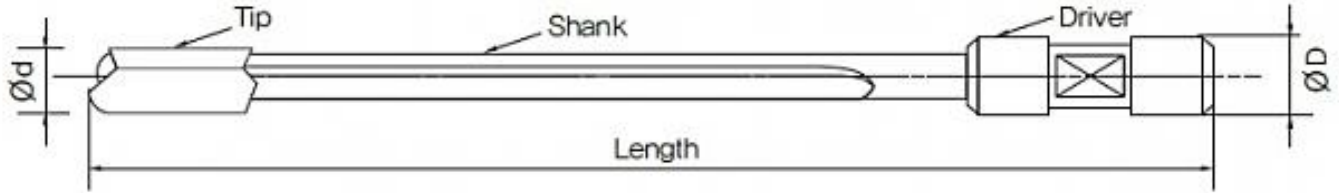


## Gun Drill Tool Drawing

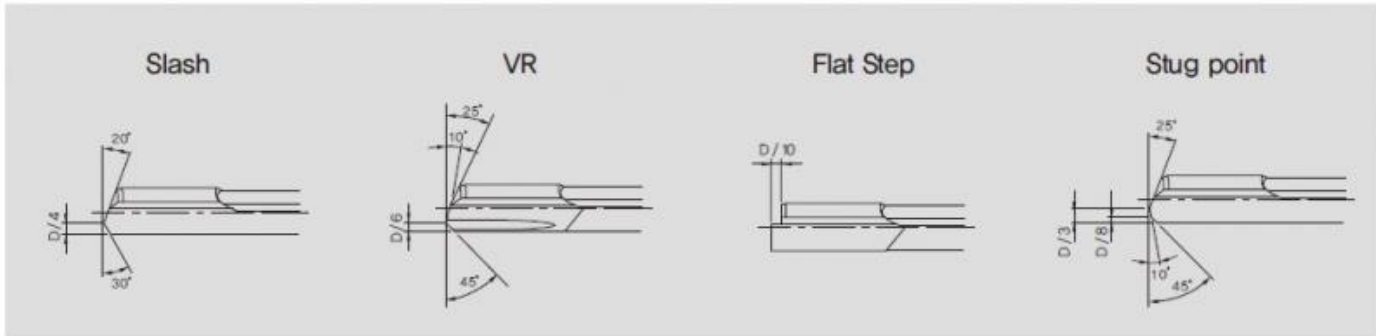


## Standard Stock List

Dia. ØD(mm)	Length (mm)							
	350 ~500	650	950	1250	1450	1650	1850	2150
3.02	○	○	○					
3.52	○	○	○					
4.02	○	○	○					
4.52	○	○	○					
5.02	○	○	○	○				
5.52	○	○	○	○				
6.02	○	○	○	○	○			
6.52	○	○	○	○	○			
7.02	○	○	○	○	○			
7.52	○	○	○	○	○	○	○	○
8.02	○	○	○	○	○	○	○	○
8.52	○	○	○	○	○	○	○	○
9.02	○	○	○	○	○	○	○	○
9.52	○	○	○	○	○	○	○	○
10.02	○	○	○	○	○	○	○	○
10.52	○	○	○	○	○	○	○	○
11.02	○	○	○	○	○	○	○	○
11.52	○	○	○	○	○	○	○	○
12.02	○	○	○	○	○	○	○	○
12.52	○	○	○	○	○	○	○	○

Dia. ØD(mm)	Length (mm)							
	350 ~500	650	950	1250	1450	1650	1850	2150
13.02				○	○	○	○	○
14.02				○	○	○	○	○
14.52				○	○	○	○	○
15.02				○	○	○	○	○
16.02				○	○	○	○	○
17.02				○	○	○	○	○
18.02				○	○	○	○	○
19.02				○	○	○	○	○
20.02				○	○	○	○	○
21.02				○	○	○	○	○
22.02				○	○	○	○	○
23.02				○	○	○	○	○
24.02				○	○	○	○	○
25.02				○	○	○	○	○
26.02				○	○	○	○	○
27.02				○	○	○	○	○
28.02				○	○	○	○	○
29.02				○	○	○	○	○
30.02				○	○	○	○	○
31.02				○	○	○	○	○

## Tip Edges



## Guide Pads



R-1: Our standard guide pad shape

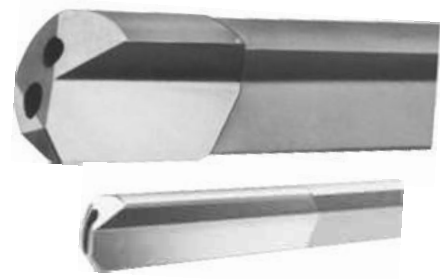
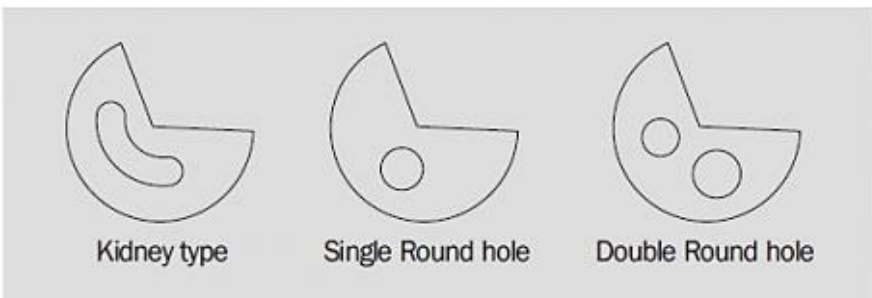
R-2: For higher machining accuracy

R-3: For higher machining accuracy than R-1

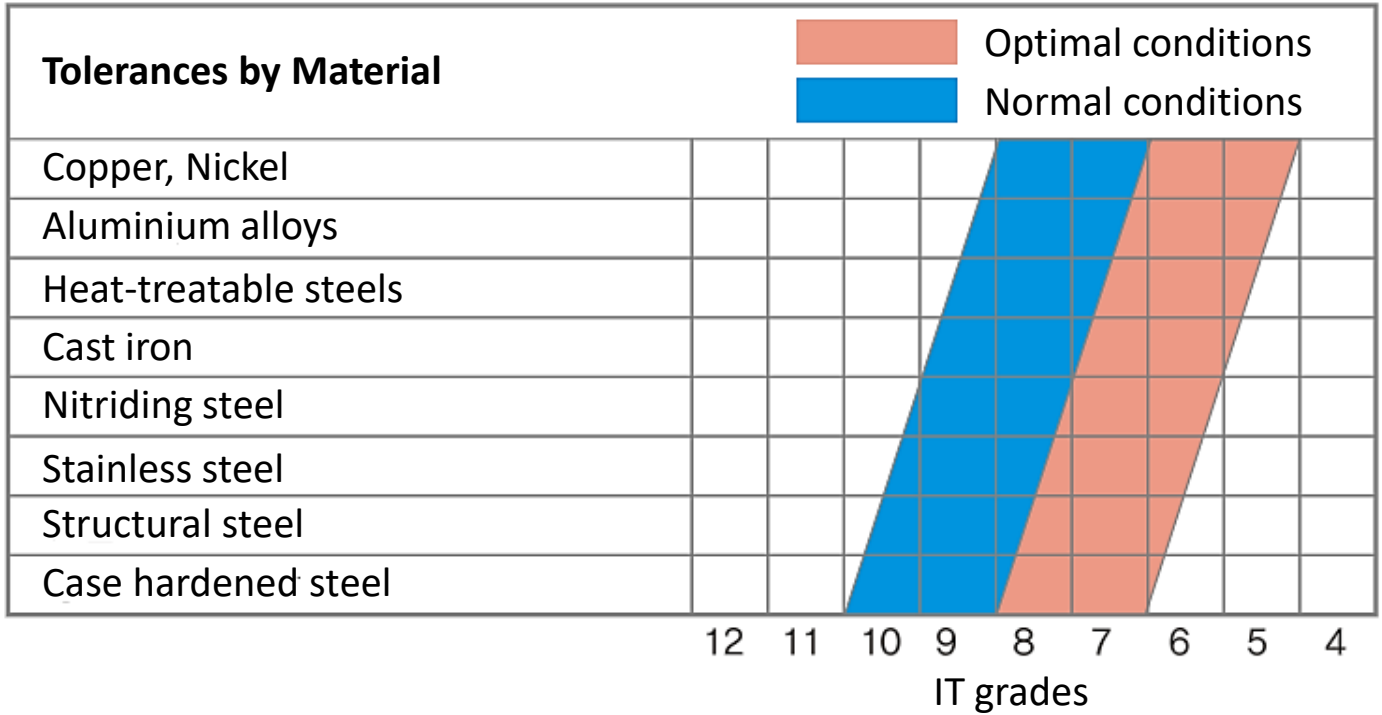
R-4: Large pad to maximize burnishing effect

R-9: Modification of R-3 to reduce burnishing resistance

## Oil Holes



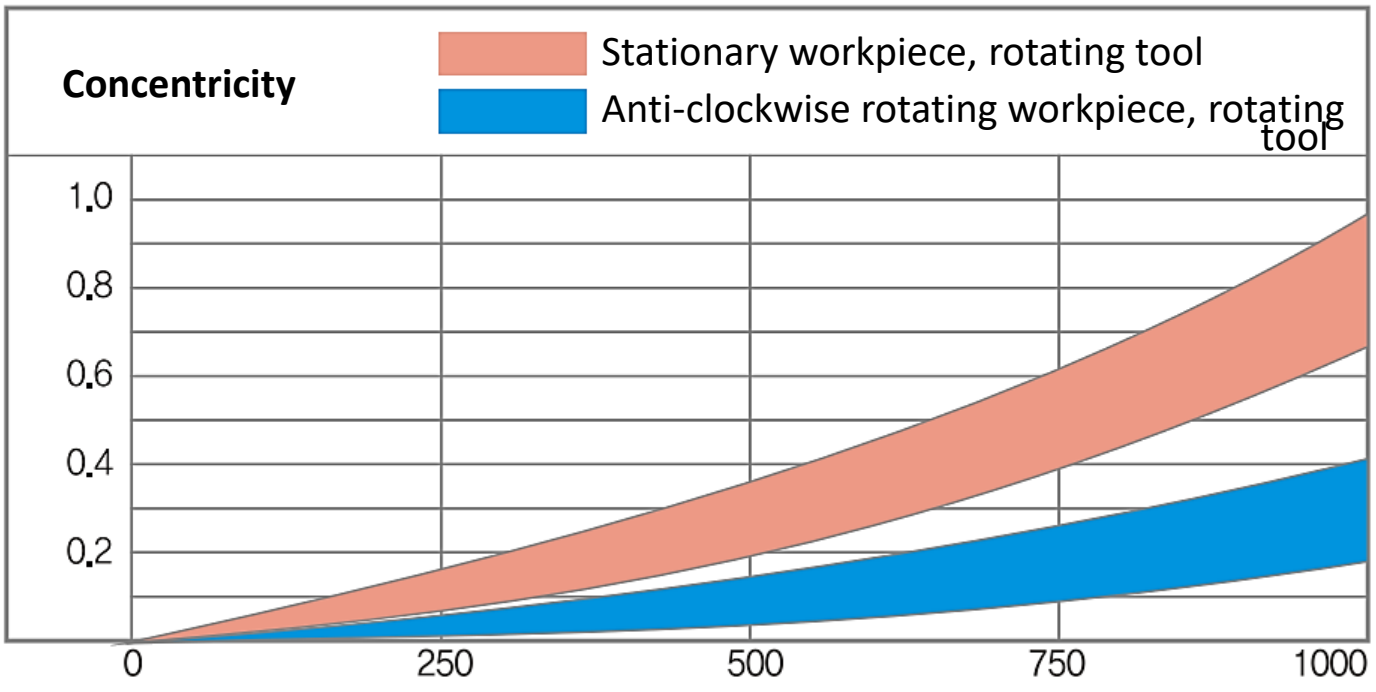
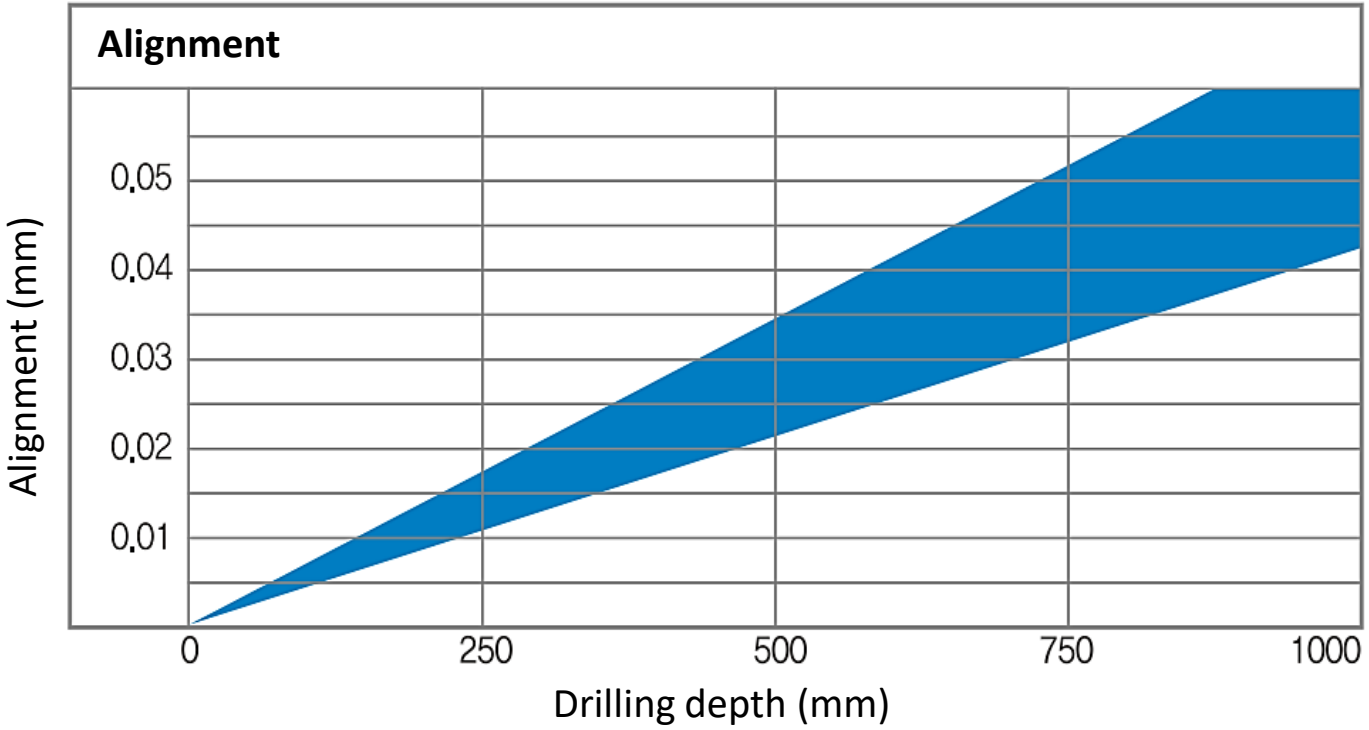
## Gun Drilling Conditions



**Surface Quality by Production Method**

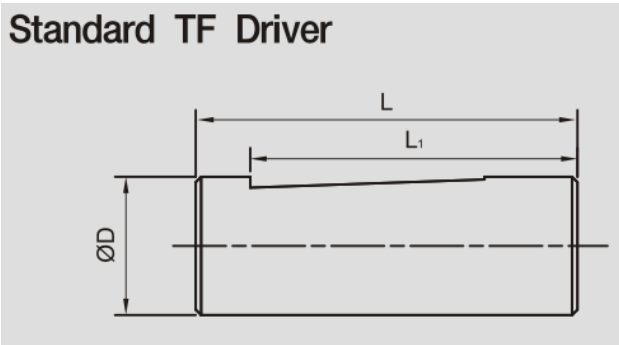
Twist drills		Light Blue	Light Blue	Light Blue							
Pilot hole				Dark Blue	Dark Blue	Dark Blue					
Reaming				Grey	Grey	Grey					
Honing					Dark Blue	Dark Blue	Dark Blue				
Deep hole drilling				Purple	Purple	Purple	Purple	Purple			
Ra (µm)	25	12,5	6,3	3,2	1,6	0,8	0,4	0,2	0,1	0,05	0,025
N values	N11	N10	N9	N8	N7	N6	N5	N4	N3	N2	N1

## Gun Drilling Conditions

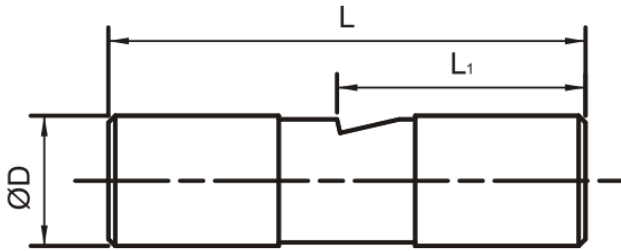


## Driver Specifications

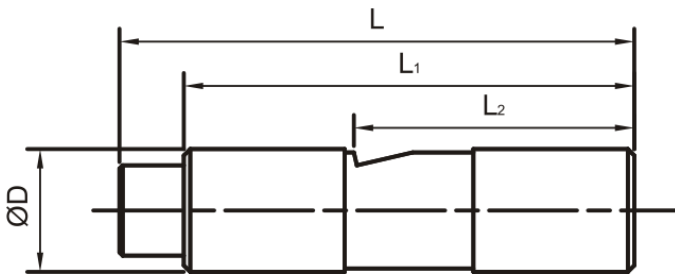
### Standard TF Driver



Style No.	Tool Diameter	D (mm)	D (Inch)	L (mm)	L <sub>1</sub> (mm)
STF	~3.0(8.0)	19.05	¾"	38	30
TF1	3.0~12.7	25.40	1"	70	57
TF2	12.7~19.0	31.70	1¼"	70	57
TF3	19.0~25.4	38.10	1½"	70	57
TF4	25.4~	50.80	2"	70	57

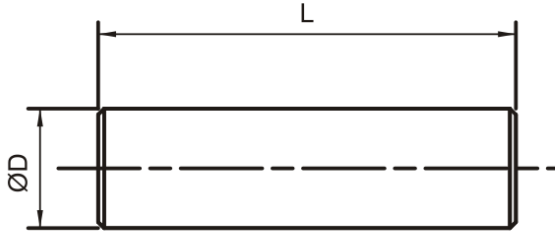


Style No.	D (mm)	L (mm)	L <sub>1</sub> (mm)
STA	12.70	38	24
TA1	19.05	70	34
TA2	25.40	70	34
TA3	31.70	70	34
TA4	38.10	70	34

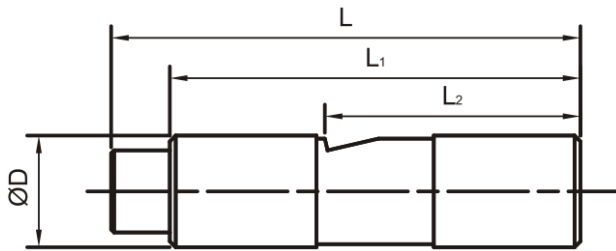


Style No.	D (mm)	L (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)
SPA	12.70	48	38	24
PA1	19.05	80	70	34
PA2	25.40	80	70	34
PA3	31.70	80	70	34
PA4	38.10	80	70	34

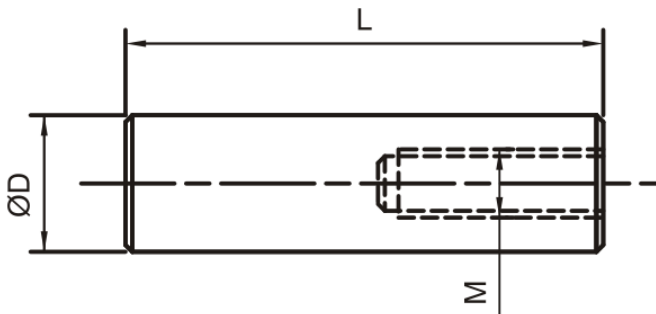
## Driver Specifications



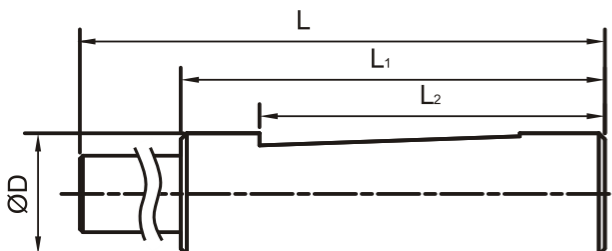
Style No.	D (mm)	L (mm)
SMC	12.70	38
MC1	19.05	70
MC2	25.40	70
MC3	31.70	70
MC4	38.10	70



Style No.	D (mm)	L (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)
SPA	12.70	48	38	24
PA1	19.05	80	70	34
PA2	25.40	80	70	34
PA3	31.70	80	70	34
PA4	38.10	80	70	34



Style No.	D (mm)	L (mm)	M (mm)
SMH	12.70	38	M6x0.5
MH1	19.05	70	M10x1
MH2	25.40	70	M16x1.5



Style No.	D (mm)	L (mm)	L <sub>1</sub> (mm)	L <sub>2</sub> (mm)
PF1	19.05	97	70	45
PF2	25.40	100	70	57.5
PF3	31.70	10	70	57.5
PF4	38.10	10	70	57.5



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