



Small Hole Drilling machines developed for the production of components with bores 0.6 – 6mm in diameter

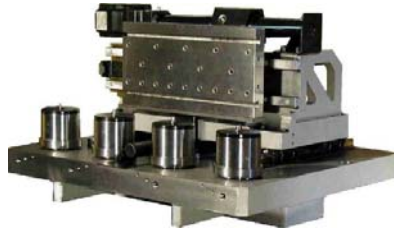
A series of deep hole drilling machines specialising in the diameter range 0.6mm – 6mm. Machines can be provided in 2 or 4 spindle configurations depending on drill diameter and customer requirements. Direct applications for which Mollart have already supplied machines in this machine range are in fuel injection, automotive, gas cutting tips, MIG welding tips, hydraulics, and medical components / instruments.

All Mollart Machines meet with the latest **CE** specifications and are supplied fully guarded.

Machine Features & Options



Optional tailstock for component counter rotation of on-centre drilled components offering greater drilling accuracy



The machine can also be fitted with a co-ordinate worktable giving the possibility to drill prismatic parts or offset hole patterns. The same table can also be used as part of an auto loading system.



Control is by the Siemens with standard features such as process monitoring, specialist parametric programming to enable operation without specialist CNC knowledge.



There are several loading systems that can be used to automate the loading of the machine. The above system can offer chip to chip times as low as 5 seconds



Customers can use simple work holding to produce prototype parts.



High volume automotive solutions can be offered as full turnkey solutions. The above picture shows a machine fitted with four hydraulically clamped fixtures

Applications



Various medical components including human implants made from stainless steel and in titanium with hole sizes from 0.6mm.



Oxy-acetylene Gas cutting nozzles. This product has hole sizes typically 1.8mm diameter with angled holes and on axis holes. Feeds and speeds up to 400mm / min are achieved in production.



2mm oil hole going down through the thin wall through the open bore and exiting at the waisted part of the lifter.

Specification

Number of Spindles	2 or 4
Gundrilling Diameter Range	0.6mm – 6mm std (8mm Option)
Maximum Drilling Depth (Programmable)	300mm
Maximum Component Length	350mm
X Axis travel	300mm (Optional)
Spindle Nose Bore	10mm (whistle notch type)
Spindle Centre Distance	180mm
Coolant Capacity	650 Litres
Coolant Pump	Moog 0 – 42 Litres/min
Coolant Pressure	0 – 160 Bar
Filtration Level	0 – 25 micron std (10 micron option)
A.C. Spindle Motor Power	0.55 kW per spindle
Spindle Speed Range (A.C. Infinitely Variable)	0 – 25,000 RPM
Drill Feed Range (A.C. Infinitely Variable)	0 – 1000mm/min
Rapid Traverse Speed	4m/min per minute
Feed Motor Power	4.65kW
Maximum Drill Thrust	70kN
Weight of Machine	1900kg (Dry load)
Machine Floor Area	1200mm (W) x 1700mm (D) x 2520mm (H)
Electrical Supply	400 Volts, 3 Ph + neutral, 50 Hertz.
Control Voltage	24 Volts DC
Rated Supply Current	32 Amps
Control System	Siemens S7300
Mollart Software including Monitoring	Spindle & Feed Power Coolant Pressure

All specifications are subject to change without prior notice.

Contact details

MOLLART ENGINEERING LTD

Headquarters • Deep Hole Drilling Machines Manufacturing • Subcontract Deep Hole Drilling with full CNC Machine Shop back-up for complete parts • Exclusive UK Agent for BOTEK Deep Hole Drilling Tools - Gundrills, BTA & Ejector

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Deep Hole Drilling Machine Range



drillsprint

1-4 spindle light-duty Gundrilling machine developed for the production drilling of shafts with deep holes in the drill diameter range 2-25mm



omnisprint

Multispindle 3-axis Knee type Gundrilling machine for off-centre drilling in the drill diameter range 2-25mm



MD Boremaster

1 or 2 spindle medium-duty Gundrilling machine in the drill diameter range 5-50mm and drilling depths up to 2000mm for centre-line drilling of shafts



MD Boremaster

4-8 spindle medium duty Gundrilling machine in the drill diameter range 5-20mm and drilling depths up to 2000mm for centre-line drilling of shafts



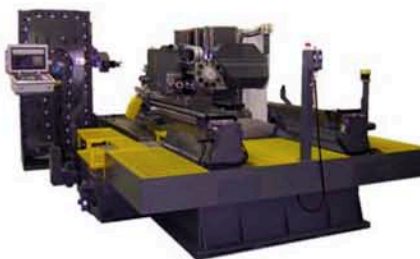
HD Boremaster

1 or 2 spindle heavy-duty BTA drilling machine in the drill diameter range 18-150mm and drilling depths up to 3 metres for centre-line drilling of shafts



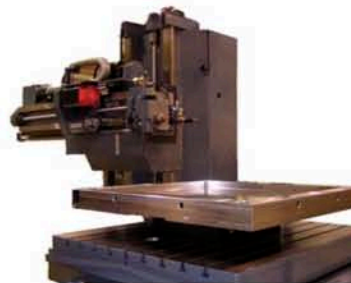
microdrill

A series of deep hole drilling machines specialising in the diameter range 0.6mm - 6mm. Machines can be provided in 2 or 4 spindle configurations



FMC

Flexible Machining Centre for gundrilling, milling and tapping prismatic parts such as mould and heat exchanger plates and hydraulic manifolds.



prismabore

Large capacity machine for gundrilling and milling of mould and heat exchanger plates, hydraulic manifolds and cylinders for rolling mills



Pellet Die

Special purpose CNC Gundrilling Machine for drilling pellet-extruding dies. 2 - 16 Spindles and up to 36,000 holes in one workpiece