



## ACCURATE SLOT DRILLING

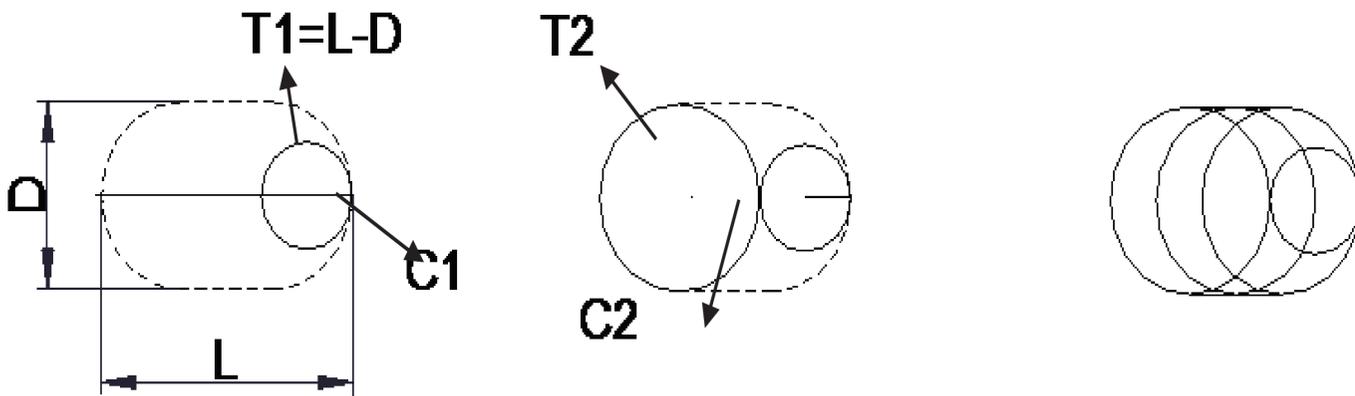
### OUR RECOMMENDATIONS

#### OPTION A

- 1 Use shorter Flute length
- 2 Pre drilling by a smaller hole

#### Solution of short slot drilling by pre-drilling

- (a) First, a pre drilled hole performed by T1
- The size of T1 is determined by the difference between slot length and slot width.
- The position of T1 is determined by the condition that the circle of T1 is tangent to the slot produced and T1 center (C1) is located on the slot centerline
- (b) Then the starting point for slot drilling is drilled by T2 on the opposite side.
- The position of T2 is determined by the condition that T1 circle, T2 circle and slot profile are tangent to each other.



- 3 Further if operating parameters (Infeed) is adjusted faster or slower it completely avoid slot shape problem.

#### OPTION B

Take size of T1 as half of T2.

### PERFORMANCE RESULTS

#### WITHOUT PRE-DRILLING

#### WITH PRE-DRILLING

#### TOP PANEL UPWARD SIDE



#### BOTTOM PANEL DOWNWARD SIDE

