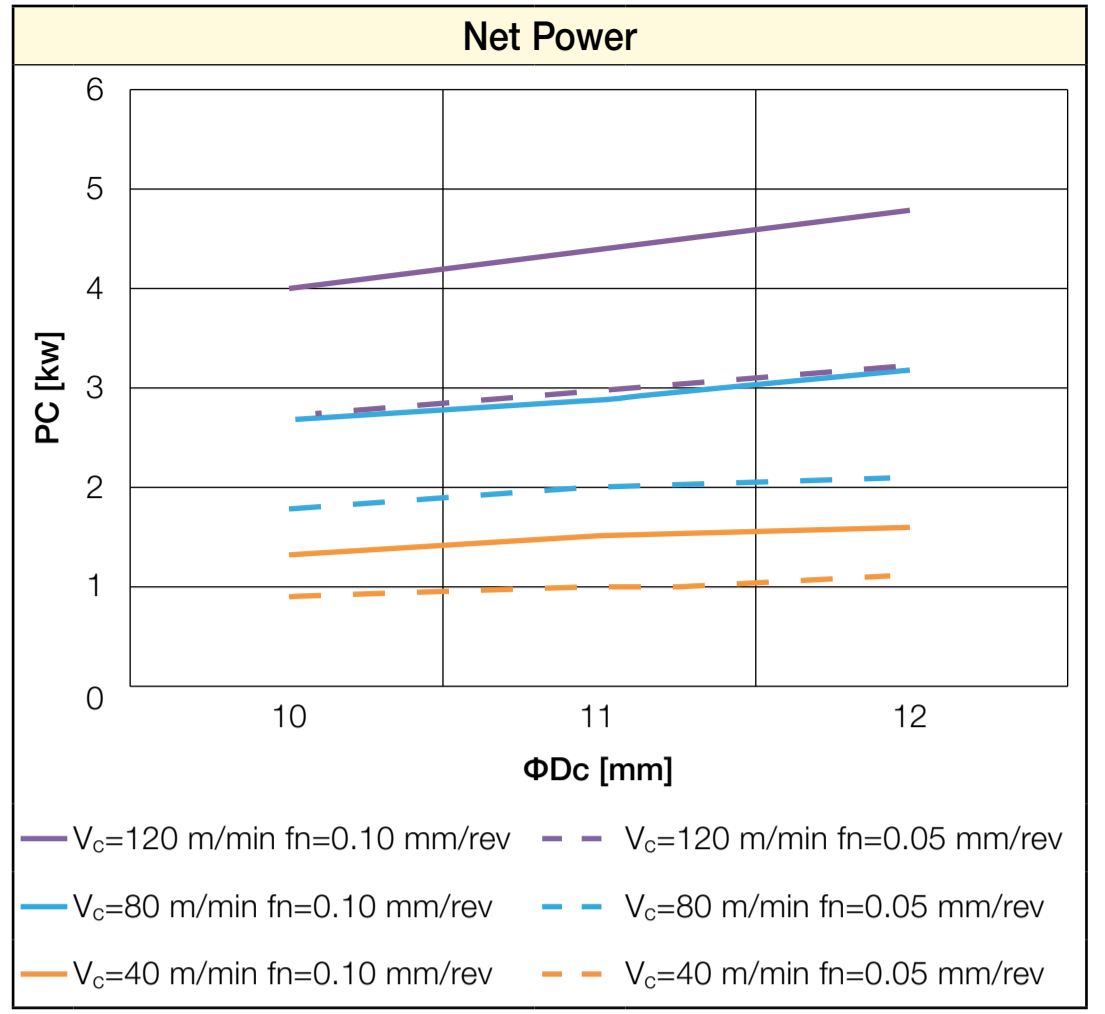
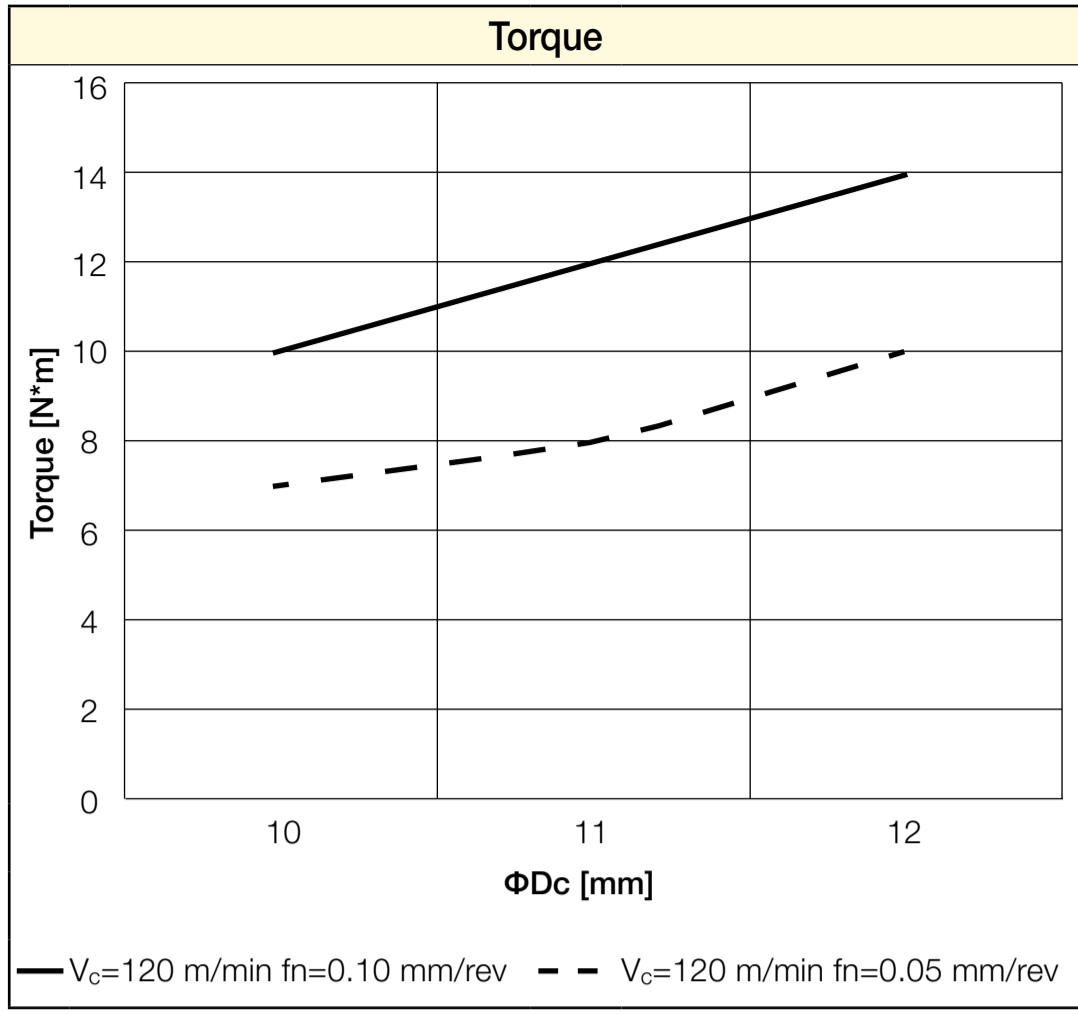
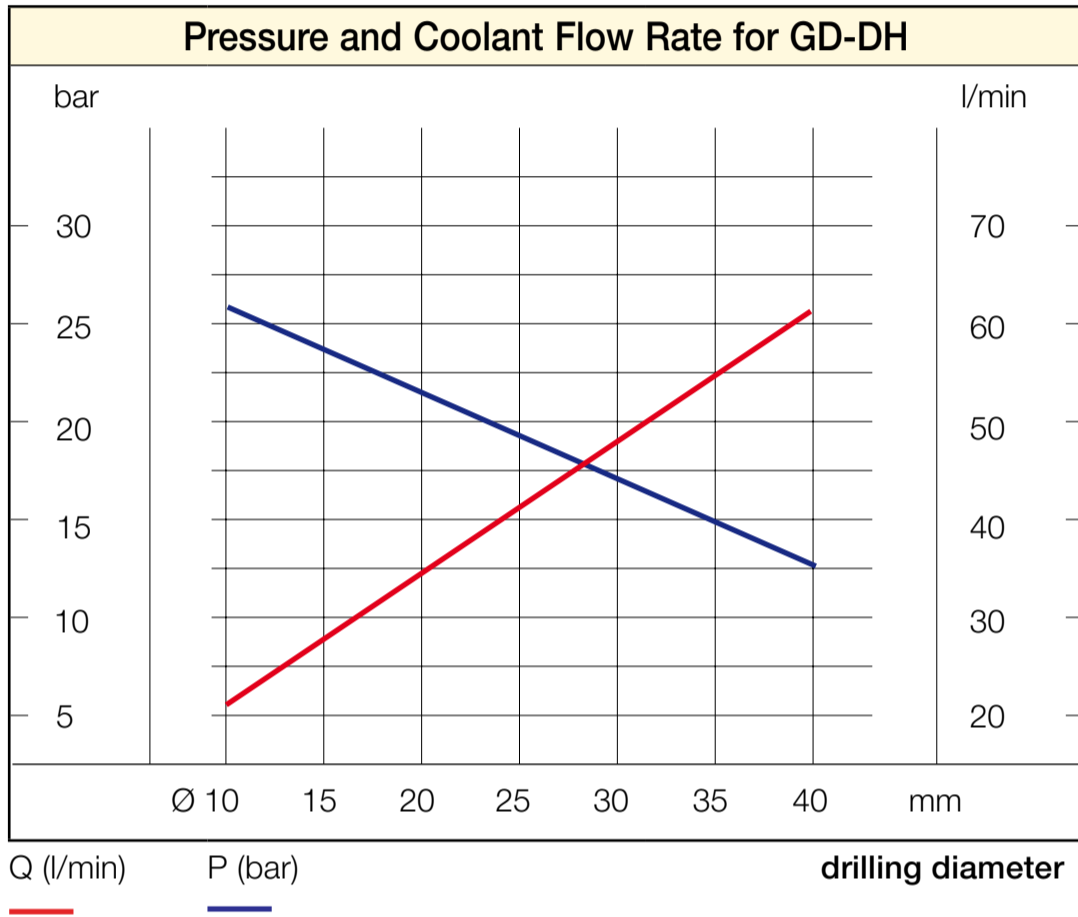


Required Power



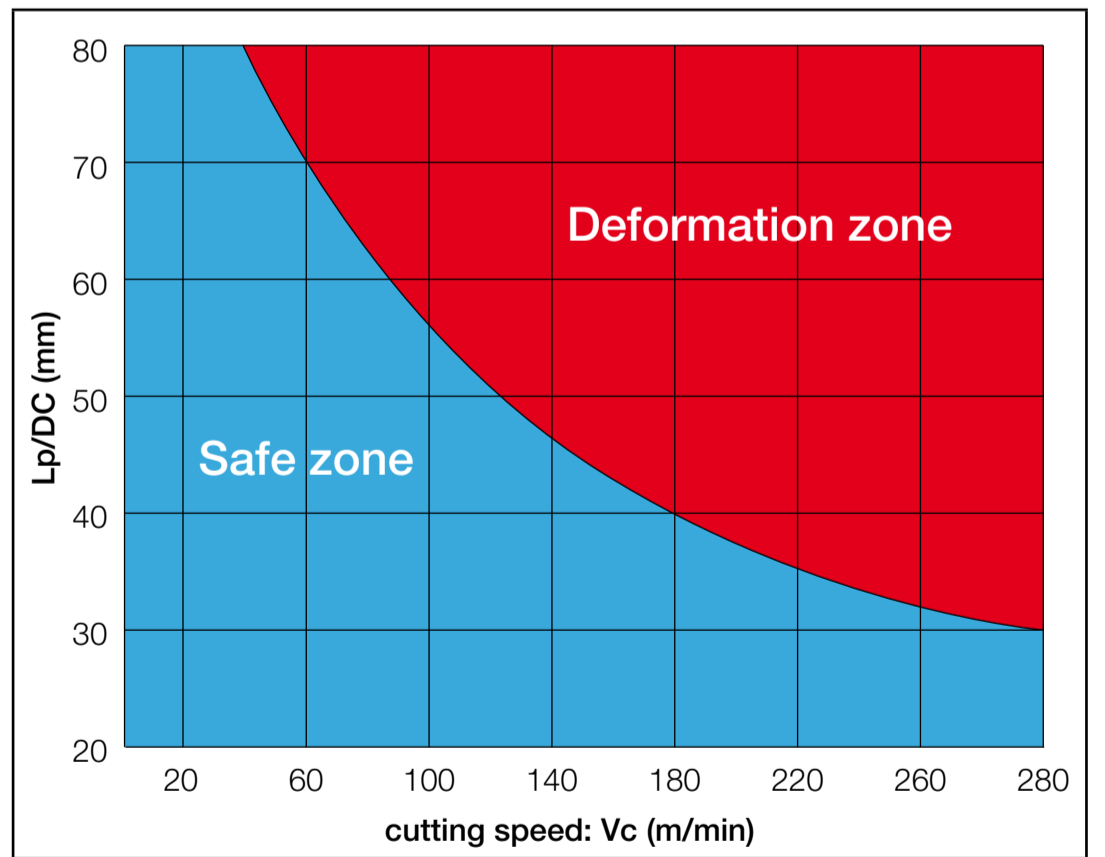
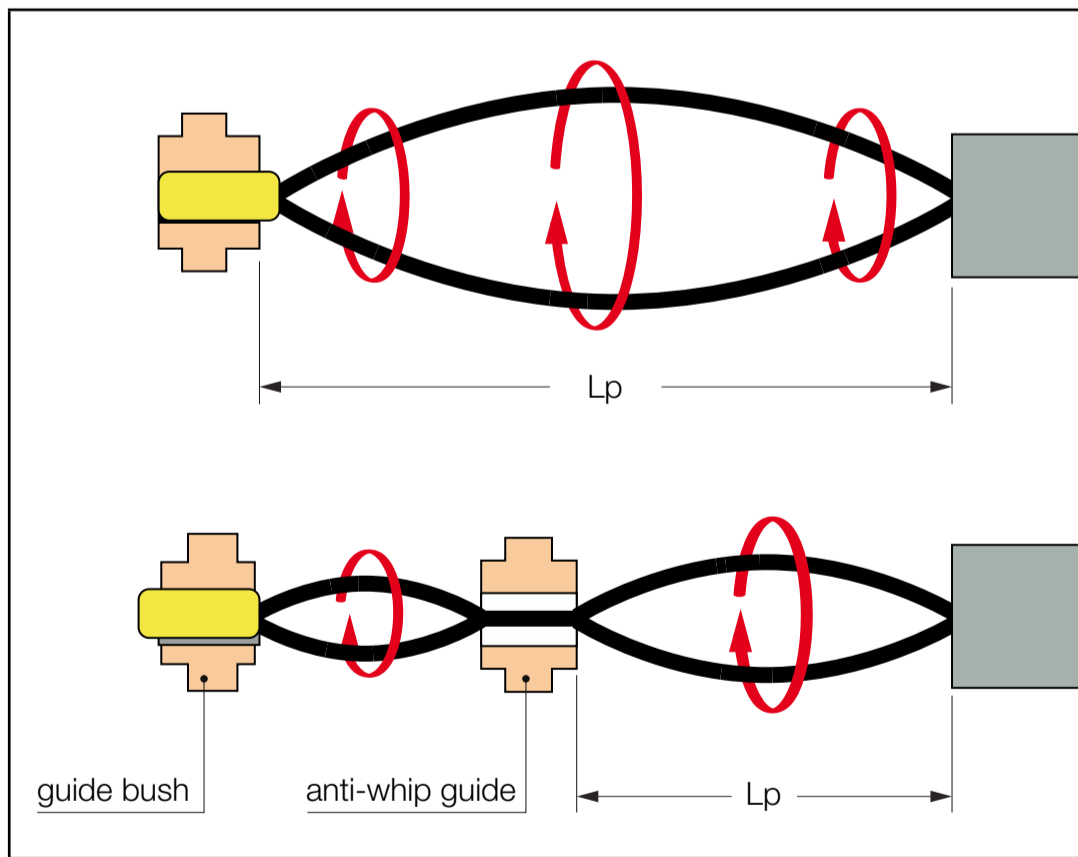
Required Coolant Pressure



Deformation by Centrifugal Force

When using gundrill tools for deep drilling, a "whip" phenomenon can occur. This can be predicted based on tool length and cutting speed.

If the parameters are in the deformation zone as shown below, cutting speed amending or use of guides for support should be considered to avoid the whip phenomenon.



Recommended Support Guide Shape

A support guide may be needed to assure a stable drilling process.

The use of a dedicated shaped guide bush is recommended.

