

## Multi-Spindle Heads for Drilling and Tapping

### THE HIGHEST QUALITY & MOST ROBUST MULTI-SPINDLE DRILLING HEADS ON THE MARKET TODAY!

- Specialists in the design & manufacture of multi-spindle Drilling & Tapping Heads
- Designed for use with small self-feed drilling units
- Standard range of 2-5 spindle heads (150/400/650/800/950/1250)
- Bespoke design available
- Our designs are patented
- Adaptors to suit all types of machines
- Full range of metric collets increments of .1mm
- Ex-stock delivery on standard items
- All designs are manufactured in the UK



Celebrating  
50 Years of  
Manufacturing!!



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Group

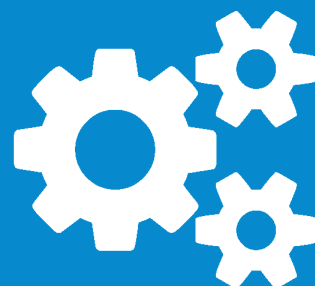
For full details & for full range of Gy-Roll products please contact:  
Gy-Roll Limited, Sand Road Industrial Estate, Sand Road, Great Gransden, Nr  
Sandy, Bedfordshire, SG19 3AH

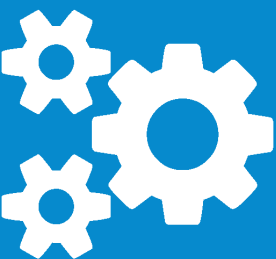
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## MODEL 400 TWIN SPINDLE ADJUSTABLE DRILLING HEAD

Minimum Spindle Centres:  
3/8" (9.5mm)  
Maximum Spindle Centres:  
2 1/8" (54.0mm)  
Drill Sizes up to maximum of:  
5/32" (4.0mm)  
Specify drill size when ordering head.

Collet Sizes Available:  
1.0mm to 4.0mm  
In 0.1mm Steps

Dimension marked 'X' varies according to the type of self-feed unit used. This dimension is kept to a minimum to keep the head as compact as possible.

Standard Adaptors available for most self-feed drilling units. Special Adaptors for other units can be quoted for.

This head is also suitable for tapping up to a maximum of M3 (1/8") with a lead screw or pitch controlled tapping unit.

Tap Shank and thread size must be specified when ordering head.

Tool Lock for preventing the drill or tap from slipping in the collet.

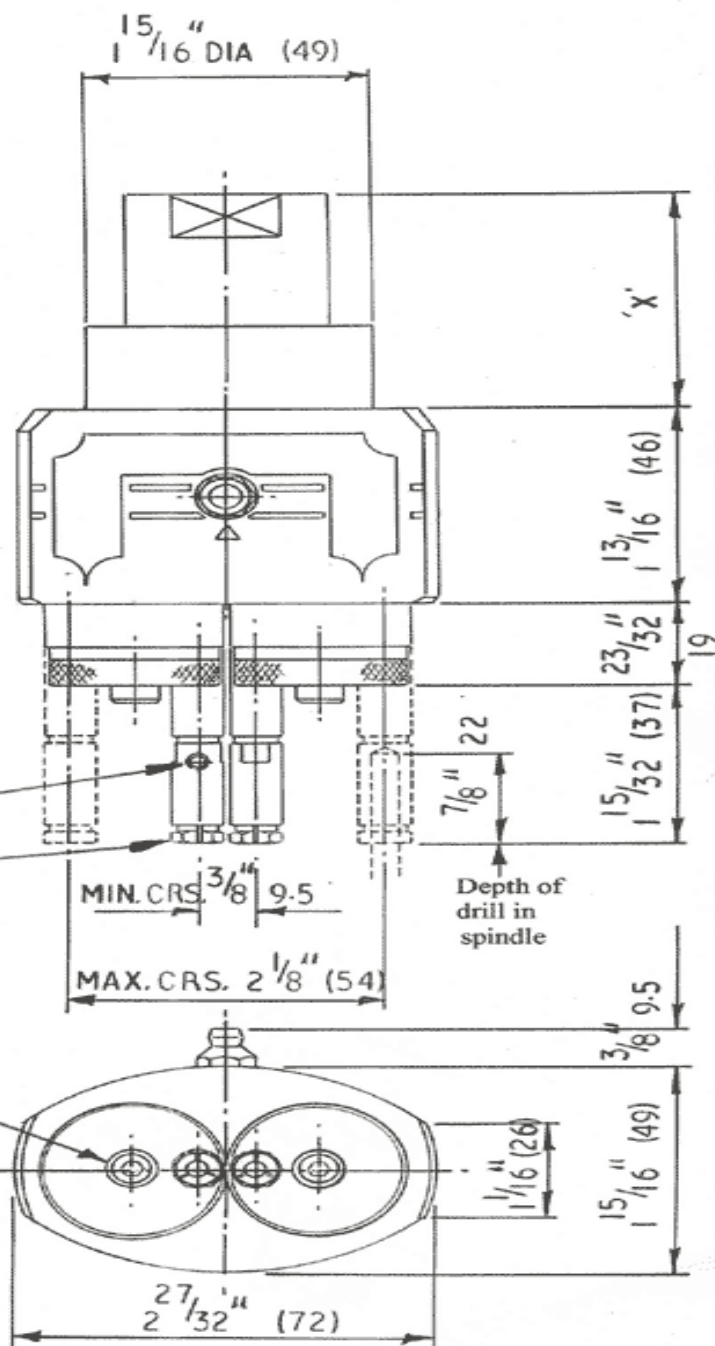
Collet P1809  
Use 8mm Ring Spanner for tightening collet when fitting drill or tap.

Slacken screw to adjust spindle position.

Slacken both screws to rotate head relative to self-feed unit.

Ratio of gearing in head  
Input to Output : 1:1

Maximum Spindle Speed :  
10,000 R.P.M.



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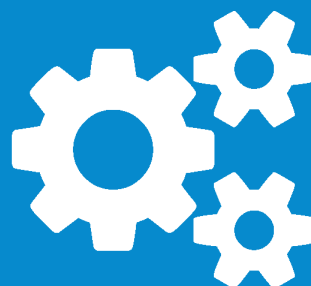
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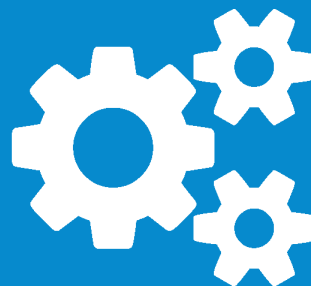
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Minimum Spindle Centres:  
1/2" (12.7mm)

Maximum Spindle Centres:  
2 1/2" (63.5mm)

Tap Sizes up to maximum of:  
M4 (5/32")

Specify tap thread and shank size when ordering head.

Self-reversing mechanism for tapping heads fitted to self-feed drills.

Where head is required for fitting to lead screw or pitch controlled tapping unit the standard GY-ROLL Drilling Head should be used.

Dimension marked 'X' varies according to the type of self-feed unit used. This dimension is kept to a minimum to keep the head as compact as possible.

Standard Adaptors available for most self-feed drilling units. Special Adaptors for other units can be quoted for.

Tool Lock for preventing the tap from slipping in the collet.

Collet P1039  
Use 11mm Ring Spanner for tightening collet when fitting tap.

Slacken screw to adjust spindle position.

Slacken both screws to rotate head relative to self-feed unit.

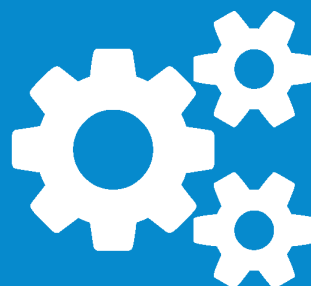
Ratio of gearing in head  
Input to Output : 1:1

Dimensions (inches / millimeters):

- Top section height: X
- Section below top: 3 15/32" (88)
- Section below that: 13" (46)
- Section below that: 3 1/8" (9.5)
- Section below that: 2" (51)
- Section below that: 15/16" (24)
- Section below that: 3 1/8" (9.5)
- Section below that: 2" (51)
- Section below that: 1 1/2" (38)
- Section below that: 3 1/4" (83) DIA.

Other dimensions and features:

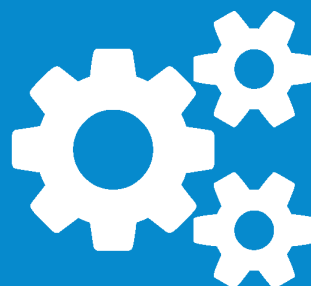
- 2 7/32" (56.4) DIA
- MIN. CRS. 1/2" (12.7)
- MAX. CRS. 2 1/2" (63.5)
- Depth of tap in spindle





The technical drawing consists of two views of a mechanical component:

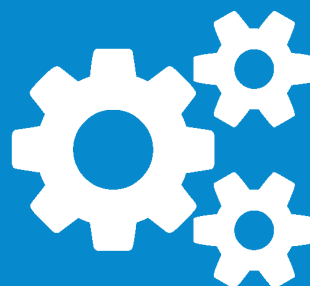
- Front View (Top):** Shows the side profile of the component. Key dimensions include:
  - Overall width:  $2\frac{23}{32}$ " (69) DIA.
  - Total height: "X".
  - Height of the upper section:  $2\frac{1}{16}$ " (52).
  - Height of the lower section:  $2\frac{7}{16}$ " (62).
  - Distance from the bottom face to the center of the lower hole:  $\frac{5}{8}$ ".
  - Radius of the lower hole: R16.
  - Minimum clearance (MIN. CRS.):  $\frac{5}{8}$ ".
  - Maximum clearance (MAX. CRS.):  $3\frac{1}{8}$ " (79).
  - Depth of drill in spindle: 29.
  - Dimension from the centerline to the edge of the lower hole:  $1\frac{5}{32}$ ".
- Top View (Bottom):** Shows the end view of the component. Key dimensions include:
  - Overall diameter: 4" (102) DIA.
  - Distance between the centers of the two main holes:  $1\frac{13}{16}$ " (46).
  - Overall height:  $2\frac{1}{2}$ " (63.5).

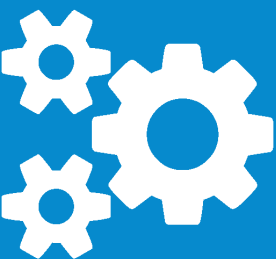




Minimum Spindle Centres:  
5/8" (16.0mm)  
Maximum Spindle Centres:  
3.1/8" (79.0mm)  
Tap Sizes up to maximum of:  
M5 (3/16")  
Specify tap thread and shank size  
when ordering head.

Ratio of gearing in head  
Input to Output : 1 : 1





## MODEL 950 TWIN SPINDLE ADJUSTABLE DRILLING HEAD

Minimum Spindle Centres:  
 $\frac{3}{4}$ " (19.0mm)  
 Maximum Spindle Centres:  
 $3\frac{3}{4}$ " (95.0mm)  
 Drill Sizes up to maximum of:  
 $\frac{3}{8}$ " (9.5mm)  
 Specify drill size when ordering head.

Collet Sizes Available:  
 2.0mm to 9.5mm  
 In 0.1mm Steps

Dimension marked 'X' varies according to the type of self-feed unit used. This dimension is kept to a minimum to keep the head as compact as possible.

Standard Adaptors available for most self-feed drilling units. Special Adaptors for other units can be quoted for.

This head is also suitable for tapping up to a maximum of M8 ( $\frac{5}{16}$ ") with a lead screw or pitch controlled tapping unit.

Tap Shank and thread size must be specified when ordering head.

Tool Lock for preventing the drill or tap from slipping in the collet.

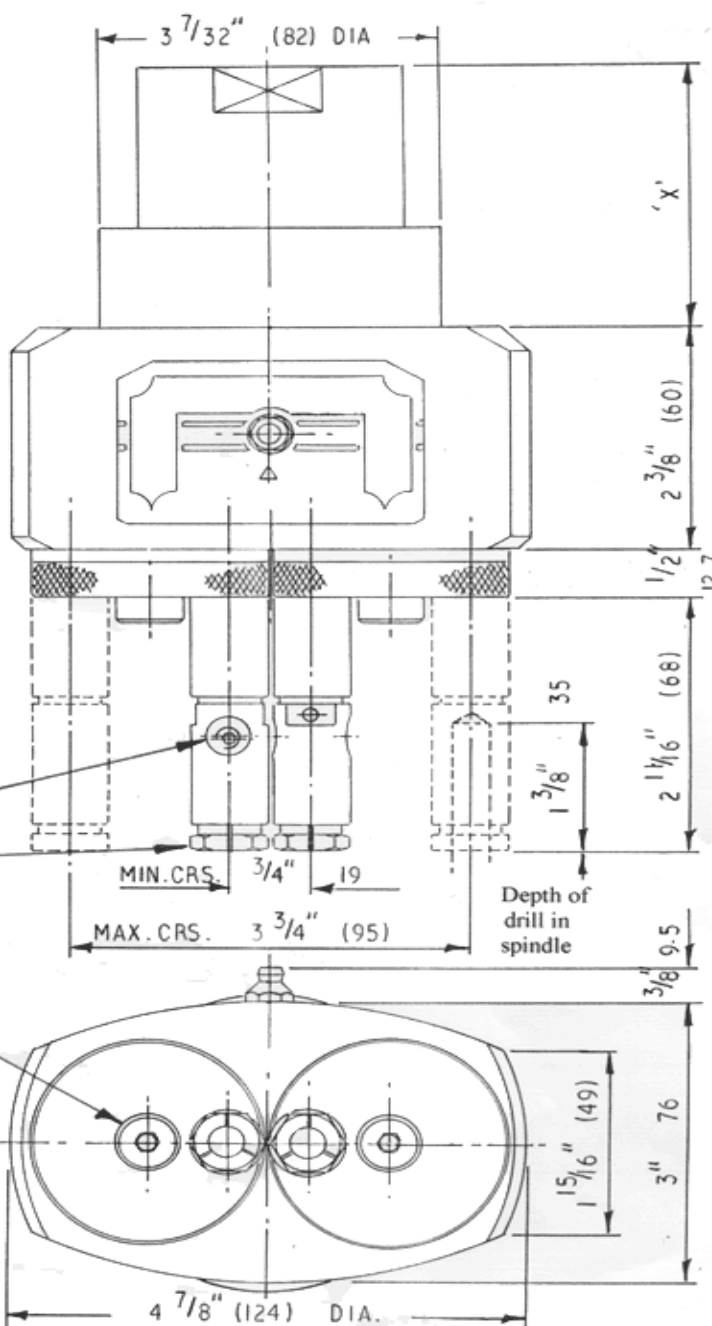
Collet P1052  
 Use 16mm Ring Spanner for tightening collet when fitting drill or tap.

Slacken screw to adjust spindle position.

Slacken both screws to rotate head relative to self-feed unit.

Ratio of gearing in head  
 Input to Output : 1:1

Maximum Spindle Speed :  
 5,000 R.P.M.



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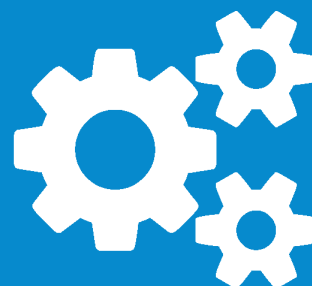
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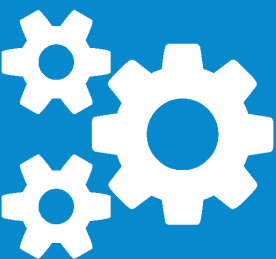
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## MODEL 950 TWIN SPINDLE ADJUSTABLE TAPPING HEAD

Minimum Spindle Centres:

3/4" (19.0mm)

Maximum Spindle Centres:

3.3/4" (95.0mm)

Tap Sizes up to maximum of:

M6 (1/4")

Specify tap thread and shank size when ordering head.

Self-reversing mechanism for tapping heads fitted to self-feed drills.

Where head is required for fitting to lead screw or pitch controlled tapping unit the standard GY-ROLL Drilling Head should be used.

Dimension marked 'X' varies according to the type of self-feed unit used. This dimension is kept to a minimum to keep the head as compact as possible.

Standard Adaptors available for most self-feed drilling units. Special Adaptors for other units can be quoted for.

Tool Lock for preventing the tap from slipping in the collet.

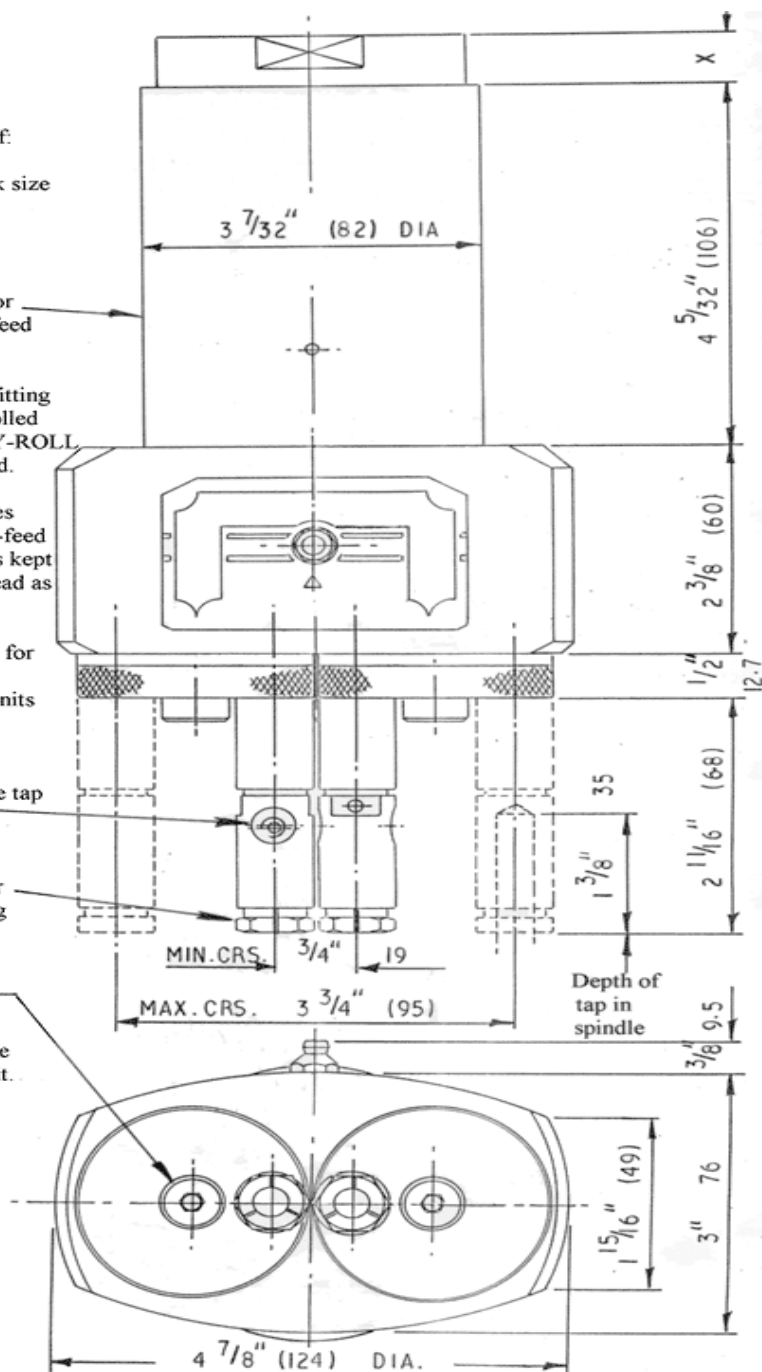
Collet P1052

Use 16mm Ring Spanner for tightening collet when fitting tap.

Slacken screw to adjust spindle position.

Slacken both screws to rotate head relative to self-feed unit.

Ratio of gearing in head  
Input to Output : 1:1



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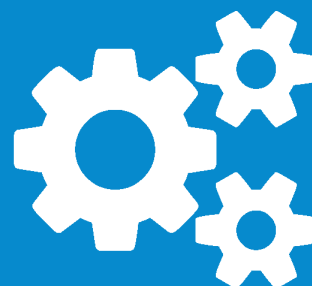
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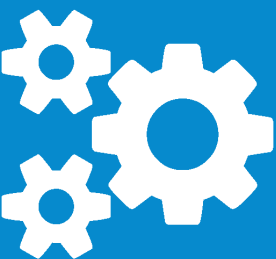
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## MODEL 1250 TWIN SPINDLE ADJUSTABLE DRILLING HEAD

Minimum Spindle Centres:

1" (25.0mm)

Maximum Spindle Centres:

5" (127.0mm)

Drill Sizes up to maximum of:

1/2" (13.0mm)

Specify drill size when ordering head.

Collet Sizes Available:

6.5mm to 13.0mm

In 0.1mm Steps

Dimension marked 'X' varies according to the type of self-feed unit used. This dimension is kept to a minimum to keep the head as compact as possible.

Standard Adaptors available for most self-feed drilling units.

Special Adaptors for other units can be quoted for.

This head is also suitable for tapping up to a maximum of M10 (3/8") with a lead screw or pitch controlled tapping unit.

Tap Shank and thread size must be specified when ordering head.

Tool Lock for preventing the drill or tap from slipping in the collet.

Collet P2847

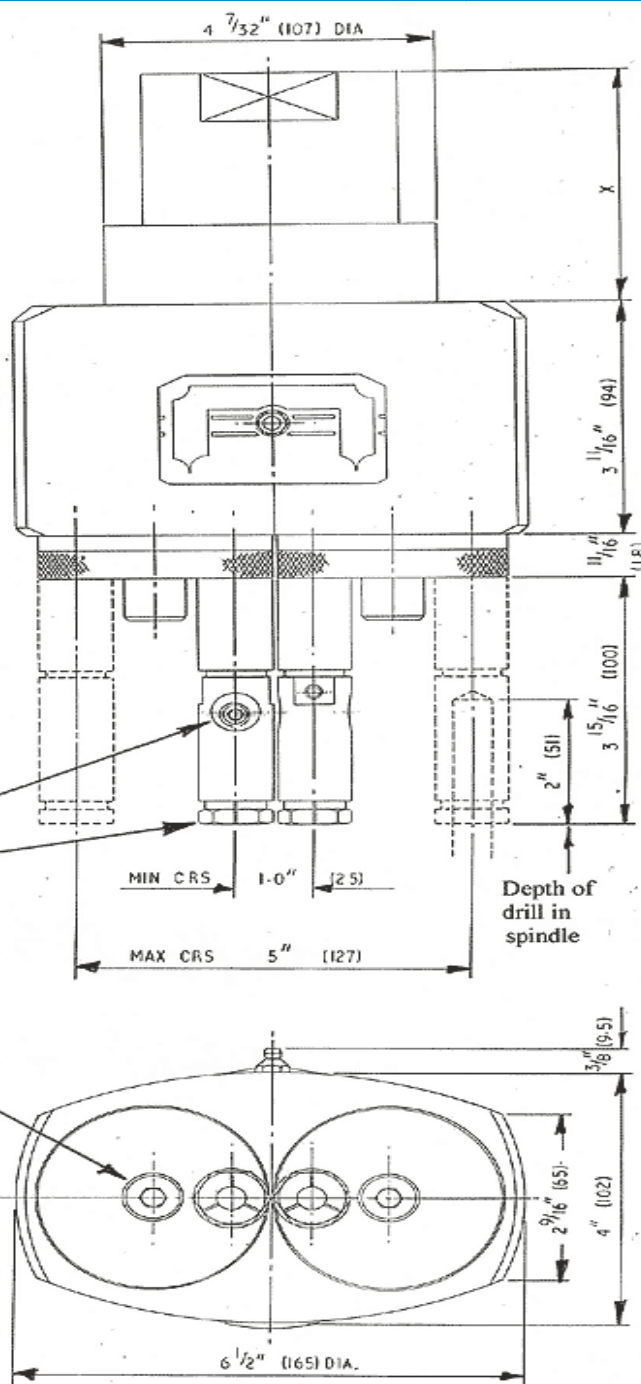
Use 22mm Ring Spanner for tightening collet when fitting drill or tap.

Slacken screw to adjust spindle position.

Slacken both screws to rotate head relative to self-feed unit.

Ratio of gearing in head  
Input to Output : 1:1

Maximum Spindle Speed :  
3,500 R.P.M.



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