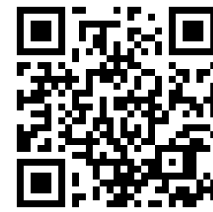


data sheet 54207



Description Twist drills
Cutting direction right hand
Tool material Carbide
Surface finish TiAlN
Coolant without
Type H
Standard Guhring standard
on shank HA
product line standard

Materials	N/mm ² ≤	v _c ft/min	VRC	infeed
Tool steels	850	558	47	≤ 16%
	1000	459	45	≤ 16%
High speed steels	1000	344	46	≤ 16%
Spring steels	330 HB	344	45	≤ 16%
Hardened steels	48 HRC	180	43	≤ 16%
	60 HRC	148	40	≤ 16%
Stainless steels, martensitic	1200	279	46	≤ 16%
Cast iron	240 HB	804	47	≤ 16%
	300 HB	738	46	≤ 16%
Spheroidal graphite iron and malleable cast iron	240 HB	656	47	≤ 16%
	300 HB	574	46	≤ 16%
Chilled cast iron	350 HB	361	46	≤ 16%
Cast materials CGI	220 HB	804	47	≤ 16%
	300 HB	738	46	≤ 16%

d1[in] ≤	40	43	45	46	47
	f _p [in]				
0.1181	0.0001	0.0004	0.0004	0.0006	0.0006
0.1969	0.0003	0.0008	0.0009	0.001	0.001
0.2362	0.0004	0.0009	0.0011	0.0012	0.0011
0.315	0.0006	0.0013	0.0014	0.0017	0.0017
0.3937	0.0008	0.0015	0.0017	0.002	0.0021
0.4724	0.001	0.0018	0.002	0.0023	0.0025
0.6299	0.0013	0.0021	0.0025	0.0028	0.0031
0.7874	0.0015	0.0026	0.0031	0.0035	0.0038

	nominal Ø [mm]	Shank Ø [mm]	Protruding length [mm]	Cutting edge length [mm]	incision length [mm]	Total length [mm]	Flute length [mm]	usable length [mm]	No. of slots
3	6	21	8	0,05	57	10,5	11,4	6	
4	6	21	11	0,05	57	14,5	15,9	6	
5	6	21	13	0,05	57	16,5	17,9	6	
6	6	21	13	0,05	57	17	21	6	
8	8	27	19	0,1	63	23	27	6	
10	10	32	22	0,1	72	26	32	6	
12	12	38	26	0,1	83	32	38	6	
14	14	38	26	0,15	83	32	38	6	

GUHRING Navigator

	nominal Ø [mm]	Shank Ø [mm]	Protruding length [mm]	Cutting edge length [mm]	incision length [mm]	Total length [mm]	Flute length [mm]	usable length [mm]	No. of slots
16	16	44	32	0,15	92	38	44	6	
18	18	44	32	0,15	92	40	44	8	
20	20	54	38	0,15	104	46	54	8	

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