

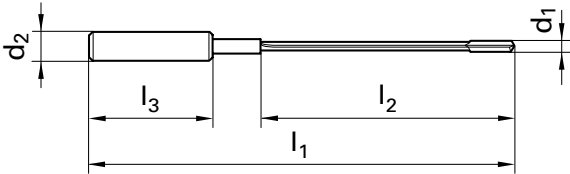
EB 100

Miniature single flute CNC style gun drill

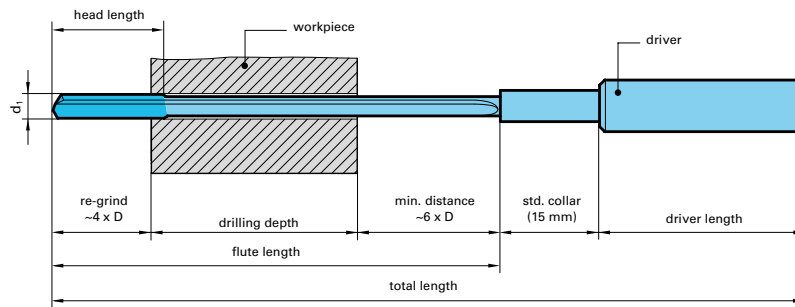
Fixed flute lengths



- **Solid carbide flute gun drill -**
carbide tube brazed into steel shank
- **Designed for CNC equipment -**
no special gun drill machine needed
- **Coolant through the drill**
- **Excellent hole accuracy and surface finish**



Diameter (d1)				Series 5024 45 mm flute			Series 5020 80 mm flute			Series 5026 120 mm flute			Series 5021 160 mm flute		
Dec. inch	Wire / letter	mm	d2 mm	l1 mm	l2 mm	l3 mm	l1 mm	l2 mm	l3 mm	l1 mm	l2 mm	l3 mm	l1 mm	l2 mm	l3 mm
0.0472		1.200	4.00	90.00	45.00	28.00	125.00	80.00	28.00						
0.0591		1.500	4.000	90.00	45.00	28.00	125.00	80.00	28.00	165.00	120.00	28.00	205.00	160.00	28.00
0.0626	1/16	1.590	4.000	90.00	45.00	28.00	125.00	80.00	28.00	165.00	120.00	28.00	205.00	160.00	28.00
0.0630		1.600	4.000	90.00	45.00	28.00	125.00	80.00	28.00	165.00	120.00	28.00	205.00	160.00	28.00
0.0780	5/64	1.980	4.000	90.00	45.00	28.00	125.00	80.00	28.00	165.00	120.00	28.00	205.00	160.00	28.00
0.0787		2.000	4.000	90.00	45.00	28.00	125.00	80.00	28.00	165.00	120.00	28.00	205.00	160.00	28.00
0.0984		2.500	10.000	100.00	45.00	40.00	135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1063		2.700	10.000	100.00	45.00	40.00	135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1181		3.000	10.000	100.00	45.00	40.00	135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1260		3.200	10.000	100.00	45.00	40.00	135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1378		3.500	10.000				135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1575		4.000	10.000				135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1654		4.200	10.000				135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1772	16	4.500	10.000				135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.1969		5.000	10.000				135.00	80.00	40.00	175.00	120.00	40.00	215.00	160.00	40.00
0.2362		6.000	16.000							225.00	160.00	48.00			
0.3150		8.000	16.000							225.00	160.00	48.00			



All deep hole drills must utilize a pilot hole.

Procedure:

- Machine a pilot hole with an m7 toleranced Guhring RT 100 drill (i.e., series 5514) to a minimum pilot depth of 1 to 1.5 x D.
- Enter the pilot hole at a speed of approx. 300 RPM, and with a feed rate of approx. 19 - 20 IPM staying just shy of the bottom of the hole.
- Start high coolant pressure and increase RPM to recommended value.
- Feed drill at recommended feed rate to final hole depth. No peck cycle required.
- For through holes with oblique exit, reduce the feed rate to 40% approx. 1 mm prior to break-through.
- After reaching hole depth reduce machine spindle to 300 RPM and withdraw the drill.