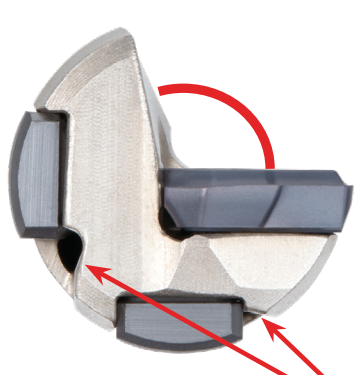




Wide Flute Angle

- Smooth chip evacuation



Double coolant along the guide pads

- Efficient lubrication
- Longer tool life for inserts and guide pads

Brazed Body



Steel Body

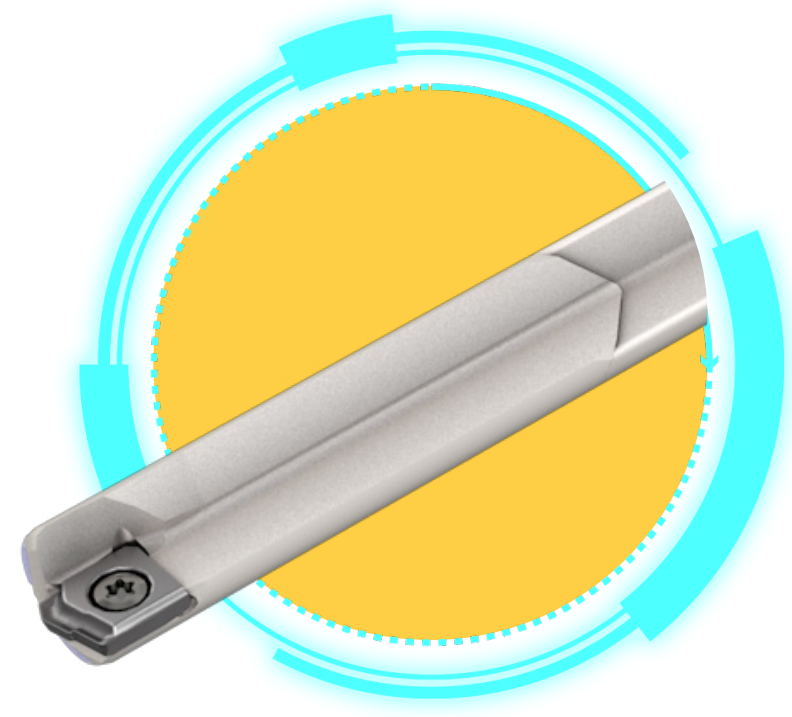
- Extremely high rigidity
- Simple direct mounting setup

Flange

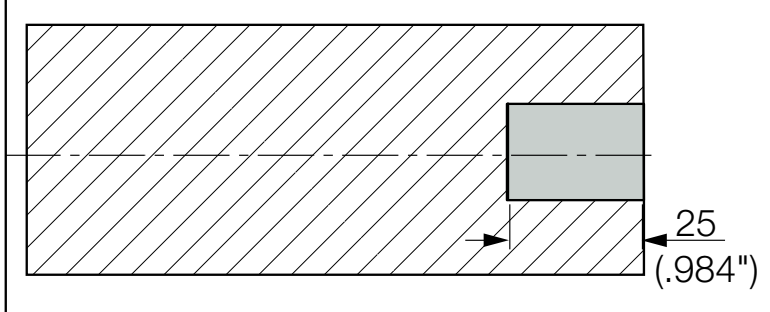
- Superior rigidity for higher speeds and feeds

Drilling Process on Machining Centers and Lathe Machines

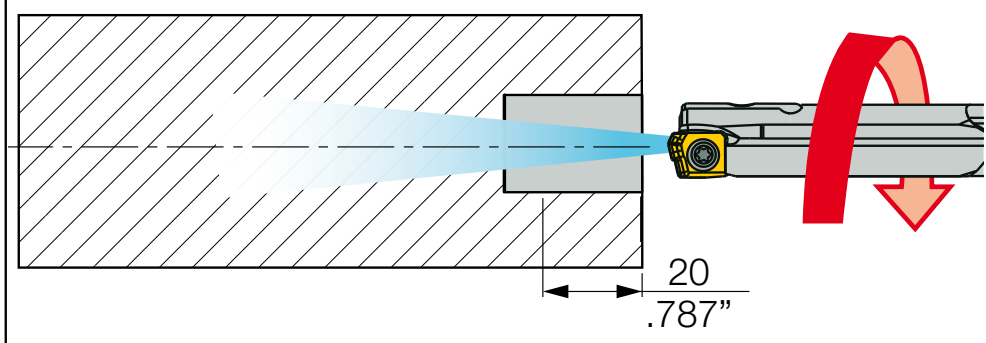
1. Drill a 25 mm (.984") pilot hole $D_{+0.01}^{+0.05}$ ($D_{+0.0004}^{+0.0019}$) flat bottom
2. Activate coolant and slowly set the tool into the pilot hole up to 20 mm (.787") depth.
 $V_c=5-10$ m/min (16-35 SFM) $f=0.5-1.0$ mm/rev (.020-.039 IPR)
 Stop the tool, start rotation at full machining speed
 Note: **Do not rotate the drill at full machining speed** before engaging the pilot hole.
3. After a full machining speed activation, the first 10 mm (.393") should be done at 80% feed rate. Thereafter, by gradual increase in feed up to 100% finish drilling to the required depth.
4. In case of through hole, drill the full hole to a depth of +5 mm (.197").
 Note: When machining gummy materials such as low carbon steel, reduce the feed rate to 70% of the normal level right before exiting the material to prevent chips from scattering.
5. Stop the rotation and coolant
 Retract the tool.



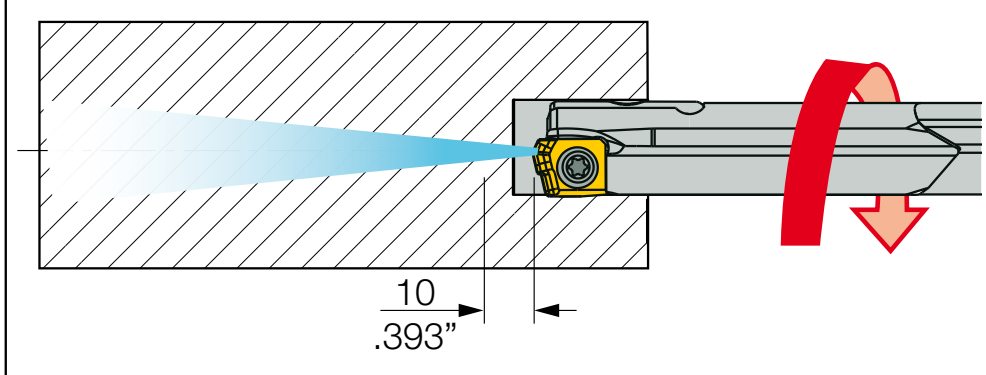
1 Drill a 25 mm (0.984") pilot hole flat bottom



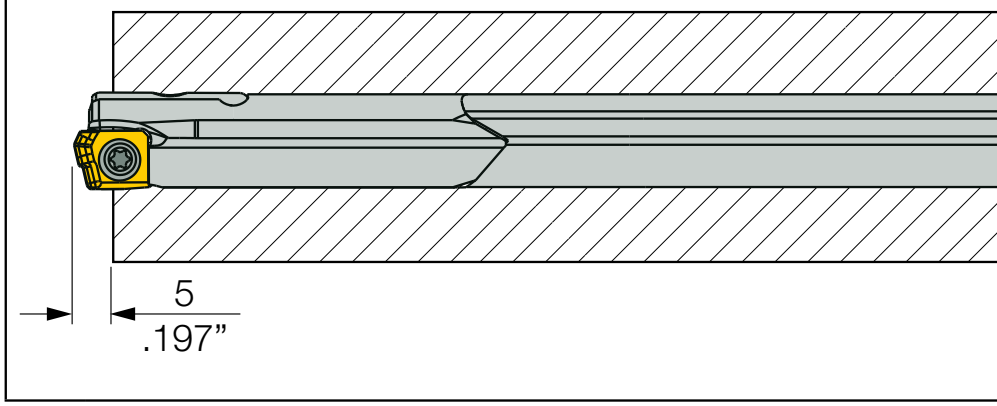
2 Activate coolant, slow rotation and feed while entering to the pre-hole up to 20 mm (.787") depth



3 First 10 mm (.393") depth with 80% feed rate



4 Drill +5mm (.197") depth through hole



Standard Gundrill Drivers for Machining Centers, Lathes, etc.

Drivers

Drivers are available for dedicated and CNC machines, for any specified diameter and length. Below are the driver codes and technical data.

Driver Type	Drawing	øD x L	Driver Code
Cylindrical		.75x2.03"	95
		20x50	10
		25x56	11
		1.00x2.28"	96
		1.25x2.28"	97
		32x60	12
Weldon		.75x2.03"	99
		20x50	22
		25x56	23
		1.00x2.28"	100
		1.25x2.28"	101
		32x60	24
Whistle Notch		20x50	34
		25x56	35
		32x60	36
		40x70	37

Standard Drivers for Gundrill Machines

Driver Type	Drawing	øD x L	Driver Code
DIN228AK		CM1	45
		CM2	46
		CM3	47
		CM4	48
DIN228BK		CM1	49
		CM2	50
		CM3	51
		CM4	52
Central Clamping Surface 15°		.750x2.75"	56
		25x70	57
		1.00x2.75"	58
		1.25x2.75"	59
		1.50x2.75"	60
Frontal Clamping Surface 15°		16x50	61
Cylindrical with Thread		25x100 M16x1.5	66
		36x120 M24x1.5	67
VDI Design		25x112 M16x1.5	70
		36x135 M24x1.5	71
Central Clamping Hexagonal		25x70	72
		32x70	73
Central Clamping Tapered		.75x2.75"	76
		20x70	77
Frontal Clamping Surface 2°		1.00x2.75"	80
		1.00x3.94"	81
		1.25x2.75"	82
		1.25x3.94"	83
		1.50x2.75"	84
Trapezoidal Thread		28x126 Tr 28x2	88
		36x162 Tr 36x2	89
Spraymist Driver		25x50	91
		35x60	92