

Ratio Drills

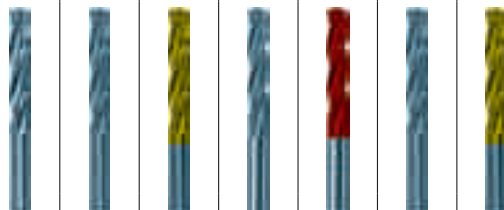
≤3×D

Tool material	Carbide	
Carbide grade	K	
Type	GS 200 G	
Surface finish	○	
Cooling	☒	
Guhr.no	DIN 6537 HA R	745
	DIN 6539 DZ	1020



≤5×D 3-fluted

Carbide						
K	K	K/P	K	K/P	K	K/P
GS 200 G	GS 200 G	GS 200 F	FT 200 G	FT 200 G	GS 200 U	GS 200 U
○	○	○	○	●	○	●
☒	☒	☒	☒	☒	☒	☒
			2713/5518	2939		
1024	1025	1027			731	611
					1021	



Material chart page 5

v _c m/min	Feed column no.
100	6
80	6
80	6
70	6
180	7
160	7
150	7
120	6
180	6
180	6

○	●	●	Feed column no.			
v _c m/min	v _c m/min	v _c m/min				
80	100			5		5
65	85			4		4
90	110			6		6
75	95			5		5
70	90			5		5
65	85			5		5
60	80			5		5
60	80			5		5
50	70			4		4
80	100			6		6
60	80			5		5
50	70			4		4
55	75			4		4
50	70			4		4
45	50			4		4
35	40			4		4
30	35			3		3
100	140	145	6	6	6	6
80	100	105	6	6	6	6
80	100	105	6	6	6	6
70	90	95	6	6	6	6
180	200	230		7	7	7
160	180	200		7	7	7
150	170	190	7	7	7	7
120	140	155	6	6	6	6
180	200	215	6	6	6	6
		250				
180	210	220	6	6	6	6

○ bright ● steam tempered ● nitrided lands ● nitrided ● golden brown ● TiAIN