Quote Request EB 100 with fixed flute length

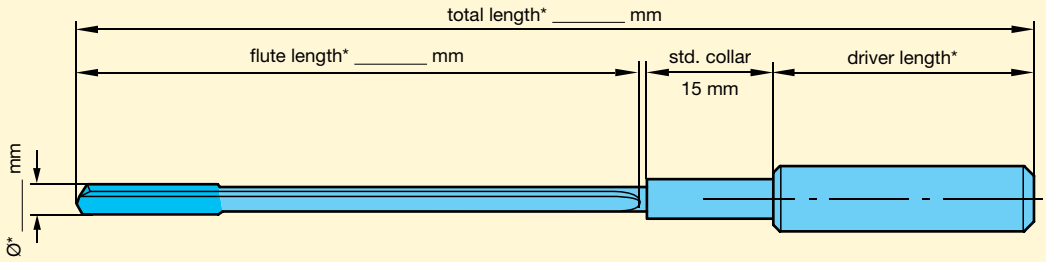
Email to Specials@guhring.com

Distributor/customer name	If a distributor inquiry list end user name, city, & state
Address	City, Zip code
Telephone	Email
Date	Name of contact

Gun drill: ❑ **EB 100** 

Quantity breaks requested: _____ tools

* Ø 0.9 - 12.0 mm
Flute length max. 500 mm
Total length and driver length are dependent on the driver selected, see following pages.



required in special cases only

Driver: ❑ **no** ❑ **Code no. _____** ❑ **to enclosed drawing**

Coating: ❑ **TiN** (S) ❑ **FIREX** (F) ❑ **nano-A™** (a) ❑ **Super-A™** (A) ☐ _____

Workpiece: **Drilling depth: ____ Hole tolerance: _____ Material/designation: _____ _____**

Machine type: ❑ **Deep hole drilling machine** ❑ **Conventional machine tool**
❑ **Pilot hole** ❑ **Drill bushing**

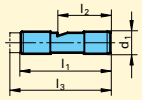
Coolant: ❑ **Deep hole drilling oil** ❑ **Soluble oil**
Pressure _____ bar **Quantity _____ l/min**

Additional technical parameters

The range of drivers introduced below is available ex-stock. However, it only represents a small selection of drivers from our complete range. We naturally also produce individual drivers of the highest precision to customer drawings. Attention! EB 100 requires drivers with positioning lugs. Further information on request.

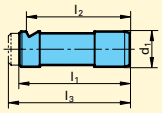
Drivers for deep drilling machines

1



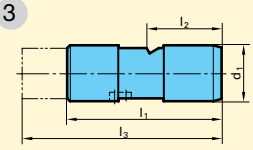
code no.	d_1	l_1	l_2	l_3
1.1	10	40	24	-
1.2	10	40	24	45
1.3	10	40	24	55
1.4	16	45	31,2	-
1.5	25	70	34	-
1.6	25	70	34	78

2



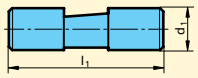
code no.	d_1	l_1	l_2	l_3
2.1	16	50	47	-
2.2	16	50	47	55
2.3	16	50	47	70

3



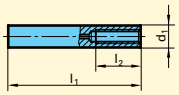
code no.	d_1	l_1	l_2	l_3
3.1	25	70	34	100

4



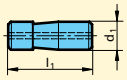
code no.	d_1	l_1
4.1	19,05	70
4.2	12,70	70
4.3	25,40	70
4.4	31,75	70
4.5	38,10	70

5



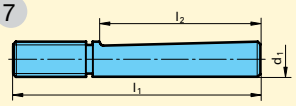
code no.	d_1	l_1	l_2
5.1	10	60	20
5.2	16	80	28
5.3	25	100	50
5.4	10	100	
5.5	10	110	

6



code no.	d_1	l_1
6.1	12.7	38
6.2	19.05	70
6.3	38.1	70

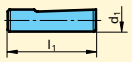
7



code no.	d_1	l_1	l_2
7.1	16	112	73
7.2	20	126	82

Drivers to DIN 1835

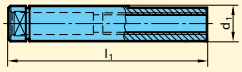
9 form E



code no.	d_1	l_1
9.1	8	36
9.2	10	40
9.3	12	45
9.4	16	48
9.5	20	50
9.6	25	56
9.7	32	60
9.8	31.75	70
9.9	38.1	70
9.10	40	70

Drivers to VDI draft

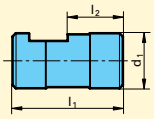
12



code no.	d_1	l_1
12.1	10	68
12.2	16	90
12.3	25	112

Drivers to Speed-Bit-System

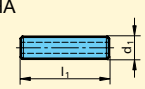
13



code no.	d_1	l_1	l_2
13.1	16	40	16
13.2	25	50	25
13.3	35.6	60	

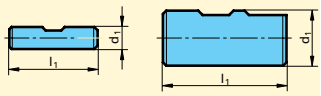
Drivers to DIN 6535

10 form HA



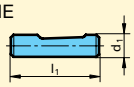
code no.	d_1	l_1
10.1	8	36
10.2	10	40
10.3	12	45
10.4	16	48
10.5	20	50
10.6	25	56
10.7	32	60
10.8	25	70
10.9	40	70

8 form HB with code no. 8.6, 8.7, 8.8



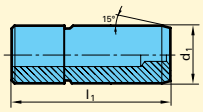
code no.	d_1	l_1
8.1	8	36
8.2	10	40
8.3	12	45
8.4	16	48
8.5	20	50
8.6	25	56
8.7	32	60
8.8	40	70

11 form HE



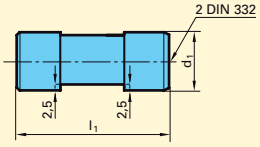
code no.	d_1	l_1
11.1	8	36
11.2	10	40
11.3	12	45
11.4	16	48
11.5	20	50
11.6	25.4	70
11.7	25	56
11.8	32	60
11.9	40	70

16 similar form HA



code no.	d_1	l_1
16.1	10	50
16.2	16	64
16.3	20	70
16.4	25	81
16.5	32	92

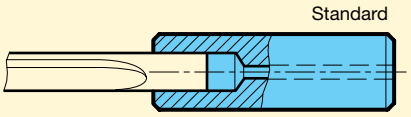
17



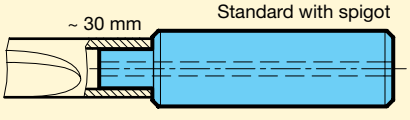
code no.	d_1	l_1
17.1	19.05	70
17.2	25.40	70
17.3	31.75	70
17.4	38.1	70

Driver variations to suit gun drill tubes

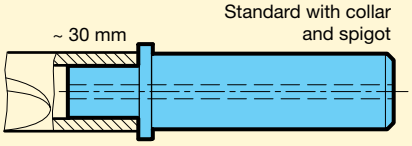
Solution for nom.-Ø < driver-Ø
(difference must be appr. 6 mm):
tube shank installed in driver



Solution for nom.-Ø ≠ driver-Ø
(close to parallel):
tube shank installed over spigot



Solution for nom.-Ø > driver-Ø:
tube shank installed over spigot,
inside-Ø of tube shank >driver-Ø,
tube shank fits against collar shoulder.

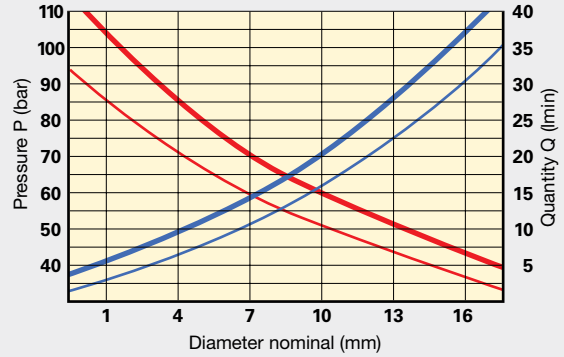


Please note:

- All gun drills must be applied with internal cooling, either air, water or oil. Without internal cooling the chips cannot be evacuated.
- All gun drills can be applied with oil as the medium for internal cooling. However, in this case a 30% higher pressure is required in order to achieve the same coolant volume.
- When MQL is applied with gun drills an increase in pressure may be necessary for smaller nominal diameters de pendent on the pressure of the MQL system.
- If the cooling lubricant data is insufficient the cutting parameters may be reduced. Pressure boosting systems are also possible.

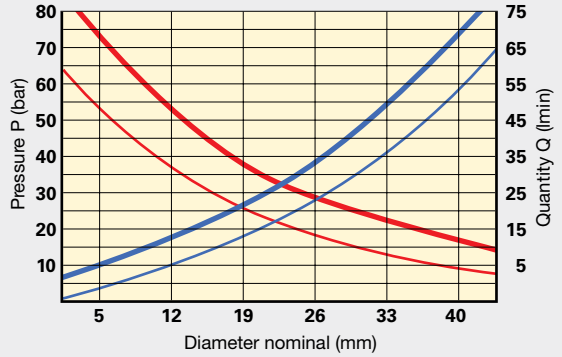
Coolant values EB 100

(recommended values for soluble oil)



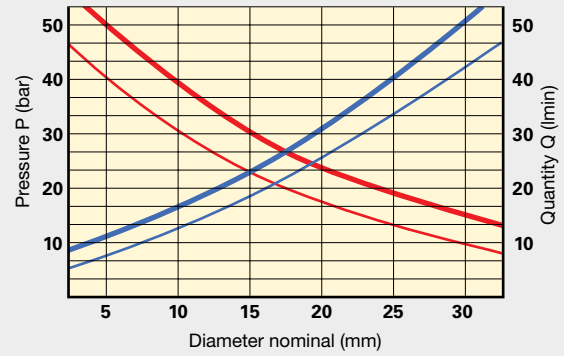
Coolant values EB 80

(recommended values for soluble oil)



Coolant values ZB 80

(recommended values for soluble oil)



Coolant values EB 800

(recommended values for soluble oil)