STEMLING GUN DRILLS, INC.

DETERMINING GUN DRILL OVERALL LENGTH

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.