




Interchangeable inserts

Tool material
Carbide grade
Surface finish
Guhring no.

Carbide		
K	K/P	K/P
○	Ⓢ	●
2747	1047	2485
		
cast iron, aluminium and Al-alloys		general steels

- for through holes supporting lands must remain in permanent contact.
- for 7 x D, centering is recommended with similar point angle of 140°, or larger, to min. 2/3 cutting edge diameter.
- interrupted cutting (grooves, transverse holes) is not recommended without prior tests. For interrupted cutting (max. 0.2xD) it is recommended to reduce the feed rate whenever possible.
- in contrast to conventional indexable inserts, RT 800 is also suitable for the drilling of stacked sheets.
- when replacing the inserts, it is recommended to also replace the original clamping screw with the included polyamide coated screw.

especially for machining of

Tool holder

$\leq 3 \times D$

Cooling		Guh. no.		5242	
with interchangeable inserts:		○		●	
v _c m/min		Feed col. no.			
100	130	6			
85	110	5			
100	130	7			
85	110	6			
100	130	6			
95	125	6			
85	110	5			
85	110	6			
70	90	5			
100	130	7			
85	110	6			
55	70	4			
80	105	5			
55	70	4			
40	55	5			
35	50	4			
40	55	3			
35	50	2			
40	55	3			
30	40	3			
25	35	3			
20	25	2			
20	25	2			
100	160	210	7		
80	120	155	7		
80	120	155	7		
70	100	130	6		
10	25	35	2		
30	40	3			
25	35	2			
200	220	290	7		
180	200	260	7		
150	180	235	7		
120	150	195	7		
180	200	260	7		
70	80	105	6		
180	210	270	7		
120	140	180	6		
70	80	105	6		
50	65	85	6		
45	50	65	6		
35	40	55	5		
50	80	105	5		
50	80	105	5		
50	80	105	5		
50	80	105	5		



$\leq 5 \times D$

Cooling		Guh. no.		5243	
with interchangeable inserts:		○		●	
v _c m/min		Feed col. no.			
95	125	6			
80	105	5			
95	125	7			
80	105	6			
95	125	6			
90	120	6			
80	105	5			
80	105	6			
65	85	5			
95	125	7			
80	105	6			
55	70	4			
80	105	5			
55	70	4			
40	55	5			
35	50	4			
40	55	3			
35	50	2			
40	55	3			
30	40	3			
25	35	3			
20	25	2			
20	25	2			
90	150	195	7		
70	110	145	7		
70	110	145	7		
60	90	120	6		
10	25	35	2		
30	40	3			
25	35	2			
180	200	260	7		
180	200	260	7		
140	170	220	7		
110	140	180	7		
180	200	260	7		
70	80	105	6		
180	210	270	7		
120	140	180	6		
70	80	105	6		
50	65	85	6		
45	50	65	6		
35	40	55	5		
50	80	105	5		
50	80	105	5		
50	80	105	5		
50	80	105	5		



$\leq 7 \times D$

Cooling		Guh. no.		5248	
with interchangeable inserts:		○		●	
v _c m/min		Feed col. no.			
90	120	5			
80	105	4			
90	120	6			
80	105	5			
90	120	5			
85	110	5			
75	100	4			
75	100	5			
65	85	4			
90	120	6			
75	100	5			
55	70	4			
80	105	4			
55	70	3			
40	55	4			
35	50	3			
40	55	2			
35	50	2			
40	55	2			
30	40	2			
25	35	2			
20	25	1			
20	25	1			
90	150	195	6		
70	110	145	6		
70	110	145	6		
60	90	120	5		
10	25	35	2		
30	40	2			
25	35	1			
180	200	260	6		
180	200	260	6		
140	170	220	6		
110	140	180	6		
180	200	260	6		
70	80	105	5		
180	210	270	6		
120	140	180	5		
70	80	105	5		
50	65	85	5		
45	50	65	5		
35	40	55	4		
50	80	105	4		
50	80	105	4		
50	80	105	4		
50	80	105	4		



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