

STERLING GUN DRILLS, INC.

DETERMINING GUN DRILL OVERALL LENGTH

Issue 1/10

Solid Flute gun drills with "spigot" drivers:

Drill depth + driver length + spigot length + chip clearance & regrind room = Drill OAL

depth of cut +	1"	+	.6"	+	length (per drill diameter)	=	OAL
	1 ½"	+	.6"		.6" (.0450" to .0759")	=	OAL
	40mm / 1.57"	+	.6"		.7" (.0760" to .1059")	=	OAL
	2"	+	.6"		.8" (.1060" to .1620")	=	OAL
	2 ¾"	+	.6"			=	OAL
	Other	+	.6"			=	OAL

Gun drill with tube flute:

Drill depth + driver length + chip clearance & regrind room

+	1.5"	+	.75"	(.125" - .500" drill diameter)
	2" (50mm)		1"	(.501" - .804" drill diameter)
	2.36" (35mm)		1.5"	(.805" - 1.014" drill diameter)
	2.75"		2"	(1.015" - 1.374" drill diameter)
	Other		2.5"	(1.375" - 1.640" drill diameter)

Exception: Inserted drivers:

The gun drill OAL will be: Drill depth + 4.5" to .804" drill diameter
(2.75" driver) Drill depth + 5" to 1.014" drill diameter
 Drill depth + 5.5" to 1.374" drill diameter
 Drill depth + 6" to 1.640" drill diameter

If driver is shorter than 2.75", subtract from these values

If driver is longer than 2.75", add to these values.