

≤5×D Drilling depth

Tool holders ≤3×D Guhring no. 4108



Guhring no.
Tool material
Carbide grade
Surface finish

4112
Carbide
K/P
●
especially for machining of steel

Guhring no.
Tool material
Carbide grade
Surface finish

4113
Carbide
K/P
●
especially for machining of cast materials

Guhring no.
Tool material
Carbide grade
Surface finish

4114
Carbide
K
○
especially for machining of aluminium and Al-alloys

Material chart page 5

V_c m/min	Feed column no.
125	6
105	5
125	7
105	6
125	6
120	6
105	5
105	6
85	5
125	7
105	6
70	4
105	5
70	4
55	5
50	4
55	3
50	2
55	3
40	3
35	3
25	2
25	2

V_c m/min	Feed column no.
100	6
90	6
80	5
80	5
80	5
80	5
80	5
120	7
100	6
90	6

V_c m/min	Feed column no.
180	7
180	7
140	7
110	7
180	7
70	6
180	7
120	6
70	6
50	6
45	6
35	5

○ bright

● steam tempered

● nitrided lands

● nitrided

● golden brown

ⓐ TiAlN