

GUHRING



RT 100 S

- ▶ for the machining of steel materials
- ▶ aggressive cutting speeds and improved tool life
- ▶ reduced cycle times and improved hole quality

RT 100 S





STEEL MACHINING



Strong in steel

RT 100

RT 100 S was developed for the complex **machining of steel materials**.

It makes a strong impression with its high cutting speeds and consistently good hole quality. An especially stable and accurate cutting edge is produced thanks to the **special micro-geometry**.

The extremely **smooth surface finish** of the RT 100 S web thinning and flute profile reduces the friction between drill and chip. The machining temperature is reduced and chip evacuation improved. Cutting forces are reduced. These tool features result in **excellent hole quality** and **tool life**.



S

The ideal tool for applications in:

- structural and free-cutting steels
- alloyed and unalloyed heat-treatable steels
- alloyed and unalloyed case hardened steels
- tool steels and high speed steels

Maximum performance thanks to premium tool quality:

- long and consistent tool life minimizes tooling costs and reduces machine down-time
- optimal component quality
- high cutting parameters ensure short machining times as well as a reduction in "cost per part"

RT 10

Tip Coating

- ▶ wear-resistant nano-FIREX® coating on tip

Polished flute with high surface finish quality

- ▶ optimal chip evacuation without chip congestion/chip blockage
- ▶ reduction in process forces thanks to reduction of friction between chip and tool

Carbide

- ▶ carbide produced by Guhring
- ▶ robust and wear-resistant with high toughness
- ▶ low tendency to crumble even under difficult machining conditions

HA-shank to DIN6535

Tool clamping in Guhring's GM300 hydraulic or shrink fit chucks:

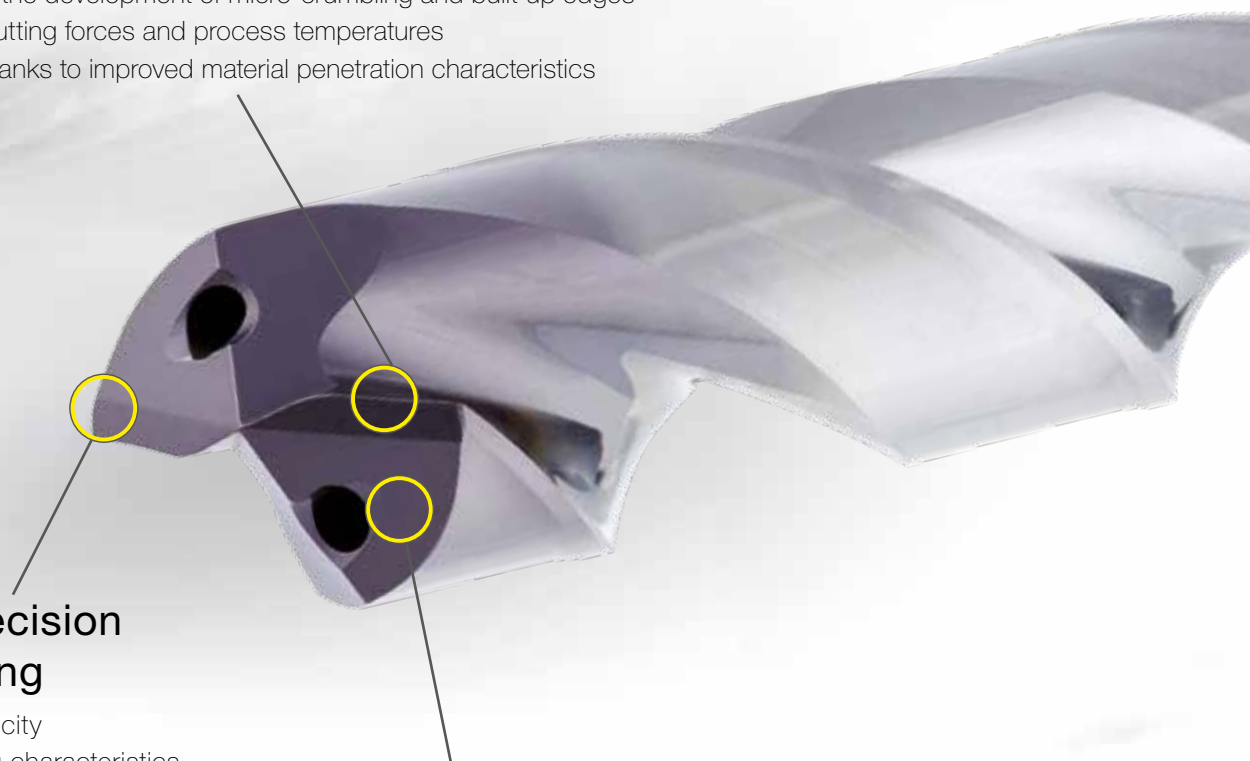
- ▶ optimal concentricity
- ▶ maximum rigidity
- ▶ minimum tool runout
- ▶ reliable tool clamping



Optimized cutting edge preparation

Stable and precise cutting edge geometry combined with ultra-fine surface in the cutting edge area:

- ▶ increased tool life
- ▶ counteracting the development of micro-crumbling and built-up edges
- ▶ reduction in cutting forces and process temperatures
- ▶ free-cutting thanks to improved material penetration characteristics



Ultimate precision when grinding

- ▶ optimal concentricity
- ▶ precise centering characteristics
- ▶ reduction in micro-vibrations

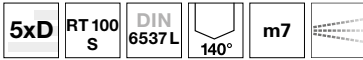
Geometry

Point geometry designed as facet point grind with straight cutting edge:

- ▶ robust cutting edge form with additional corner protection
- ▶ optimal spotting characteristics
- ▶ generates shorter chips

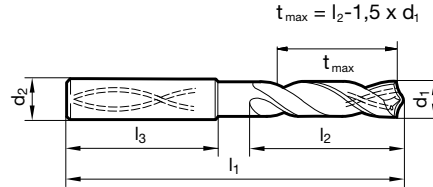


RT 100 S Coolant-fed carbide drills



Tool material **Solid carbide**
 Surface **F nano-FIREX**
 Shank form **HA**

- P** ● facet point grinding • main cutting edge form straight • optimized cutting geometry • maximum performance
- M** ○
- K** ○
- N** ○ structural and case hardened steels • free-cutting steels, heat-treatable steels • steels (alloyed/unalloyed) up to 1400 N/mm²
- S** ○
- H** ○



									Series no.	5759
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	EDP #	
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm		
0.1181			3.000	6.00	66.00	23.50	28.00	36.00	9057590030000	
0.1220			3.100	6.00	66.00	23.30	28.00	36.00	9057590031000	
0.1248	1/8		3.170	6.00	66.00	23.20	28.00	36.00	9057590031700	
0.1260			3.200	6.00	66.00	23.20	28.00	36.00	9057590032000	
0.1280			3.250	6.00	66.00	23.10	28.00	36.00	9057590032500	
0.1299			3.300	6.00	66.00	23.00	28.00	36.00	9057590033000	
0.1339			3.400	6.00	66.00	22.90	28.00	36.00	9057590034000	
0.1378			3.500	6.00	66.00	22.70	28.00	36.00	9057590035000	
0.1406	9/64	28	3.570	6.00	66.00	22.60	28.00	36.00	9057590035700	
0.1417			3.600	6.00	66.00	22.60	28.00	36.00	9057590036000	
0.1457			3.700	6.00	66.00	22.40	28.00	36.00	9057590037000	
0.1496		25	3.800	6.00	74.00	30.30	36.00	36.00	9057590038000	
0.1535			3.900	6.00	74.00	30.10	36.00	36.00	9057590039000	
0.1563	5/32		3.970	6.00	74.00	30.00	36.00	36.00	9057590039700	
0.1575			4.000	6.00	74.00	30.00	36.00	36.00	9057590040000	
0.1591		21	4.040	6.00	74.00	29.90	36.00	36.00	9057590040400	
0.1614			4.100	6.00	74.00	29.80	36.00	36.00	9057590041000	
0.1654			4.200	6.00	74.00	29.70	36.00	36.00	9057590042000	
0.1693		18	4.300	6.00	74.00	29.50	36.00	36.00	9057590043000	
0.1720	11/64		4.370	6.00	74.00	29.40	36.00	36.00	9057590043700	
0.1732			4.400	6.00	74.00	29.40	36.00	36.00	9057590044000	
0.1772		16	4.500	6.00	74.00	29.20	36.00	36.00	9057590045000	
0.1811			4.600	6.00	74.00	29.10	36.00	36.00	9057590046000	
0.1831			4.650	6.00	74.00	29.00	36.00	36.00	9057590046500	
0.1850		13	4.700	6.00	74.00	28.90	36.00	36.00	9057590047000	
0.1874	3/16		4.760	6.00	82.00	36.80	44.00	36.00	9057590047600	
0.1890		12	4.800	6.00	82.00	36.80	44.00	36.00	9057590048000	
0.1929			4.900	6.00	82.00	36.60	44.00	36.00	9057590049000	
0.1969			5.000	6.00	82.00	36.50	44.00	36.00	9057590050000	
0.2008			5.100	6.00	82.00	36.30	44.00	36.00	9057590051000	
0.2012		7	5.110	6.00	82.00	36.30	44.00	36.00	9057590051100	
0.2031	13/64		5.160	6.00	82.00	36.20	44.00	36.00	9057590051600	
0.2047			5.200	6.00	82.00	36.20	44.00	36.00	9057590052000	
0.2087			5.300	6.00	82.00	36.00	44.00	36.00	9057590053000	
0.2126			5.400	6.00	82.00	35.90	44.00	36.00	9057590054000	
0.2130		3	5.410	6.00	82.00	35.80	44.00	36.00	9057590054100	
0.2165			5.500	6.00	82.00	35.70	44.00	36.00	9057590055000	



Series no.									5759
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	EDP #
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.2185			5.550	6.00	82.00	35.60	44.00	36.00	9057590055500
0.2189	7/32		5.560	6.00	82.00	35.60	44.00	36.00	9057590055600
0.2205			5.600	6.00	82.00	35.60	44.00	36.00	9057590056000
0.2224			5.650	6.00	82.00	35.50	44.00	36.00	9057590056500
0.2244			5.700	6.00	82.00	35.40	44.00	36.00	9057590057000
0.2283			5.800	6.00	82.00	35.30	44.00	36.00	9057590058000
0.2323			5.900	6.00	82.00	35.10	44.00	36.00	9057590059000
0.2343	15/64		5.950	6.00	82.00	35.00	44.00	36.00	9057590059500
0.2362			6.000	6.00	82.00	35.00	44.00	36.00	9057590060000
0.2402			6.100	8.00	91.00	43.80	53.00	36.00	9057590061000
0.2441			6.200	8.00	91.00	43.70	53.00	36.00	9057590062000
0.2480			6.300	8.00	91.00	43.50	53.00	36.00	9057590063000
0.2500	1/4	E	6.350	8.00	91.00	43.40	53.00	36.00	9057590063500
0.2520			6.400	8.00	91.00	43.40	53.00	36.00	9057590064000
0.2559			6.500	8.00	91.00	43.20	53.00	36.00	9057590065000
0.2571		F	6.530	8.00	91.00	43.20	53.00	36.00	9057590065300
0.2598			6.600	8.00	91.00	43.10	53.00	36.00	9057590066000
0.2638			6.700	8.00	91.00	42.90	53.00	36.00	9057590067000
0.2657	17/64	H	6.750	8.00	91.00	42.80	53.00	36.00	9057590067500
0.2677			6.800	8.00	91.00	42.80	53.00	36.00	9057590068000
0.2717		I	6.900	8.00	91.00	42.60	53.00	36.00	9057590069000
0.2756			7.000	8.00	91.00	42.50	53.00	36.00	9057590070000
0.2795			7.100	8.00	91.00	42.30	53.00	36.00	9057590071000
0.2811	9/32	K	7.140	8.00	91.00	42.20	53.00	36.00	9057590071400
0.2835			7.200	8.00	91.00	42.20	53.00	36.00	9057590072000
0.2874			7.300	8.00	91.00	42.00	53.00	36.00	9057590073000
0.2913			7.400	8.00	91.00	41.90	53.00	36.00	9057590074000
0.2953			7.500	8.00	91.00	41.70	53.00	36.00	9057590075000
0.2969	19/64		7.540	8.00	91.00	41.60	53.00	36.00	9057590075400
0.2972			7.550	8.00	91.00	41.60	53.00	36.00	9057590075500
0.2992			7.600	8.00	91.00	41.60	53.00	36.00	9057590076000
0.3012			7.650	8.00	91.00	41.50	53.00	36.00	9057590076500
0.3031			7.700	8.00	91.00	41.40	53.00	36.00	9057590077000
0.3071			7.800	8.00	91.00	41.30	53.00	36.00	9057590078000
0.3110			7.900	8.00	91.00	41.10	53.00	36.00	9057590079000
0.3126	5/16		7.940	8.00	91.00	41.00	53.00	36.00	9057590079400
0.3150			8.000	8.00	91.00	41.00	53.00	36.00	9057590080000
0.3189			8.100	10.00	103.00	48.80	61.00	40.00	9057590081000
0.3228		P	8.200	10.00	103.00	48.70	61.00	40.00	9057590082000
0.3268			8.300	10.00	103.00	48.50	61.00	40.00	9057590083000
0.3280	21/64		8.330	10.00	103.00	48.50	61.00	40.00	9057590083300
0.3307			8.400	10.00	103.00	48.40	61.00	40.00	9057590084000
0.3346			8.500	10.00	103.00	48.20	61.00	40.00	9057590085000
0.3386			8.600	10.00	103.00	48.10	61.00	40.00	9057590086000
0.3425			8.700	10.00	103.00	47.90	61.00	40.00	9057590087000
0.3437	11/32		8.730	10.00	103.00	47.90	61.00	40.00	9057590087300
0.3465			8.800	10.00	103.00	47.80	61.00	40.00	9057590088000
0.3504			8.900	10.00	103.00	47.60	61.00	40.00	9057590089000
0.3543			9.000	10.00	103.00	47.50	61.00	40.00	9057590090000
0.3583			9.100	10.00	103.00	47.30	61.00	40.00	9057590091000
0.3594	23/64		9.130	10.00	103.00	47.30	61.00	40.00	9057590091300
0.3622			9.200	10.00	103.00	47.20	61.00	40.00	9057590092000
0.3642			9.250	10.00	103.00	47.10	61.00	40.00	9057590092500
0.3661			9.300	10.00	103.00	47.00	61.00	40.00	9057590093000
0.3677		U	9.340	10.00	103.00	46.90	61.00	40.00	9057590093400
0.3701			9.400	10.00	103.00	46.90	61.00	40.00	9057590094000
0.3740			9.500	10.00	103.00	46.70	61.00	40.00	9057590095000
0.3748	3/8		9.520	10.00	103.00	46.70	61.00	40.00	9057590095200



Series no.									5759
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	EDP #
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.3760			9.550	10.00	103.00	46.60	61.00	40.00	9057590095500
0.3780			9.600	10.00	103.00	46.60	61.00	40.00	9057590096000
0.3819			9.700	10.00	103.00	46.40	61.00	40.00	9057590097000
0.3858		W	9.800	10.00	103.00	46.30	61.00	40.00	9057590098000
0.3898			9.900	10.00	103.00	46.10	61.00	40.00	9057590099000
0.3906	25/64		9.920	10.00	103.00	46.10	61.00	40.00	9057590099200
0.3937			10.000	10.00	103.00	46.00	61.00	40.00	9057590100000
0.3976			10.100	12.00	118.00	55.80	71.00	45.00	9057590101000
0.4016			10.200	12.00	118.00	55.70	71.00	45.00	9057590102000
0.4055			10.300	12.00	118.00	55.50	71.00	45.00	9057590103000
0.4063	13/32		10.320	12.00	118.00	55.50	71.00	45.00	9057590103200
0.4094			10.400	12.00	118.00	55.40	71.00	45.00	9057590104000
0.4134			10.500	12.00	118.00	55.20	71.00	45.00	9057590105000
0.4173			10.600	12.00	118.00	55.10	71.00	45.00	9057590106000
0.4213			10.700	12.00	118.00	54.90	71.00	45.00	9057590107000
0.4220	27/64		10.720	12.00	118.00	54.90	71.00	45.00	9057590107200
0.4252			10.800	12.00	118.00	54.80	71.00	45.00	9057590108000
0.4291			10.900	12.00	118.00	54.60	71.00	45.00	9057590109000
0.4331			11.000	12.00	118.00	54.50	71.00	45.00	9057590110000
0.4370			11.100	12.00	118.00	54.30	71.00	45.00	9057590111000
0.4374	7/16		11.110	12.00	118.00	54.30	71.00	45.00	9057590111100
0.4409			11.200	12.00	118.00	54.20	71.00	45.00	9057590112000
0.4449			11.300	12.00	118.00	54.00	71.00	45.00	9057590113000
0.4488			11.400	12.00	118.00	53.90	71.00	45.00	9057590114000
0.4528			11.500	12.00	118.00	53.70	71.00	45.00	9057590115000
0.4531	29/64		11.510	12.00	118.00	53.70	71.00	45.00	9057590115100
0.4547			11.550	12.00	118.00	53.60	71.00	45.00	9057590115500
0.4567			11.600	12.00	118.00	53.60	71.00	45.00	9057590116000
0.4606			11.700	12.00	118.00	53.40	71.00	45.00	9057590117000
0.4646			11.800	12.00	118.00	53.30	71.00	45.00	9057590118000
0.4685			11.900	12.00	118.00	53.10	71.00	45.00	9057590119000
0.4689	15/32		11.910	12.00	118.00	53.10	71.00	45.00	9057590119100
0.4724			12.000	12.00	118.00	53.00	71.00	45.00	9057590120000
0.4764			12.100	14.00	124.00	58.80	77.00	45.00	9057590121000
0.4803			12.200	14.00	124.00	58.70	77.00	45.00	9057590122000
0.4843	31/64		12.300	14.00	124.00	58.50	77.00	45.00	9057590123000
0.4882			12.400	14.00	124.00	58.40	77.00	45.00	9057590124000
0.4921			12.500	14.00	124.00	58.20	77.00	45.00	9057590125000
0.4961			12.600	14.00	124.00	58.10	77.00	45.00	9057590126000
0.5000	1/2		12.700	14.00	124.00	57.90	77.00	45.00	9057590127000
0.5039			12.800	14.00	124.00	57.80	77.00	45.00	9057590128000
0.5079			12.900	14.00	124.00	57.60	77.00	45.00	9057590129000
0.5118			13.000	14.00	124.00	57.50	77.00	45.00	9057590130000
0.5157	33/64		13.100	14.00	124.00	57.30	77.00	45.00	9057590131000
0.5197			13.200	14.00	124.00	57.20	77.00	45.00	9057590132000
0.5236			13.300	14.00	124.00	57.00	77.00	45.00	9057590133000
0.5276			13.400	14.00	124.00	56.90	77.00	45.00	9057590134000
0.5311	17/32		13.490	14.00	124.00	56.70	77.00	45.00	9057590134900
0.5315			13.500	14.00	124.00	56.70	77.00	45.00	9057590135000
0.5354			13.600	14.00	124.00	56.60	77.00	45.00	9057590136000
0.5394			13.700	14.00	124.00	56.40	77.00	45.00	9057590137000
0.5433			13.800	14.00	124.00	56.30	77.00	45.00	9057590138000
0.5469	35/64		13.890	14.00	124.00	56.10	77.00	45.00	9057590138900
0.5472			13.900	14.00	124.00	56.10	77.00	45.00	9057590139000
0.5512			14.000	14.00	124.00	56.00	77.00	45.00	9057590140000
0.5551			14.100	16.00	133.00	61.80	83.00	48.00	9057590141000
0.5591			14.200	16.00	133.00	61.70	83.00	48.00	9057590142000
0.5626	9/16		14.290	16.00	133.00	61.50	83.00	48.00	9057590142900



Series no. 5759									EDP #
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.5669			14.400	16.00	133.00	61.40	83.00	48.00	9057590144000
0.5709			14.500	16.00	133.00	61.20	83.00	48.00	9057590145000
0.5748			14.600	16.00	133.00	61.10	83.00	48.00	9057590146000
0.5780	37/64		14.680	16.00	133.00	60.90	83.00	48.00	9057590146800
0.5787			14.700	16.00	133.00	60.90	83.00	48.00	9057590147000
0.5827			14.800	16.00	133.00	60.80	83.00	48.00	9057590148000
0.5866			14.900	16.00	133.00	60.60	83.00	48.00	9057590149000
0.5906			15.000	16.00	133.00	60.50	83.00	48.00	9057590150000
0.5937	19/32		15.080	16.00	133.00	60.30	83.00	48.00	9057590150800
0.5945			15.100	16.00	133.00	60.30	83.00	48.00	9057590151000
0.5984			15.200	16.00	133.00	60.20	83.00	48.00	9057590152000
0.6024			15.300	16.00	133.00	60.00	83.00	48.00	9057590153000
0.6063			15.400	16.00	133.00	59.90	83.00	48.00	9057590154000
0.6094	39/64		15.480	16.00	133.00	59.70	83.00	48.00	9057590154800
0.6102			15.500	16.00	133.00	59.70	83.00	48.00	9057590155000
0.6122			15.550	16.00	133.00	59.60	83.00	48.00	9057590155500
0.6142			15.600	16.00	133.00	59.60	83.00	48.00	9057590156000
0.6181			15.700	16.00	133.00	59.40	83.00	48.00	9057590157000
0.6220			15.800	16.00	133.00	59.30	83.00	48.00	9057590158000
0.6248	5/8		15.870	16.00	133.00	59.10	83.00	48.00	9057590158700
0.6260			15.900	16.00	133.00	59.10	83.00	48.00	9057590159000
0.6299			16.000	16.00	133.00	59.00	83.00	48.00	9057590160000
0.6406	41/64		16.270	18.00	143.00	68.50	93.00	48.00	9057590162700
0.6496			16.500	18.00	143.00	68.20	93.00	48.00	9057590165000
0.6563	21/32		16.670	18.00	143.00	67.90	93.00	48.00	9057590166700
0.6575			16.700	18.00	143.00	67.90	93.00	48.00	9057590167000
0.6654			16.900	18.00	143.00	67.60	93.00	48.00	9057590169000
0.6693			17.000	18.00	143.00	67.50	93.00	48.00	9057590170000
0.6720	43/64		17.070	18.00	143.00	67.30	93.00	48.00	9057590170700
0.6874	11/16		17.460	18.00	143.00	66.80	93.00	48.00	9057590174600
0.6890			17.500	18.00	143.00	66.70	93.00	48.00	9057590175000
0.6909			17.550	18.00	143.00	66.60	93.00	48.00	9057590175500
0.6969			17.700	18.00	143.00	66.40	93.00	48.00	9057590177000
0.7031	45/64		17.860	18.00	143.00	66.20	93.00	48.00	9057590178600
0.7087			18.000	18.00	143.00	66.00	93.00	48.00	9057590180000
0.7189	23/32		18.260	20.00	153.00	73.60	101.00	50.00	9057590182600
0.7283			18.500	20.00	153.00	73.20	101.00	50.00	9057590185000
0.7362			18.700	20.00	153.00	72.90	101.00	50.00	9057590187000
0.7441			18.900	20.00	153.00	72.60	101.00	50.00	9057590189000
0.7480			19.000	20.00	153.00	72.50	101.00	50.00	9057590190000
0.7500	3/4		19.050	20.00	153.00	72.40	101.00	50.00	9057590190500
0.7579			19.250	20.00	153.00	72.10	101.00	50.00	9057590192500
0.7598			19.300	20.00	153.00	72.00	101.00	50.00	9057590193000
0.7656			19.446	20.00	153.00	71.80	101.00	50.00	9057590194460
0.7677			19.500	20.00	153.00	71.70	101.00	50.00	9057590195000
0.7697			19.550	20.00	153.00	71.60	101.00	50.00	9057590195500
0.7756			19.700	20.00	153.00	71.40	101.00	50.00	9057590197000
0.7811	25/32		19.840	20.00	153.00	71.20	101.00	50.00	9057590198400
0.7874			20.000	20.00	153.00	71.00	101.00	50.00	9057590200000



RT 100 S Coolant-fed carbide drills



Tool material **Solid carbide**

Surface **F nano-FIREX**

Shank form **HA**

P ● facet point grinding • main cutting edge form straight • optimized cutting geometry • maximum performance

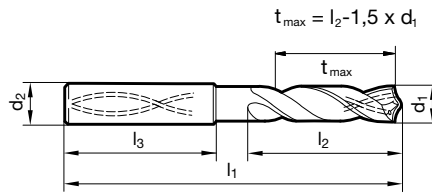
M ○

K ○

N ○ structural and case hardened steels • free-cutting steels, heat-treatable steels • steels (alloyed/unalloyed) up to 1400 N/mm²

S ○

H ○



Series no. **5760**

d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	EDP #
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.1181			3.000	6.00	70.00	25.50	30.00	36.00	9057600030000
0.1220			3.100	6.00	70.00	25.30	30.00	36.00	9057600031000
0.1248	1/8		3.170	6.00	70.00	25.20	30.00	36.00	9057600031700
0.1260			3.200	6.00	70.00	25.20	30.00	36.00	9057600032000
0.1280			3.250	6.00	70.00	25.10	30.00	36.00	9057600032500
0.1299			3.300	6.00	70.00	25.00	30.00	36.00	9057600033000
0.1339			3.400	6.00	75.00	30.40	35.50	36.00	9057600034000
0.1378			3.500	6.00	75.00	30.20	35.50	36.00	9057600035000
0.1406	9/64	28	3.570	6.00	75.00	30.10	35.50	36.00	9057600035700
0.1417			3.600	6.00	75.00	30.10	35.50	36.00	9057600036000
0.1457			3.700	6.00	75.00	29.90	35.50	36.00	9057600037000
0.1496		25	3.800	6.00	75.00	31.80	37.50	36.00	9057600038000
0.1535			3.900	6.00	75.00	31.60	37.50	36.00	9057600039000
0.1563	5/32		3.970	6.00	75.00	31.50	37.50	36.00	9057600039700
0.1575			4.000	6.00	75.00	31.50	37.50	36.00	9057600040000
0.1591		21	4.040	6.00	75.00	31.40	37.50	36.00	9057600040400
0.1614			4.100	6.00	75.00	31.30	37.50	36.00	9057600041000
0.1654			4.200	6.00	75.00	31.20	37.50	36.00	9057600042000
0.1693		18	4.300	6.00	85.00	38.50	45.00	36.00	9057600043000
0.1720	11/64		4.370	6.00	85.00	38.40	45.00	36.00	9057600043700
0.1732			4.400	6.00	85.00	38.40	45.00	36.00	9057600044000
0.1772		16	4.500	6.00	85.00	38.20	45.00	36.00	9057600045000
0.1811			4.600	6.00	85.00	38.10	45.00	36.00	9057600046000
0.1831			4.650	6.00	85.00	38.00	45.00	36.00	9057600046500
0.1850		13	4.700	6.00	85.00	37.90	45.00	36.00	9057600047000
0.1874	3/16		4.760	6.00	90.00	42.80	50.00	36.00	9057600047600
0.1890		12	4.800	6.00	90.00	42.80	50.00	36.00	9057600048000
0.1929			4.900	6.00	90.00	42.60	50.00	36.00	9057600049000
0.1969			5.000	6.00	90.00	42.50	50.00	36.00	9057600050000
0.2008			5.100	6.00	90.00	42.30	50.00	36.00	9057600051000
0.2012		7	5.110	6.00	90.00	42.30	50.00	36.00	9057600051100
0.2031	13/64		5.160	6.00	90.00	42.20	50.00	36.00	9057600051600
0.2047			5.200	6.00	90.00	42.20	50.00	36.00	9057600052000
0.2087			5.300	6.00	90.00	42.00	50.00	36.00	9057600053000



Series no.									5760
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	EDP #
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.2126			5.400	6.00	97.00	48.90	57.00	36.00	9057600054000
0.2130		3	5.410	6.00	97.00	48.80	57.00	36.00	9057600054100
0.2165			5.500	6.00	97.00	48.70	57.00	36.00	9057600055000
0.2185			5.550	6.00	97.00	48.60	57.00	36.00	9057600055500
0.2189	7/32		5.560	6.00	97.00	48.60	57.00	36.00	9057600055600
0.2205			5.600	6.00	97.00	48.60	57.00	36.00	9057600056000
0.2244			5.700	6.00	97.00	48.40	57.00	36.00	9057600057000
0.2283			5.800	6.00	97.00	48.30	57.00	36.00	9057600058000
0.2323			5.900	6.00	97.00	48.10	57.00	36.00	9057600059000
0.2343	15/64		5.950	6.00	97.00	48.00	57.00	36.00	9057600059500
0.2362			6.000	6.00	97.00	48.00	57.00	36.00	9057600060000
0.2402			6.100	8.00	106.00	56.80	66.00	36.00	9057600061000
0.2441			6.200	8.00	106.00	56.70	66.00	36.00	9057600062000
0.2480			6.300	8.00	106.00	56.50	66.00	36.00	9057600063000
0.2500	1/4	E	6.350	8.00	106.00	56.40	66.00	36.00	9057600063500
0.2520			6.400	8.00	106.00	56.40	66.00	36.00	9057600064000
0.2559			6.500	8.00	106.00	56.20	66.00	36.00	9057600065000
0.2571		F	6.530	8.00	106.00	56.20	66.00	36.00	9057600065300
0.2598			6.600	8.00	106.00	56.10	66.00	36.00	9057600066000
0.2638			6.700	8.00	106.00	55.90	66.00	36.00	9057600067000
0.2657	17/64	H	6.750	8.00	106.00	55.80	66.00	36.00	9057600067500
0.2677			6.800	8.00	106.00	55.80	66.00	36.00	9057600068000
0.2717		I	6.900	8.00	116.00	65.60	76.00	36.00	9057600069000
0.2756			7.000	8.00	116.00	65.50	76.00	36.00	9057600070000
0.2795			7.100	8.00	116.00	65.30	76.00	36.00	9057600071000
0.2811	9/32	K	7.140	8.00	116.00	65.20	76.00	36.00	9057600071400
0.2835			7.200	8.00	116.00	65.20	76.00	36.00	9057600072000
0.2874			7.300	8.00	116.00	65.00	76.00	36.00	9057600073000
0.2913			7.400	8.00	116.00	64.90	76.00	36.00	9057600074000
0.2953			7.500	8.00	116.00	64.70	76.00	36.00	9057600075000
0.2969	19/64		7.540	8.00	116.00	64.60	76.00	36.00	9057600075400
0.2992			7.600	8.00	116.00	64.60	76.00	36.00	9057600076000
0.3031			7.700	8.00	116.00	64.40	76.00	36.00	9057600077000
0.3071			7.800	8.00	116.00	64.30	76.00	36.00	9057600078000
0.3110			7.900	8.00	116.00	64.10	76.00	36.00	9057600079000
0.3126	5/16		7.940	8.00	116.00	64.00	76.00	36.00	9057600079400
0.3150			8.000	8.00	116.00	64.00	76.00	36.00	9057600080000
0.3189			8.100	10.00	131.00	74.80	87.00	40.00	9057600081000
0.3228		P	8.200	10.00	131.00	74.70	87.00	40.00	9057600082000
0.3268			8.300	10.00	131.00	74.50	87.00	40.00	9057600083000
0.3280	21/64		8.330	10.00	131.00	74.50	87.00	40.00	9057600083300
0.3307			8.400	10.00	131.00	74.40	87.00	40.00	9057600084000
0.3346			8.500	10.00	131.00	74.20	87.00	40.00	9057600085000
0.3386			8.600	10.00	131.00	74.10	87.00	40.00	9057600086000
0.3425			8.700	10.00	131.00	73.90	87.00	40.00	9057600087000
0.3437	11/32		8.730	10.00	131.00	73.90	87.00	40.00	9057600087300
0.3465			8.800	10.00	131.00	73.80	87.00	40.00	9057600088000
0.3504			8.900	10.00	131.00	73.60	87.00	40.00	9057600089000
0.3543			9.000	10.00	131.00	73.50	87.00	40.00	9057600090000
0.3583			9.100	10.00	139.00	81.30	95.00	40.00	9057600091000
0.3594	23/64		9.130	10.00	139.00	81.30	95.00	40.00	9057600091300
0.3622			9.200	10.00	139.00	81.20	95.00	40.00	9057600092000
0.3642			9.250	10.00	139.00	81.10	95.00	40.00	9057600092500
0.3661			9.300	10.00	139.00	81.00	95.00	40.00	9057600093000
0.3677		U	9.340	10.00	139.00	80.90	95.00	40.00	9057600093400
0.3701			9.400	10.00	139.00	80.90	95.00	40.00	9057600094000
0.3740			9.500	10.00	139.00	80.70	95.00	40.00	9057600095000
0.3748	3/8		9.520	10.00	139.00	80.70	95.00	40.00	9057600095200



Series no. 5760									EDP #
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.3780			9.600	10.00	139.00	80.60	95.00	40.00	9057600096000
0.3819			9.700	10.00	139.00	80.40	95.00	40.00	9057600097000
0.3858		W	9.800	10.00	139.00	80.30	95.00	40.00	9057600098000
0.3898			9.900	10.00	139.00	80.10	95.00	40.00	9057600099000
0.3906	25/64		9.920	10.00	139.00	80.10	95.00	40.00	9057600099200
0.3937			10.000	10.00	139.00	80.00	95.00	40.00	9057600100000
0.3976			10.100	12.00	155.00	90.80	106.00	45.00	9057600101000
0.4016			10.200	12.00	155.00	90.70	106.00	45.00	9057600102000
0.4055			10.300	12.00	155.00	90.50	106.00	45.00	9057600103000
0.4063	13/32		10.320	12.00	155.00	90.50	106.00	45.00	9057600103200
0.4094			10.400	12.00	155.00	90.40	106.00	45.00	9057600104000
0.4134			10.500	12.00	155.00	90.20	106.00	45.00	9057600105000
0.4173			10.600	12.00	155.00	90.10	106.00	45.00	9057600106000
0.4213			10.700	12.00	155.00	89.90	106.00	45.00	9057600107000
0.4220	27/64		10.720	12.00	155.00	89.90	106.00	45.00	9057600107200
0.4252			10.800	12.00	155.00	89.80	106.00	45.00	9057600108000
0.4291			10.900	12.00	155.00	89.60	106.00	45.00	9057600109000
0.4331			11.000	12.00	155.00	89.50	106.00	45.00	9057600110000
0.4370			11.100	12.00	163.00	97.30	114.00	45.00	9057600111000
0.4374	7/16		11.110	12.00	163.00	97.30	114.00	45.00	9057600111100
0.4409			11.200	12.00	163.00	97.20	114.00	45.00	9057600112000
0.4449			11.300	12.00	163.00	97.00	114.00	45.00	9057600113000
0.4488			11.400	12.00	163.00	96.90	114.00	45.00	9057600114000
0.4528			11.500	12.00	163.00	96.70	114.00	45.00	9057600115000
0.4531	29/64		11.510	12.00	163.00	96.70	114.00	45.00	9057600115100
0.4567			11.600	12.00	163.00	96.60	114.00	45.00	9057600116000
0.4606			11.700	12.00	163.00	96.40	114.00	45.00	9057600117000
0.4646			11.800	12.00	163.00	96.30	114.00	45.00	9057600118000
0.4685			11.900	12.00	163.00	96.10	114.00	45.00	9057600119000
0.4689	15/32		11.910	12.00	163.00	96.10	114.00	45.00	9057600119100
0.4724			12.000	12.00	163.00	96.00	114.00	45.00	9057600120000
0.4764			12.100	14.00	182.00	114.00	133.00	45.00	9057600121000
0.4803			12.200	14.00	182.00	114.00	133.00	45.00	9057600122000
0.4843	31/64		12.300	14.00	182.00	114.00	133.00	45.00	9057600123000
0.4921			12.500	14.00	182.00	114.00	133.00	45.00	9057600125000
0.5000	1/2		12.700	14.00	182.00	113.00	133.00	45.00	9057600127000
0.5118			13.000	14.00	182.00	113.00	133.00	45.00	9057600130000
0.5157	33/64		13.100	14.00	182.00	113.00	133.00	45.00	9057600131000
0.5311	17/32		13.490	14.00	182.00	112.00	133.00	45.00	9057600134900
0.5315			13.500	14.00	182.00	112.00	133.00	45.00	9057600135000
0.5394			13.700	14.00	182.00	112.00	133.00	45.00	9057600137000
0.5469	35/64		13.890	14.00	182.00	112.00	133.00	45.00	9057600138900
0.5512			14.000	14.00	182.00	112.00	133.00	45.00	9057600140000
0.5551			14.100	16.00	204.00	130.00	152.00	48.00	9057600141000
0.5591			14.200	16.00	204.00	130.00	152.00	48.00	9057600142000
0.5626	9/16		14.290	16.00	204.00	130.00	152.00	48.00	9057600142900
0.5709			14.500	16.00	204.00	130.00	152.00	48.00	9057600145000
0.5787			14.700	16.00	204.00	129.00	152.00	48.00	9057600147000
0.5906			15.000	16.00	204.00	129.00	152.00	48.00	9057600150000
0.5945			15.100	16.00	204.00	129.00	152.00	48.00	9057600151000
0.6094	39/64		15.480	16.00	204.00	128.00	152.00	48.00	9057600154800
0.6102			15.500	16.00	204.00	128.00	152.00	48.00	9057600155000
0.6181			15.700	16.00	204.00	128.00	152.00	48.00	9057600157000
0.6248	5/8		15.870	16.00	204.00	128.00	152.00	48.00	9057600158700
0.6299			16.000	16.00	204.00	128.00	152.00	48.00	9057600160000
0.6496			16.500	18.00	223.00	146.00	171.00	48.00	9057600165000
0.6654			16.900	18.00	223.00	145.00	171.00	48.00	9057600169000
0.6693			17.000	18.00	223.00	145.00	171.00	48.00	9057600170000



Series no. 5760									EDP #
d1	d1	d1	d1	d2	l1	t _{max}	l2	l3	
dec. inch	inch	wire/letter	mm	mm	mm	mm	mm	mm	
0.6890			17.500	18.00	223.00	144.00	171.00	48.00	9057600175000
0.6969			17.700	18.00	223.00	144.00	171.00	48.00	9057600177000
0.7087			18.000	18.00	223.00	144.00	171.00	48.00	9057600180000
0.7283			18.500	20.00	244.00	162.00	190.00	50.00	9057600185000
0.7441			18.900	20.00	244.00	161.00	190.00	50.00	9057600189000
0.7480			19.000	20.00	244.00	161.00	190.00	50.00	9057600190000
0.7500	3/4		19.050	20.00	244.00	161.00	190.00	50.00	9057600190500
0.7677			19.500	20.00	244.00	160.00	190.00	50.00	9057600195000
0.7874			20.000	20.00	244.00	160.00	190.00	50.00	9057600200000





Series # 5759 - Operating Parameters

Material group	Hardness		SFM	Feed Rate - IPR								
	HRc	Bhn		1/64 in. .5 mm	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
Common structural steels	-	≤ 150	475			0.0065	0.0100	0.0155	0.0155	0.0195	0.0250	
	≤ 32	≤ 301	395			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
Free-cutting steels	≤ 25	≤ 255	560			0.0065	0.0100	0.0155	0.0155	0.0195	0.0250	
	≤ 32	≤ 301	475			0.0065	0.0100	0.0155	0.0155	0.0195	0.0250	
Unalloyed heat-treatable steels	≤ 20	≤ 220	425			0.0065	0.0100	0.0155	0.0155	0.0195	0.0250	
	≤ 25	≤ 255	410			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 32	≤ 301	395			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
Alloyed heat-treatable steels	≤ 32	≤ 301	395			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 43	≤ 402	345			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
Unalloyed case hardened steels	≤ 25	≤ 255	475			0.0065	0.0100	0.0155	0.0155	0.0195	0.0250	
Alloyed case hardened steels	≤ 32	≤ 301	395			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 43	≤ 402	345			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
Nitriding steels	≤ 32	≤ 301	360			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 43	≤ 402	330			0.0030	0.0050	0.0080	0.0080	0.0100	0.0125	
Tool steels	≤ 25	≤ 255	230			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
	≤ 43	≤ 402	180			0.0030	0.0050	0.0080	0.0080	0.0100	0.0125	
High speed steels	≤ 43	≤ 402	195			0.0030	0.0050	0.0080	0.0080	0.0100	0.0125	
Spring steels	≤ 38	≤ 354	195			0.0030	0.0050	0.0080	0.0080	0.0100	0.0125	
Hardened steels	≤ 48	≤ 460										
	≤ 66	-										
Stainless steels, sulphured	≤ 28	≤ 273										
austenitic	≤ 36	≤ 337										
martensitic	≤ 46	≤ 435										
Cast iron	≤ 23	≤ 242										
	≤ 38	≤ 354										
Spheroidal graphite iron and	≤ 23	≤ 242										
malleable cast iron	≤ 38	≤ 354										
Chilled cast iron	≤ 38	≤ 354										
New cast materials GGV	≤ 20	≤ 220										
	≤ 32	≤ 301										
New cast materials ADI	≤ 32	≤ 301										
	≤ 43	≤ 402										
Special alloys	≤ 54	≤ 549										
Ti and Ti-alloys	≤ 25	≤ 255										
	≤ 43	≤ 402										
Aluminium and Al-alloys	-	≤ 120										
Al wrought alloys	-	≤ 200										
Al cast alloys ≤ 10 % Si	-	≤ 180										
> 10 % Si	-	≤ 180										
Magnesium alloys	-	≤ 120										
Copper, low-alloyed	-	≤ 150										
Brass, short-chipping	-	≤ 180										
long-chipping	-	≤ 180										
Bronze, short-chipping	-	≤ 180										
	≤ 25	≤ 255										
Bronze, long-chipping	≤ 25	≤ 255										
	≤ 32	≤ 301										

Series # 5760

Material group	Hardness		SFM	Feed Rate - IPR								
	HRc	Bhn		1/64 in. .5 mm	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
Common structural steels	-	≤ 150	475			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 32	≤ 301	395			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
Free-cutting steels	≤ 25	≤ 255	560			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 32	≤ 301	475			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
Unalloyed heat-treatable steels	≤ 20	≤ 220	425			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
	≤ 25	≤ 255	410			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
	≤ 32	≤ 301	395			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
Alloyed heat-treatable steels	≤ 32	≤ 301	395			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
	≤ 43	≤ 402	345			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
Unalloyed case hardened steels	≤ 25	≤ 255	475			0.0050	0.0080	0.0125	0.0125	0.0155	0.0195	
Alloyed case hardened steels	≤ 32	≤ 301	395			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
	≤ 43	≤ 402	345			0.0030	0.0050	0.0080	0.0080	0.0100	0.0125	
Nitriding steels	≤ 32	≤ 301	360			0.0040	0.0065	0.0100	0.0100	0.0125	0.0155	
	≤ 43	≤ 402	330			0.0025	0.0040	0.0065	0.0065	0.0080	0.0100	
Tool steels	≤ 25	≤ 255	230			0.0030	0.0050	0.0080	0.0080	0.0100	0.0125	
	≤ 43	≤ 402	215			0.0025	0.0040	0.0065	0.0065	0.0080	0.0100	
High speed steels	≤ 43	≤ 402	195			0.0025	0.0040	0.0065	0.0065	0.0080	0.0100	
Spring steels	≤ 38	≤ 354	195			0.0025	0.0040	0.0065	0.0065	0.0080	0.0100	
Hardened steels	≤ 48	≤ 460										
	≤ 66	-										
Stainless steels, sulphured	≤ 28	≤ 273										
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Cast iron	≤ 23	≤ 242										
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long-chipping	-	≤ 180										
Bronze, short-chipping	-	≤ 180										
	≤ 25	≤ 255										
Bronze, long-chipping	≤ 25	≤ 255										
	≤ 32	≤ 301										

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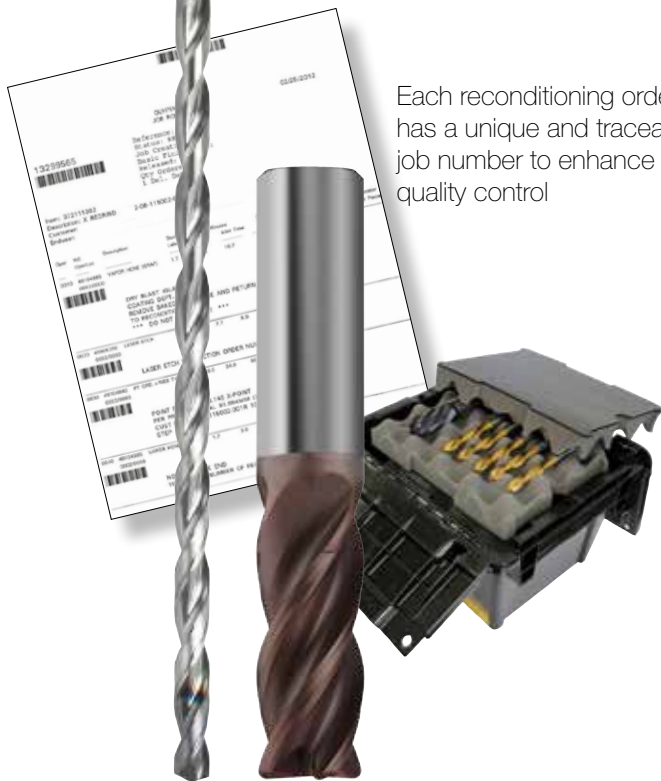
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Each reconditioning order has a unique and traceable job number to enhance quality control

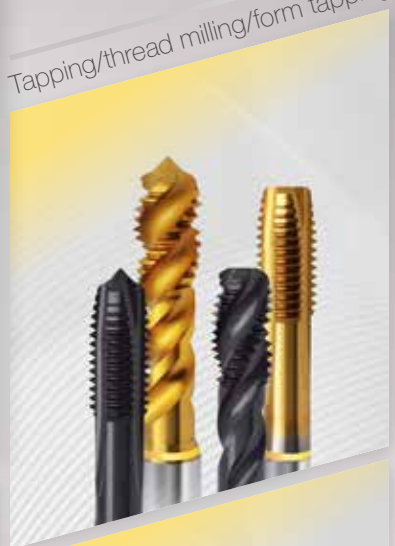


Guhring produces its own manufacturing equipment, which is used not only for tool production but also for reconditioning at the four Guhring plants across the USA. In-house coating chambers allow for quick and consistent recoats.

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