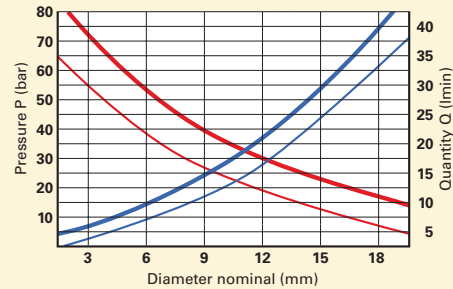


EB 80 Greater than 35xD

Material group	Hardness	SFM	Feed Rate - IPR									
			1/16 in. 1.590 mm	1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm	5/8 in. 15.870 mm	3/4 in. 19.050 mm	1 in. 25.400 mm	1 1/4 in. 31.750 mm	1 1/2 in. 38.100 mm
Common structural steels	≤100 Bhn	330	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
	>100-260 Bhn	280	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
Free-cutting steels	≤24 Rc	295	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
	>24-30 Rc	265	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
Unalloyed heat-treatable steels	≤16 Rc	295	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	16-24 Rc	265	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	24-30 Rc	245	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Alloyed heat-treatable steels	24-30 Rc	245	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	>30-38 Rc	215	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Unalloyed case hardened steels	≤230 Bhn	265	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
Alloyed case hardened steels	24-30 Rc	245	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	>30-38 Rc	215	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Nitriding steels	≥24-30 Rc	245	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	>30-38 Rc	215	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Tool steels	≤24 Rc	245	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
	>24-30 Rc	215	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
High speed steels	≥14-30 Rc	180	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
Spring steels	≤330 Bhn	215	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
Stainless steels, sulphured	≤24 Rc	180	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	austenitic	150	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
	martensitic	115	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Hardened steels	≤40-48 Rc	100	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
	>48-60 Rc	85	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
Special alloys	≤38 Rc	115	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
Cast iron	≤240 Bhn	180	0.0003	0.0005	0.0009	0.0013	0.0016	0.0020	•	•	•	•
	<300 Bhn	160	0.0003	0.0005	0.0009	0.0013	0.0016	0.0020	•	•	•	•
Spheroidal graphite iron and malleable cast iron	≤240 Bhn	260	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
	<300 Bhn	230	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
Chilled cast iron	≤350 Bhn	180	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Ti and Ti-alloys	≤24 Rc	115	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
	>24-38 Rc	100	0.0001	0.0002	0.0003	0.0004	0.0005	0.0008	•	•	•	•
Aluminum and Al-alloys	≤120 Bhn	590	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
Al wrought alloys	≤150 Bhn	655	0.0003	0.0005	0.0009	0.0013	0.0016	0.0020	•	•	•	•
Al cast alloys ≤ 10 % Si	≤200 Bhn	525	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
	> 10 % Si	395	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
Magnesium alloys	≤150 Bhn	245	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
Copper, low-alloyed	≤120 Bhn	395	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
	>120 Bhn	295	0.0008	0.0012	0.0024	0.0027	0.0030	0.0033	•	•	•	•
Brass, short-chipping	≤200 Bhn	295	0.0008	0.0012	0.0024	0.0027	0.0030	0.0033	•	•	•	•
	long-chipping	215	0.0008	0.0012	0.0024	0.0027	0.0030	0.0033	•	•	•	•
Bronze, short-chipping	≤200 Bhn	245	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
	>200-260 Bhn	230	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
Bronze, long-chipping	≤24 Rc	230	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
	>24-30 Rc	230	0.0005	0.0007	0.0014	0.0018	0.0022	0.0026	•	•	•	•
Duroplastics	-	230	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
Thermoplastics	-	200	0.0002	0.0003	0.0005	0.0009	0.0011	0.0014	•	•	•	•
Reinforced plastics - Kevlar	-	165	0.0002	0.0002	0.0004	0.0006	0.0006	0.0010	•	•	•	•
Reinforced plastics - GFK / CFK	-	-	-	-	-	-	-	-	•	•	•	•

Coolant values RT 100T

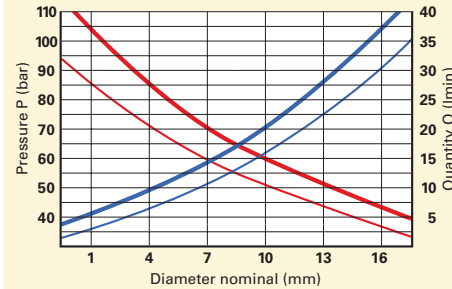
(Recommended values for soluble oil)



— Coolant pressure max. — Coolant quantity max.
— Coolant pressure min. — Coolant quantity min.

Coolant values EB 100

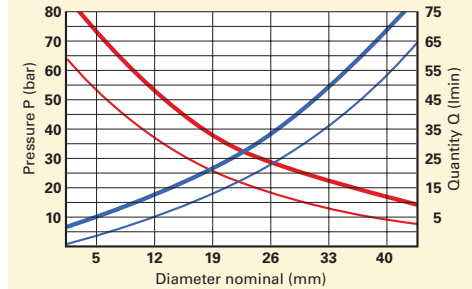
(Recommended values for soluble oil)



— Coolant pressure max. — Coolant quantity max.
— Coolant pressure min. — Coolant quantity min.

Coolant values EB 80

(Recommended values for soluble oil)



— Coolant pressure max. — Coolant quantity max.
— Coolant pressure min. — Coolant quantity min.

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