

NEW

RT 100 "US"

**The ultimate drill family
for high heat applications**



*Proven "wave" cutting edge design
Blazing fast penetration rates
Heat-resistant nano-A[®] coating
Ultra fine grain carbide*

NEW

RT 100 US

The ultimate drill for high heat applications

Increased feed rates -- 3 to 5 times higher than conventional style drills due to these features:

Radius or "wave" cutting edge design

Promotes better cutting edge shearing action and chip formation

Self-centering 140° point geometry

Allows aggressive feed rates, and does not require a spot drilling operation

Rolled heel design

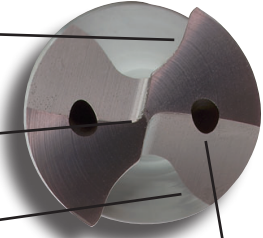
Extra chip space and improved chip evacuation

Larger coolant holes

Extra large ducts for improved delivery & maximum chip evacuation, NO PECK CYCLES NEEDED

nano-A® microlayer heat-resistant coating

Improves tool life in high temperature applications, resists built-up edge



- Series 5741 (3xD, solid carbide)**
- Series 5744 (5xD, coolant through)**
- Series 5746 (7xD, coolant through)**

Diameter (d1)				Series 5741		Series 5744		Series 5746	
Dec. inch	Fract. inch	Wire / letter	mm	I1 mm	I2 mm	I1 mm	I2 mm	I1 mm	I2 mm
0.1181			3.000	62.00	20.00	66.00	28.00	70.00	30.00
0.1220			3.100	62.00	20.00	66.00	28.00	70.00	30.00
0.1248	1/8		3.170	62.00	20.00	66.00	28.00	70.00	30.00
0.1260			3.200	62.00	20.00	66.00	28.00	70.00	30.00
0.1280			3.250	62.00	20.00	66.00	28.00		
0.1299			3.300	62.00	20.00	66.00	28.00	70.00	30.00
0.1339			3.400	62.00	20.00	66.00	28.00	75.00	37.50
0.1378			3.500	62.00	20.00	66.00	28.00	75.00	37.50
0.1406		28	3.570	62.00	20.00	66.00	28.00	75.00	37.50
0.1417			3.600	62.00	20.00	66.00	28.00	75.00	37.50
0.1457			3.700	62.00	20.00	66.00	28.00	75.00	37.50
0.1496		25	3.800	66.00	24.00	74.00	36.00	75.00	37.50
0.1535			3.900	66.00	24.00	74.00	36.00	75.00	37.50
0.1563	5/32		3.970	66.00	24.00	74.00	36.00	75.00	37.50
0.1575			4.000	66.00	24.00	74.00	36.00	75.00	37.50
0.1614			4.100	66.00	24.00	74.00	36.00	75.00	37.50
0.1654			4.200	66.00	24.00	74.00	36.00	75.00	37.50
0.1693		18	4.300	66.00	24.00	74.00	36.00	85.00	45.00
0.1720	11/64		4.370	66.00	24.00	74.00	36.00	85.00	45.00
0.1732			4.400	66.00	24.00	74.00	36.00	85.00	45.00
0.1772		16	4.500	66.00	24.00	74.00	36.00	85.00	45.00
0.1811			4.600	66.00	24.00	74.00	36.00	85.00	45.00
0.1831			4.650	66.00	24.00	74.00	36.00	85.00	45.00
0.1850		13	4.700	66.00	24.00	74.00	36.00	85.00	45.00
0.1874	3/16		4.760	66.00	28.00	82.00	44.00	90.00	50.00
0.1890		12	4.800	66.00	28.00	82.00	44.00	90.00	50.00
0.1929			4.900	66.00	28.00	82.00	44.00	90.00	50.00
0.1969			5.000	66.00	28.00	82.00	44.00	90.00	50.00
0.2008			5.100	66.00	28.00	82.00	44.00	90.00	50.00
0.2031	13/64		5.160	66.00	28.00	82.00	44.00	90.00	50.00
0.2047			5.200	66.00	28.00	82.00	44.00	90.00	50.00
0.2087			5.300	66.00	28.00	82.00	44.00	90.00	50.00
0.2126			5.400	66.00	28.00	82.00	44.00	90.00	50.00
0.2165			5.500	66.00	28.00	82.00	44.00	97.00	57.00

Diameter (d1)				Series 5741		Series 5744		Series 5746	
Dec. inch	Fract. inch	Wire / letter	mm	I1 mm	I2 mm	I1 mm	I2 mm	I1 mm	I2 mm
0.2185			5.550	66.00	28.00	82.00	44.00		
0.2189	7/32		5.560	66.00	28.00	82.00	44.00	97.00	57.00
0.2205			5.600	66.00	28.00	82.00	44.00		
0.2244			5.700	66.00	28.00	82.00	44.00	97.00	57.00
0.2283			5.800	66.00	28.00	82.00	44.00	97.00	57.00
0.2323			5.900	66.00	28.00	82.00	44.00	97.00	57.00
0.2343	15/64		5.950	66.00	28.00	82.00	44.00	97.00	57.00
0.2362			6.000	66.00	28.00	82.00	44.00	97.00	57.00
0.2402			6.100	79.00	34.00	91.00	53.00	106.00	66.00
0.2441			6.200	79.00	34.00	91.00	53.00	106.00	66.00
0.2480			6.300	79.00	34.00	91.00	53.00	106.00	66.00
0.2500	1/4	E	6.350	79.00	34.00	91.00	53.00	106.00	66.00
0.2520			6.400	79.00	34.00	91.00	53.00		
0.2559			6.500	79.00	34.00	91.00	53.00	106.00	66.00
0.2571			6.530			91.00	53.00	106.00	66.00
0.2598			6.600	79.00	34.00	91.00	53.00	106.00	66.00
0.2638			6.700	79.00	34.00	91.00	53.00	106.00	66.00
0.2657	17/64	H	6.750	79.00	34.00	91.00	53.00	106.00	66.00
0.2677			6.800	79.00	34.00	91.00	53.00	106.00	66.00
0.2717		I	6.900	79.00	34.00	91.00	53.00	116.00	76.00
0.2756			7.000	79.00	34.00	91.00	53.00	116.00	76.00
0.2795			7.100	79.00	34.00	91.00	53.00	116.00	76.00
0.2811	9/32	K	7.140	79.00	41.00	91.00	53.00	116.00	76.00
0.2835			7.200	79.00	41.00	91.00	53.00	116.00	76.00
0.2874			7.300	79.00	41.00	91.00	53.00	116.00	76.00
0.2913			7.400	79.00	41.00	91.00	53.00	116.00	76.00
0.2953			7.500	79.00	41.00	91.00	53.00	116.00	76.00
0.2969	19/64		7.540	79.00	41.00	91.00	53.00	116.00	76.00
0.2992			7.600	79.00	41.00	91.00	53.00	116.00	76.00
0.3031			7.700	79.00	41.00	91.00	53.00	116.00	76.00
0.3071			7.800	79.00	41.00	91.00	53.00	116.00	76.00
0.3110			7.900	79.00	41.00	91.00	53.00		
0.3126	5/16		7.940	79.00	41.00	91.00	53.00	116.00	76.00
0.3150			8.000	79.00	41.00	91.00	53.00	116.00	76.00

To order, specify drill series and mm diameter, i.e. 5744 5.500

Diameter (d1)				Series 5741		Series 5744		Series 5746	
Dec. inch	Fract. inch	Wire / letter	mm	I1 mm	I2 mm	I1 mm	I2 mm	I1 mm	I2 mm
0.3189			8.100	89.00	47.00	103.00	61.00	131.00	87.00
0.3228		P	8.200	89.00	47.00	103.00	61.00	131.00	87.00
0.3268			8.300	89.00	47.00	103.00	61.00		
0.3280	21/64		8.330	89.00	47.00	103.00	61.00	131.00	87.00
0.3307			8.400	89.00	47.00	103.00	61.00	131.00	87.00
0.3346			8.500	89.00	47.00	103.00	61.00	131.00	87.00
0.3386			8.600	89.00	47.00	103.00	61.00	131.00	87.00
0.3425			8.700	89.00	47.00	103.00	61.00	131.00	87.00
0.3437	11/32		8.730	89.00	47.00	103.00	61.00	131.00	87.00
0.3465			8.800	89.00	47.00	103.00	61.00	131.00	87.00
0.3504			8.900	89.00	47.00	103.00	61.00		
0.3543			9.000	89.00	47.00	103.00	61.00	131.00	87.00
0.3583			9.100	89.00	47.00	103.00	61.00	139.00	95.00
0.3594	23/64		9.130	89.00	47.00	103.00	61.00	139.00	95.00
0.3622			9.200	89.00	47.00	103.00	61.00	139.00	95.00
0.3642			9.250	89.00	47.00	103.00	61.00		
0.3661			9.300	89.00	47.00	103.00	61.00	139.00	95.00
0.3701			9.400	89.00	47.00	103.00	61.00	139.00	95.00
0.3740			9.500	89.00	47.00	103.00	61.00	139.00	95.00
0.3748	3/8		9.520	89.00	47.00	103.00	61.00	139.00	95.00
0.3780			9.600	89.00	47.00	103.00	61.00		
0.3819			9.700	89.00	47.00	103.00	61.00	139.00	95.00
0.3858		W	9.800	89.00	47.00	103.00	61.00	139.00	95.00
0.3898			9.900	89.00	47.00	103.00	61.00	139.00	95.00
0.3906	25/64		9.920	89.00	47.00	103.00	61.00	139.00	95.00
0.3937			10.000	89.00	47.00	103.00	61.00	139.00	95.00
0.3976			10.100	102.00	55.00	118.00	71.00		
0.4016			10.200	102.00	55.00	118.00	71.00	155.00	106.00
0.4055			10.300	102.00	55.00	118.00	71.00	155.00	106.00
0.4063	13/32		10.320	102.00	55.00	118.00	71.00	155.00	106.00
0.4094			10.400	102.00	55.00	118.00	71.00		
0.4134			10.500	102.00	55.00	118.00	71.00	155.00	106.00

Diameter (d1)				Series 5741		Series 5744		Series 5746	
Dec. inch	Fract. inch	Wire / letter	mm	I1 mm	I2 mm	I1 mm	I2 mm	I1 mm	I2 mm
0.4173			10.600	102.00	55.00	118.00	71.00		
0.4220	27/64		10.720	102.00	55.00	118.00	71.00	155.00	106.00
0.4252			10.800	102.00	55.00	118.00	71.00	155.00	106.00
0.4291			10.900	102.00	55.00	118.00	71.00		
0.4331			11.000	102.00	55.00	118.00	71.00	155.00	106.00
0.4370			11.100	102.00	55.00	118.00	71.00		
0.4374	7/16		11.110	102.00	55.00	118.00	71.00	163.00	114.00
0.4409			11.200	102.00	55.00	118.00	71.00	163.00	114.00
0.4449			11.300	102.00	55.00	118.00	71.00		
0.4488			11.400	102.00	55.00	118.00	71.00		
0.4528			11.500	102.00	55.00	118.00	71.00	163.00	114.00
0.4531	29/64		11.510	102.00	55.00	118.00	71.00		
0.4567			11.600	102.00	55.00	118.00	71.00		
0.4606			11.700	102.00	55.00	118.00	71.00		
0.4646			11.800	102.00	55.00	118.00	71.00	163.00	114.00
0.4685			11.900	102.00	55.00	118.00	71.00		
0.4689	15/32		11.910	102.00	55.00	118.00	71.00	163.00	114.00
0.4724			12.000	102.00	55.00	118.00	71.00	163.00	114.00
0.4764			12.100	107.00	60.00	124.00	77.00	182.00	133.00
0.4803			12.200	107.00	60.00	124.00	77.00	182.00	133.00
0.4843	31/64		12.300	107.00	60.00	124.00	77.00	182.00	133.00
0.4882			12.400	107.00	60.00	124.00	77.00		
0.4921			12.500	107.00	60.00	124.00	77.00	182.00	133.00
0.4961			12.600	107.00	60.00	124.00	77.00		
0.5000	1/2		12.700	107.00	60.00	124.00	77.00	182.00	133.00

Drill diameter	Shank diameter
3.0 - 6.0 mm	6.0 mm
6.1 - 8.0	8.0
8.1 - 10.0	10.0
10.1 - 12.0	12.0

Drill diameter	Shank diameter
12.1 - 14.0	14.0
14.1 - 16.0	16.0
16.1 - 18.0	18.0
18.1 - 20.0	20.0

To order, specify drill series and mm diameter, i.e. 5744 5.500

Additional diameters and lengths available as specials made in the USA - contact Guhring for price and delivery information.

RT 100 US

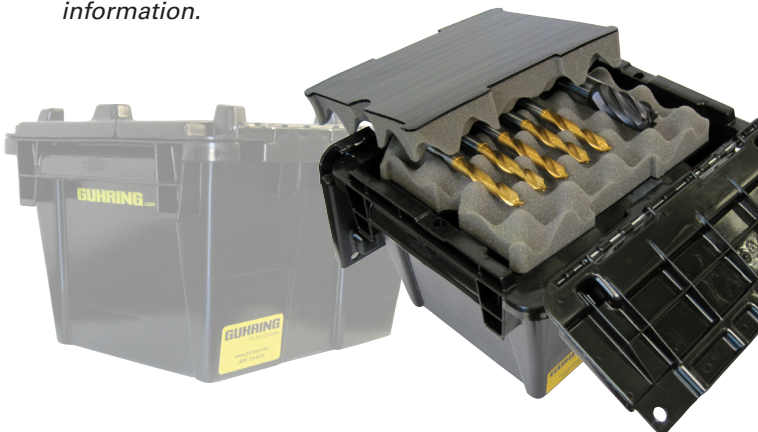
Excellent for use in stainless steels, nickel alloys, or hardened steels

An ideal solution for job shops running a range of heat generating materials

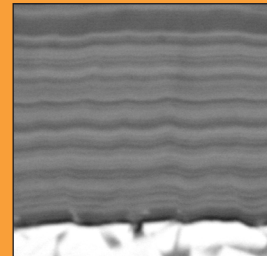
Reconditioning Services by Guhring -

High-performance drills that are too valuable to discard after one use are drills that require high-quality regrinds. Trust Guhring to restore the original point geometry and recoat your carbide drills as well as carbide end mills. Our quick turnaround and in-house coating chambers help to ensure your continued productivity.

Go to www.guhring.com/PS/Reconditioning.htm for further information.



nano-A®



Structure of nano layering - each layer is only a few nanometers thick

Guhring's newest PVD applied coating is nano-A®, a multi-layer coating that combines TiAlN and AlTiN coatings in a micro-layer structure that is harder and more wear resistant. Whereas TiAlN coating has an oxidation temperature of approximately 1470° F, AlTiN's oxidation temperature is approximately 1650° F, and the hardness is increased to 3,800 (HV 0.05). The micro-layer structure of nano-A makes this a better choice for applications where AlTiN would normally be used, such as hard milling steel and materials over 45 HRC; but test results have also shown that nano-A is frequently the best coating for high speed drilling and milling of all grades of stainless steels including 300 and 400 series grades.

Operating Parameters

Series # 5741

Material group	Hardness	SFM	Feed Rate- IPR			
			1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm
Common structural steels	≤100 Bhn >100-260 Bhn	425 360	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125
Free-cutting steels	≤24 Rc >24-30 Rc	475 360	0.0080 0.0065	0.0125 0.0100	0.0160 0.0125	0.0200 0.0160
Unalloyed heat-treatable steels	≤16 Rc 16-24 Rc 24-30 Rc	395 360 345	0.0065 0.0065 0.0065	0.0100 0.0100 0.0100	0.0125 0.0125 0.0125	0.0160 0.0160 0.0160
Alloyed heat-treatable steels	24-30 Rc >30-38 Rc	345 330	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125
Unalloyed case hardened steels	≤230 Bhn	425	0.0080	0.0125	0.0160	0.0200
Alloyed case hardened steels	24-30 Rc >30-38 Rc	395 280	0.0065 0.0040	0.0100 0.0065	0.0125 0.0080	0.0160 0.0100
Nitriding steels	≥24-30 Rc >30-38 Rc	330 295	0.0050 0.0040	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100
Tool steels	≤24 Rc >24-30 Rc	215 180	0.0050 0.0040	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100
High speed steels	≥14-30 Rc	150	0.0030	0.0050	0.0065	0.0080
Spring steels	≤330 Bhn	150	0.0025	0.0040	0.0050	0.0065
Stainless steels, sulphured	≤24 Rc	180	0.0030	0.0050	0.0065	0.0080
Stainless steels, austenitic	≤24 Rc	150	0.0030	0.0050	0.0065	0.0080
Stainless steels, martensitic	≤24 Rc	150	0.0025	0.0040	0.0050	0.0065
Hardened steels	≤40-48 Rc >48-60 Rc	150 80	0.0025 0.0020	0.0040 0.0030	0.0050 0.0040	0.0065 0.0050
Special alloys	≤38 Rc	80	0.0030	0.0050	0.0065	0.0080
Cast iron	≤240 Bhn <300 Bhn	690 510	0.0080 0.0080	0.0125 0.0125	0.0160 0.0160	0.0200 0.0200
Spheroidal graphite iron and malleable cast iron	≤240 Bhn <300 Bhn	510 410	0.0065 0.0065	0.0100 0.0100	0.0125 0.0125	0.0160 0.0160
Chilled cast iron	≤350 Bhn	115	0.0025	0.0040	0.0050	0.0065
Ti and Ti-alloys	≤24 Rc >24-38 Rc	130 115	0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065
Aluminium and Al-alloys	≤120 Bhn	855	0.0100	0.0160	0.0200	0.0245
Al wrought alloys	≤150 Bhn	855	0.0100	0.0160	0.0200	0.0245
Al cast alloys ≤ 10 % Si	≤200 Bhn	720	0.0080	0.0125	0.0160	0.0200
Al cast alloys > 10 % Si	≤200 Bhn	590	0.0080	0.0125	0.0160	0.0200
Magnesium alloys	≤150 Bhn	855	0.0080	0.0125	0.0160	0.0200
Copper, low-alloyed	≤120 Bhn	360	0.0065	0.0065	0.0100	0.0125
Brass, short-chipping	≤200 Bhn	885	0.0080	0.0125	0.0160	0.0200
Brass, long-chipping	≤200 Bhn	590	0.0065	0.0100	0.0125	0.0160
Bronze, short-chipping	≤200 Bhn	360	0.0065	0.0065	0.0100	0.0125
Bronze, long-chipping	>200-260 Bhn	330	0.0050	0.0050	0.0080	0.0100
Bronze, long-chipping	≤24 Rc >24-30 Rc	240 215	0.0050 0.0050	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100
Duroplastics	-	•	•	•	•	•
Thermoplastics	-	•	•	•	•	•
Reinforced plastics - Kevlar	-	•	•	•	•	•
Reinforced plastics - GFK / CFK	-	•	•	•	•	•

Series # 5744

Material group	Hardness	SFM	Feed Rate- IPR			
			1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm
Common structural steels	≤100 Bhn >100-260 Bhn	475 395	0.0065 0.0050	0.0100 0.0080	0.0125 0.0100	0.0160 0.0125
Free-cutting steels	≤24 Rc >24-30 Rc	560 475	0.0080 0.0080	0.0125 0.0125	0.0160 0.0160	0.0200 0.0200
Unalloyed heat-treatable steels	≤16 Rc 16-24 Rc 24-30 Rc	425 410 395	0.0080 0.0065 0.0065	0.0125 0.0100 0.0100	0.0160 0.0125 0.0125	0.0200 0.0160 0.0160
Alloyed heat-treatable steels	24-30 Rc >30-38 Rc	395 345	0.0065 0.0065	0.0100 0.0100	0.0125 0.0125	0.0160 0.0160
Unalloyed case hardened steels	≤230 Bhn	475	0.0080	0.0125	0.0160	0.0200
Alloyed case hardened steels	24-30 Rc >30-38 Rc	395 280	0.0065 0.0040	0.0100 0.0065	0.0125 0.0080	0.0160 0.0100
Nitriding steels	≥24-30 Rc >30-38 Rc	350 330	0.0065 0.0040	0.0100 0.0065	0.0125 0.0080	0.0160 0.0100
Tool steels	≤24 Rc >24-30 Rc	240 180	0.0050 0.0040	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100
High speed steels	≥14-30 Rc	195	0.0030	0.0050	0.0065	0.0080
Spring steels	≤330 Bhn	195	0.0025	0.0040	0.0050	0.0065
Stainless steels, sulphured	≤24 Rc	195	0.0040	0.0065	0.0080	0.0100
Stainless steels, austenitic	≤24 Rc	180	0.0040	0.0065	0.0080	0.0100
Stainless steels, martensitic	≤24 Rc	165	0.0040	0.0065	0.0080	0.0100
Hardened steels	≤40-48 Rc >48-60 Rc	180 115	0.0025 0.0020	0.0040 0.0030	0.0050 0.0040	0.0065 0.0050
Special alloys	≤38 Rc	115	0.0030	0.0050	0.0065	0.0080
Cast iron	≤240 Bhn <300 Bhn	690 525	0.0100 0.0100	0.0160 0.0160	0.0200 0.0200	0.0245 0.0245
Spheroidal graphite iron and malleable cast iron	≤240 Bhn <300 Bhn	450 425	0.0100 0.0080	0.0160 0.0125	0.0200 0.0160	0.0245 0.0200
Chilled cast iron	≤350 Bhn	130	0.0025	0.0040	0.0050	0.0065
Ti and Ti-alloys	≤24 Rc >24-38 Rc	150 130	0.0030 0.0025	0.0050 0.0040	0.0065 0.0050	0.0080 0.0065
Aluminium and Al-alloys	≤120 Bhn	1015	0.0080	0.0125	0.0160	0.0200
Al wrought alloys	≤150 Bhn	1015	0.0080	0.0125	0.0160	0.0200
Al cast alloys ≤ 10 % Si	≤200 Bhn	855	0.0080	0.0125	0.0160	0.0200
Al cast alloys > 10 % Si	≤200 Bhn	720	0.0080	0.0125	0.0160	0.0200
Magnesium alloys	≤150 Bhn	920	0.0080	0.0125	0.0160	0.0200
Copper, low-alloyed	≤120 Bhn	410	0.0065	0.0100	0.0125	0.0160
Brass, short-chipping	≤200 Bhn	1065	0.0080	0.0125	0.0160	0.0200
Brass, long-chipping	≤200 Bhn	720	0.0065	0.0100	0.0125	0.0160
Bronze, short-chipping	≤200 Bhn	410	0.0065	0.0100	0.0125	0.0160
Bronze, long-chipping	>200-260 Bhn	345	0.0050	0.0080	0.0100	0.0125
Bronze, long-chipping	≤24 Rc >24-30 Rc	295 260	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125
Duroplastics	-	•	•	•	•	•
Thermoplastics	-	•	•	•	•	•
Reinforced plastics - Kevlar	-	•	•	•	•	•
Reinforced plastics - GFK / CFK	-	•	•	•	•	•

Series # 5746

Material group	Hardness	SFM	Feed Rate- IPR			
			1/8 in. 3.170 mm	1/4 in. 6.350 mm	3/8 in. 9.520 mm	1/2 in. 12.700 mm
Common structural steels	≤100 Bhn >100-260 Bhn	460 395	0.0050 0.0040	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100
Free-cutting steels	≤24 Rc >24-30 Rc	550 480	0.0065 0.0065	0.0100 0.0100	0.0125 0.0125	0.0160 0.0160
Unalloyed heat-treatable steels	≤16 Rc 16-24 Rc 24-30 Rc	415 400 395	0.0065 0.0050 0.0050	0.0100 0.0080 0.0080	0.0125 0.0100 0.0100	0.0160 0.0125 0.0125
Alloyed heat-treatable steels	24-30 Rc >30-38 Rc	395 335	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125
Unalloyed case hardened steels	≤230 Bhn	465	0.0065	0.0100	0.0125	0.0160
Alloyed case hardened steels	24-30 Rc >30-38 Rc	395 270	0.0050 0.0030	0.0080 0.0050	0.0100 0.0065	0.0125 0.0080
Nitriding steels	≥24-30 Rc >30-38 Rc	340 325	0.0050 0.0040	0.0080 0.0065	0.0100 0.0080	0.0125 0.0100
Tool steels	≤24 Rc >24-30 Rc	230 175	0.0040 0.0030	0.0065 0.0050	0.0080 0.0065	0.0100 0.0080
High speed steels	≥14-30 Rc	195	0.0025	0.0040	0.0050	0.0065
Spring steels	≤330 Bhn	195	0.0020	0.0030	0.0040	0.0050
Stainless steels, sulphured	≤24 Rc	195	0.0030	0.0050	0.0065	0.0080
Stainless steels, austenitic	≤24 Rc	175	0.0030	0.0050	0.0065	0.0080
Stainless steels, martensitic	≤24 Rc	155	0.0030	0.0050	0.0065	0.0080
Hardened steels	≤40-48 Rc >48-60 Rc	175 110	0.0020 0.0020	0.0030 0.0030	0.0040 0.0040	0.0050 0.0050
Special alloys	≤38 Rc	110	0.0025	0.0040	0.0050	0.0065
Cast iron	≤240 Bhn <300 Bhn	640 525	0.0080 0.0080	0.0125 0.0125	0.0160 0.0160	0.0200 0.0200
Spheroidal graphite iron and malleable cast iron	≤240 Bhn <300 Bhn	435 415	0.0080 0.0065	0.0125 0.0100	0.0160 0.0125	0.0200 0.0160
Chilled cast iron	≤350 Bhn	130	0.0020	0.0030	0.0040	0.0050
Ti and Ti-alloys	≤24 Rc >24-38 Rc	140 130	0.0020 0.0020	0.0030 0.0030	0.0040 0.0040	0.0050 0.0050
Aluminium and Al-alloys	≤120 Bhn	1000	0.0080	0.0125	0.0160	0.0200
Al wrought alloys	≤150 Bhn	1000	0.0080	0.0125	0.0160	0.0200
Al cast alloys ≤ 10 % Si	≤200 Bhn	845	0.0080	0.0125	0.0160	0.0200
Al cast alloys > 10 % Si	≤200 Bhn	710	0.0080	0.0125	0.0160	0.0200
Magnesium alloys	≤150 Bhn	900	0.0065	0.0100	0.0125	0.0160
Copper, low-alloyed	≤120 Bhn	400	0.0065	0.0100	0.0125	0.0160
Brass, short-chipping	≤200 Bhn	1050	0.0080	0.0125	0.0160	0.0200
Brass, long-chipping	≤200 Bhn	710	0.0065	0.0100	0.0125	0.0160
Bronze, short-chipping	≤200 Bhn	410	0.0065	0.0100	0.0125	0.0160
Bronze, long-chipping	>200-260 Bhn	345	0.0050	0.0080	0.0100	0.0125
Bronze, long-chipping	≤24 Rc >24-30 Rc	285 250	0.0050 0.0050	0.0080 0.0080	0.0100 0.0100	0.0125 0.0125
Duroplastics	-	•	•	•	•	•
Thermoplastics	-	•	•	•	•	•
Reinforced plastics - Kevlar	-	•	•	•	•	•
Reinforced plastics - GFK / CFK	-	•	•	•	•	•

GUHRING

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