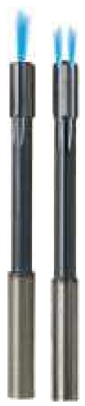
EXCLUSIVELINE®

HR 500 solid carbide high-performance reamers
Application examples and special solutions

Carb./K10
Carbo
1678
1679

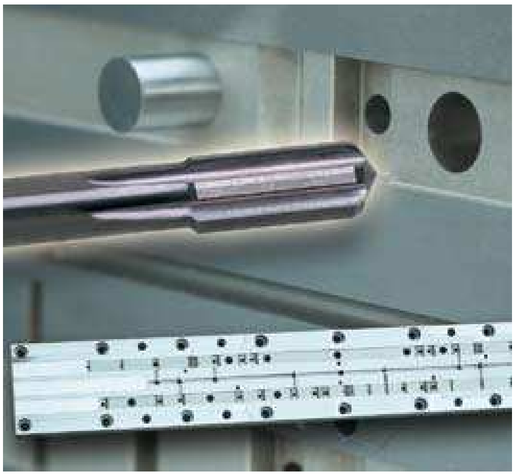


vc m/min	Feed column no.
200-400	76-77
200-400	76-77
200-400	76-77
200-400	76-77

Application examples for Guhring's new HR 500 S and HR 500 D solid carbide high-performance reamers with highest feed rates and tool life

The new HR 500 S and HR 500 D solid carbide high-performance reamers have shown their performance in several applications, see following table:

Tool type	HR 500 S	HR 500 D	HR 500 D	HR 500 S
Guhring no.	1685	1686	special reamer for tighter tolerances	1685
component machined	hinge	ring	valve body	ring
workpiece material	gen. steel	alloyed steel	gen. steel	alloyed steel
hole diameter (mm)	9	8	5.9	15
hole tolerance	H7	H7	H6	IT 5
reaming depth (mm)	30	25	48	20
cutting speed v_c (m/min.)	120	200	190	250
feed rate v_f (mm/min.)	4200	12700	6100	7200
tool life (m)	60	100	55	70

Hard reaming instead of eroding: Enormous savings thanks to HR 500

Guhring's HR 500 high performance reamers are not only first choice for volume production. They are also the ideal solution for especially demanding machining tasks.
They replace the expensive eroding operation of highly accurate ejector bores in hardened steel. Advantage for the customer: The machining time of in excess of 30 minutes per bore for eroding is reduced to less than 1 second with hard reaming.