

# ***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 +	<b>1"</b>	+	<b>.6"</b>	+	length (per drill diameter)	=	OAL
	<b>1 ½"</b>	+	<b>.6"</b>		<b>.6"</b> (.0450" to .0759")	=	OAL
	<b>40mm / 1.57"</b>	+	<b>.6"</b>		<b>.7"</b> (.0760" to .1059")	=	OAL
	<b>2"</b>	+	<b>.6"</b>		<b>.8"</b> (.1060" to .1620")	=	OAL
	<b>2 ¾"</b>	+	<b>.6"</b>			=	OAL
	<b>Other</b>	+	<b>.6"</b>			=	OAL

### **Gun drill with tube flute:**

Drill depth + driver length + chip clearance & regrind room

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