

data sheet 272



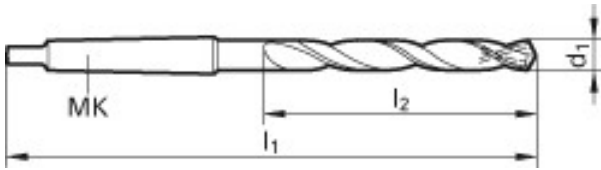
Description	Oil feed drills, flute length to DIN 341
Cutting direction	right hand
Tool material	HSS
Surface finish	steam tempered
Coolant	with
Type	N
Standard	Guhring standard
on shank	Morse taper
product line	standard
discount group	138
Point angle	118°

Materials	N/mm ²	v _c	VRC
	<=	ft/min	
Common structural steels	500	85	6
	1000	72	5
Free-cutting steels	850	98	6
	1000	98	5
Unalloyed heat-treatable steels	700	79	5
	850	79	5
	1000	72	4
Alloyed heat-treatable steels	1000	66	4
	1400	46	3
Unalloyed case hardened steels	850	98	6
	1000	56	4
Alloyed case hardened steels	1400	39	3
	1000	46	4
Nitriding steels	1400	33	3
	850	49	4
Tool steels	1400	33	3
	1400	33	3
High speed steels	1400	33	3
Spring steels	350 HB	23	2
Cast iron	240 HB	98	6
	350 HB	98	6
Spheroidal graphite iron and malleable cast iron	240 HB	79	6
	350 HB	66	6
Chilled cast iron	350 HB	23	3
Al Si cast alloys	10 %	164	7
	20 %	164	6
Copper, low-alloyed	500	197	5
Brass, long-chipping	600	131	5
Bronze, short-chipping	850	79	4
Bronze, long-chipping	850	79	4
	1000	72	4
Thermoplastics	100	79	5

d1[in]	2	3	4	5	6	7
<=	f _w [in]					
0.3937	0.0039	0.0049	0.0063	0.0079	0.0098	0.0124

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0.4921	0.0039	0.0049	0.0063	0.0079	0.0098	0.0124
0.6299	0.0049	0.0063	0.0079	0.0098	0.0124	0.0157
0.7874	0.0063	0.0079	0.0098	0.0124	0.0157	0.0197
0.9843	0.0079	0.0098	0.0124	0.0157	0.0197	0.0248
1.2402	0.0079	0.0098	0.0124	0.0157	0.0197	0.0248
1.5748	0.0098	0.0124	0.0157	0.0197	0.0248	0.0315
1.9685	0.0124	0.0157	0.0197	0.0248	0.0315	0.0394



	nominal $\varnothing d_1$ [mm]	Total length l_1 [mm]	Flute length l_2 [mm]	No. of slots MK
10	233	116	2	
10,5	233	116		
10,72	242	125		
10,8	242	125		
11	242	125	2	
11,11	242	125		
11,5	242	125	2	
11,8	242	125	2	
12	251	134	2	
12,5	251	134	2	
12,7	251	134	2	
12,8	251	134	2	
13,2	251	134	2	
13,49	259	142	2	
13,5	259	142	2	
13,8	259	142	2	
14	259	142	2	
14,25	264	147	2	
14,5	264	147	2	
14,75	264	147	2	
15	264	147	2	
15,5	270	153	2	
15,87	270	153	2	
16,25	276	159	2	
16,5	276	159	2	
16,67	276	159	2	
16,75	276	159	2	
17	276	159	2	
17,25	282	165	2	
17,5	282	165	2	
17,75	282	165	2	
18	282	165	2	
18,5	307	171	2	
19	307	171		
19,25	313	177	2	
19,5	313	177	2	
19,75	313	177	2	
20	313	177	2	
20,25	320	184	2	
20,5	320	184	2	

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nominal Ø d1 [mm]
 Total length l1 [mm]
 Flute length l2 [mm]
 No. of slots
 MK

20,64	320	184	2
21	320	184	2
21,43	327	191	2
21,5	327	191	2
22	327	191	2
22,25	327	191	2
22,5	334	198	2
23	334	198	2
23,25	334	198	2
23,5	334	198	2
23,81	342	206	
24	342	206	2
24,5	342	206	2
25	342	206	2
25,25	350	214	2
25,5	350	214	2
25,75	350	214	2
26	350	214	2
26,5	350	214	2
26,99	385	222	2
27,5	385	222	2
27,75	385	222	
27,78	385	222	2
28	385	222	2
28,5	393	230	2
29	393	230	2
29,5	393	230	2
30	393	230	2
30,16	402	239	2
31,5	402	239	2
31,75	411	248	2
32	421	248	2
32,5	421	248	
33	421	248	2
34	430	257	
35	430	257	
36	440	267	
37	440	267	
38	450	277	
39	450	277	
40	450	277	
41	460	287	
42	460	287	
44,45	471	298	2
46	483	310	
47	483	310	
48	494	321	2
49	494	321	2
50	494	321	

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