

HT 800 WP - Application Tips

Please observe the following notes and recommendations for the application of Guhring's HT 800 WP tools:

We recommend when changing the insert to also replace the clamping screw!

Therefore, every holder is supplied with a clamping screw, Guhring no. 4071, and screwdriver, Guhring no. 1612. Every interchangeable insert is also supplied with a clamping screw, Guhring no. 4071.

When changing the insert please observe the following tightening torques for the clamping screw. Adhering to them is absolutely necessary for optimal machining results!

Diameter range	11.0 - 12.99	13.0 - 13.99	14.0 - 15.99	16.0 - 17.99	18.0 - 19.99	20.0 - 21.99	22.0 - 25.99
Thread	M2.2	M2.5	M3	M3.5	M4	M4.5	M5
Torx size	T7	T8	T9	T10	T15	T15	T20
Tightening torque[Ncm]	80	100	170	270	400	580	810

Details apply to thread locking (Loctite)!

Selected machining results

Guhring no.	4107 + 4112	4109 + 4112	4109 + 4112	4107 + 4113	4108 + 4113
Diameter	17.5	17.5	17.5	17.5	14.1
Coating	nanoFIRE	nanoFIRE	nanoFIRE	FIRE	FIRE
Material group	alloyed heat-treatable steel	alloyed heat-treatable steel	general structural steels	cast iron	cast iron
Material description	42CrMo4/ 1.7275	42CrMo4/ 1.7275	St52-3/ 1.0570	GG25/ 0.6025	GGG40/ 0.7040
Drill. depth [mm]	50	122,5	122,5	50	70
Hole type	blind hole	blind hole	blind hole	blind hole	blind hole
Cooling	IC 40 bar	IC 40 bar	IC 40 bar	IC 40 bar	IC 55 bar
Coolant	soluble oil	soluble oil	soluble oil	soluble oil	soluble oil
Machine type	machining centre	machining centre	machining centre	machining centre	machining centre
v_c [mm/min]	100	85	130	80	160
f_z [mm]	0,28	0,25	0,15	0,30	0,60
Tool life [m]	50	30	35	250	120

