

**KONETOOL**



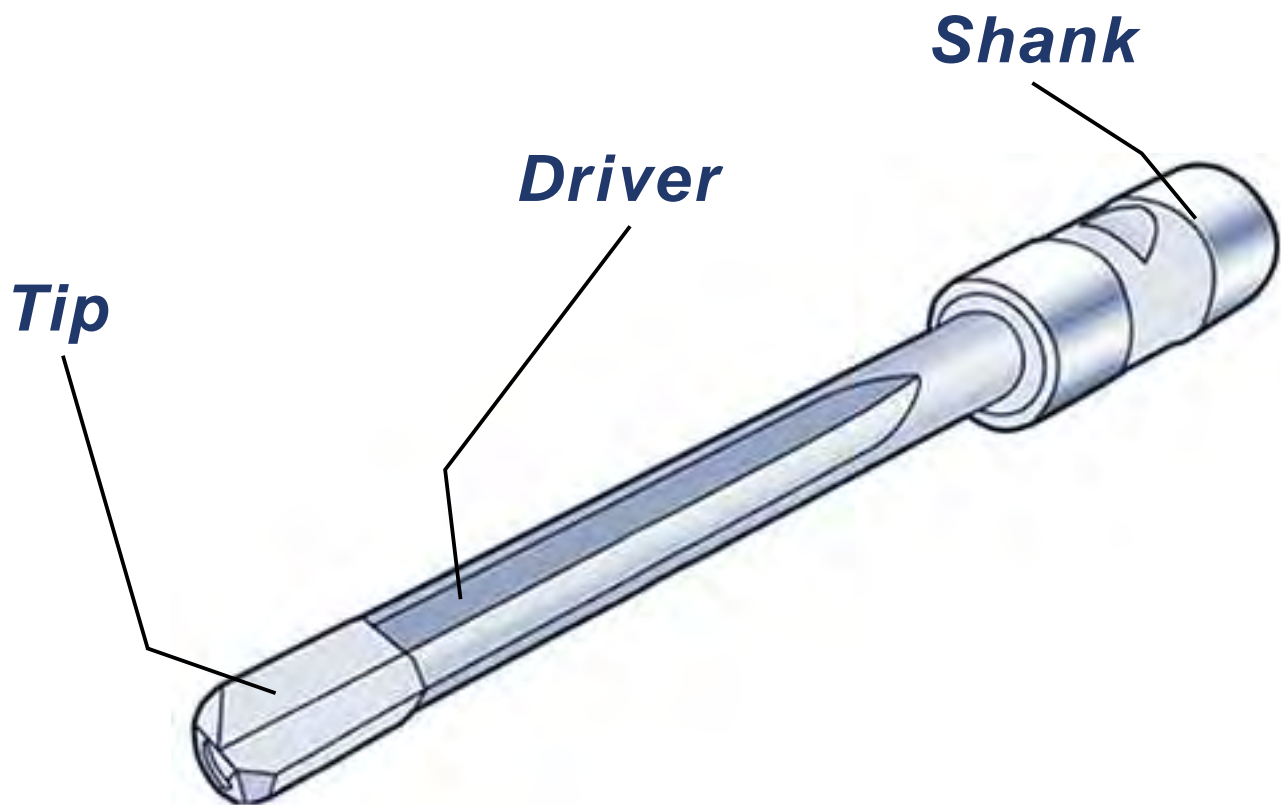
# GUNDRILL PRODUCTS

成都泛亚科锐硬质合金科技有限公司  
KONE CARBIDE TOOL LTD

# Gun Drill tip

Many types of tools have been developed for precision hole drilling and reaming holes using coolants under pressure. The most widely used of these tools is the External Chip Removal gun drill which is made up of three parts:

- **Tip**
- **Shank**
- **Driver**

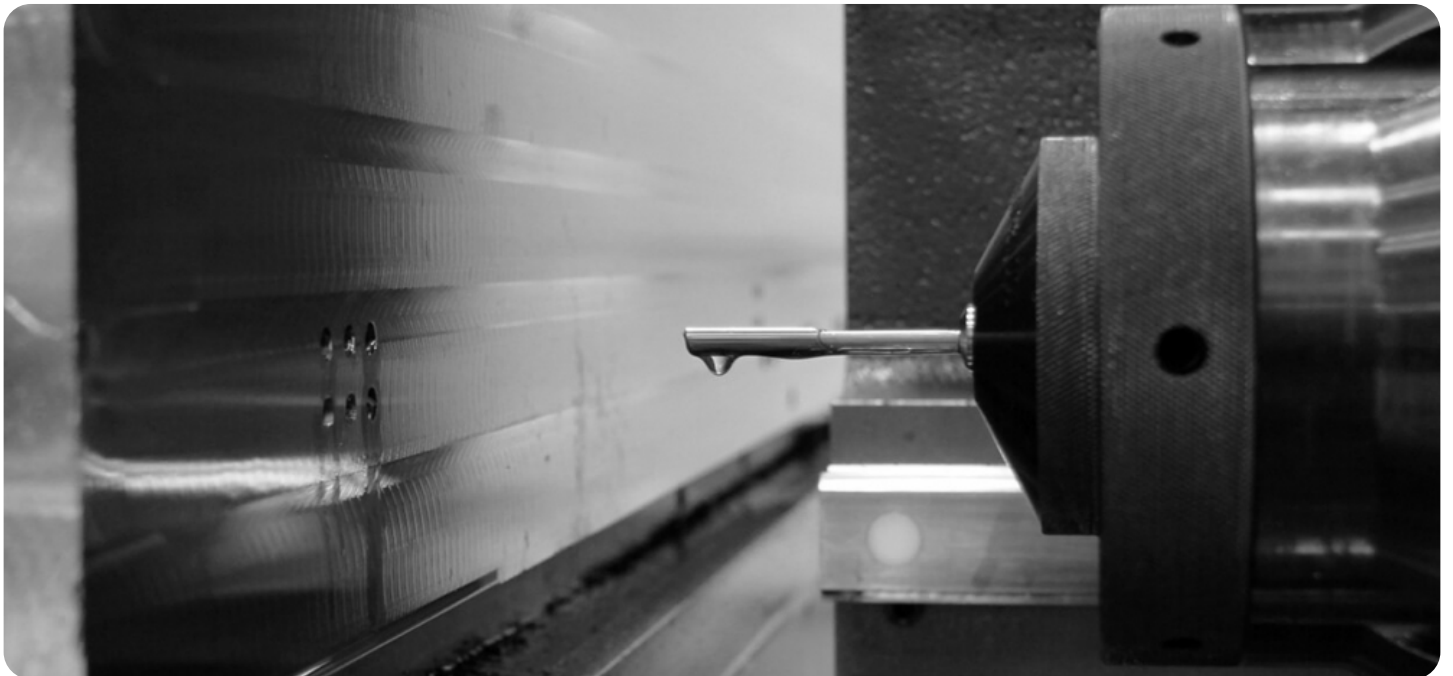


# Grade info for Tips

The finest carbide grade is used for tips to assure longest possible service life. A properly designed carbide tip can drill precision holes at high speed through almost any material.

Grade specification comparison

KONETOOL	K30-K40	Kf25	10% Co	0.6 $\mu\text{m}$	92.1 HRA
GUHRING	K10-K15	DK 105	6% Co	1.0 $\mu\text{m}$	92.3 HRA
HARTMETALL	K10-K20	RF 13	6.5% Co	0.8 $\mu\text{m}$	92.4 HRA
CERATIZIT	K10-K15	CTF12E	6% Co	0.8 $\mu\text{m}$	92.2 HRA
STARCUTTER	K30-K40	HB 110	10% Co	0.8 $\mu\text{m}$	92.0 HRA



# Coating for Tips

Coated gun drills provide an advantage in tool life and surface finish in many materials. New drills, coated, often perform better after the first sharpening, the sharper edge forming a smaller chip.

## ***TiN - Coating:***

Hardness 2100HV, Gold color

To increase anti - adhesive and wear - resistance.

Suitable for stainless steel, chrome steel, nickel etc.

## ***AlTiN - Coating***

Hardness 2200HV, Black color

To increase red - hardness and wear - resistance.

Suitable for high - temperature alloy, mold steel(NAK80, 738) etc.



# Gun Drill Tips

Frequent asked sizes are usually available in Stock

## Product specifications

Order No.	Outer diameter	Half diameter	Length
QGT20K10945A01	20	10.9	45
QGT21K11447A01	21	11.4	47
QGT22K11950A01	22	11.9	50
QGT23K12452A01	23	12.4	52
QGT24K12953A01	24	12.9	53
QGT25K13455A01	25	13.4	55
QGT26K14055A01	26	14.05	55
QGT27K14555A01	27	14.55	55
QGT28K15355A01	28	15.3	55
QGT29K15557A01	29	15.55	57



Other dimensions and specifications upon Request

# Gun Drill Tips

Frequent asked sizes are usually available in Stock

## Product specifications

Order No.	Outer diameter	Half diameter	Length
QGT30K16360A01	30	16.3	60
QGT31K16862A01	31	16.8	62
QGT32K17363A01	32	17.3	63
QGT33K17865A01	33	17.8	65
QGT34K18365A01	34	18.3	65
QGT35K18868A01	35	18.8	68
QGT36K19470A01	36	19.4	70
QGT37K19970A01	37	19.9	70
QGT38K20470A01	38	20.4	70
QGT40K21472A01	40	21.4	72



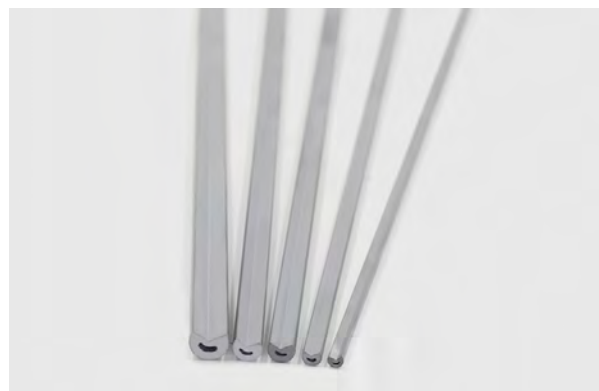
Other dimensions and specifications upon Request



# Solid rods with kidney hole

## Product specifications

Order No.	Dia. (mm)	L(mm)
QGT24K310K01	2.40	310
QGT26K310K01	2.60	310
QGT39K310K01	3.90	310
QGT65K310K01	6.50	310
QGT87K310K01	8.70	310
QGT92K310K01	9.20	310
QGT106K310K01	10.60	310



Other dimensions and specifications upon Request

# Preformed blanks with Twin hole

## Product specifications

Order No.	Dia. (mm)	L(mm)
QGT197330D01	19.7	330
QGT165330D01	16.5	330
QGT100330D01	10.0	330
QGT120330D01	12.0	330
QGT130330D01	13.0	330
QGT140330D01	14.0	330
QGT150330D01	15.0	330



Other dimensions and specifications upon Request



# Popular gun drill size

## Product specifications

Order No.	Cutting Diameter	Tip length	Total length
QGD03K32K1200A01	3	32	1200
QGD04K32K1200A01	4	32	1200
QGD05K32K1200A01	5	32	1200
QGD06K32K1600A01	6	32	1600
QGD07K32K1600A01	7	34	1600
QGD08K34K2000A01	8	34	2000
QGD09K36K2000A01	9	36	2000
QGD10K36K2200A01	10	36	2200
QGD11K38K2400A01	11	38	2400
QGD12K40K2400A01	12	40	2400
QGD13K40K2600A01	13	40	2600
QGD14K40K2600A01	14	40	2600
QGD15K42K2600A01	15	42	2600
QGD16K45K2800A01	16	45	2800



Other dimensions and specifications upon Request

# Popular gun drill size

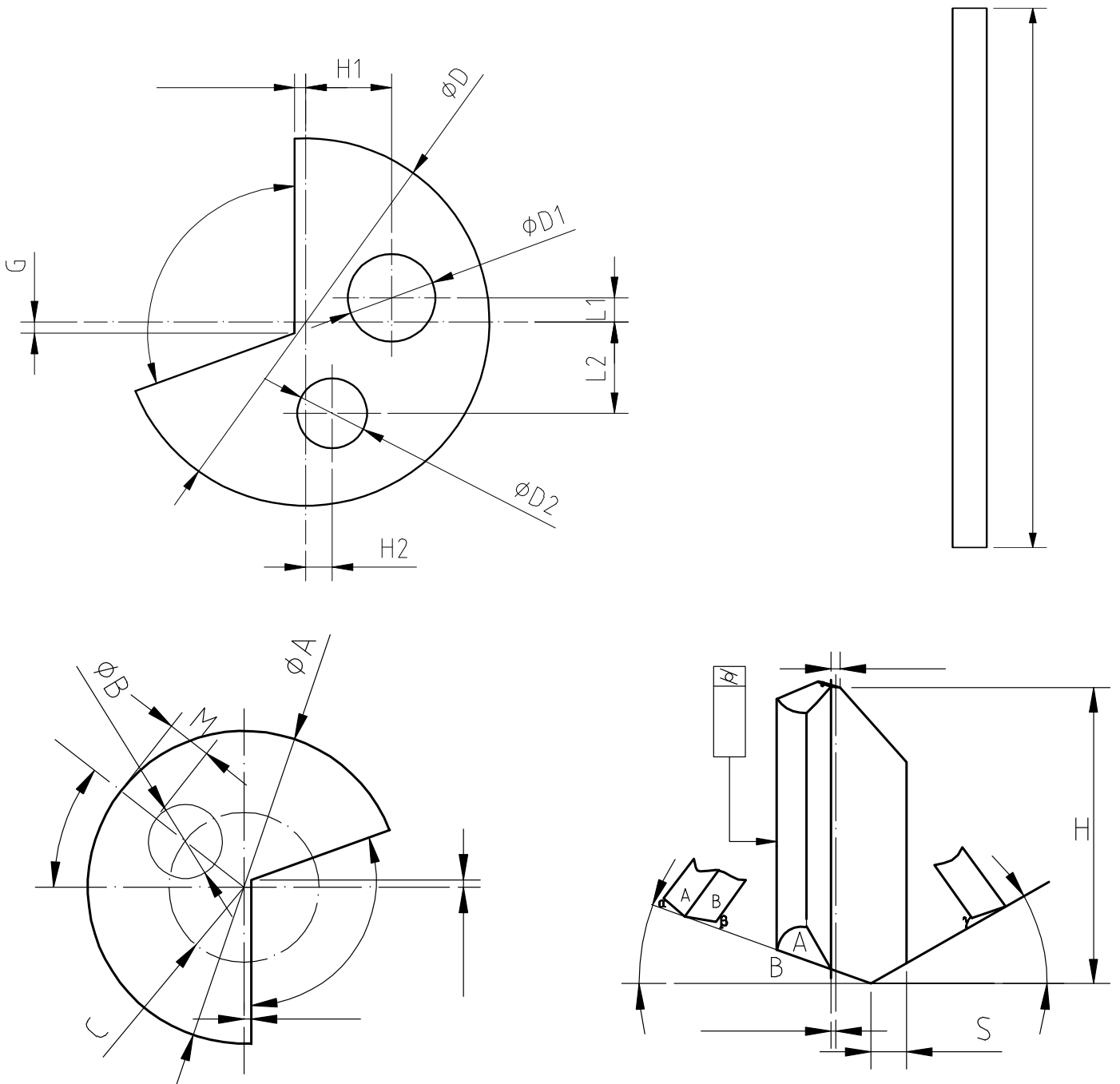
## Product specifications

Order No.	Cutting Diameter	Tip length	Total length
QGD17K45K2800A01	17	45	2800
QGD18K45K2800A01	18	45	2800
QGD19K51K2800A01	19	51	2800
QGD20K51K2800A01	20	51	2800
QGD22K55K2800A01	22	55	2800
QGD24K58K2800A01	24	58	2800
QGD26K61K2800A01	26	61	2800
QGD28K61K2800A01	28	61	2800
QGD30K63K2800A01	30	63	2800
QGD31K65K2800A01	31	65	2800
QGD33K65K2800A01	33	65	2800
QGD35K65K2800A01	35	65	2800
QGD37K65K2800A01	37	65	2800
QGD40K65K2800A01	40	65	2800



Other dimensions and specifications upon Request

# Drawings provided for details and tolerances confirmation



Regarding the technical complexity of gun drill, please tell your detailed requirement to our sales.

# Recommended standard parameters

## Standard parameter

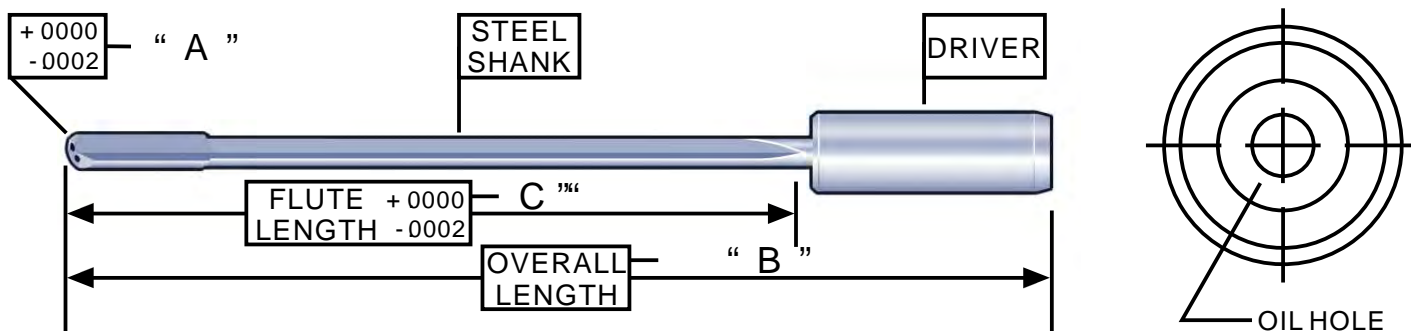
D(mm)	Rev(rpm)	Feed-S50C(mm/min)	Feed-P20(mm/min)	Feed-NAK80(mm/min)
3.02	2400-2600	18-24	12-21	9-15
4.02	2100-2300	21-30	15-28	12-21
5.02	1900-2100	24-35	18-28	15-24
6.02	1800-2000	28-45	21-32	18-28
7.02	1500-1700	32-50	24-32	21-32
8.02	1400-1600	40-70	28-50	24-36
9.02	1300-1400	60-90	32-50	28-40
10.02	1200-1400	80-120	36-60	32-45
11.02	1100-1300	80-120	36-60	32-45
12.02	900-1100	70-110	36-60	30-40
13.02	800-1000	60-80	32-50	28-36
14.02	700-1000	45-70	28-45	24-32
15.02	600-900	40-60	24-40	24-32
16.02	600-800	40-60	21-40	21-32



# Filling your questionnaire with first enquiry

**THREE - PIECE  
CONSTRUCTION**

**DIMENSIONS NOT SHOWN  
ARE MFG STANDARDS**



CARBIDE DIAMETER "A" \_\_\_\_\_ MATERIAL \_\_\_\_\_

OVERALL LENGTH "B" \_\_\_\_\_ MACHINE \_\_\_\_\_

FLUTE LENGTH "C" \_\_\_\_\_ SPEED \_\_\_\_\_

OIL HOLE TYPE=KIDNEY \_\_\_\_\_ 2 HOLE \_\_\_\_\_ FEED \_\_\_\_\_

SPECIAL DRIVER \_\_\_\_\_ COOLANT \_\_\_\_\_

Which part of gun drill do you need? Tip    Shank    Driver  
 Need coating for tips?                      No    Yes    \_\_\_\_\_  
 Sending drawings for your interested part, which our  
 engineer will check your requirements at the first time.



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