



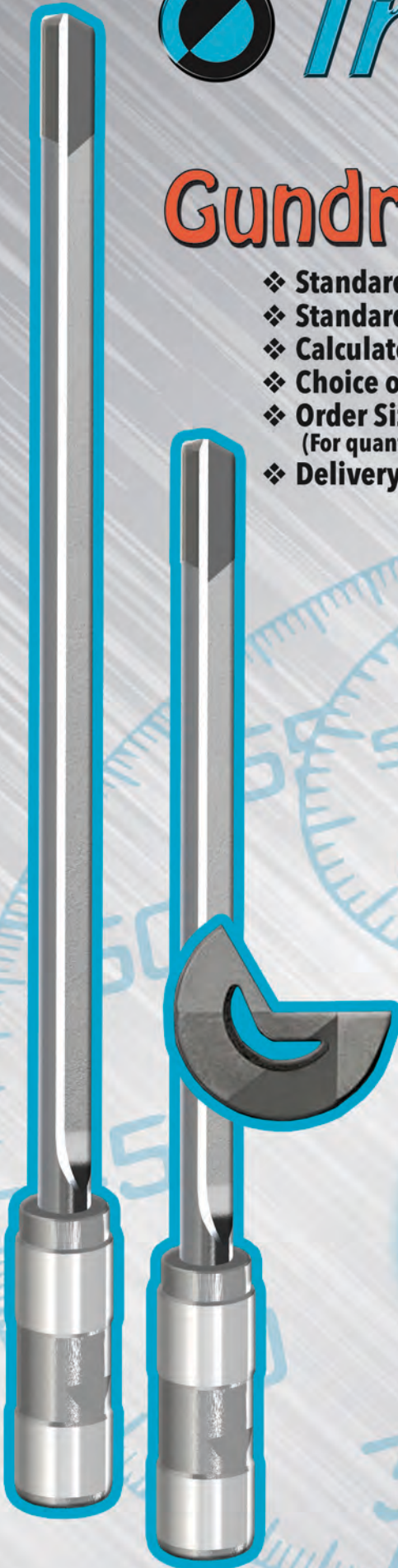
Member IMC Group

Ingersoll

Cutting Tools

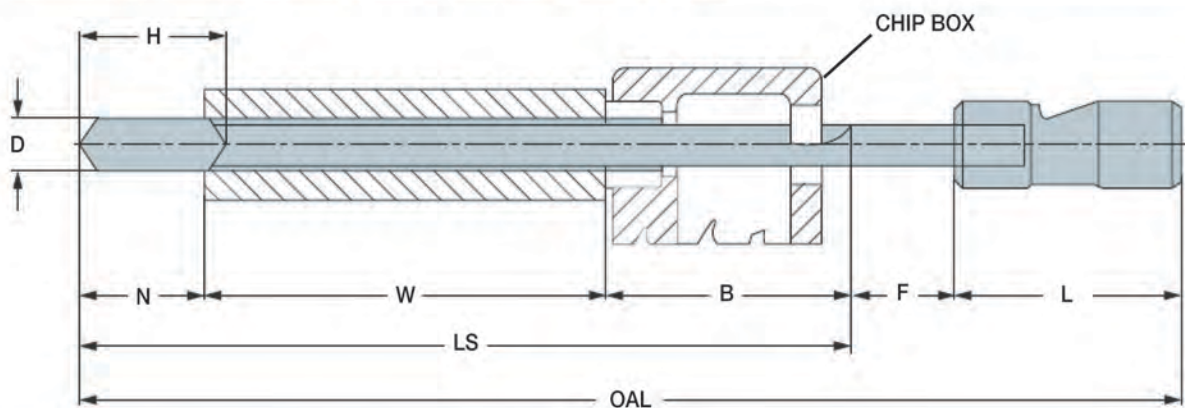
Gundrill Express Delivery

- ❖ Standard Metric Diameters From 2.5mm to 20mm in 0.1mm Increments
- ❖ Standard Inch Diameters Also Available (See page 2)
- ❖ Calculate the Correct Length Per Guidelines (See page 2)
- ❖ Choice of Driver (See page 3)
- ❖ Order Size Limited to 6 Pieces
(For quantities over 6 pieces, please contact ICTC for delivery)
- ❖ Delivery 2-3 Weeks

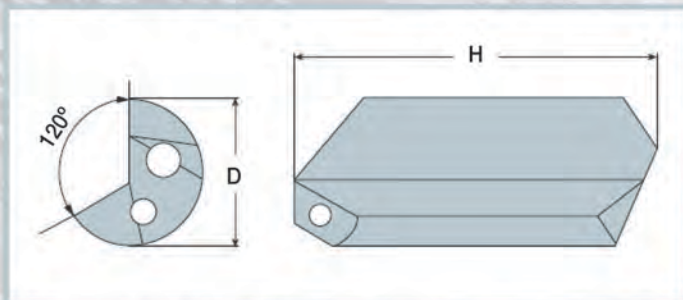


Gundrill Express Delivery

Standard Gundrill Length Calculation



Standard Gundrill Carbide Head Length



Diameter Range		Head Length	
mm	inch	mm	inch
2.50-3.80mm	.098"-.149"	20mm	.787"
3.80-4.05mm	.150"-.159"	23mm	.906"
4.05-5.05mm	.160"-.199"	25mm	.984"
5.05-6.55mm	.200"-.258"	30mm	1.181"
6.55-11.05mm	.259"-.435"	35mm	1.378"
11.05-18.35mm	.436"-.722"	40mm	1.575"
18.35-20mm	.723"-.787"	45mm	1.772"

Note: regrindable length=H-D

- D** = Cutting diameter
- H** = Carbide length
- N** = Regrinding area = H-D
- W** = Hole depth
- B** = Chip evacuation area
 - = For typical gundrill machines with chip box, 250 mm
 - = For machining centers, 2xD (minimum 15 mm)
- F** = 10 mm
- L** = Driver Length
- LS** = Flute Length
- OAL** = Overall Length

Inch Sizes Available

inch	mm
1/8"	3.175
3/16"	4.76
7/32"	5.556
1/4"	6.35
5/16"	7.937
11/32"	8.731
3/8"	9.525
7/16"	11.113
1/2"	12.7
9/16"	14.288
5/8"	15.875
3/4"	19.05

Overall Length Calculation:

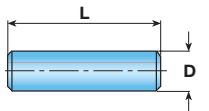
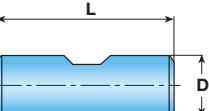
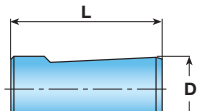
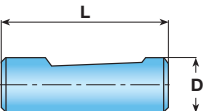
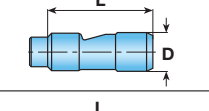
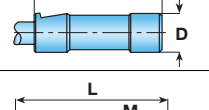
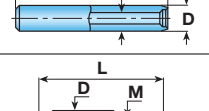
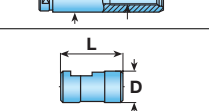
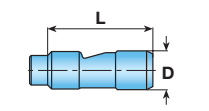
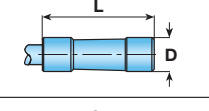
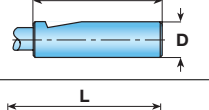
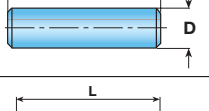
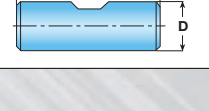
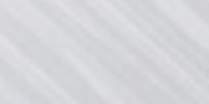
$$OAL = W + N + B + F + L$$

Gundrill Designation (Carbide Tipped):

Ordering Example for Ø.216" x 19.685" OAL

STGD - 05500 - 0500 - 57 - IN05S (the only available carbide grade)
 Drill Overall Driver Uncoated
 Diameter Length Code
 (mm) (mm)

Standard Gundrill Drivers for Machining Centers, Lathes, Etc.

	Driver Type	Drawing	D x L	Driver Code	Carbide Tipped Gun Drills	Solid Carbide Gun Drills
METRIC	Cylindrical DIN1835A DIN6535HA		10 x 40	05	●	●
			12 x 45	06	●	●
			16 x 48	08	●	●
			20 x 50	10	●	●
			25 x 56	11	●	●
	Weldon DIN1835B DIN6535HB		10 x 40	18	●	●
			12 x 45	19	●	●
			16 x 48	20	●	●
			20 x 50	22	●	●
			25 x 56	23	●	●
	Whistle Notch DIN1835E		10 x 40	30	●	●
			12 x 45	31	●	●
			16 x 48	32	●	●
			20 x 50	34	●	●
			25 x 56	35	●	●
	Whistle Notch DIN6535HE		10 x 40	40	●	●
			12 x 45	41	●	●
			16 x 48	42	●	●
			18 x 50	44	●	●
	Central clamping surface 15°		10 x 40	54	●	●
16 x 45			55	●	●	
25 x 70			57	●	●	
Frontal clamping surface 15°		16 x 50	61	●	●	
Cylindrical with thread		16 x 80	65	●	●	
		25 x 100	66	●	●	
VDI design		16 x 90	69	●	●	
		25 x 112	70	●	●	
Spraymist driver		16 x 40	90	●	●	
		25 x 50	91	●	●	
INCH	Central clamping surface 15°		.750 x 2.748	56	●	●
			1.00 x 2.748	58	●	●
	Central clamping tapered		.750 x 2.748	76	●	●
	Frontal clamping surface 2°		.750 x 2.748	79	●	●
			1.00 x 2.748	80	●	●
	Cylindrical DIN1835A DIN6535HA		.500 x 1.781	94	●	●
			.750 x 2.031	95	●	●
			1.00 x 2.281	96	●	●
	Weldon DIN1835B DIN6535HB		.500 x 1.781	98	●	●
			.750 x 2.031	99	●	●
1.00 x 2.281			100	●	●	

● Recommended design