

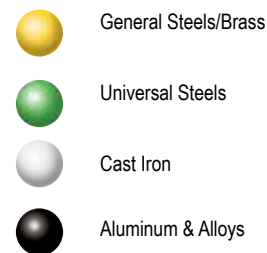
EB 80

Single flute gun drill

Carbide head, steel body, Type G point, standard driver, RH cut

Cut Dia. = h5 tolerance range, Shank Dia. = h6

Application Materials:



TICN coated

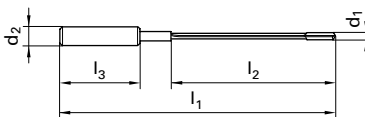


Coolant Through



Reinforced Straight Shank

Speeds & Feeds
information pg 490-491



Series 5641 40xD

Diameter (d1)			mm	d2 mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch	Wire / letter					
0.1563	5/32		3.970	10.00	230.00	185.00	9056410039700
0.1575			4.000	10.00	230.00	185.00	9056410040000
0.1969			5.000	16.00	280.00	232.00	9056410050000
0.2030	13/64		5.156	16.00	280.00	232.00	9056410051560
0.2362			6.000	16.00	320.00	272.00	9056410060000
0.2500			6.350	16.00	340.00	292.00	9056410063500
0.2756			7.000	16.00	370.00	322.00	9056410070000
0.3125	5/16		7.938	16.00	430.00	372.00	9056410079380
0.3150			8.000	16.00	430.00	372.00	9056410080000
0.3543			9.000	16.00	450.00	402.00	9056410090000
0.3750	3/8		9.525	16.00	480.00	432.00	9056410095250
0.3937			10.000	20.00	510.00	460.00	9056410100000
0.4331			11.000	20.00	550.00	500.00	9056410110000
0.4375	7/16		11.113	20.00	550.00	500.00	9056410111130
0.4724			12.000	20.00	600.00	550.00	9056410120000
0.5000	1/2		12.700	20.00	635.00	585.00	9056410127000

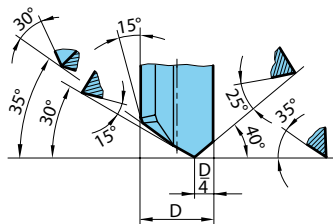
Series 5642 80xD

Diameter (d1)			mm	d2 mm	l1 mm	l2 mm	EDP #
Dec. inch	Fract. inch	Wire / letter					
0.1949			4.950	16.00	480.00	432.00	9056420049500
0.2010			5.106	16.00	480.00	432.00	9056420051060
0.2343			5.950	16.00	560.00	512.00	9056420059500
0.2480			6.300	16.00	590.00	542.00	9056420063000
0.2736			6.950	16.00	650.00	602.00	9056420069500
0.3106			7.888	16.00	740.00	692.00	9056420078880
0.3130			7.950	16.00	740.00	692.00	9056420079500
0.3524			8.950	16.00	820.00	772.00	9056420089500
0.3730			9.475	16.00	870.00	822.00	9056420094750
0.3917			9.950	20.00	919.00	860.00	9056420099500
0.4311			10.950	20.00	995.00	945.00	9056420109500
0.4356			11.063	20.00	995.00	945.00	9056420110630
0.4705			11.950	20.00	1080.00	1030.00	9056420119500
0.4980			12.650	20.00	1140.00	1090.00	9056420126500

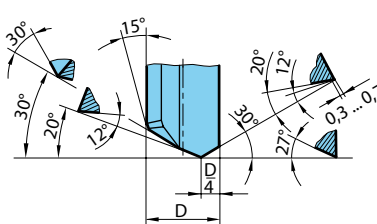
EB 80 standard point grinds

(special point grinds available)

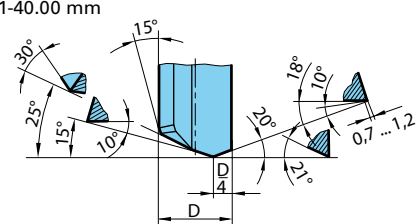
Ø 2.00-4.00 mm



Ø 4.01-20.00 mm



Ø 20.01-40.00 mm



Tech Tip:

Gun drills hold location to precise tolerances in extremely deep hole applications. Conventional gun drills consist of a steel body and driver with a brazed carbide head for extended tool life and performance. When applying standard gun drills some basic steps should be observed:

- Drilling a pilot hole (tol. h8) is advisable. Enter the pilot hole at low RPM and feed rate (example: 200 RPM at 20 in/min)
- Gun drills for drilling depths over 40xD should enter pilot hole in a counterclockwise direction.
- Continuous drilling without pecking is required.
- Switch off coolant supply after reaching maximum drilling depth.
- Use a rapid withdrawal with a stationary spindle.