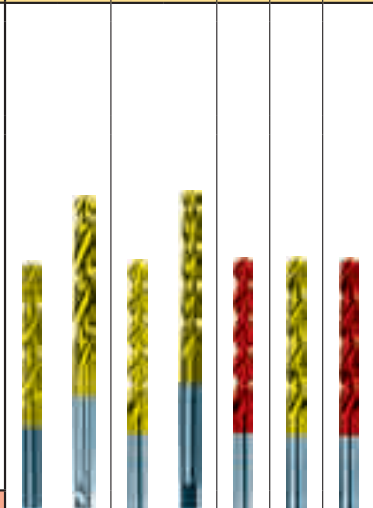




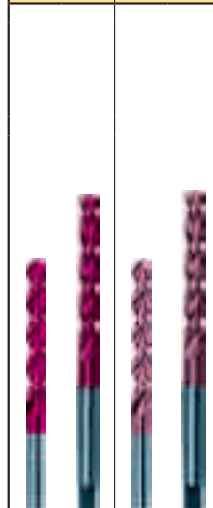
# $\leq 5 \times D$ drilling depth

Tool material		HSCo				
		N	GT 100	Ti		
Surface finish		(S)	(S)	(P)	(S)	(P)
str.	DIN 338	2997	658	2459	657	2458
MT	DIN 345	R				
		661	662			



(S)	(P)	Feed column no.				
V <sub>c</sub> m/min	V <sub>c</sub> m/min					
38	42	6	6	6		
33	36	5	5	5		
44	48	5	5	6		
38	42	5	5	6		
44	48					
44	48	5	5	6		
38	42	4	4	5		
27	30	4	4	5	3	4
22	34	3	3	4		
44	48	4	4	6		
22	24	4	4	5		
18	20	3	3	4		
22	24	4	4	5		
18	20	3	3	4		
19	21	4	4	5		
14	16	3	3	4		
14	17	3	3	4	3	4
9	11	2	2	3	2	2
20	22	4	4	5	4	5
15	17	3		4	3	3
18	20		3	4	3	4
4	6			1		
6	7				2	2
40	45	6	6	7		
35	40	6	6	7		
33	36	6	6	7		
27	29	6	6	7		
12	14			4	3	3
11	12				2	2
7	8				2	2
	85			8		
	72			7		
88	96	5	5	6		
40	45	4				
22	25	4	4	5		
17	20	4	4	5	4	4
22	24	4	4	5		

HSCo	
GT 100	
(A)	(C)
1223	1221
1224	1222



V <sub>c</sub> m/min	Feed column no.	
42		6
36		6
48		6
42	5	6
48		
48		
42		5
30		5
34		4
48		7
24		5
20		4
20		5
15		4
21		5
16		4
17		4
11		3
22		5
18		4
45	7	
40	7	
36	7	
29	7	
85	7	
96	6	
25	5	
20	5	
24	5	

HSCo
P2000
(O)
2047



V <sub>c</sub> m/min	Feed col. no.
35	6
30	5
40	6
40	5
40	5
40	5
35	4
25	4
20	3
40	6
20	4
15	3
20	4
15	3
18	4
12	3
12	3
8	2
14	4
10	3
12	3
5	2
38	6
30	6
30	6
25	6
10	3
90	7
90	7
80	7
70	6
85	6
80	5
70	5
40	5
40	4
30	4
25	4
15	4
20	4
25	5

(A) AITIN

(C) TiCN

(P) FIRE

(P) AlCrN

(S) TiN

(M) MolyGlide

\* Use bright finish drills or use drills with bright polished flutes.

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