Best accuracy:** +/- 0,1 mm for unit positioning within 500 mm
- **Milling possibilities:** long holes, big diameters...

