

Email to Specials@guhring.com

Distributor/customer name

Address

Telephone

Date

If a distributor inquiry list end user name, city, & state

City, Zip code

Email

Name of contact

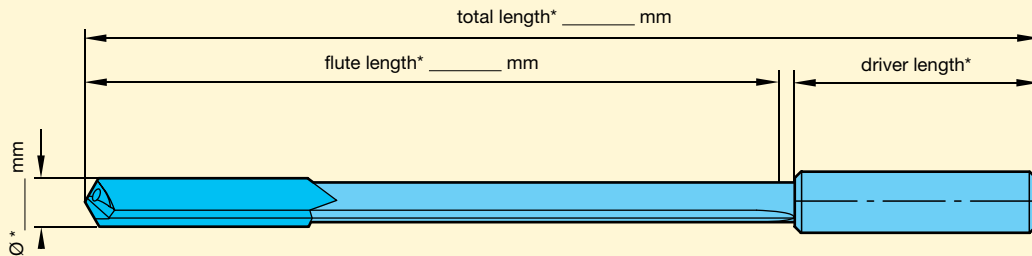
Gun drill:

ZB 80



Quantity breaks requested: _____ tools

* Ø 6.0 - 27.0 mm
Total length max. 1000 mm
Total length, flute 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: nano-ATM **a** FIREX **F** bright _____

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		5	
code no.	d ₁ l ₁ l ₂ l ₃	code no.	d ₁ l ₁ l ₂
1.1	10 40 24 -	5.1	10 60 20
1.2	10 40 24 45	5.2	16 80 28
1.3	10 40 24 55	5.3	25 100 50
1.4	16 45 31,2 -	5.4	10 100
1.5	25 70 34 -	5.5	10 110
1.6	25 70 34 78		
2		6	
code no.	d ₁ l ₁ l ₂ l ₃	code no.	d ₁ l ₁
2.1	16 50 47 -	6.1	12.7 38
2.2	16 50 47 55	6.2	19.05 70
2.3	16 50 47 70	6.3	38.1 70
3		7	
code no.	d ₁ l ₁ l ₂ l ₃	code no.	d ₁ l ₁ l ₂
3.1	25 70 34 100	7.1	16 112 73
4		7.2	20 126 82
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		

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

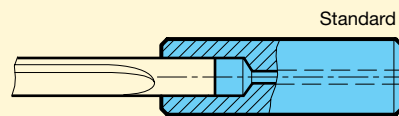
code no.	d ₁ l ₁
16.1	10 50
16.2	16 64
16.3	20 70
16.4	25 81
16.5	32 92

17

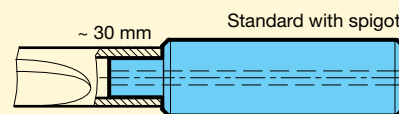
code no.	d ₁ l ₁
17.1	19.05 70
17.2	25.40 70
17.3	31.75 70
17.4	38.1 70

Driver variations to suit gun drill tubes

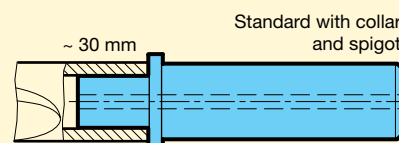
Solution for nom.-Ø < driver-Ø
(difference must be appr. 6 mm):
tube shank installed in driver



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 dependent 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.

