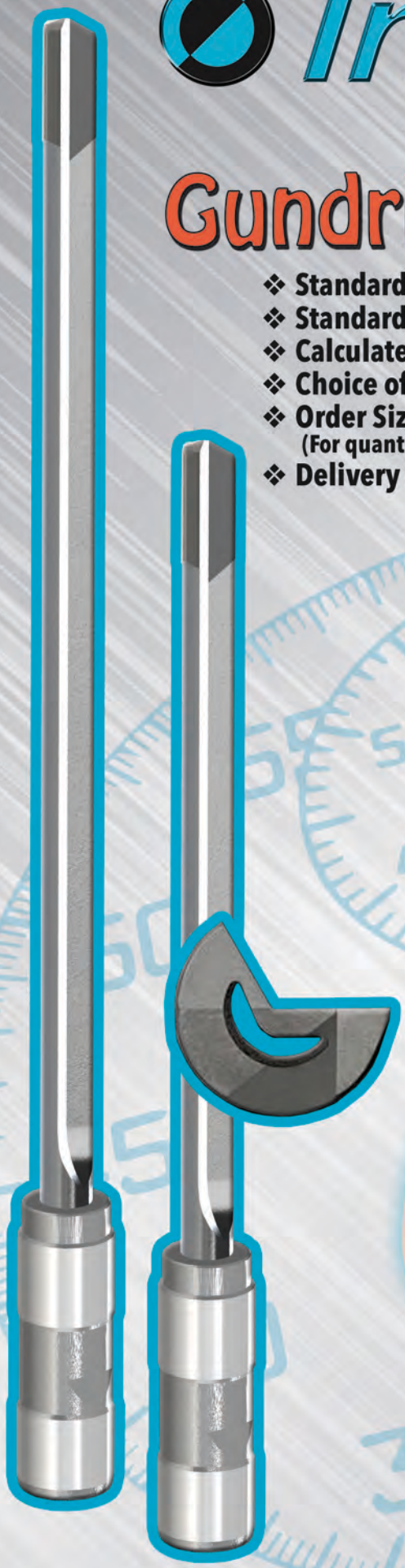
Member IMC Group

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



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Complete Metalworking Solutions

Roseville Saginaw & Jackson, MI

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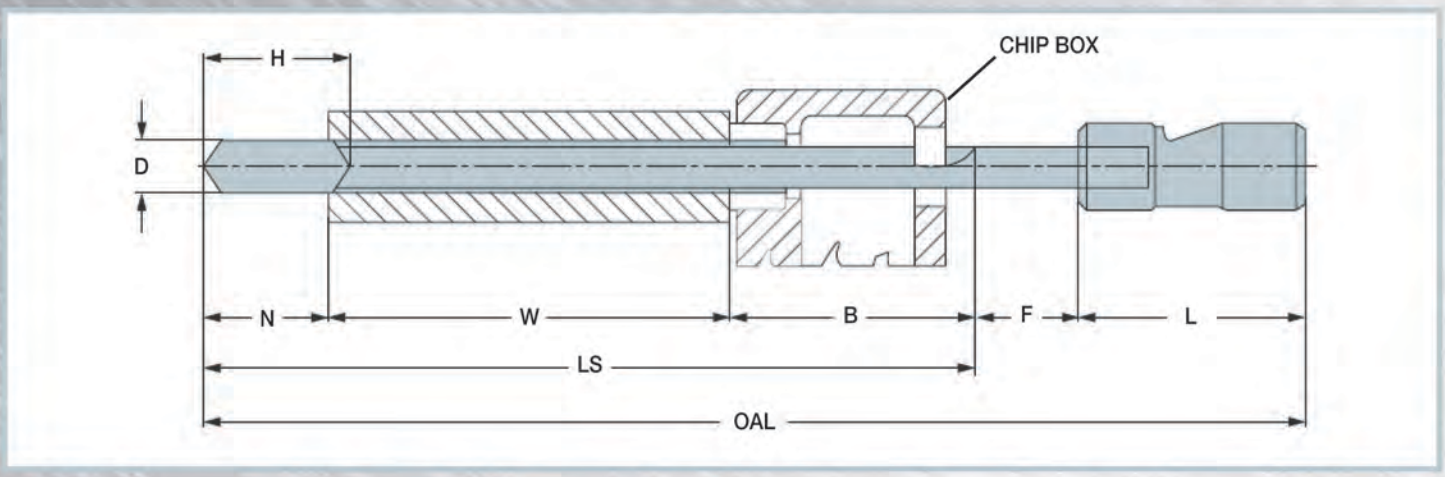
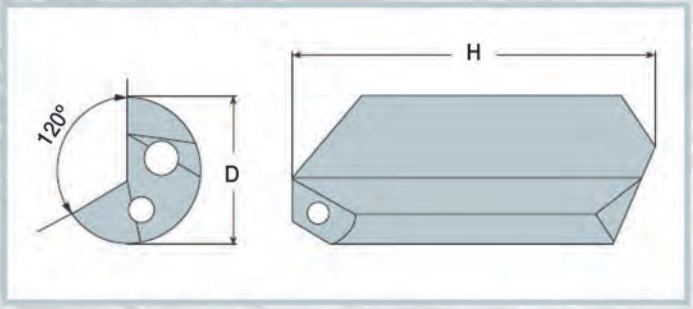
Gundrill Express Delivery

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:

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

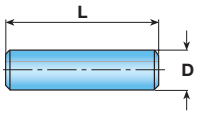
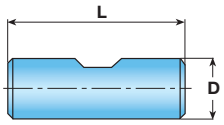
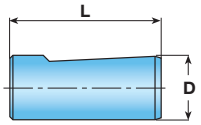
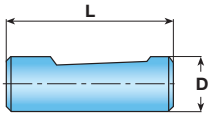
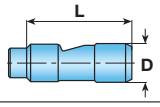
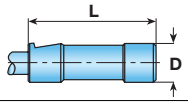
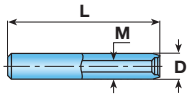
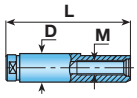
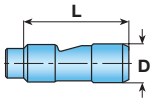
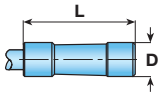
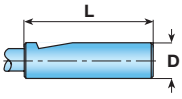
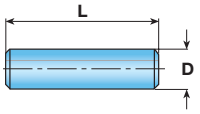
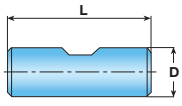
Gundrill Designation (Carbide Tipped):

Ordering Example for Ø.216" x 19.685" OAL

STGD – 05500 – 0500 – 57 – IN05S (the only available carbide grade) Uncoated

- 05500: Drill Diameter (mm)
- 0500: Overall Length (mm)
- 57: Driver Code

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