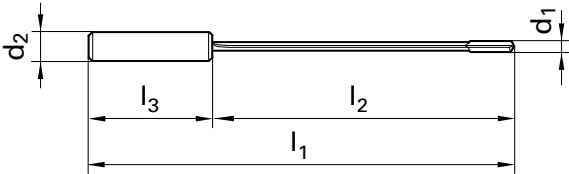


## EB 80

Brazed single flute gun drill  
Fixed flute lengths



- Brazed head construction
- Oversized universal shank
- TiCN coated tip
- Excellent hole accuracy and surface finish



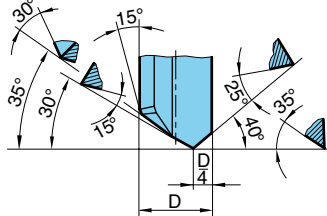
Diameter (d1)				Series 5641 40 x D		
Dec. inch	Fract. inch	mm	d2 mm	l1 mm	l2 mm	l3 mm
0.1563	5/32	3.970	10.00	230.00	185.00	40.00
0.1575		4.000	10.00	230.00	185.00	40.00
0.1969		5.000	16.00	280.00	232.00	48.00
0.2030	13/64	5.156	16.00	280.00	232.00	48.00
0.2362		6.000	16.00	320.00	272.00	48.00
0.2500	1/4	6.350	16.00	340.00	292.00	48.00
0.2756		7.000	16.00	370.00	322.00	48.00
0.3125	5/16	7.938	16.00	430.00	372.00	48.00
0.3150		8.000	16.00	430.00	372.00	48.00
0.3543		9.000	16.00	450.00	402.00	48.00
0.3750	3/8	9.525	16.00	480.00	432.00	48.00
0.3937		10.000	20.00	510.00	460.00	50.00
0.4331		11.000	20.00	550.00	500.00	50.00
0.4375	7/16	11.113	20.00	550.00	500.00	50.00
0.4724		12.000	20.00	600.00	550.00	50.00
0.5000	1/2	12.700	20.00	635.00	585.00	50.00

Diameter (d1)				Series 5642 80 x D		
Dec. inch	Fract. inch	mm	d2 mm	l1 mm	l2 mm	l3 mm
0.1949		4.950	16.00	480.00	432.00	48.00
0.2010		5.106	16.00	480.00	432.00	48.00
0.2343		5.950	16.00	560.00	512.00	48.00
0.2480		6.300	16.00	590.00	542.00	48.00
0.2736		6.950	16.00	650.00	602.00	48.00
0.3106		7.888	16.00	740.00	692.00	48.00
0.3130		7.950	16.00	740.00	692.00	48.00
0.3524		8.950	16.00	820.00	772.00	48.00
0.3730		9.475	16.00	870.00	822.00	48.00
0.3917		9.950	20.00	910.00	860.00	50.00
0.4311		10.950	20.00	995.00	945.00	50.00
0.4356		11.063	20.00	995.00	945.00	50.00
0.4705		11.950	20.00	1080.00	1030.00	50.00
0.4980		12.650	20.00	1140.00	1090.00	50.00

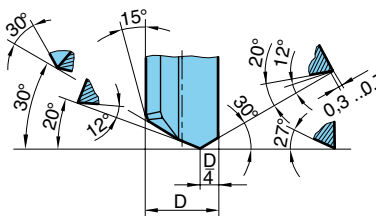
Drill diameters for the 80xD EB 80 Series 5642 are offered as stocked standards in increments of -0.05mm (0.0019") below the nominal diameter of the pilot tool, which is normally an RT 100 T high penetration rate drill or EB 80 40xD series 5641 standard gun drill. Guhring recommends a full depth pilot drill of 40xD followed by series 5642 EB 80 finish drill.

### EB 80 standard point grinds (special point grinds available)

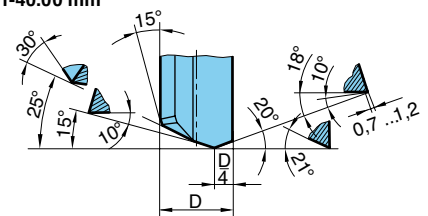
Ø 2.00-4.00 mm



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.