

GÜHRING

MONOLITHIC FOR MORE PERFORMANCE

EB 100 M

- ▶ UP TO 30 % HIGHER FEED RATE
- ▶ NEW STOCK PROGRAMME: NOW WITH BRIGHT SURFACE FINISH



Single-Fluted Gun Drills EB 100 M

GÜHRING – YOUR WORLDWIDE PARTNER

EB 100 M single-fluted gun drills



P	○	solid carbide shank with MQL shank end • head form G
M	○	
K	○	
N	•	
S	•	
H	○	

Tool material
Surface
Shank form
Cutting depth

Solid carbide

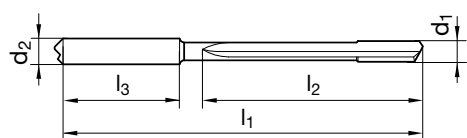


HA

25xD

50xD

75xD



Article no.					5685		5686		5687	
d1 h5		d2 h6	l3	Code no.	l1	l2	l1	l2	l1	l2
mm	inch	mm	mm		mm	mm	mm	mm	mm	mm
1.000		3.000	28.00	1.000	65.00	32.00	90.00	57.00	115.00	82.00
1.191	3/64	3.000	28.00	1.190	70.00	39.00	100.00	68.00	130.00	98.00
1.500		4.000	28.00	1.500	80.00	49.00	120.00	86.00	155.00	124.00
1.588	1/16	4.000	28.00	1.590	85.00	51.00	125.00	91.00	165.00	131.00
1.984	5/64	4.000	28.00	1.980	95.00	64.00	145.00	114.00	195.00	163.00
2.000		4.000	28.00	2.000	95.00	65.00	145.00	115.00	195.00	165.00
2.381	3/32	4.000	28.00	2.380	100.00	70.00	160.00	130.00	220.00	190.00
2.500		4.000	28.00	2.500	115.00	85.00	185.00	155.00	255.00	220.00
2.778	7/64	4.000	28.00	2.780	115.00	85.00	185.00	155.00	255.00	220.00
3.000		6.000	36.00	3.000	145.00	105.00	230.00	190.00	290.00	274.00
3.175	1/8	6.000	36.00	3.170	145.00	105.00	230.00	190.00	320.00	280.00
3.500		6.000	36.00	3.500	145.00	105.00	230.00	190.00	320.00	280.00
3.572	9/64	6.000	36.00	3.570	160.00	120.00	260.00	220.00	360.00	320.00
3.969	5/32	6.000	36.00	3.970	160.00	120.00	260.00	220.00	360.00	320.00
4.000		6.000	36.00	4.000	160.00	120.00	260.00	220.00	360.00	320.00
4.366	11/64	6.000	36.00	4.370	220.00	180.00	290.00	245.00	395.00	355.00
4.763	3/16	6.000	36.00	4.760	220.00	180.00	310.00	268.00	430.00	387.00
5.000		6.000	36.00	5.000	220.00	180.00	370.00	330.00	450.00	406.00
5.159	13/64	6.000	36.00	5.160	220.00	180.00	370.00	330.00	465.00	419.00
5.556	7/32	6.000	36.00	5.560	220.00	180.00	370.00	330.00	525.00	485.00
5.953	15/64	6.000	36.00	5.950	220.00	180.00	370.00	330.00	525.00	485.00
6.000		6.000	36.00	6.000	220.00	180.00	370.00	330.00	525.00	485.00
6.350	1/4	8.000	36.00	6.350	260.00	210.00	430.00	385.00	560.00	516.00
6.500		8.000	36.00	6.500	260.00	210.00	430.00	385.00	575.00	528.00
6.747	17/64	8.000	36.00	6.750	260.00	210.00	430.00	385.00	595.00	548.00
7.000		8.000	36.00	7.000	260.00	210.00	430.00	385.00	615.00	568.00
7.144	9/32	8.000	36.00	7.140	285.00	240.00	485.00	440.00	625.00	580.00
7.541	19/64	8.000	36.00	7.540	285.00	240.00	485.00	440.00		
7.938	5/16	8.000	36.00	7.940	285.00	240.00	485.00	440.00		
8.000		8.000	36.00	8.000	285.00	240.00	485.00	440.00		
9.000		10.000	40.00	9.000	350.00	300.00	555.00	506.00		
10.000		10.000	40.00	10.000	350.00	300.00	615.00	562.00		
11.000		12.000	45.00	11.000	420.00	360.00				
11.113	7/16	12.000	45.00	11.113	420.00	360.00				
12.000		12.000	45.00	12.000	420.00	360.00				
12.700	1/2	14.000	45.00	12.700	455.00	396.00				
14.000		14.000	45.00	14.000	500.00	437.00				
15.000		16.000	48.00	15.000	535.00	468.00				
15.875	5/8	16.000	48.00	15.875	560.00	495.00				
16.000		16.000	48.00	16.000	565.00	499.00				

EB 100 M single-fluted gun drills



Tool material

Solid carbide

Surface



Shank form

HA

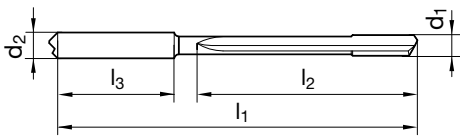
Cutting depth

25xD

50xD

75xD

P	•	solid carbide shank with MQL shank end • head form G
M	•	
K	○	
N	○	
S	○	
H	○	



Article no.					5646		5647		5648	
d1 h5		d2 h6	l3	Code no.	l1	l2	l1	l2	l1	l2
mm	inch	mm	mm		mm	mm	mm	mm	mm	mm
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16.000		16.000	48.00	16.000	565.00	499.00				



EB 100 M

- monolithic solid carbide single-fluted gun drills
- no brazed points and therefore higher stability
- 20 - 30% higher feed rates possible
- shrinkable
- MQL shank end
- for extra tight drilling tolerances
- up to 75xD with only one tool
- suitable for most materials



All gun drills must have support for the pilot hole.
Gun drills must never operate at full speed without
support in the machine shop.

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