

RPM = $\frac{SFM}{DIAM. in.} \times 3.82$ IPM = IPR x RPM

для размещения заказа - guhring@guhring-tools.ru
 HOLE DEPTH in. x 60 = Cut Time mm = in. x 25.40

m/min. = SFM ÷ 3.28 Bar = PSI ÷ 14.50
 mm/rev. = IPR x 25.40 Liter = Gal. ÷ 3.79

Series # 527

Material group	Hardness	SFM	Feed Rate - IPR									
			1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	≤100 Bhn >100-260 Bhn	70 55	•	•	•	0.0080	0.0100	0.0100	0.0110	0.0125	•	•
Free-cutting steels	≤24 Rc >24-30 Rc	70 55	•	•	•	0.0080	0.0100	0.0100	0.0110	0.0125	•	•
Unalloyed heat-treatable steels	≤16 Rc 16-24 Rc 24-30 Rc	70 55 •	•	•	•	0.0065	0.0080	0.0080	0.0090	0.0100	•	•
Alloyed heat-treatable steels	24-30 Rc >30-38 Rc	35 •	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Unalloyed case hardened steels	≤230 Bhn	70	•	•	•	0.0080	0.0100	0.0100	0.0110	0.0125	•	•
Alloyed case hardened steels	24-30 Rc >30-38 Rc	30 •	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Nitriding steels	≥24-30 Rc >30-38 Rc	25 •	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Tool steels	≤24 Rc >24-30 Rc	35 15	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
High speed steels	≥14-30 Rc	15	•	•	•	0.0040	0.0050	0.0050	0.0055	0.0065	•	•
Spring steels	≤330 Bhn	•	•	•	•	•	•	•	•	•	•	•
Stainless steels, sulphured austenitic martensitic	≤24 Rc • • •	25 • • •	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Hardened steels	≤40-48 Rc >48-60 Rc	• •	•	•	•	•	•	•	•	•	•	•
Special alloys	≤38 Rc	•	•	•	•	•	•	•	•	•	•	•
Cast iron	≤240 Bhn <300 Bhn	70 55	•	•	•	0.0080	0.0100	0.0100	0.0110	0.0125	•	•
Spheroidal graphite iron and malleable cast iron	≤240 Bhn <300 Bhn	65 45	•	•	•	0.0080	0.0100	0.0100	0.0110	0.0125	•	•
Chilled cast iron	≤350 Bhn	•	•	•	•	•	•	•	•	•	•	•
Ti and Ti-alloys	≤24 Rc >24-38 Rc	• •	•	•	•	•	•	•	•	•	•	•
Aluminium and Al-alloys	≤120 Bhn	•	•	•	•	•	•	•	•	•	•	•
Al wrought alloys	≤150 Bhn	•	•	•	•	•	•	•	•	•	•	•
Al cast alloys ≤ 10 % Si > 10 % Si	≤200 Bhn 115	145 115	•	•	•	0.0100	0.0125	0.0125	0.0140	0.0160	•	•
Magnesium alloys	≤150 Bhn	180	•	•	•	0.0080	0.0100	0.0100	0.0110	0.0125	•	•
Copper, low-alloyed	≤120 Bhn	70	•	•	•	0.0065	0.0080	0.0080	0.0090	0.0100	•	•
Brass, short-chipping long-chipping	≤200 Bhn • •	• • 90	•	•	•	•	•	•	•	•	•	•
Bronze, short-chipping	≤200 Bhn >200-260 Bhn	70 65	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Bronze, long-chipping	≤24 Rc >24-30 Rc	55 •	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Duroplastics	-	35	•	•	•	0.0050	0.0065	0.0065	0.0070	0.0080	•	•
Thermoplastics	-	55	•	•	•	0.0065	0.0080	0.0080	0.0090	0.0100	•	•
Reinforced plastics - Kevlar	-	•	•	•	•	•	•	•	•	•	•	•
Reinforced plastics - GFK / CFK	-	•	•	•	•	•	•	•	•	•	•	•

Series # 530

Material group	Hardness	SFM	Feed Rate - IPR									
			1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	≤100 Bhn >100-260 Bhn	160 130	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	•	•	•	•
Free-cutting steels	≤24 Rc >24-30 Rc	195 160	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	•	•	•	•
Unalloyed heat-treatable steels	≤16 Rc 16-24 Rc 24-30 Rc	130 130 100	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	•	•	•	•
Alloyed heat-treatable steels	24-30 Rc >30-38 Rc	100 100	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	•	•	•	•
Unalloyed case hardened steels	≤230 Bhn	130	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	•	•	•	•
Alloyed case hardened steels	24-30 Rc >30-38 Rc	80 65	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	•	•	•	•
Nitriding steels	≥24-30 Rc >30-38 Rc	65 65	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	•	•	•	•
Tool steels	≤24 Rc >24-30 Rc	80 65	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	•	•	•	•
High speed steels	≥14-30 Rc	65	0.0010	0.0025	0.0040	0.0050	0.0065	0.0065	•	•	•	•
Spring steels	≤330 Bhn	35	0.0007	0.0020	0.0030	0.0040	0.0050	0.0050	•	•	•	•
Stainless steels, sulphured austenitic martensitic	≤24 Rc • • •	65 45 65	0.0012	0.0030	0.0050	0.0065	0.0080	0.0080	•	•	•	•
Hardened steels	≤40-48 Rc >48-60 Rc	• •	•	•	•	•	•	•	•	•	•	•
Special alloys	≤38 Rc	40	0.0007	0.0020	0.0030	0.0040	0.0050	0.0050	•	•	•	•
Cast iron	≤240 Bhn <300 Bhn	145 115	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	•	•	•	•
Spheroidal graphite iron and malleable cast iron	≤240 Bhn <300 Bhn	130 100	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	•	•	•	•
Chilled cast iron	≤350 Bhn	•	•	•	•	•	•	•	•	•	•	•
Ti and Ti-alloys	≤24 Rc >24-38 Rc	• •	•	•	•	•	•	•	•	•	•	•
Aluminium and Al-alloys	≤120 Bhn	•	•	•	•	•	•	•	•	•	•	•
Al wrought alloys	≤150 Bhn	•	•	•	•	•	•	•	•	•	•	•
Al cast alloys ≤ 10 % Si > 10 % Si	≤200 Bhn 260	295 260	0.0020	0.0065	0.0100	0.0125	0.0160	0.0160	•	•	•	•
Magnesium alloys	≤150 Bhn	260	0.0017	0.0050	0.0080	0.0100	0.0125	0.0125	•	•	•	•
Copper, low-alloyed	≤120 Bhn	•	•	•	•	•	•	•	•	•	•	•
Brass, short-chipping long-chipping	≤200 Bhn • •	• • •	•	•	•	•	•	•	•	•	•	•
Bronze, short-chipping	≤200 Bhn >200-260 Bhn	• •	•	•	•	•	•	•	•	•	•	•
Bronze, long-chipping	≤24 Rc >24-30 Rc	• •	•	•	•	•	•	•	•	•	•	•
Duroplastics	-	•	•	•	•	•	•	•	•	•	•	•
Thermoplastics	-	•	•	•	•	•	•	•	•	•	•	•
Reinforced plastics - Kevlar	-	•	•	•	•	•	•	•	•	•	•	•
Reinforced plastics - GFK / CFK	-	•	•	•	•	•	•	•	•	•	•	•