



GÜHRING



HIGH- LIGHTS 2024

Our trade fair highlights

Top tools for the highest of standards



Contents

new

Solid carbide drill RT 100 H

High performance in hardened steels up to 67 HRC

new

Solid carbide drill RT 100 H Micro

46 % shorter machining times in steel materials up to 67 HRC

new

Solid carbide drill RT 100 AL

No built-up edges and perfect chip removal

new

Flat drill FB 200 U

Three-fluted flat drill for efficient & high quality 180° holes

new

Solid carbide single-fluted deep hole drill EB 100 M AL

High-performance deep hole drilling in aluminium

new

Indexable insert drill

50 % longer tool lives thanks to carbide & coating

new

PCD face and corner milling cutter

Flexibility & economy combined



from page 6



from page 8



from page 10



from page 12



from page 14



from page 16



from page 18



new

Solid carbide milling cutter RF 100 AL Micro

Smooth milling with extreme metal removal rates

new

Solid carbide milling cutter RF 100 AL

30 % higher machining performance in aluminium and plastic

new

Solid carbide single-fluted cutter AL

Solid carbide single-fluted cutter for reliable aluminium profile machining

new

High-speed milling cutter with indexable inserts

Four cutting edges for the best possible results

new

Modular tap

The perfect combination of toughness & wear resistance

new

Tap AL & fluteless tap AL

No chance for built-up edges & material adhesion

new

Fluteless tap InoxPro

Up to twice the tool life in stainless steel

new

High-performance reamer HR 500

Up to 50x faster than conventional reamers

new

System 222 for grooving and parting off

Addition for limited space in sliding headstock lathes



from page 22



from page 24



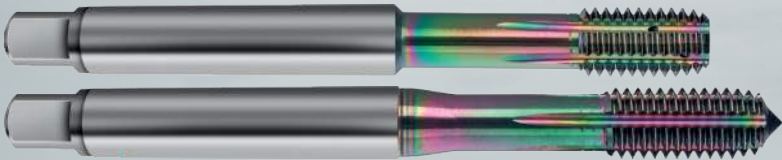
from page 26



from page 28



from page 30



from page 32



from page 34



from page 36



from page 38





RT 100 H

The drilling specialist for hardened steels




High performance
in hardened steels
up to 67 HRC

The RT 100 H is the new high-performance drill for hardened steel materials up to 67 HRC.

The tool is characterised by a newly developed cutting edge profile, which – in combination with the stable tip geometry – guarantees a very good tool life with maximum process reliability in hardened steel materials.

The extremely hard carbide substrate is used in combination with the proven nanoA coating for optimum wear resistance.

- x **Machining time** reduced by 10 %
- x **Tool life** increased by 350 %

-  X maximum process reliability
-  X coating & cutting edge geometry adapted to the machining temperature
-  X reduction of machining time



adapted cutting edge profile & design
for a long tool life in hardened steel materials

resistant to wear
nanoA coating

optimised carbide
for best possible wear resistance

available in the diameter range
3xD, Ø 3.1 – 16.0 mm

Application example

Component: Insert for punching tool, 1.2379 (61 HRC)

Tool: #7052, Ø 6.9 mm

Customer target: Increased tool life

Difficulty: Wear resistance and hardness of the component material

Cutting data:	Gühring	Competition
	v_c 30 m/min	v_c 15 m/min
	f 0.035 mm/rev without peck drilling	f 0.07 mm/rev with peck drilling

Tool life:	140 holes	40 holes
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RT 100 H Micro

High performance in the micro range





46 % shorter machining
times in steel materials
up to 67 HRC

**With the new high-performance drill
RT 100 H Micro, you can produce perfect micro-holes
in steel materials up to 67 HRC.**


The micro drill is characterised by its robust, very stable geometry with a straight main cutting edge, the extremely hard carbide substrate and the exceptionally wear-resistant Perrox coating.


Thanks to these features, the tool also shines during difficult machining operations with reduced machining times and maximum process reliability.


X **Machining time** reduced by 46 %


-  X coating & cutting edge geometry adapted to the machining temperature
-  X maximum process reliability
-  X reduction of machining time
-  X dry machining with external cooling possible for micro tools



 **adapted cutting edge profile & design**
for a long tool life in hardened steel materials

 **HiPIMS coating**
for maximum wear resistance

 **extremely hard carbide substrate**
for best possible wear resistance

 available in the diameter range
3xD, Ø 0.8–3.0 mm

Application example

Component: Perforated dies, 1.2436 (61 HRC)

Tool: #7053, Ø 1.8 mm

Customer target: Reduction of machining time

Difficulty: Effective full drilling in 61 HRC material
without cooling lubricant

Cutting data:	Gühring	Competition
	v_c 22 m/min	v_c 12 m/min
	n 3,890 rpm	n 2,122 rpm
	f 0.03 mm/rev	f 0.03 mm/rev
	v_f 117 mm/min with peck drilling	v_f 63.7 mm/min with peck drilling



RT 100 AL

Drilling specialist for non-ferrous metals

No built-up edges and
perfect chip removal

**The RT 100 AL is characterised by its round,
open point geometry and concave cutting edge shape.**

As a result, the drill ensures optimum chip formation and
safe chip removal in both wrought and cast aluminium alloys.

Furthermore, the sharp, micro-polished cutting edges
ensure smooth cutting characteristics and low process
temperatures. Combined with the polished flutes – which
further promote chip removal – the polished surfaces in
the web thinning and on the clearance faces prevent
material adhesion and minimise built-up edges.

Your advantages: With the RT 100 AL, you benefit
from maximum process reliability when machining
non-ferrous metals, even with high cutting values.

- x **Tool life** increased by 16 %
- x **Machining time** reduced by 25 %

- X** soft cut & low process temperature even in heat-treated AISi alloys
- X** fewer built-up edges & less material adhesion
- X** long tool life thanks to wear-resistant carbide grade
- X** optimum formation & removal of chips in non-ferrous metals



optimised open point geometry
for optimum chip removal

sharp, concave cutting edges
for smooth cutting characteristics & low process temperatures

polished functional surfaces
prevent material adhesion & minimise built-up edges

available in the diameter range
3xD | 5xD | 7xD, Ø 3.0–20.0 mm
12xD, Ø 3.0–16.0 mm

Application example

Component: Moulded part in the food industry, AlMg5 (3.3555)

Tool: #6062, Ø 11.8 mm

Customer target: Process-reliable and economical machining

Difficulty: Reliable chip removal with high machining parameters

Cutting data:	Gühring	Competition
v_c	250 m/min	220 m/min
f	0.35 mm/rev	0.30 mm/rev

Tool life:	4608 m	3974 m
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FB 200 U

Faster to the 180° hole base





Three-fluted flat drill
for efficient & high quality
180° holes

**Compared to conventional flat drills,
the FB 200 U can be used on flat surfaces
without any pre-drilling or feed rate reduction.**

As a result, you not only benefit from a significant reduction in machining time: In terms of hole quality, the FB 200 U is on a par with conventional two-fluted flat drills.

In contrast: With the three-fluted design, you can create significantly rounder holes with much greater dimensional accuracy and up to 50 % higher cutting values.

- x Improved **chip formation**
- x **Machining time** reduced by 47 %

-  X drilling on flat surfaces without pre-drilling or reducing the cutting values
-  X up to 50 % higher cutting values compared to two-fluted flat drills
-  X reduced process costs as inclined surfaces no longer need to be faced
-  X spot drilling without deflection on inclined & curved surfaces up to 45° with 3xD version



3 cutting edges with 180° point angle
for dimensionally accurate and round holes

available in the diameter range
~3xD | ~5xD, Ø 4.0–20.0 mm

reinforced shank transition
for greater stability

Application example

Component: Cog, 42CrMo4 surface-hardened to 60 HRC

Tool: #6065, Ø 4.2 mm

Customer target: Process-reliable drilling with short chips,
reduction of machining time

Difficulty: Chip formation, high hardness in the edge area of the
component with lower hardness inside the component

Cutting data:	Gühring	Competition
v_c	50 m/min	39.6 m/min
f	0.06 mm/rev	0.04 mm/rev



EB 100 M AL




High-performance deep hole drilling in aluminium

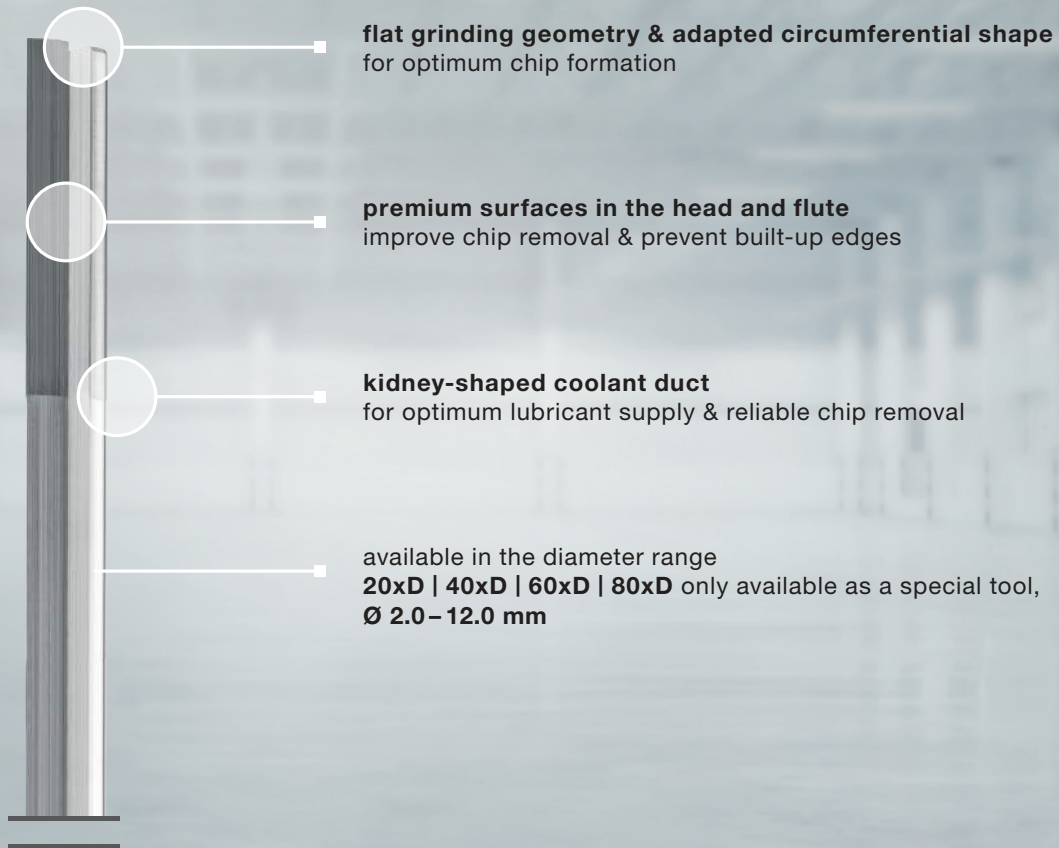
The solid carbide single-fluted deep hole drill for greater cutting performance

The solid carbide single-fluted deep-hole drill EB 100 M AL is available in the diameter range 2–12 mm and can be used in any aluminium materials without any problems.

Whether MQL or wet machining: With the aluminium specialist, you can produce hole depths of up to 80xD with just one tool. The EB 100 M AL shines with maximum process reliability and the highest possible cutting values – and guarantees the best hole quality over the entire tool life.

X **Machining time** reduced by 75 %

-  X maximum process reliability
-  X highest hole quality
-  X universal compatibility with all types of aluminium



flat grinding geometry & adapted circumferential shape
for optimum chip formation

premium surfaces in the head and flute
improve chip removal & prevent built-up edges

kidney-shaped coolant duct
for optimum lubricant supply & reliable chip removal

available in the diameter range
20xD | 40xD | 60xD | 80xD only available as a special tool,
Ø 2.0 – 12.0 mm

Application example

Component: Intermediate insert, AlZnMgCu1,5 (EN-AW-7075)

Tool: #6071, Ø 8 x 412 mm

Customer target: Reduction of cycle time while maintaining the best hole quality

Difficulty: Chip removal and concentricity

Cutting data:	Gühring	Competition
v_c	100 m/min	v_c 100 m/min
f	0.32 mm/rev	f 0.08 mm/rev



Indexable insert drill

50 % longer tool life thanks to carbide & coating

Best machining results for demanding holes

The new indexable insert drill type GMD is characterised by an extensive portfolio of carriers with economical inserts.

You can achieve the best possible surfaces and the longest tool life thanks to different carbide grades and coatings of the tougher interior cutting insert and the more wear-resistant exterior cutting insert.

Furthermore, the special geometry of the central indexable inserts guarantees good self-centring. The perfect combination of cutting inserts and high-quality carrier tools makes the indexable insert drill a reliable solution for optimum machining results.

X **Tool life** increased by 50 %

- X good self-centring thanks to special geometry of the internal cutting insert
- X different cutting materials for interior (tough) & exterior (wear-resistant) use



user-friendly **Torx Plus screw**
powerful **HiPIMS coating**

nickel-plated surface
for optimum protection against wear

high-strength cutting material
for a long tool life

available in the diameter range
2xD | 3xD | 4xD | 5xD, Ø 14.0–50.0 mm

Application example

Component: Injection mould, tool steel (X33CrS16)

Tool: #28502, Ø 28 mm

Customer target: Process reliability, longer tool life

Difficulty: Chip removal at 4xD drilling depth

Cutting data:	Gühring	Competition
v_c	170 m/min	140 m/min
f	0.18 mm/rev	0.12 mm/rev

Tool life:	60 min	40 min
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PCD face and corner milling cutter

The all-rounder for non-ferrous metals & non-metallic materials

Flexibility and economy combined

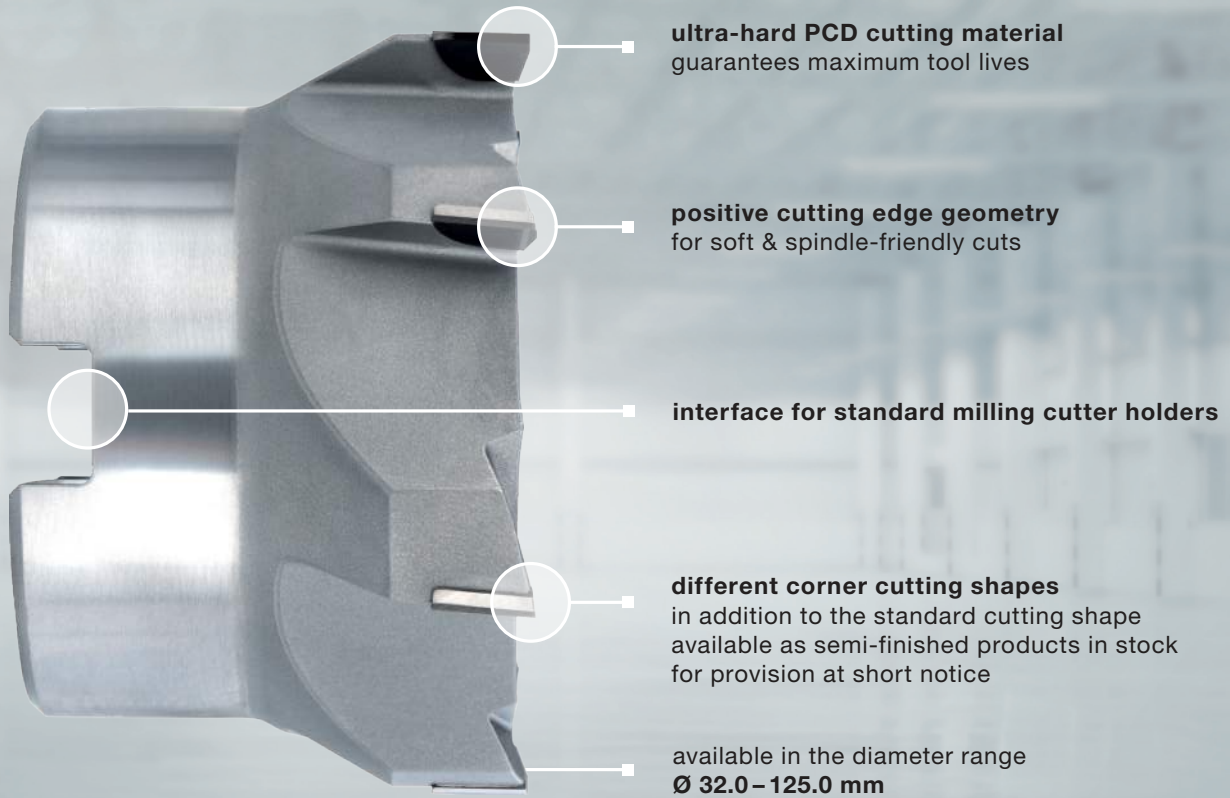
The PCD face and corner milling cutter guarantees low-burr component edges and maximum tool lives.

This is ensured by the combination of lasered cutting edges, positive positioning and the selected standard cutting shape. Its optimum face geometry allows for both helical and linear plunging into the component.

To tailor the tool perfectly to your requirements, you can choose between two variants: While the PCD face and corner milling cutter with a reduced number of cutting edges is ideally suited as a face milling tool for small and medium batch production, the variant with a higher number of cutting edges impresses with powerful spindles and maximum performance.

X Cycle time reduced by 50 %

- X ultimate flexibility
- X standard cutting shape for low-burr machining
- X soldered PCD cutting edges for easy handling



Application example

Component: Valve block, EN AW-6061-T6 (AlSi1SiCu)

Tool: #4194, Ø 50 mm

Customer target: Cycle time reduction:
one-tool roughing-finishing operation

Difficulty: Defined surface between R_a 0.4 – 0.8 mm

Cutting data:	Gühring	Competition
	v_c 1,500 m/min	v_c 1,000 m/min
	f_z 0.15 mm Z6	f_z 0.12 mm Z5



GÜHRING NAVIGATOR

Easy, quick & convenient

Our intuitive product finder guides you to the ideal tool solution and associated cutting data among 100.000 Gühring tools.

New tolerance calculator

Find the most economical dimension to achieve maximum tool life & process reliability for your desired fit:

1. Scan the QR code & open the tolerance calculator
2. Enter the desired hole tolerance
3. Select the recommended reamer
4. Buy everything you need directly in the shop



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GÜHRING

Suchen

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Navigator

- 1 Produktgruppe auswählen
- 2 Konfiguration eingeben
- 3 Werkstoff bestimmen
- 4 Werkzeug spezifizieren

01 | Produktgruppe auswählen



Bohren Gewinden Fräsen Bohren Tischbohren

02 | Anwendung



Stufenbohren





RF 100 AL Micro

Smooth milling with extreme metal removal rates





A new level of non-ferrous micro-machining

Materials in the ISO-N group are becoming increasingly important in the machining industry. They pose no problems to the RF 100 AL Micro solid carbide milling cutter, even in the micro range.

This rise in usage is due, for example, to increasing requirements in the electrical industry, as components for electric drives must be lighter and must be produced more efficiently.

With the RF 100 AL Micro, Gühring is bringing a high-end tool to the market that meets the requirements of these materials. The micro-precision milling cutter impresses with extreme metal removal rates, maximum running smoothness and perfect surfaces. And you don't have to worry about burr development or process reliability with this material specialist.

X **Machining time reduced by 76 %**

-  X significantly enhanced machining performance at medium & high speeds
-  X longer tool lives thanks to adapted carbide & Carbo+ coating
-  X new round bevel chamfer for high running smoothness & perfect finishing surfaces
-  X very high process reliability thanks to perfected cooling & chip removal



corner radius or corner chamfer
for specific requirements & wear protection

ultra-thin Carbo+ coating
for significantly increased performance & long tool lives

innovative GührJet internal cooling
for reliable chip removal

available in the diameter range
2.5xD | 5xD, Ø 0.5 – 3.0 mm

Application example

Component: Joint body, AIMGSi1

Tool: #8069, Ø 2.4 mm

Customer target: Reduction of machining time, fewer infeeds

Difficulty: 4 mm slot depth infeed in two cuts

Cutting data:	Gühring (two steps)	Competition (three steps)
v_c	240 m/min	182 m/min
n	31,800 rpm	24,000 rpm
f_z	0.053 mm/z	0.025 mm/z
v_f	5,056 mm/min	1,824 mm/min
a_p	2.4 mm (1xD)	1.8 mm (0.75xD)

Machining time: 2.4 sec

10 sec



RF 100 AL

For guaranteed perfect surfaces

30 % higher machining performance in aluminium and plastic

The new RF 100 AL solid carbide milling cutter unleashes its strengths when machining aluminium, non-ferrous metals and plastics. The three-fluted cutter scores points with the highest cutting performance as well as perfect surfaces and dimensional accuracy.

Thanks to its nano-polished round bevel support chamfer, the solid carbide milling cutter achieves the tightest tolerances and optimum running smoothness. Thanks to the large, polished flutes with a dynamic flute profile, you benefit from long tool lives and better chip removal.

The RF 100 AL with optional Carbo+ coating is ideal for dry and MQL machining. The extra-smooth coating prevents built-up edges and guarantees a long tool life.

- x **Tool life** increased by 54 %
- x **Machining time** reduced by 59 %

- X** perfect dimensional accuracy & the best surface qualities
- X** highest machining performance & perfect chip removal
- X** continuous range from 1–20 mm with corner chamfers
- X** wide range of corner radii from R 0.1–4 mm



symmetrical drill face
for plunging

nano-polished round bevel support chamfer
for optimum running smoothness & tightest tolerances

dynamic flute profile
with polished surface & reinforced core

3 different production lengths
with neck clearance (short, medium, long)

Application example

Component: Integral component, AlCuMg1

Tool: #8240, Ø 12 mm

Customer target: Running time reduction

Difficulty: The component contains thin-walled, vibration-sensitive lands

Cutting data:	Gühring	Competition
	v_c 546 m/min	v_c 452 m/min
	n 14,500 rpm	n 12,000 rpm
	v_f 5,220 mm/min	v_f 3,600 mm/min
	a_e 2.5 mm	a_e 1.5 mm

Tool life:	485 m	315 m
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Solid carbide single-fluted cutter AL

Low-burr milling in aluminium

Solid carbide single-fluted
cutter for burr-free aluminium
profile machining




Be it in e-mobility, aviation or mechanical engineering – demand for aluminium components is not only increasing all the time, but also its use is growing across a wide range of industries. A case for the solid carbide single-fluted cutter AL.

With its large, polished flutes, the tool ensures excellent chip removal during aluminium and plastic machining, ensuring a safe machining process. Thanks to its very positive geometry, you can achieve an easy, low-burr cut with the lowest power consumption when machining aluminium profiles.

And you don't have to worry about wear either: The thin Carbo+ coating keeps the cutting edges extremely sharp. This makes the solid carbide single-fluted cutter ideal for dry and MQL machining.

The tool is available in four designs, including an extra-long design with neck clearance.

x Tool life increased by 51 %

-  X low-burr cut & best possible surfaces
-  X low power consumption
-  X reliable chip removal



Application example

Component: Special AL profile for tent construction (anodised), AlMgSi05

Tool: #8138, Ø 10 mm

Customer target: Burr-free and rework-free cutting edges

Difficulty: Due to the anodised layer, conventional milling cutters suffer wear and produce burrs & poor surfaces

Cutting data:	Gühring	Competition
v_c	785 m/min	v _c 785 m/min
n	24,990 rpm	n 24,990 rpm
f	1,960 mm/min	f 1,273 mm/min

Tool life:	355 m	235 m
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**High-speed milling cutter
with indexable inserts**



Four cutting edges for the best possible results

Maximum removal rates
thanks to stable cutting insert

When maximum cost-effectiveness and process reliability are required for roughing with high chip removal rates, the GHM high-speed milling cutter with indexable inserts is the first choice.

This is ensured by the stable and high-quality holder tools, equipped with double-sided cutting plates. These high-performance cutting plates impress with four usable cutting edges and ensure the best machining results.

X Machining time reduced by 25 %

-  X double-sided indexable insert with four usable cutting edges
-  X two different types of inserts for ISO P & K and ISO M & S



Application example

Component: Injection moulding tool, Toolox33

Tool: #28001, Ø 25 mm

Customer target: Reduction of machining time

Difficulty: Dry machining, cooling with air

Cutting data:	Gühring	Competition
	v_c 200 m/min	v_c 180 m/min
	f_z 1.2 mm	f_z 1.0 mm
	a_p 0.9 mm	a_p 0.8 mm



Modular tap

Most economically possible threads

The perfect combination of toughness & wear resistance





Maximum economic efficiency & flexibility:

These are the two hallmarks of modular taps by Gühring, which combine the advantages of the two cutting materials – HSS and carbide.

While the HSS tool shank can be used several times, only the tool head needs to be changed at the end of the tool life.

This thread head is made of carbide and offers a high level of wear protection thanks to the fire coating. As a result, you not only halve your cycle times, but also multiply your tool lives – and manufacture for the lowest cost per component.

- x **Tool life** increased 16-fold
- x **Machining time** reduced by 40 %

-  X easy-to-install insert system reduces costs
-  X at the end of the tool life, only the thread head needs to be replaced
-  X multiple use of the HSS tool shank
-  X use of a carbide tool even under unstable conditions



replaceable carbide thread head
for up to 16 times the tool life

Fire coating
for high wear resistance

M12 – M30
MF12x1.5 – MF30x1.5

HSS shank
reduces costs as it can be used multiple times

Application example

Component: Differential housing, GG20

Tool: #6120, M20

Customer target: Increased tool life and reduced machining time

Difficulty: Sub-optimal conditions

Cutting data:	Gühring	Competition
	v_c 25 m/min	v_c 15 m/min

Tool life:	36,000 threads	2,220 threads
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Machining time:	38 sec	63 sec
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Tap AL Fluteless tap AL

No chance for built-up edges & material adhesion





Extra smooth coating
for maximum tool lives

**Whether you are thread tapping or fluteless tapping –
with these aluminium specialists, you can produce
perfect threads at the highest cutting speeds.**

Thanks to the optimum combination of geometry and
coating, almost all aluminium and cast aluminium alloys
can be easily processed with AL taps and fluteless taps.

The new Carbo+ coating prevents built-up edges
and material adhesion – and ensures high durability
and process reliability.

- x **Cycle time** reduced by 25 %
- x **Tool life** increased by 30 %

-  X maximum process reliability & tool life thanks to Carbo+ coating
-  X fewer built-up edges & less material adhesion
-  X high cutting speeds during aluminium machining
-  X targeted lubricant distribution through internal cooling with radial coolant ducts



radial coolant ducts
for optimum distribution of the lubricant during fluteless tapping

new Carbo+ coating
ensures long tool lives

M3-M16

adapted solid carbide
for maximum cutting performance

Application example

Component: Connection block pneumatics, EN AW-6063 (AlMg0,7Si)

Tool: #4671 Tap AL, M3

Customer target: Reliable threading with the highest performance in terms of tool life and cycle time

Difficulty: Prevent material adhesion and remove chips reliably

Cutting data:	Gühring	Competition
	v_c 20 m/min	v_c 15 m/min

Tool life:	3250 threads	2500 threads
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Fluteless tap InoxPro

Perfect dimensional accuracy

Up to twice the tool life
in stainless steel

With the new InoxPro fluteless tap, you can overcome stainless steel challenges with maximum process reliability.

This is ensured by its perfectly synced macro and micro geometry with optimised oil groove geometry and polygon shape. In addition, the particularly smooth and temperature-resistant coating minimises tool wear during fluteless tapping.

With the InoxPro fluteless tap, you can also rest assured that you'll enjoy the highest tool life and perfect dimensional accuracy for your threads in combination with water-mixed emulsions.

x **Tool life** increased by 50 %

- X** outstanding tool lives thanks to smooth & temperature-resistant AlCrN coating
- X** reliable fluteless tapping, even with water-mixed emulsions
- X** optimised oil groove geometry & polygon shape for perfect thread quality



optimised macro geometry
for maximum process reliability

internal cooling from M5

powerful
HiPIMS AlCrN coating

available in the diameter range
M2 – M12 | MF6x0.75 – MF20x1.5

Application example

Component: Valve body, stainless steel (1.4301/ X5CrNi18-10)

Tool: #8100, M8

Customer target: Maximum tool life in large-scale batch production

Difficulty: Difficult deformability of stainless steel
due to high elongation at break coefficient

Cutting data:	Gühring	Competition
v_c	6 m/min	6 m/min
a_p	20 mm	20 mm
v_f	298 mm/min	298 mm/min

Tool life:	30 min	20 min
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HR 500

The perfect fit for any diameter range





Up to 50 x faster than conventional reamers

The high-performance reamers from the HR 500 family are characterised by maximum performance and precision.

While conventional fixed sizes offer a range of ± 0.03 and in 10μ increments, Gühring is expanding the fixed-size series to a range of ± 0.05 and in 5μ increments. In this way, we now also cover numerous tolerances outside the H7 class and are the only tool manufacturer to close this gap in the market.

Gühring is also expanding the HR 500 range with a material specialist for aluminium and a compact dimension for machining in limited installation space.

- x **Tool life** increased by 100 %
- x **Machining time** reduced by 87.5 %

-  X precise reaming without compromises or expensive custom-made products
-  X 100 % more wear buffer and longer tool lives thanks to finer increments
-  X programme covers numerous tolerances even outside the H7 range
-  X universally applicable in a wide range of materials



extremely unequal blade pitch
for a smooth cut & excellent surface finishes

nanoA coating prevents built-up edges
and ensures maximum process reliability

available in the diameter range
Ø 1.95 – 12.05 mm

intermediate dimension in 5 µ increments
provides more wear buffer

Application example

Component: Mould insert, hardened steel (1.2399)

Tool: #1676, Ø 10 mm

Customer target: Increased tool life

Difficulty: Premature wear, insufficient dimensional accuracy

Cutting data:	Gühring	Competition
	v_c 50 m/min	v_c 10 m/min
	n 1,590 rpm	n 320 rpm
	v_f 500 mm/min	v_f 65 mm/min

Tool life:	230 min	115 min
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Grooving tools

High flexibility when grooving and parting off




System 222 for grooving and parting off has been expanded

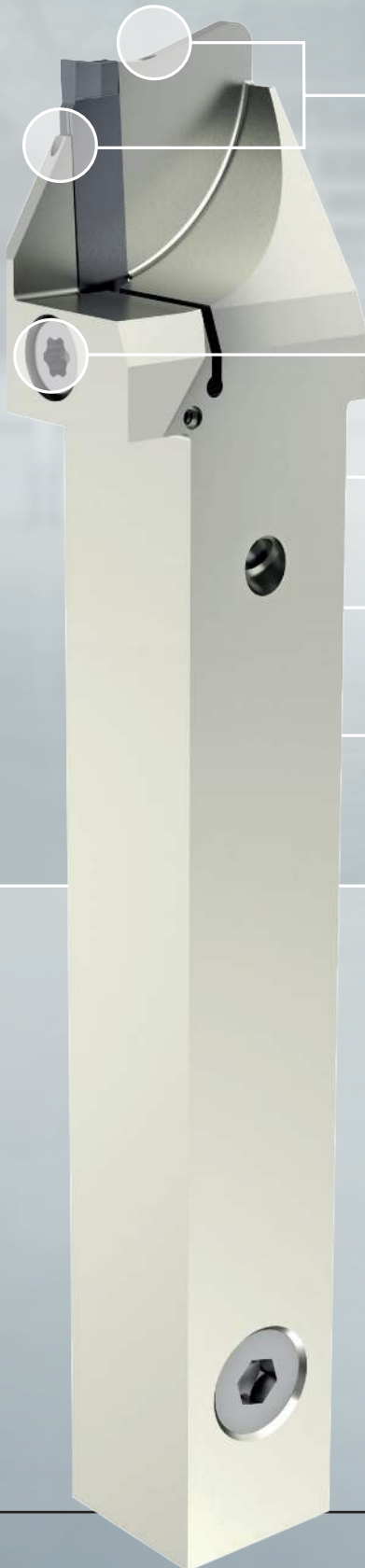
Optimised head length for tight spaces in sliding headstock lathes.

Even more flexibility when grooving and parting off:
This is ensured by the new tool holders with an optimised head length, which are ideally suited for narrow spaces in sliding headstock lathes.

They are characterised by their newly developed clamping screw with Torx Plus on both sides in the same size.
This allows the indexable inserts to be clamped from both the top and bottom.

x Tool life increased by 80 %

-  X long tool life
-  X maximum stability
-  X reliable chip removal



■ **optimised IC supply**
on the clearance & rake face

■ **Torx Plus screw on both sides**
enables clamping from above and below

■ **nickel-plated surface**
for optimum protection against wear

■ **high-strength cutting material**
for a long tool life

■ **various designs**
for 2 mm insert width

Application example

Component: Drive shaft, 42CrMo4

Tool: Indexable insert: 26601 22,020; holder: 26106

Customer target: Surface finish of $R_z = 3-6 \mu\text{m}$,
very good chip constriction, consistent tool life

Difficulty: Tool life fluctuating, approx. 500 parting cuts, poor surface
 $R_z = 8-15 \mu\text{m}$; chip constriction too low

Cutting data:	Gühring	Competition
v_c	170 m/min	v_c 170 m/min
f	0.10 rev	f 0.08 rev

Tool life:	900 parting cuts	500 parting cuts
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