



# Maximum unsupported drill length chart



When you need single flute gun-drills in an emergency contact our sales office for our 24-hour and 72-hour shipping programs.

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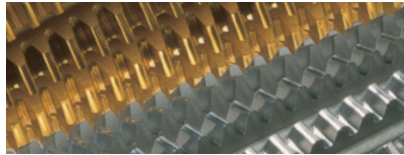
Example: .250" Diameter at 200 SFM = 15" Maximum Unsupported Length

Gundrill Diameter	Surface Feet Per Minute										
	100	150	200	250	300	350	400	450	500	550	600
0.078"	6	5	5	4	4	4	3	3	3	2.5	2.5
0.093"	8	7	6	5	5	4	4	4	4	3.5	3.5
0.109"	9	7	6	6	5	5	5	4	4	4	4
0.125"	10	8	7	7	6	6	5	5	5	5	5
0.140"	12	10	8	7	7	6	6	6	5	5	5
0.156"	13	10	9	8	8	7	7	6	6	6	5
0.171"	14	12	10	9	8	8	7	7	6	6	6
0.187"	16	14	11	10	9	8	8	7	7	7	6
0.203"	17	14	12	11	10	9	9	8	8	7	7
0.218"	18	15	13	12	11	10	9	9	8	8	7
0.234"	20	16	14	12	11	11	10	9	9	8	8
0.250"	21	17	15	13	12	11	11	10	9	9	9
0.256"	22	18	16	14	13	12	11	10	10	9	9
0.281"	24	19	17	15	14	13	12	11	11	10	10
0.296"	25	20	18	16	14	13	12	12	11	11	10
0.312"	26	21	19	17	15	14	13	12	12	11	11
0.328"	28	22	19	17	16	15	14	13	12	12	11
0.343"	29	24	20	18	17	15	14	14	13	12	12
0.359"	30	25	21	19	17	16	15	14	13	13	12
0.375"	32	26	22	20	18	17	16	15	14	13	13
0.390"	33	27	23	21	19	18	16	15	15	14	13
0.406"	34	28	24	22	20	18	17	16	15	15	14
0.421"	35	29	25	22	20	19	18	17	16	15	14
0.437"	37	30	26	23	21	20	18	17	16	16	15
0.453"	38	31	27	24	22	20	19	18	17	16	16
0.468"	39	32	28	25	23	21	20	19	18	17	16
0.484"	41	33	29	26	23	22	20	19	18	17	17
0.500"	42	34	30	27	24	22	21	20	19	18	17

# System technology from one source

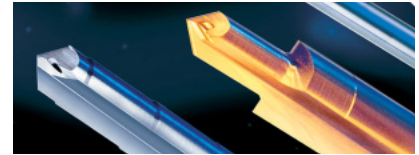


Cylindrical gear hobbing  
 Bevel gear cutting  
 Shaping  
 Profile grinding  
 Continuous generating grinding  
 Honing/shave grinding  
 Shaving cutter grinding  
 Hob grinding  
 Universal tool grinding  
 Carbide tool grinding  
 Chamfering and deburring



HSS and carbide hobs  
 Shaper cutters  
 Broaches  
 Milling cutters  
 Rack and saw cutters  
 Shaving cutters  
 Profile grinding wheels  
 Master gears  
 Chamfering and deburring tools

Regrinding of gear cutting tools  
 Coating of gear cutting tools  
 Decorative coatings  
 Replating of grinding wheels  
 Grinding of compressor rotors, gears of special design, worms and cams



Single and double flute gundrills  
 Solid carbide gundrills  
 Two-fluted milled style deep hole drills

Solid carbide drills and reamers  
 Pressure coolant drills and reamers  
 "PCD" drills and reamers  
 Integrated holder "PCD" tooling



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