

## RT 100 VA

For the production of accurate holes in stainless steels with highest cutting rates and long tool life, Guhring has developed the new RT 100 VA. The RT 100 VA achieves its extraordinary efficiency thanks to

- carbide developed for the machining of stainless steels
- the TiAlN nanoA wear resistant coating
- tool geometry perfected for the machining of stainless steels

In addition, the high feed rates achievable with the RT 100 VA are thanks to the optimal heat dissipation via the chips. Additionally the highly effective coolant supply via the internal coolant ducts, having maximum cross section, supports the heat dissipation as well as chip evacuation and also counteracts the risk of localised hardening.

### The program

The RT 100 VA is available in four designs as part of the standard program:

Standard	Type	Shank form	Cooling	Cutting direction	Drilling depth	Tolerance	Tool description	Tool material	Surface finish	Diameter	Guhring no.
DIN 6537 K	RT 100 VA	HA			3xD	m7		Solid carbide	TiAlN nanoA	3,00 - 20,00	8510
DIN 6537 K	RT 100 VA	HE			3xD	m7		Solid carbide	TiAlN nanoA	3,00 - 20,00	8610
DIN 6537 L	RT 100 VA	HA			5xD	m7		Solid carbide	TiAlN nanoA	3,00 - 20,00	8511
DIN 6537 L	RT 100 VA	HE			5xD	m7		Solid carbide	TiAlN nanoA	3,00 - 20,00	8611

### Special solutions

Furthermore, we supply intermediate sizes or step drills as special tools for your specific application tasks on request. Designs are also possible for drilling depths in excess of 5xD. Complete the form on page 16 or contact us!

### Notes regarding application

A cutting speed should be chosen out of the Navigator and can greatly depend on the material composition. Machining tests are paramount for selecting the optimal cutting speed.

Due to the high cutting load particular attention must be paid to maximum rigidity of the machine as well as the workpiece and tool clamping. Always select the shortest possible tool for your machining task.

### Application recommendations for Guhring RT 100 high-performance Ratio drills

Recommendations regarding tool suitability for the following application groups can be found on the following price and program pages:

- optimal suitability
- limited suitability
- not suitable

Application group	Material examples
P	Steel, high-alloyed steel
M	Stainless steel
K	Grey cast iron, spheroidal and malleable cast iron
N	Aluminium and other non-ferrous metals
S	Special-, super- and Ti-alloys
H	Hardened steel and hard cast iron

Pictograms see page 14