

# NPN

New Product News



## T-DEEP

### Drill Diameter Adjustment Shims for T-DEEP Gundrills



## KEY POINT

**TaeguTec has launched a shim set that allow precise diameter adjustment of T-DEEP gundrills.**

TaeguTec's new shim set for T-DEEP gundrills provides quick and easy adjustment of drill diameter and minimizes inventory of special products.

The shim set allows the diameter of TRGD(L) T-DEEP (diameter 14-28 mm) gundrills to be precisely adjusted to 0.01-0.1 mm. The shim set must be mounted under the guide pads which are assembled on to the TRGD(L) T-DEEP gundrill line.

Please contact the product manager for further technical questions.

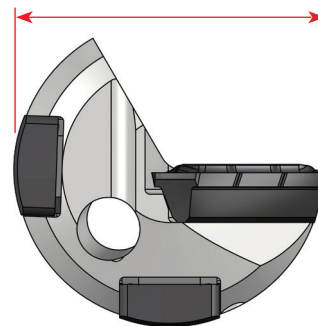
### Features

- The diameter of the TRGD(L) T-DEEP gundrill can be adjusted using the shim (diameter 14-28 mm)
- Simple and fast diameter adjustment range: 0.01-0.1 mm
- Two sets of shims can be used to adjust to the desired drill dimensions
- Precise diameter machining is possible, such as using HSS carbide long drills or brazed gundrills

## Assembly Instructions

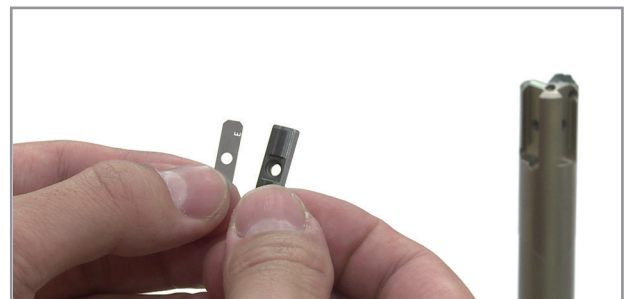
### STEP 1

Measure the diameter between the guide pad and the insert using a micrometer or vernier caliper. You can also measure the diameter of the hole after actual machining.



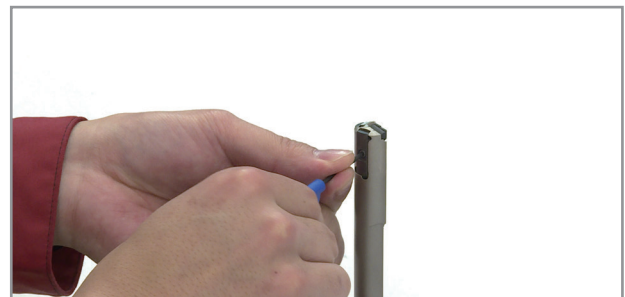
### STEP 2

Refer to the table on page 5 to combine the shims in order to obtain the required diameter. The actual drilling diameter is usually slightly (20-30  $\mu\text{m}$ ) larger than the measured drill diameter in step 1.



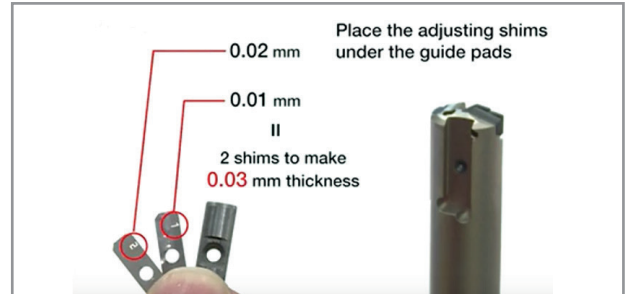
### STEP 3

Remove the guide pads to install the shim.



## STEP 4

Place the shim underneath the guide pad and tighten the guide pad to the drill holder.



## STEP 5

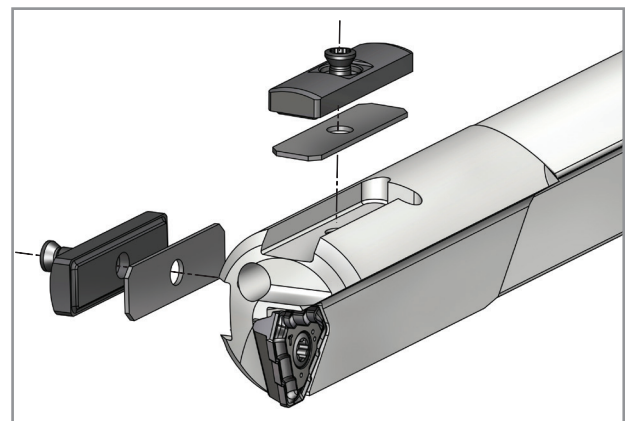
Make sure the drill diameter is the desired dimension.



\* Real drill machining diameter: 16.03-16.04 mm

## STEP 6

After machining the hole, make sure that the hole diameter is the desired dimension.



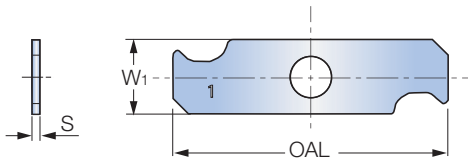
### Shim thickness:

There are numbers marked on each shim; 1-5.

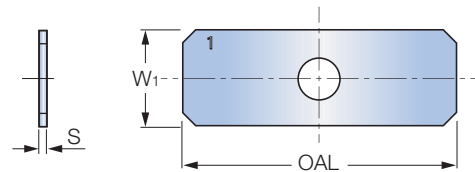
The number on the shim indicates the shim's thickness i.e.

1=0.01 mm, 2=0.02 mm, 3=0.03 mm

4=0.04 mm, 5=0.05 mm



SHIMSET-GO04  
SHIMSET-GO05



SHIMSET-GO06

Item #	Designation	Width W <sub>1</sub> (mm)	Length OAL (mm)	Thickness S (mm)	Applicable guide pad size
6221768	SHIMSET-GO04	4	16	0.01-0.05	PAD-GO04
6339582	SHIMSET-GO05	5	18	0.01-0.05	PAD-GO05
6221769	SHIMSET-GO06	6	20	0.01-0.05	PAD-GO06

• The shim set consists of five shims in different thicknesses. (0.01, 0.02, 0.03, 0.04, 0.05 mm)

• Shims are sold by set only, and are not to be sold separately

### Shim combinations for various diameters

Diameter adjustments (mm)	Shim (s) for measuring guide pad	Shim (s) for supporting guide pad	Number of shim sets needed
+0.01	0.01	-	1
+0.02	0.02	0.01	1
+0.03	0.03	0.01+0.02	1
+0.04	0.04	0.01+0.03	1
+0.05	0.05	0.02+0.03	1
+0.06	0.01+0.05	0.02+0.04	1
+0.07	0.02+0.05	0.03+0.04	1
+0.08	0.03+0.05	0.04+0.04	2
+0.09	0.04+0.05	0.04+0.05	2
+0.10	0.05+0.05	0.04+0.04+0.02	2

