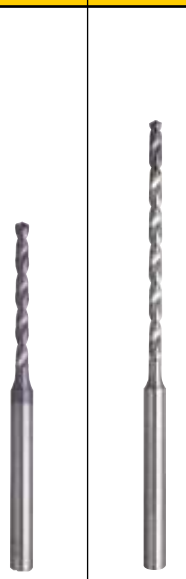
EXCLUSIVELINE®

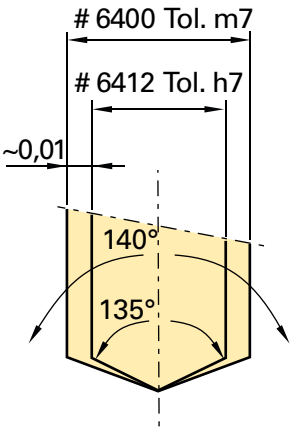
Made by Guhring

Tool material	Solid carbide		Solid carbide	
Surface finish	Super A		Super A	
Cooling	☒		■	
Drilling depth	~ 4 x D	~ 7 x D	~ 8 x D	~ 15 x D
Guhring no.	**6400**	**6401**	**6408**	**6412**
				

v_c m/min	Feed column no.		v_c m/min	Feed column no.	
90-120	**64**	**62**	*90-120*	**58**	**58**
90-110	**64**	**62**	*90-110*	**58**	**58**
90-120	**64**	**62**	*90-120*	**59**	**59**
80-100	**63**	**61**	*80-100*	**59**	**59**
80-110	**64**	**62**	*80-110*	**58**	**58**
80-110	**64**	**62**	*80-110*	**58**	**58**
80-100	**63**	**61**	*80-100*	**58**	**58**
80-100	**63**	**61**	*80-100*	**58**	**58**
60-80	**62**	**60**	*60-80*	**58**	**58**
90-110	**63**	**61**	*90-110*	**57**	**57**
70-100	**63**	**61**	*70-100*	**58**	**58**
60-80	**62**	**60**	*60-80*	**58**	**58**
60-80	**62**	**60**	*60-80*	**57**	**57**
50-70	**62**	**60**	*50-70*	**57**	**57**
40-60	**62**	**60**	*40-60*	**58**	**58**
40-60	**62**	**60**	*40-60*	**58**	**58**
40-60	**57**	**57**	*40-60*	**57**	**57**
40-60	57	57	*40-60*	57	57
30	**57**	**57**	*60-80*	**57**	**57**
15	**56**	**56**	*60*	**56**	**56**
30	**57**	**57**	*60-80*	**57**	**57**
10	56	56	*25*	56	56
<150	**68**	**66**	*<150*	**60**	**60**
<140	**68**	**66**	*<140*	**60**	**60**
<140	**68**	**66**	*<140*	**60**	**60**
<130	**67**	**65**	*<130*	**60**	**60**
15	56	56	*35*	56	56
15	56	56	*35*	56	56
60-80	68	68	*60-80*	68	68
60-80	68	68	*60-80*	68	68
120-150	59	59	*120-150*	59	59
120-150	59	59	*120-150*	59	59

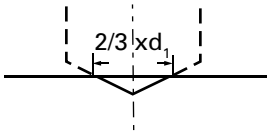
Pilot drilling

For the application of solid carbide micro-precision drills 15xD we recommend a pilot hole 1xD up to 2xD depth. For this pilot hole, the solid carbide micro-precision drill 4xD is optimally suitable. Its point angle and its diameter tolerance are perfectly adapted.



Centering

In order to achieve full performance with solid carbide micro-precision drills from 8xD drilling depth, we recommend centering.
The ExclusiveLine solid carbide micro-precision drill up to 4xD, Guhring no. 6400, can be applied for this purpose. The centering diameter should be approximately $^2/_3$xD.



Filter quality

When applying solid carbide micro-precision drills we recommend constant monitoring of the lubricant's filter quality due to the extremely small coolant duct diameters, for example with our check instrument CC 3000.