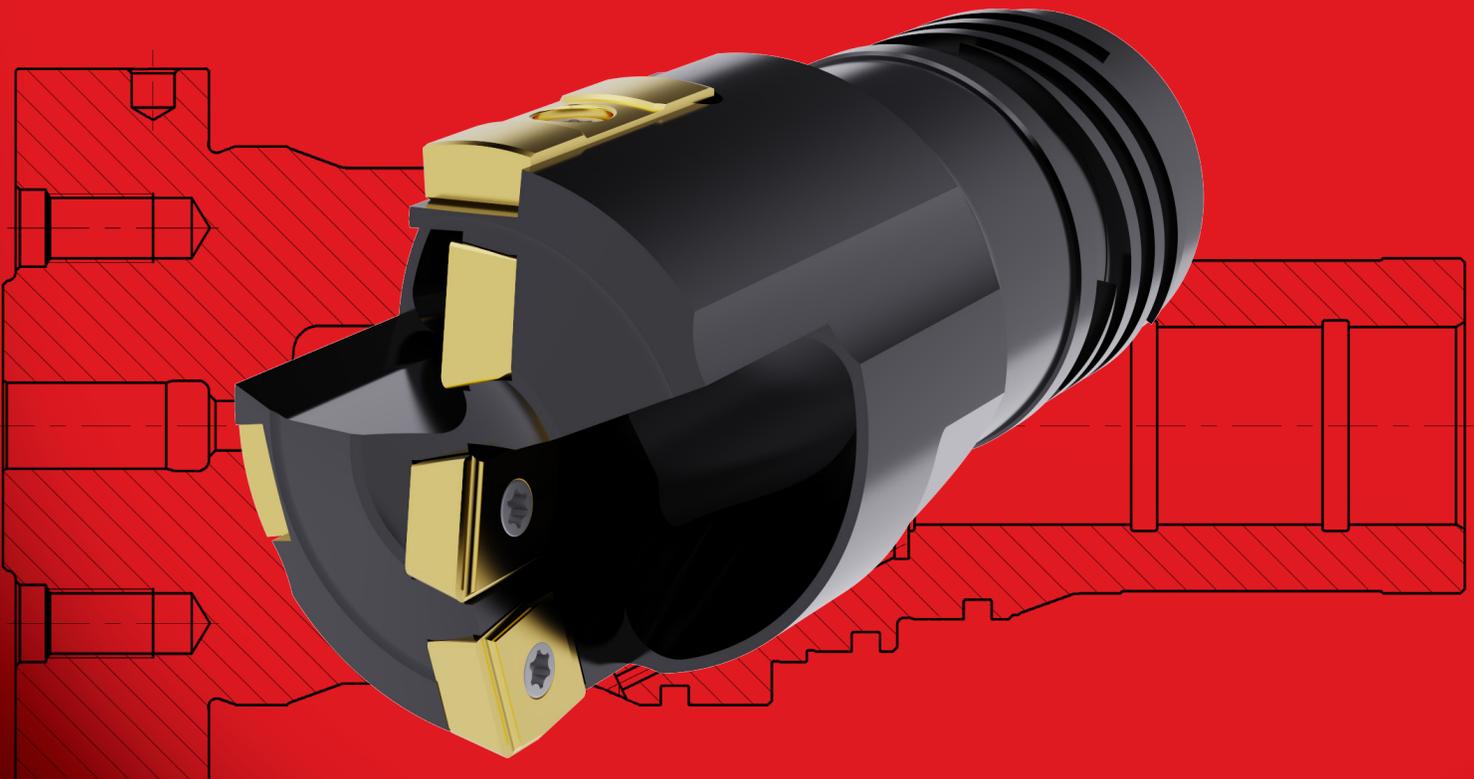




DIRECTDEX SOLID DRILLING TOOLS

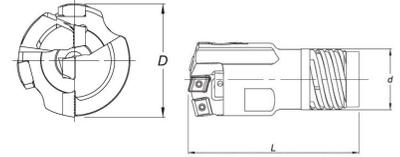
Diameter range 25.00 mm – 65.00 mm (0.984 in – 2.559 in)



DirectDex Single Tube System

Diameter Range: 25.00 mm – 65.00 mm (0.984 in – 2.559 in)

Drill Head Part Numbering Code Example: Metric: DDSM02500M403 Imperial: DDS02500M403



DD		S		M02500		M		4		03	
DirectDex Prefix		Fluid Introduction		Bore Size		Connection Type		Thread Starts		Connection Size	
Description	Code	Description	Code	Description	Code	Description	Code	Description	Code	Description	Code
DirectDex	DD	Single-Tube	S	Size in Metric (###.### mm)	M#####	Male/ External	M	Four-Start	4	25.00 - 26.40 mm .984 - 1.039 in	03
				Size in Imperial ##.### in	#####						
				Example: 25.00 mm (1.000")	M02500 (01000)	Female/ Internal	F	Single-Start	1		

Connection Size Numbering Code

Bore Size Range	25.00 - 26.40 mm	26.41 - 28.70 mm	28.71 - 31.00 mm	31.01 - 33.30 mm	33.31 - 36.20 mm	36.21 - 39.60 mm	39.61 - 43.00 mm	43.01 - 47.00 mm	47.01 - 51.70 mm	51.71 - 56.20 mm	56.21 - 65.00 mm	60.61 - 65.00 mm
	.984 - 1.039 in	1.040 - 1.129 in	1.130 - 1.220 in	1.221 - 1.311 in	1.312 - 1.425 in	1.426 - 1.559 in	1.560 - 1.693 in	1.694 - 1.850 in	1.851 - 2.035 in	2.036 - 2.212 in	2.213 - 2.559 in	2.386 - 2.554 in
Code	03	04	05	06	07	08	09	10	11	12	13	13E

Drill 'D'	Item Code	Drill Tube	Dimensions		Item Code			
			Tube OD 'd'	L	Peripheral	Center	Intermediate	Guide Pad
25.00 - 26.40 mm	DDSM#####M403	03	22 mm	73 mm	BTDDN06PGU1TE 800-06 03 08H-P-G	BTDDN05CGU1TE 800-05 03 08M-C-G	BTDDN05IGU1TE 800-05 03 08M-I-G	GPS0618DDTE 800-06A
0.984 - 1.039 in	DDS#####M403		0.866 in	2.874 in				
26.41 - 28.70 mm	DDSM#####M404	04	24 mm	74 mm	BTDDN06PGU1TE 800-06 03 08H-P-G	BTDDN05CGU1TE 800-05 03 08M-C-G	BTDDN05IGU1TE 800-05 03 08M-I-G	GPS0618DDTE 800-06A
1.04 - 1.129 in	DDS#####M404		0.945 in	2.913 in				
28.71 - 31.00 mm	DDSM#####M405	05	26 mm	75 mm	BTDDN06PGU1TE 800-06 03 08H-P-G	BTDDN06CGU1TE 800-06 03 08M-C-G	BTDDN05IGU1TE 800-05 03 08M-I-G	GPS0618DDTE 800-06A
1.130 - 1.220 in	DDS#####M405		1.024 in	2.953 in				
31.01 - 33.30 mm	DDSM#####M406	06	28 mm	76 mm	BTDDN08PGU1TE 800-08 T3 08H-P-G	BTDDN06CGU1TE 800-06 T3 08M-C-G	BTDDN06IGU1TE 800-06 T3 08M-I-G	GPS0720DDTE 800-07A
1.221 - 1.311 in	DDS#####M406		1.102 in	2.992 in				
33.31 - 33.99 mm	DDSM#####M407	07	30 mm	77 mm	BTDDN08PGU1TE 800-08 T3 08H-P-G	BTDDN06CGU1TE 800-06 T3 08M-C-G	BTDDN06IGU1TE 800-06 T3 08M-I-G	GPS0720DDTE 800-07A
1.312 - 1.338 in	DDS#####M407		1.181 in	3.031 in				
34.00 - 34.99 mm	DDSM#####M407	07	30 mm	77 mm	BTDDN08PGU1TE 800-08 T3 08H-P-G	BTDDN08CGU1TE 800-08 T3 08M-C-G	BTDDN06IGU1TE 800-06 T3 08M-I-G	GPS0720DDTE 800-07A
1.339 - 1.377 in	DDS#####M407		1.181 in	3.031 in				
35.00 - 36.20 mm	DDSM#####M407	07	30.0 mm	77 mm	BTDDN08PGU1TE 800-08 T3 08H-P-G	BTDDN08CGU1TE 800-08 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS0720DDTE 800-07A
1.378 - 1.425 in	DDS#####M407		1.181 in	3.031 in				
36.21 - 38.99 mm	DDSM#####M408	08	33 mm	89 mm	BTDDN08PGU1TE 800-08 T3 08H-P-G	BTDDN08CGU1TE 800-08 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS0720DDTE 800-07A
1.426 - 1.535 in	DDS#####M408		1.299 in	3.504 in				
39.00 - 39.60 mm	DDSM#####M408	08	33.0 mm	89 mm	BTDDN09PGU1TE 800-09 T3 08H-P-G	BTDDN08CGU1TE 800-08 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS0720DDTE 800-07A
1.536 - 1.559 in	DDS#####M408		1.299 in	3.504 in				
39.61 - 43.00 mm	DDSM#####M409	09	36.0 mm	93 mm	BTDDN09PGU1TE 800-09 T3 08H-P-G	BTDDN08CGU1TE 800-08 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS0825DDTE 800-08A
1.560 - 1.692 in	DDS#####M409		1.417 in	3.661 in				
43.01 - 47.00 mm	DDSM#####M410	10	39 mm	95 mm	BTDDN09PGU1TE 800-09 T3 08H-P-G	BTDDN10CGU1TE 800 10 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS0825DDTE 800-08A
1.693 - 1.850 in	DDS#####M410		1.535 in	3.740 in				
47.01 - 49.99 mm	DDSM#####M411	11	43 mm	102 mm	BTDDN09PGU1TE 800-09 T3 08H-P-G	BTDDN12CGU1TE 800-12 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS1030DDTE 800-10A
1.851 - 1.968 in	DDS#####M411		1.692 in	4.016 in				
50.00 - 51.70 mm	DDSM#####M411	11	43 mm	102 mm	BTDDN11PGU1TE 800-11 T3 08H-P-G	BTDDN10CGU1TE 800-10 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS1030DDTE 800-10A
1.969 - 2.035 in	DDS#####M411		1.692 in	4.016 in				
51.71 - 54.99 mm	DDSM#####M412	12	47 mm	110 mm	BTDDN11PGU1TE 800-11 T3 08H-P-G	BTDDN10CGU1TE 800-10 T3 08M-C-G	BTDDN08IGU1TE 800-08 T3 08M-I-G	GPS1030DDTE 800-10A
2.036 - 2.165 in	DDS#####M412		1.850 in	4.331 in				
55.00 - 56.20 mm	DDSM#####M412	12	47.0 mm	110 mm	BTDDN11PGU1TE 800-11 T3 08H-P-G	BTDDN10CGU1TE 800-10 T3 08M-C-G	BTDDN12IGU1TE 800-12 T3 08M-I-G	GPS1235DDTE 800-12A
2.166 - 2.212 in	DDS#####M412		1.850 in	4.331 in				
56.21 - 57.99 mm	DDSM#####M413	13	51 mm	115 mm	BTDDN11PGU1TE 800-11 T3 08H-P-G	BTDDN10CGU1TE 800-10 T3 08M-C-G	BTDDN12IGU1TE 800-12 T3 08M-I-G	GPS1235DDTE 800-12A
2.213 - 2.283 in	DDS#####M413		2.008 in	4.528 in				
58.00 - 65.00 mm	DDSM#####M413	13	51 mm	115 mm	BTDDN11PGU1TE 800-11 T3 08H-P-G	BTDDN12CGU1TE 800-12 T3 08M-C-G	BTDDN12IGU1TE 800-12 T3 08M-I-G	GPS1235DDTE 800-12A
2.284 - 2.559 in	DDS#####M413		2.008 in	4.528 in				

Sandvik Coromant part number shown in Red

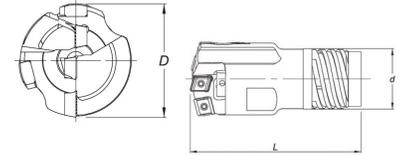
Sunnen DirectDex Inserts are available with both "G" and "L" chip breakers.

Order Example for "L" chip breaker = 800-06 03 08H-P-L



DirectDex Double Tube System

Diameter Range: 25.00 mm – 65.00 mm (0.984 in – 2.559 in)



Drill Head Part Numbering Code Example: Metric: DDDM02500M403 Imperial: DDD02500M403

DD		D		M02500		M		4		03	
DirectDex Prefix		Fluid Introduction		Bore Size (x#####)		Connection Type		Thread Starts		Connection Size	
Description	Code	Description	Code	Description	Code	Description	Code	Description	Code	Description	Code
DirectDex	DD	Double-Tube	D	Size in Metric (###.## mm)	M#####	Male/ External	M	Four-Start	4	25.00 - 26.40 mm .984 - 1.039 in	03
				Size in Imperial (##.### in)	#####						
				Example: 25.00 mm (1.000")	M02500 (01000)	Female/ Internal	F	Single-Start	1		

Connection Size Numbering Code

Bore Size Range	25.00 - 26.40 mm	26.41 - 28.70 mm	28.71 - 31.00 mm	31.01 - 33.30 mm	33.31 - 36.20 mm	36.21 - 39.60 mm	39.61 - 43.00 mm	43.01 - 47.00 mm	47.01 - 51.70 mm	51.71 - 56.20 mm	56.21 - 65.00 mm
	.984 - 1.039 in	1.040 - 1.129 in	1.130 - 1.220 in	1.221 - 1.311 in	1.312 - 1.425 in	1.426 - 1.559 in	1.560 - 1.693 in	1.694 - 1.850 in	1.851 - 2.035 in	2.036 - 2.212 in	2.213 - 2.559 in
Code	03	04	05	06	07	08	09	10	11	12	13

Drill 'D'	Item Code	Outer Drill Tube	Dimensions		Item Code			
			Tube OD 'd'	L	Peripheral	Center	Intermediate	Guide Pad
25.00 - 26.40 mm	DDM#####M403	03	23.50 mm	74 mm	BTDDN06PGU1TE	BTDDN05CGU1TE	BTDDN05IGU1TE	GPS0618DDTE
0.984 - 1.039 in	DDD#####M403		0.925 in	2.913 in	800-06 03 08H-P-G	800-05 03 08M-C-G	800-05 03 08M-I-G	800-06A
26.41 - 28.70 mm	DDM#####M404	04	26 mm	75 mm	BTDDN06PGU1TE	BTDDN05CGU1TE	BTDDN05IGU1TE	GPS0618DDTE
1.04 - 1.129 in	DDD#####M404		1.024 in	2.953 mm	800-06 03 08H-P-G	800-05 03 08M-C-G	800-05 03 08M-I-G	800-06A
28.71 - 31.00 mm	DDM#####M405	05	28 mm	76 mm	BTDDN06PGU1TE	BTDDN06CGU1TE	BTDDN05IGU1TE	GPS0618DDTE
1.130 - 1.220 in	DDD#####M405		1.102 in	2.992 in	800-06 03 08H-P-G	800-06 T3 08M-C-G	800-05 03 08M-I-G	800-06A
31.00 - 33.30 mm	DDM#####M406	06	30.5 mm	77 mm	BTDDN08PGU1TE	BTDDN06CGU1TE	BTDDN06IGU1TE	GPS0720DDTE
1.220 - 1.311 in	DDD#####M406		1.201 in	3.031 in	800-08 T3 08H-P-G	800-06 T3 08M-C-G	800-06 T3 08M-I-G	800-07A
33.31 - 33.99 mm	DDM#####M407	07	33 mm	89 mm	BTDDN08PGU1TE	BTDDN06CGU1TE	BTDDN06IGU1TE	GPS0720DDTE
1.311 - 1.338 in	DDD#####M407		1.299 in	3.504 in	800-08 T3 08H-P-G	800-06 T3 08M-C-G	800-06 T3 08M-I-G	800-07A
34.00 - 34.99 mm	DDM#####M407	07	33 mm	89 mm	BTDDN08PGU1TE	BTDDN08CGU1TE	BTDDN06IGU1TE	GPS0720DDTE
1.339 - 1.377 in	DDD#####M407		1.299 in	3.504 in	800-08 T3 08H-P-G	800-08 T3 08M-C-G	800-06 T3 08M-I-G	800-07A
35.00 - 36.20 mm	DDM#####M407	07	33 mm	89 mm	BTDDN08PGU1TE	BTDDN08CGU1TE	BTDDN08IGU1TE	GPS0720DDTE
1.378 - 1.425 mm	DDD#####M407		1.299 in	3.504 in	800-08 T3 08H-P-G	800-08 T3 08M-C-G	800-08 T3 08M-I-G	800-07A
36.21 - 38.99 mm	DDM#####M408	08	35.50 mm	93 mm	BTDDN08PGU1TE	BTDDN08CGU1TE	BTDDN08IGU1TE	GPS0720DDTE
1.426 - 1.535 in	DDD#####M408		1.398 in	3.661 in	800-08 T3 08H-P-G	800-08 T3 08M-C-G	800-08 T3 08M-I-G	800-07A
39.00 - 39.60 mm	DDM#####M408	08	35.50 mm	93 mm	BTDDN09PGU1TE	BTDDN08CGU1TE	BTDDN08IGU1TE	GPS0720DDTE
1.536 - 1.559 in	DDD#####M408		1.398 in	3.661 in	800-09 T3 08H-P-G	800-08 T3 08M-C-G	800-08 T3 08M-I-G	800-07A
39.61 - 43.00 mm	DDM#####M409	09	39 mm	95 mm	BTDDN09PGU1TE	BTDDN08CGU1TE	BTDDN08IGU1TE	GPS0825DDTE
1.559 - 1.692 in	DDD#####M409		1.535 in	3.740 in	800-09 T3 08H-P-G	800-08 T3 08M-C-G	800-08 T3 08M-I-G	800-08A
43.01 - 47.00 mm	DDM#####M410	10	42.5 mm	102 mm	BTDDN09PGU1TE	BTDDN10CGU1TE	BTDDN08IGU1TE	GPS0825DDTE
1.693 - 1.850 in	DDD#####M410		1.673 in	4.016 in	800-09 T3 08H-P-G	800-10 T3 08M-C-G	800-08 T3 08M-I-G	800-08A
47.01 - 49.99 mm	DDM#####M411	11	46.5 mm	110 mm	BTDDN09PGU1TE	BTDDN12CGU1TE	BTDDN08IGU1TE	GPS1030DDTE
1.851 - 1.968 in	DDD#####M411		1.831 in	4.331 in	800-09 T3 08H-P-G	800-12 T3 08M-C-G	800-08 T3 08M-I-G	800-10A
50.00 - 51.70 mm	DDM#####M411	11	46.5 mm	110 mm	BTDDN11PGU1TE	BTDDN10CGU1TE	BTDDN08IGU1TE	GPS1030DDTE
1.968 - 2.035 in	DDD#####M411		1.831 in	4.331 in	800-11 T3 08H-P-G	800-10 T3 08M-C-G	800-08 T3 08M-I-G	800-10A
51.71 - 54.99 mm	DDM#####M412	12	51 mm	115 mm	BTDDN11PGU1TE	BTDDN10CGU1TE	BTDDN08IGU1TE	GPS1030DDTE
2.036 - 2.165 in	DDD#####M412		2.008 in	4.528 in	800-11 T3 08H-P-G	800-10 T3 08M-C-G	800-08 T3 08M-I-G	800-10A
55.00 - 56.20 mm	DDM#####M412	12	51 mm	115 mm	BTDDN11PGU1TE	BTDDN10CGU1TE	BTDDN12IGU1TE	GPS1235DDTE
2.166 - 2.211 in	DDD#####M412		2.008 in	4.528 in	800-11 T3 08H-P-G	800-10 T3 08M-C-G	800-12 T3 08M-I-G	800-12A
56.21 - 57.99 mm	DDM#####M413	13	55.5 mm	115 mm	BTDDN11PGU1TE	BTDDN10CGU1TE	BTDDN12IGU1TE	GPS1235DDTE
2.212 - 2.283 in	DDD#####M413		2.185 in	4.528 in	800-11 T3 08H-P-G	800-10 T3 08M-C-G	800-12 T3 08M-I-G	800-12A
58.00 - 65.00 mm	DDM#####M413	13	55.5 mm	115 mm	BTDDN11PGU1TE	BTDDN12CGU1TE	BTDDN12IGU1TE	GPS1235DDTE
2.284 - 2.559 in	DDD#####M413		2.185 in	4.528 in	800-11 T3 08H-P-G	800-12 T3 08M-C-G	800-12 T3 08M-I-G	800-12A

Sandvik Coromant part number shown in Red

Sunnen DirectDex Inserts are available with both "G" and "L" chip breakers. Additional carbide grades are available, please contact your Sunnen sales representative.

Order Example for "L" chip breaker = 800-06 03 08H-P-L

SDT Drill Tubes



D		DT		803		L01600		T1	
Tube Type				Connection Size		Tube Length		Threads	
Description	Code	Description	Code	Description	Code	Description	Code	Description	Code
Single Tube	S	Drill Tube	DT	Sandvik # (Female 4-start thread)	803	Length in Metric (##### mm)	L#####	Threaded One End	T1
Double Tube (Ejector)	D			BTA Heller # (Male 1-start thread)	03M			Threaded Both Ends	T2
				SPECIAL	S##			Flange	FL
								Special	S## S01, S02, S03, S...

NOTES: Sandvik 794 - 798; 2-Start thread
 Sandvik 800 - 813; inner tube 30mm longer than outer tube
 Sandvik 814 - 820; inner tube 190mm longer than outer tube
 Sandvik 821-825; inner tube 220mm longer than outer tube
 Sandvik Double tubes 814 and larger , threads on both ends, no inner tube flange
 Other BTA Heller Connections, not common, doesn't need to be in chart; A, B, C, G (GH), M, W (HW)

STS Drill Tube (threaded one end)

Sunnen #	Sandvik Ref.	Connection Size	Tube OD (mm)	Tube ID (mm)	Tube OD (in)	Tube ID (in)
SDT-794-L#####-T1	420.5-794-L#####	794	11.0	7.0	0.433	0.276
SDT-795-L#####-T1	420.5-795-L#####	795	12.0	8.0	0.472	0.315
SDT-796-L#####-T1	420.5-796-L#####	796	13.0	8.5	0.512	0.335
SDT-797-L#####-T1	420.5-797-L#####	797	14.0	9.0	0.551	0.354
SDT-798-L#####-T1	420.5-798-L#####	798	15.0	10.0	0.591	0.394
SDT-799-L#####-T1	420.5-799-L#####	799	16.0	10.5	0.630	0.413
SDT-800-L#####-T1	420.5-800-L#####	800	17.0	11.5	0.669	0.453
SDT-801-L#####-T1	420.5-801-L#####	801	18.0	12.0	0.709	0.472
SDT-802-L#####-T1	420.5-802-L#####	802	20.0	13.0	0.787	0.512
SDT-803-L#####-T1	420.5-803-L#####	803	22.0	14.0	0.866	0.551
SDT-804-L#####-T1	420.5-804-L#####	804	24.0	15.5	0.945	0.610
SDT-805-L#####-T1	420.5-805-L#####	805	26.0	17.0	1.024	0.669
SDT-806-L#####-T1	420.5-806-L#####	806	28.0	18.5	1.102	0.728
SDT-807-L#####-T1	420.5-807-L#####	807	30.0	20.0	1.181	0.787
SDT-808-L#####-T1	420.5-808-L#####	808	33.0	23.0	1.299	0.906
SDT-809-L#####-T1	420.5-809-L#####	809	36.0	25.5	1.417	0.984
SDT-810-L#####-T1	420.5-810-L#####	810	39.0	28.0	1.535	1.102
SDT-811-L#####-T1	420.5-811-L#####	811	43.0	31.0	1.693	1.220
SDT-812-L#####-T1	420.5-812-L#####	812	47.0	35.0	1.850	1.378
SDT-813-L#####-T1	420.5-813-L#####	813	51.0	39.0	2.008	1.535
SDT-813E-L#####-T1	420.5-813E-L#####	813E	56.0	39.0	2.205	1.614

DDT Drill Tubes

DTS Drill Tube Outer (threaded one end)

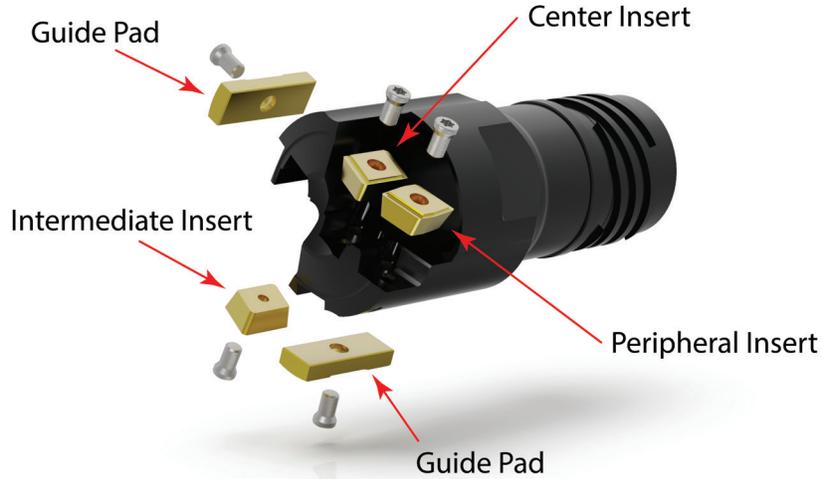


Sunnen #	Sandvik Ref.	Outer Tube	Drilled Hole Diameter (mm)	Drilled Hole Diameter (in)	"Tube OD (mm)"	"Tube ID (mm)"	"Tube OD (in)"	"Tube ID (in)"
DDT-800-L#####-T1	424.2-800-L#####	800	18.4 - 20.0	0.724 - 0.787	18.0	12.0	0.709	0.472
DDT-801-L#####-T1	424.2-801-L#####	801	20.0 - 21.8	0.788 - 0.858	19.5	14.0	0.768	0.551
DDT-802-L#####-T1	424.2-802-L#####	802	21.8 - 24.1	0.859 - 0.948	21.5	15.0	0.846	0.591
DDT-803-L#####-T1	424.2-803-L#####	803	24.1 - 26.4	0.949 - 1.039	23.5	16.0	0.925	0.630
DDT-804-L#####-T1	424.2-804-L#####	804	26.4 - 28.7	1.040 - 1.130	26.0	18.0	1.024	0.709
DDT-805-L#####-T1	424.2-805-L#####	805	28.7 - 31.0	1.131 - 1.220	28.0	20.0	1.102	0.787
DDT-806-L#####-T1	424.2-806-L#####	806	31.0 - 33.3	1.221 - 1.311	30.5	22.0	1.201	0.866
DDT-807-L#####-T1	424.2-807-L#####	807	33.3 - 36.2	1.312 - 1.425	33.0	24.0	1.299	0.945
DDT-808-L#####-T1	424.2-808-L#####	808	36.2 - 39.6	1.426 - 1.559	35.5	26.0	1.398	1.024
DDT-809-L#####-T1	424.2-809-L#####	809	39.6 - 43.0	1.560 - 1.692	39.0	29.0	1.535	1.149
DDT-810-L#####-T1	424.2-810-L#####	810	43.0 - 47.0	1.693 - 1.850	42.5	32.0	1.673	1.260
DDT-811-L#####-T1	424.2-811-L#####	811	47.0 - 51.7	1.851 - 2.035	46.5	35.0	1.831	1.378
DDT-812-L#####-T1	424.2-812-L#####	812	51.7 - 56.2	2.036 - 2.212	51.0	39.0	2.008	1.535
DDT-813-L#####-T1	424.2-813-L#####	813	56.2 - 65.0	2.213 - 2.559	55.5	43.0	2.185	1.693

DTS Drill Tube Inner

Sunnen #	Sandvik Ref.	Inner Tube	"Tube OD (mm)"	"Tube ID (mm)"	"Tube OD (in)"	"Tube ID (in)"
DDT-850-L#####	424.2-850-L#####	850	10.0	9.0	0.394	0.354
DDT-851-L#####	424.2-851-L#####	851	12.0	11.0	0.472	0.433
DDT-852-L#####	424.2-852-L#####	852	13.0	12.0	0.512	0.472
DDT-853-L#####	424.2-853-L#####	853	14.0	13.0	0.551	0.512
DDT-854-L#####	424.2-854-L#####	854	16.0	14.0	0.630	0.551
DDT-855-L#####	424.2-855-L#####	855	18.0	16.0	0.709	0.630
DDT-856-L#####	424.2-856-L#####	856	20.0	18.0	0.787	0.709
DDT-857-L#####	424.2-857-L#####	857	22.0	20.0	0.866	0.787
DDT-858-L#####	424.2-858-L#####	858	24.0	22.0	0.945	0.866
DDT-859-L#####	424.2-859-L#####	859	27.0	25.0	1.063	0.984
DDT-860-L#####	424.2-860-L#####	860	30.0	28.0	1.181	1.102
DDT-861-L#####	424.2-861-L#####	861	32.0	30.0	1.260	1.181
DDT-862-L#####	424.2-862-L#####	862	36.0	34.0	1.417	1.339
DDT-863-L#####	424.2-863-L#####	863	40.0	38.0	1.575	1.496

Insert and Guide Pad Sizes



Cutting Diameter Range	Center Insert	Cutting Diameter Range	Intermediate Insert	Cutting Diameter Range	Peripheral Insert	Cutting Diameter Range	Guide Pad
25.00 - 28.70 mm	BTDDN05CGU1TE 800-05 03 08M-C-G	25.00 - 31.00 mm	BTDDN05IGU1TE 800-05 03 08M-I-G	25.00 - 31.00 mm	BTDDN06PGU1TE 800-06 03 08H-P-G	25.00 - 31.00 mm	GPS0618DDTE 800-06A
0.984 - 1.139 in	Screw PHSM1151 5513 020 05					0.984 - 1.220 in	Screw PHSM1151 5513 020 05
28.71 - 33.99 mm	BTDDN06CGU1TE 800-06 T3 08M-C-G	31.01 - 34.99 mm	BTDDN06IGU1TE 800-06 T3 08M-I-G	31.01 - 38.99 mm	BTDDN08PGU1TE 800-08 T3 08H-P-G	31.01 - 39.60 mm	GPS0720DDTE 800-07A
1.140 - 1.338 in	Screw PHSM1153 5513 020 34					1.221 - 1.378 in	Screw PHSM 1153 5513 020 34
34.00 - 43.00 mm	BTDDN08CGU1TE 800-08 T3 08M-C-G	35.00 - 54.99 mm	BTDDN08IGU1TE 800-08 T3 08M-I-G	39.00 - 49.99 mm	BTDDN09PGU1TE 800-09 T3 08H-P-G	39.61 - 47.00 mm	GPS0825DDTE 800-08A
1.339 - 1.693 in	Screw PHSM1153 5513 020 34					1.379 - 2.165 in	Screw PHSM1153 5513 020 34
43.01 - 47.00 mm	BTDDN10CGU1TE 800-10 T3 08M-C-G	55.00 - 65.00 mm	BTDDN12IGU1TE 800-12 T3 08M-I-G	50.00 - 65.00 mm	BTDDN11PGU1TE 800-11 T3 08H-P-G	47.01 - 54.99 mm	GPS1030DDTE 800-10A
1.694 - 1.850 in	Screw PHSM1153 5513 020 34					2.166 - 2.559 in	Screw PHSM1153 5513 020 34
47.01 - 49.99 mm	BTDDN12CGU1TE 800-12 T3 08M-C-G	55.00 - 65.00 mm				55.00 - 65.00 mm	GPS1235DDTE 800-12A
1.851 - 1.968 in	Screw PHSM1153 5513 020 34					2.166 - 2.559 in	
50.00 - 57.99 mm	BTDDN10CGU1TE 800-10 T3 08M-C-G						
1.969 - 2.283 in	Screw PHSM1153 5513 020 34						
58.00 - 65.00 mm	BTDDN12CGU1TE 800-12 T3 08M-C-G						
2.284 - 2.559 in	Screw PHSM1153 5513 020 34						

Center



Intermediate



Peripheral



Guide Pad



DirectDex - Feed & Speed



Inch values

ISO	ANSI	Material	Specific cutting force	Hardness Brinell	Geometry / Grade	Cutting speed	Drill diameter, inch
			kc1 lbs/in ²	HB			≥ 2.500
							Feed f _n inch/rev
P	1018, 1020, 1215	Unalloyed steel Non-hardened 0.10-0.25% C	290 000	90-200	-G/-L/TE	260-330	.007-.014
	1045, 1050, 1335	Non-hardened 0.25-0.55% C	304 500	125-225	-G/TE	260-330	.007-.014
	1055, 1060	Non-hardened 0.55-0.80% C	316 100	150-250	-G/TE	260-330	.007-.014
	1095	High carbon steel, annealed	336 400	180-275	-G/TE	260-330	.007-.014
	4140, 52100, 8620	Low alloy steel Non hardened	304 500	150-260	-G/TE	230-330	.007-.014
	4140, 52100, 8620	Hardened and tempered	402 400	220-450	-G/TE	200-330	.006-.014
	D3, H13, A2	High alloy steel Annealed	362 500	150-250	-G/TE	200-330	.007-.012
	M3, M35 D3, H13, A2	Annealed HSS Hardened tool steel	398 750 543 750	150-250 250-350	-G/TE -G/TE	200-330 200-330	.007-.012 .007-.012
	D3, H13, A2	Hardened steel, others	580 000	250-450	-G/TE	200-330	.007-.012
	1018, 1045, 1055 4140, 52100, 8620	Castings Unalloyed Low alloyed (alloying elements < 5%)	261 000 2304 500	90-225 150-250	-G/TE -G/TE	165-330 165-330	.006-.012 .006-.012
M	403, 405, 410	Rolled/forged Ferritic/Martensitic, non hardened	333 500	150-270	-G/L/TE	165-300	.006-.014
	15-5, 17-4	Corrosion Resistance	350.000	277-352	-L/TE	128-190	.008-.013
	304, 316, 318	Austenitic	377 000	150-270	-L/TE	165-300	.006-.014
K	32510 40010, 50005	Malleable Ferritic Pearlitic	137 750 159 500	110-145 150-270	-G/TE -G/TE	260-330 260-330	.007-.012 .007-.012
	Class 20, 25, 30 Class 45, 50, 60	Grey Low tensile strength High tensile strength	159 500 187 050	150-220 200-330	-G/TE -G/TE	200-330 200-330	.006-.014 .006-.014
	60-40-18, 80-55-56 100-70-03	Nodular Ferritic Pearlitic	152 250 253 750	125-230 200-300	-G/TE -G/TE	165-330 165-330	.006-.014 .006-.014
N	7075, 2024, 7010	Aluminium alloys Wrought or wrought and coldworked, non- aging	72 500	30-100	-L/TE	210-600	.004-.012
	7075, 2024, 7010	Wrought or wrought and aged	116 000	30-150	-L/TE	210-600	.004-.012
	7075, 2024, 7010	Cast, non aging	108 750	40-100	-L/TE	210-600	.004-.012
	7075, 2024, 7010	Cast or cast and aged	130 500	70-140	-L/TE	210-600	.004-.012
	Copper Copper	Copper and copper alloys Free cutting alloys (Pb > 1%) Brass and leaded alloys (Pb < 1%)	101 500 101 500	70-160 50-200	-L/TE -L/TE	210-600 210-600	.004-.012 .004-.012
S	330	Iron base Annealed or solution treated	435 000	180-230	-G/L/TES	65-210	.006-.012
	Waspaloy, Inconel	Nickel base Annealed or solution treated	481 400	140-300	-L/TES	65-210	.006-.012
	Air Resistant 213, Jetalloy 209	Cobalt alloys Annealed or solution treated	478 500	180-230	-L/TES	65-210	.006-.012
	Ti6Al4V	Titanium Alfa-, near Alfa- and Alfa + Beta alloys annealed	242 875	600-1100	-L/TES -L/TES	100-330 100-330	.006-.012 .006-.012

DirectDex - Feed & Speed



Metric values

ISO	ANSI	Material	Specific cutting force kc1 N/mm ²	Hardness Brinell HB	Geometry / Grade	Cutting speed vc m/min	Drill diameter, mm
							≥ 63.50
							Feed f _n mm/r
P	1018, 1020, 1215	Unalloyed steel Non-hardened 0.10-0.25% C	1500	90-200	-G/-L/TE	80-100	0.18-0.35
	1045, 1050, 1335	Non-hardened 0.25-0.55% C	1600	125-225	-G/TE	80-100	0.18-0.35
	1055, 1060	Non-hardened 0.55-0.80% C	1700	150-250	-G/TE	80-100	0.18-0.35
	1095	High carbon steel, annealed	1800	180-275	-G/TE	80-100	0.18-0.35
	4140, 52100, 8620	Low alloy steel Non hardened	1700	150-260	-G/TE	70-100	0.18-0.35
	4140, 52100, 8620	Hardened and tempered	1900	220-450	-G/TE	60-100	0.18-0.35
	D3, H13, A2	High alloy steel Annealed	1950	150-250	-G/TE	70-100	0.18-0.30
	M3, M35	Annealed HSS	2150	150-250	-G/TE	70-100	0.18-0.30
	D3, H13, A2	Hardened tool steel	2900	250-350	-G/TE	60-100	0.16-0.30
	D3, H13, A2	Hardened steel, others	3100	250-450	-G/TE	60-100	0.16-0.30
	1018, 1045, 1055	Castings Unalloyed	1400	90-225	-G/TE	50-100	0.15-0.30
	4140, 52100, 8620	Low alloyed (alloying elements < 5%)	1600	150-250	-G/TE	50-100	0.15-0.30
M	403, 405, 410	Rolled/forged Ferritic/Martensitic, non hardened	1800	150-270	-G/L/TE	50-90	0.15-0.30
	16-5, 17-4	Corrosion Resistance	1900	277-352	-L/TE	39-58	0.20-0.33
	304, 316, 318	Austenitic	1950	150-275	-L/TE	50-90	0.15-0.30
K	32510	Malleable Ferritic	790	110-145	-G/TE	80-100	0.18-0.30
	40010, 50005	Pearlitic	900	150-270	-G/TE	80-100	0.18-0.30
	Class 20, 25, 30 Class 45, 50, 60	Grey Low tensile strength High tensile strength	890 1100	150-220 200-330	-G/TE -G/TE	60-100 60-100	0.16-0.35 0.16-0.35
N	60-40-18, 80-55-56 100-70-03	Nodular Ferritic Pearlitic	900 1350	125-230 200-300	-G/TE -G/TE	50-100 50-100	0.16-0.35 0.16-0.35
	7075, 2024, 7010	Aluminium alloys Wrought or wrought and coldworked, non- aging	400	30-100	-L/TE	65-130	0.10-0.30
	7075, 2024, 7010	Wrought or wrought and aged	650	30-150	-L/TE	65-130	0.10-0.30
7075, 2024, 7010	Cast, non aging	600	40-100	-L/TE	65-130	0.10-0.30	
7075, 2024, 7010	Cast or cast and aged	700	70-140	-L/TE	65-130	0.10-0.30	
S	Copper Copper	Copper and copper alloys Free cutting alloys (Pb > 1%) Brass and leaded alloys (Pb < 1%)	550 550	70-160 50-200	-L/TE -L/TE	65-130 65-130	0.10-0.30 0.10-0.30
	330	Iron base Annealed or solution treated	2400	180-230	-G/TES	20-65	0.15-0.30
S	Waspaloy, Inconel	Nickel base Annealed or solution treated	2650	140-300	-L/TES	20-65	0.15-0.30
	Air Resistant 213, Jetalloy 209	Cobalt alloys Annealed or solution treated	2700	180-230	-L/TES	20-65	0.15-0.30
	Ti6Al4V	Titanium Alfa-, near Alfa- and Alfa + Beta alloys annealed	1400	600-1100	-L/TES -L/TES	30-60 30-100	0.15-0.30 0.15-0.30

Sunnen's Deep Hole Drilling Tools

Offering the lowest cost per hole for identical replacements of discontinued Sandvik Tools

Sunnen is committed to designing, manufacturing, and delivering world class deep hole machining tools and systems that meet or exceed customer requirements.

Whether a Single Tube, Double Tube, Gun Drilling or other specialty system is needed, Sunnen has the engineering expertise and manufacturing capabilities to meet any deep hole machining requirements.



MicroDex - Replaces Brazed Drill Heads

STS

Diameter Range
12.00 – 28.00 mm
0.472 – 1.102 inch



DirectDex - Replaces CoroDrill 800 series

STS

Diameter Range
25.00 – 65.00 mm
0.984 - 2.559 inch

DTS

Diameter Range
25.00 – 65.00 mm
0.984 - 2.559 inch



FlexiDex - Replaces CoroDrill 801 series

STS

Diameter Range
65.00 mm – 195.99 mm
2.559 in – 7.716 in



TrueDex - Replaces Sandvik 424.10 series

STS

Diameter Range
63.50 mm – 183.90 mm
2.500 in – 7.240 in



CounterDex - Replaces Sandvik 818 series

STS

Diameter Range
35.00 mm – 216.00 mm
1.378 in – 8.503 in

Sunnen also offers replacement parts for all of these tools, including inserts, pads, cartridges, shims and screws.

Sunnen's SHDD Series Deep Hole Drills

Easy-to-use, efficient, heavy-duty

- Available in three standard models
 - 2-meter maximum part length (SHDD-2500)
 - 4-meter maximum part length (SHDD-4500)
 - 6-meter maximum part length (SHDD-6500)
- Large 394 mm (15.5 in) color HMI with intuitive controls for ease of use.
- Heavy-duty Bosch-Rexroth 55 mm (2.16 in) linear rails for maximum durability.
- Standard safety system with a combination of multiple E-stops, light curtains, interlocked guarding and fencing.
- Standard 67 kw (90 hp) tool motor with headstock drive for optimum power.
- Standard 38 kw (50 HP) workpiece headstock drive (counter rotation).
- Beckhoff servo driven heavy-duty ball screws for tool feed.
 - 80 mm ball screw (3.15 in) SHDD-2500 / SHDD-4500
 - 100 mm ball screw (3.84 in) SHDD-6500
- Electrical enclosure air conditioning unit standard to protect critical electronics in high temperature environments.
- Heavy-duty welded base.
- Heavy-duty 3-jaw chucks standard.
- Automatic lubrication system for ball screw, rack and pinion, and linear rails standard.
- Heavy-duty servo rack and pinion driven work piece positioning and clamping.
- Spindle carriage control station for ease of driveshaft installation.
- Sunnen is the complete system supplier... machines, tools, chip management, cooling systems and cutting fluids.



Sunnen Designed and Developed Intuitive Control System

Features include:

- Beckhoff PLC with 394 mm (15.5 in) color touchscreen
- All machine functions controlled from the operator station
- Real time graphical display of tool position, tool feed load, spindle loads, and coolant pressure and volume
- Two-button part-to-part mode for high production operation
- Slow start tool feed for setup
- Tool protection function
- USB port for ease of backup
- Metric/inch units screen selectable
- Up to 500 part setups can be saved and retrieved
- Machine diagnostics
- On-screen, multi-language selection



Heavy-Duty Sunnen Designed and Built Coolant System

Features include:

- Modular clean and dirty tanks with 6245 liter (1650 gallon) maximum capacity and 3785 liter (1000 gallon) operating capacity
- Heavy-duty welded construction using 4.75 mm (.187 in) plate with a double wall option available
- High flow 10-micron, four-bag filtration system
- Heavy-duty screw type pump with 757 lpm (200 gpm) max flow and 5.2MPa (750 psig) max pressure
- 70-micron inlet filter
- Standard chiller for hot environments
- Designed for maintainability with multiple level sensors, clean-out ports and instrumentation
- Heavy-duty chip conveyor
- Active coolant level monitoring



a legacy of excellence since 1924.

SUNNEN WORLDWIDE



With world headquarters in St. Louis, Missouri, Sunnen is the largest fully integrated company in the world specializing in precision bore creation, sizing and finishing equipment. A Sunnen solution might include honing, lapping, skiving/roller burnishing or deep hole machining...or a combination of those processes.

Our 13 international subsidiaries and over 40 authorized distributors allow us to deliver top quality Sunnen machines, tools, service and training wherever they are needed around the globe.

Sunnen Products Company

World Headquarters
St. Louis, MO – USA

Phone (314) 781-2100
Fax (314) 781-2268
Toll Free (800) 325-3670
Email sunnen@sunnen.com
www.sunnen.com

Austria – Sunnen Austria GmbH

Phone +43 (0) 5576 74194
Fax +43 (0) 5576 74196
Email sales@sunnen.eu
www.sunnen.at

Belgium – Sunnen Benelux BVBA

Phone +32 38 80 2800
Fax +32 38 44 3901
Email info@sunnen.be
www.sunnen.be

Brazil – Sunnen do Brasil LTDA.

Phone +55 11 4368-4900
Email sunnen@sunnen.com.br
www.sunnen.com.br

Canada – Sunnen Products Company

Phone 844-356-0006
Email canadasales@sunnen.com
www.sunnen.com

China – Shanghai Sunnen Mechanical Co. Ltd.

Phone +86 21 5813 3990
Fax +86 21 5813 2299
Email shsunnen@sunnensh.com
www.sunnensh.com

Czech Republic – Sunnen s.r.o.

Phone +420 383 376 317
Fax +420 383 376 316
Email sunnen@sunnen.cz
www.sunnen.cz

France – Sunnen SAS

Phone +33 01 69 30 0000
Fax +33 01 69 30 1111
Email info@sunnen.fr
www.sunnen.fr

India – Sunnen India Pvt. Ltd.

Phone +91 223 913 6055
Fax +91 223 913 6056
Email sales@sunnen.in
www.sunnen.in

Italy – Sunnen Italia S.r.l.

Phone +39 02 383 417 1
Fax +39 02 383 417 50
Email sunnen@sunnenitalia.com
www.sunnenitalia.com

Poland – Sunnen Polska Sp. z o.o.

Phone +48 22 814 34 29
Fax +48 22 814 34 28
Email sunnen@sunnen.pl
www.sunnen.pl

Switzerland – Sunnen AG

Phone +41 71 649 33 33
Email sales@sunnen.eu
www.sunnen.eu

UK – Sunnen Products Ltd.

Phone +44 1442 39 39 39
Fax +44 1442 39 12 12
Email hemel@sunnen.co.uk

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