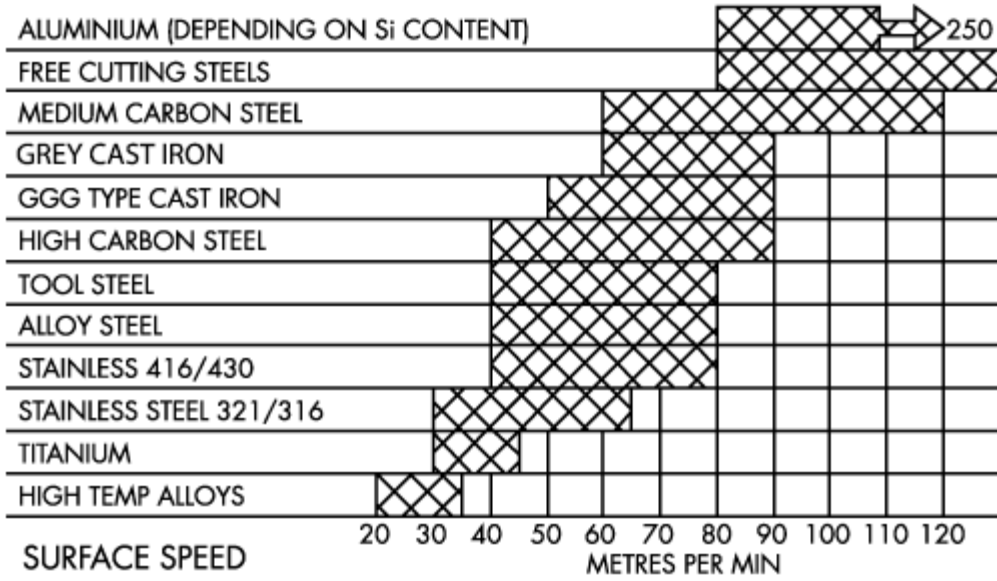
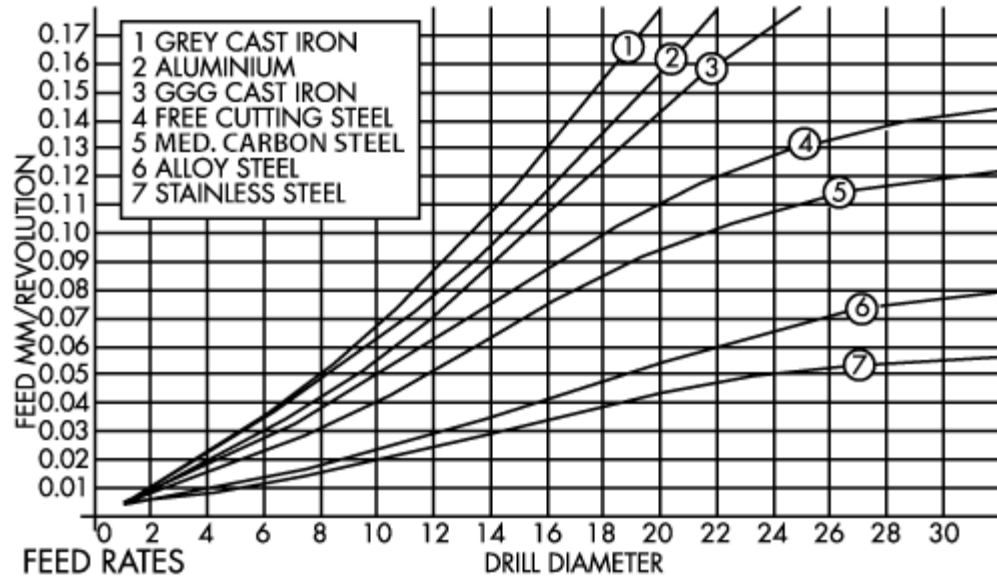


Cutting Parameters

Gun drills operate at relatively high cutting speeds with low feeds per revolution. Approximate starting values are shown in the charts on this page.



Feed rates are critical to chip formation. The values shown here may need to be adjusted for optimum results.



Reliable chip evacuation and good surface finish can only be ensured if sufficient coolant volume and pressure are available.

Pressure and volume vary according to length/diameter ratio.

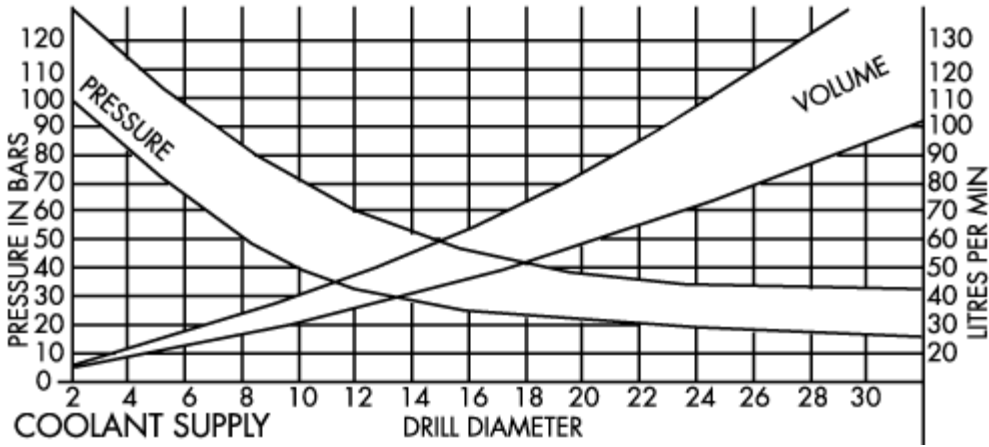


Chart shows maximum unsupported flute length

