

GÜHRING



RT 100 **XF**

TOUGH. *EXTREME.* **POWERFUL.**

TOUGH. *EXTREME.* POWERFUL.

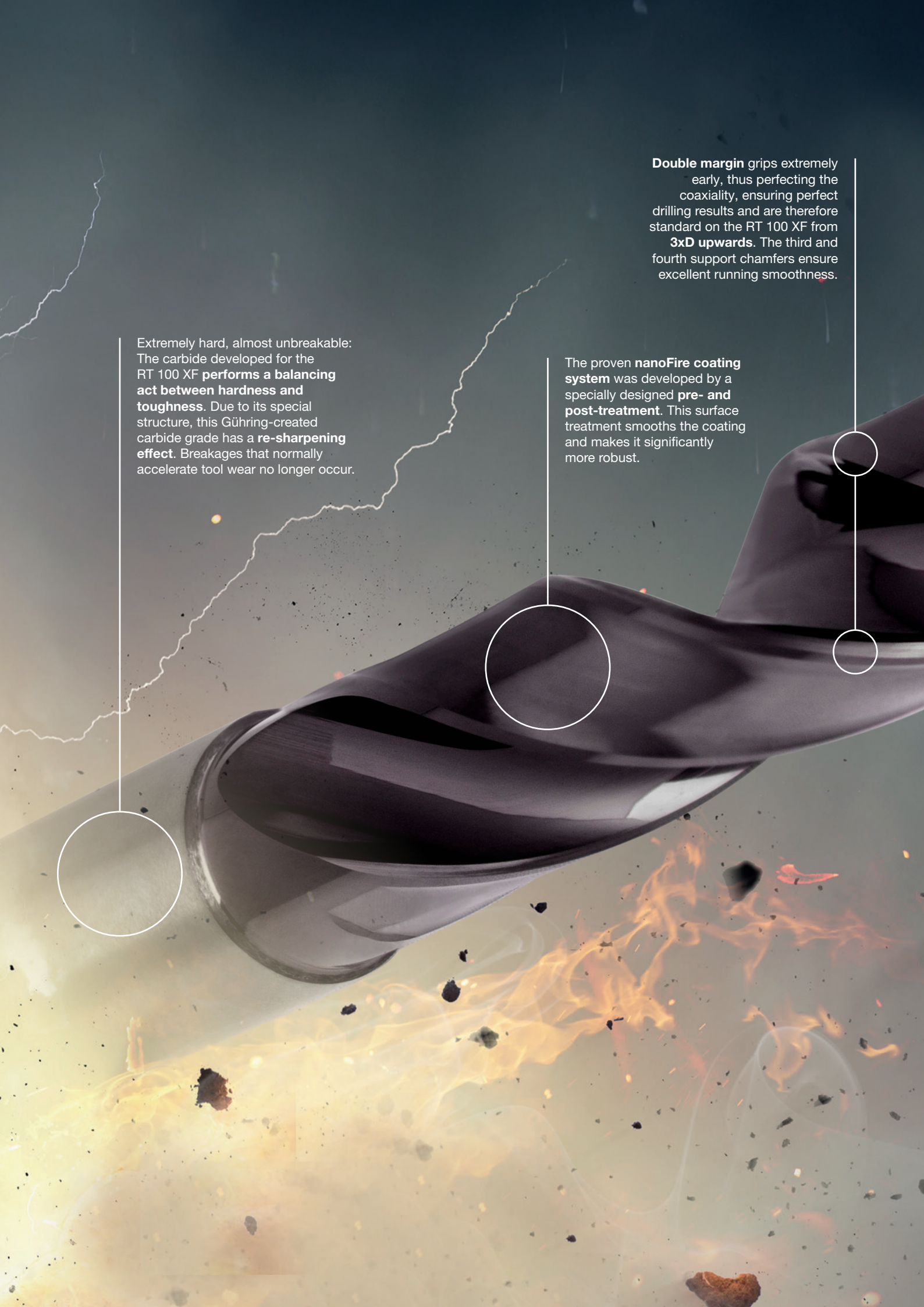
- ▶ **EXCEPTIONAL** METAL REMOVAL RATE
- ▶ **POWERFUL** MACHINING

120 years of manufacturing expertise, innovation and synergy: These are the pillars of our success that have allowed Gühring, once a pioneer of drilling solutions, to develop into an industry-leading full-service provider. This was made possible by our own R&D departments in geometry, production and coating, the production of proprietary cutting materials, as well as grinding and coating systems. These elements find their way into the performance of our products, enabling us to continually set new standards for the industry.

This leading expertise serves as the basis for the RT 100 XF. Exceptional performance and a qualitative advantage. With unbridled power and guaranteed outstanding results for your processes.

The RT 100 XF. Tough. Extreme. Powerful.

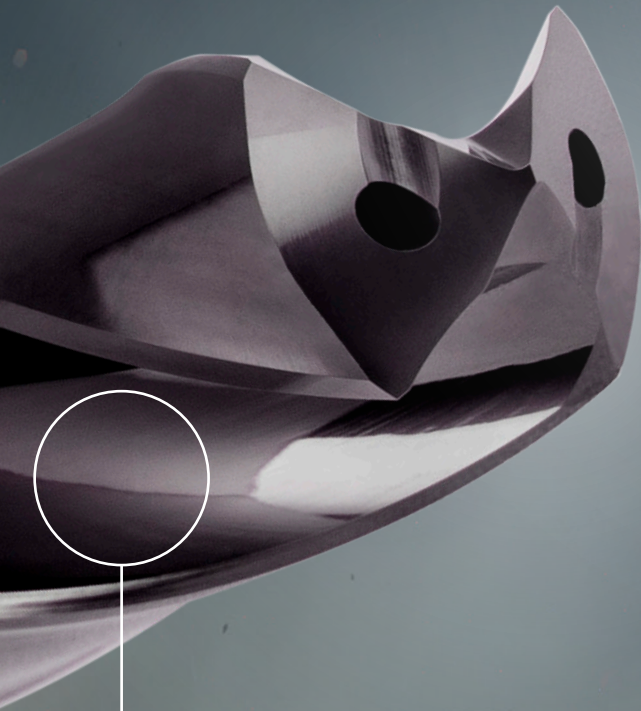




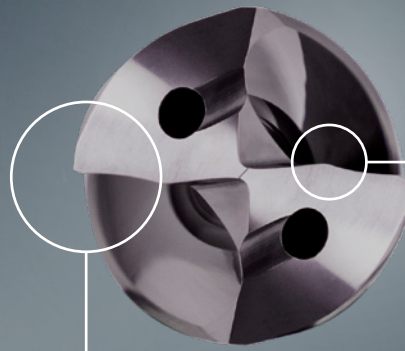
Double margin grips extremely early, thus perfecting the coaxiality, ensuring perfect drilling results and are therefore standard on the RT 100 XF from **3xD upwards**. The third and fourth support chamfers ensure excellent running smoothness.

Extremely hard, almost unbreakable: The carbide developed for the RT 100 XF **performs a balancing act between hardness and toughness**. Due to its special structure, this Gühring-created carbide grade has a **re-sharpening effect**. Breakages that normally accelerate tool wear no longer occur.

The proven **nanoFire coating system** was developed by a specially designed **pre- and post-treatment**. This surface treatment smooths the coating and makes it significantly more robust.



Polished flutes reduce the heat input into the component. The chip flows off faster; thermal changes such as hardening are avoided.



The **point geometry, protected by a negative chamfer along the side cutting edge**, makes the cutting edge ultra-robust and durable. For exceptional performance.

The **rounding of the cutting edge** produces a stable and efficient cutting edge. The **accurate reproducibility** of this rounding (to the nearest micrometre) is made possible by our manufacturing competence. Original quality is restored in the in-house regrinding and re-coating centres.

- Combined optimisation of all tool parameters enables **outstanding feed rates** and **exceptional metal removal rates**
- In-house high-end finishing for **maximum performance utilisation**
- **Reduced cycle times** for difficult-to-machine materials and special applications in series production

RT 100 **XF**

TOUGH. EXTREME. POWERFUL.

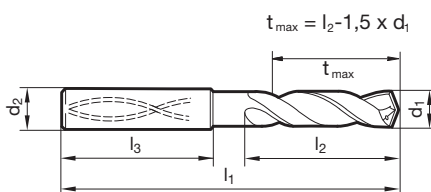


Ratio drills with coolant ducts



- P** ● relieved cone • main cutting edge form concave • optimised 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** ○

Tool material	Solid carbide
Surface	F
Shank form	HA



Article no. **6498**

Discount group **255**

Cutting direction

d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
3.000		6.00	62.00	20.00	36.00	●
3.100		6.00	62.00	20.00	36.00	●
3.170	1/8	6.00	62.00	20.00	36.00	●
3.200		6.00	62.00	20.00	36.00	●
3.250		6.00	62.00	20.00	36.00	●
3.300		6.00	62.00	20.00	36.00	●
3.400		6.00	62.00	20.00	36.00	●
3.500		6.00	62.00	20.00	36.00	●
3.570	9/64	6.00	62.00	20.00	36.00	●
3.600		6.00	62.00	20.00	36.00	●
3.700		6.00	62.00	20.00	36.00	●
3.800		6.00	66.00	24.00	36.00	●
3.900		6.00	66.00	24.00	36.00	●
3.970	5/32	6.00	66.00	24.00	36.00	●
4.000		6.00	66.00	24.00	36.00	●
4.040		6.00	66.00	24.00	36.00	●
4.100		6.00	66.00	24.00	36.00	●
4.200		6.00	66.00	24.00	36.00	●
4.300		6.00	66.00	24.00	36.00	●
4.370	11/64	6.00	66.00	24.00	36.00	●
4.400		6.00	66.00	24.00	36.00	●
4.500		6.00	66.00	24.00	36.00	●
4.600		6.00	66.00	24.00	36.00	●
4.650		6.00	66.00	24.00	36.00	●
4.700		6.00	66.00	24.00	36.00	●
4.760	3/16	6.00	66.00	28.00	36.00	●
4.800		6.00	66.00	28.00	36.00	●
4.900		6.00	66.00	28.00	36.00	●
5.000		6.00	66.00	28.00	36.00	●
5.100		6.00	66.00	28.00	36.00	●
5.110		6.00	66.00	28.00	36.00	●
5.160	13/64	6.00	66.00	28.00	36.00	●
5.200		6.00	66.00	28.00	36.00	●
5.300		6.00	66.00	28.00	36.00	●
5.400		6.00	66.00	28.00	36.00	●
5.410		6.00	66.00	28.00	36.00	●



Article no. 6498						Availability
Discount group 255						
Cutting direction (R)						
d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
5.500		6.00	66.00	28.00	36.00	●
5.550		6.00	66.00	28.00	36.00	●
5.560	7/32	6.00	66.00	28.00	36.00	●
5.600		6.00	66.00	28.00	36.00	●
5.700		6.00	66.00	28.00	36.00	●
5.800		6.00	66.00	28.00	36.00	●
5.900		6.00	66.00	28.00	36.00	●
5.950	15/64	6.00	66.00	28.00	36.00	●
6.000		6.00	66.00	28.00	36.00	●
6.100		8.00	79.00	34.00	36.00	●
6.200		8.00	79.00	34.00	36.00	●
6.300		8.00	79.00	34.00	36.00	●
6.350	1/4	8.00	79.00	34.00	36.00	●
6.400		8.00	79.00	34.00	36.00	●
6.500		8.00	79.00	34.00	36.00	●
6.530		8.00	79.00	34.00	36.00	●
6.550		8.00	79.00	34.00	36.00	●
6.600		8.00	79.00	34.00	36.00	●
6.700		8.00	79.00	34.00	36.00	●
6.750	17/64	8.00	79.00	34.00	36.00	●
6.800		8.00	79.00	34.00	36.00	●
6.900		8.00	79.00	34.00	36.00	●
7.000		8.00	79.00	34.00	36.00	●
7.100		8.00	79.00	41.00	36.00	●
7.140	9/32	8.00	79.00	41.00	36.00	●
7.200		8.00	79.00	41.00	36.00	●
7.300		8.00	79.00	41.00	36.00	●
7.400		8.00	79.00	41.00	36.00	●
7.500		8.00	79.00	41.00	36.00	●
7.540	19/64	8.00	79.00	41.00	36.00	●
7.550		8.00	79.00	41.00	36.00	●
7.600		8.00	79.00	41.00	36.00	●
7.650		8.00	79.00	41.00	36.00	●
7.700		8.00	79.00	41.00	36.00	●
7.800		8.00	79.00	41.00	36.00	●
7.900		8.00	79.00	41.00	36.00	●
7.940	5/16	8.00	79.00	41.00	36.00	●
8.000		8.00	79.00	41.00	36.00	●
8.100		10.00	89.00	47.00	40.00	●
8.200		10.00	89.00	47.00	40.00	●
8.300		10.00	89.00	47.00	40.00	●
8.330	21/64	10.00	89.00	47.00	40.00	●
8.400		10.00	89.00	47.00	40.00	●
8.500		10.00	89.00	47.00	40.00	●
8.600		10.00	89.00	47.00	40.00	●
8.700		10.00	89.00	47.00	40.00	●
8.730	11/32	10.00	89.00	47.00	40.00	●
8.800		10.00	89.00	47.00	40.00	●
8.900		10.00	89.00	47.00	40.00	●
9.000		10.00	89.00	47.00	40.00	●
9.100		10.00	89.00	47.00	40.00	●
9.130	23/64	10.00	89.00	47.00	40.00	●
9.200		10.00	89.00	47.00	40.00	●
9.250		10.00	89.00	47.00	40.00	●
9.300		10.00	89.00	47.00	40.00	●
9.340		10.00	89.00	47.00	40.00	●
9.400		10.00	89.00	47.00	40.00	●
9.500		10.00	89.00	47.00	40.00	●
9.520	3/8	10.00	89.00	47.00	40.00	●
9.550		10.00	89.00	47.00	40.00	●



Article no. 6498						Availability
Discount group 255						
Cutting direction (R)						
d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
9.600		10.00	89.00	47.00	40.00	●
9.700		10.00	89.00	47.00	40.00	●
9.800		10.00	89.00	47.00	40.00	●
9.900		10.00	89.00	47.00	40.00	●
9.920	25/64	10.00	89.00	47.00	40.00	●
10.000		10.00	89.00	47.00	40.00	●
10.100		12.00	102.00	55.00	45.00	●
10.200		12.00	102.00	55.00	45.00	●
10.300		12.00	102.00	55.00	45.00	●
10.320	13/32	12.00	102.00	55.00	45.00	●
10.400		12.00	102.00	55.00	45.00	●
10.500		12.00	102.00	55.00	45.00	●
10.600		12.00	102.00	55.00	45.00	●
10.700		12.00	102.00	55.00	45.00	●
10.720	27/64	12.00	102.00	55.00	45.00	●
10.800		12.00	102.00	55.00	45.00	●
10.900		12.00	102.00	55.00	45.00	●
11.000		12.00	102.00	55.00	45.00	●
11.100		12.00	102.00	55.00	45.00	●
11.110	7/16	12.00	102.00	55.00	45.00	●
11.200		12.00	102.00	55.00	45.00	●
11.300		12.00	102.00	55.00	45.00	●
11.400		12.00	102.00	55.00	45.00	●
11.500		12.00	102.00	55.00	45.00	●
11.510	29/64	12.00	102.00	55.00	45.00	●
11.550		12.00	102.00	55.00	45.00	●
11.600		12.00	102.00	55.00	45.00	●
11.700		12.00	102.00	55.00	45.00	●
11.800		12.00	102.00	55.00	45.00	●
11.900		12.00	102.00	55.00	45.00	●
11.910	15/32	12.00	102.00	55.00	45.00	●
12.000		12.00	102.00	55.00	45.00	●
12.100		14.00	107.00	60.00	45.00	●
12.200		14.00	107.00	60.00	45.00	●
12.300	31/64	14.00	107.00	60.00	45.00	●
12.400		14.00	107.00	60.00	45.00	●
12.500		14.00	107.00	60.00	45.00	●
12.600		14.00	107.00	60.00	45.00	●
12.700	1/2	14.00	107.00	60.00	45.00	●
12.800		14.00	107.00	60.00	45.00	●
12.900		14.00	107.00	60.00	45.00	●
13.000		14.00	107.00	60.00	45.00	●
13.100	33/64	14.00	107.00	60.00	45.00	●
13.200		14.00	107.00	60.00	45.00	●
13.300		14.00	107.00	60.00	45.00	●
13.400		14.00	107.00	60.00	45.00	●
13.490	17/32	14.00	107.00	60.00	45.00	●
13.500		14.00	107.00	60.00	45.00	●
13.600		14.00	107.00	60.00	45.00	●
13.700		14.00	107.00	60.00	45.00	●
13.800		14.00	107.00	60.00	45.00	●
13.890	35/64	14.00	107.00	60.00	45.00	●
13.900		14.00	107.00	60.00	45.00	●
14.000		14.00	107.00	60.00	45.00	●
14.100		16.00	115.00	65.00	48.00	●
14.200		16.00	115.00	65.00	48.00	●
14.290	9/16	16.00	115.00	65.00	48.00	●
14.300		16.00	115.00	65.00	48.00	●
14.400		16.00	115.00	65.00	48.00	●
14.500		16.00	115.00	65.00	48.00	●



Article no. 6498						Availability
Discount group 255						
Cutting direction (R)						
d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
14.600		16.00	115.00	65.00	48.00	●
14.680	37/64	16.00	115.00	65.00	48.00	●
14.700		16.00	115.00	65.00	48.00	●
14.800		16.00	115.00	65.00	48.00	●
14.900		16.00	115.00	65.00	48.00	●
15.000		16.00	115.00	65.00	48.00	●
15.080	19/32	16.00	115.00	65.00	48.00	●
15.100		16.00	115.00	65.00	48.00	●
15.200		16.00	115.00	65.00	48.00	●
15.300		16.00	115.00	65.00	48.00	●
15.400		16.00	115.00	65.00	48.00	●
15.480	39/64	16.00	115.00	65.00	48.00	●
15.500		16.00	115.00	65.00	48.00	●
15.550		16.00	115.00	65.00	48.00	●
15.600		16.00	115.00	65.00	48.00	●
15.700		16.00	115.00	65.00	48.00	●
15.800		16.00	115.00	65.00	48.00	●
15.870	5/8	16.00	115.00	65.00	48.00	●
15.900		16.00	115.00	65.00	48.00	●
16.000		16.00	115.00	65.00	48.00	●
16.270	41/64	18.00	123.00	73.00	48.00	●
16.300		18.00	123.00	73.00	48.00	●
16.500		18.00	123.00	73.00	48.00	●
16.670	21/32	18.00	123.00	73.00	48.00	●
16.700		18.00	123.00	73.00	48.00	●
16.900		18.00	123.00	73.00	48.00	●
17.000		18.00	123.00	73.00	48.00	●
17.070	43/64	18.00	123.00	73.00	48.00	●
17.460	11/16	18.00	123.00	73.00	48.00	●
17.500		18.00	123.00	73.00	48.00	●
17.550		18.00	123.00	73.00	48.00	●
17.700		18.00	123.00	73.00	48.00	●
17.860	45/64	18.00	123.00	73.00	48.00	●
18.000		18.00	123.00	73.00	48.00	●
18.260	23/32	20.00	131.00	79.00	50.00	●
18.500		20.00	131.00	79.00	50.00	●
18.700		20.00	131.00	79.00	50.00	●
18.900		20.00	131.00	79.00	50.00	●
19.000		20.00	131.00	79.00	50.00	●
19.050	3/4	20.00	131.00	79.00	50.00	●
19.250		20.00	131.00	79.00	50.00	●
19.300		20.00	131.00	79.00	50.00	●
19.450	49/64	20.00	131.00	79.00	50.00	●
19.500		20.00	131.00	79.00	50.00	●
19.550		20.00	131.00	79.00	50.00	●
19.700		20.00	131.00	79.00	50.00	●
19.800		20.00	131.00	79.00	50.00	●
19.840	25/32	20.00	131.00	79.00	50.00	●
20.000		20.00	131.00	79.00	50.00	●



Ratio drills with coolant ducts

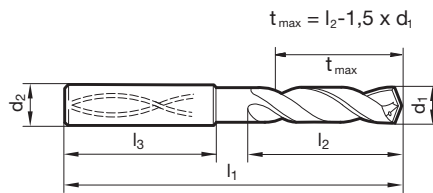


Tool material **Solid carbide**

Surface **F**

Shank form HA

- P** ● relieved cone • main cutting edge form concave • optimised 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** ○



Article no. **5498**

Discount group **255**

Cutting direction **R**

d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
3.000		6.00	66.00	28.00	36.00	●
3.100		6.00	66.00	28.00	36.00	●
3.170	1/8	6.00	66.00	28.00	36.00	●
3.200		6.00	66.00	28.00	36.00	●
3.250		6.00	66.00	28.00	36.00	●
3.300		6.00	66.00	28.00	36.00	●
3.400		6.00	66.00	28.00	36.00	●
3.500		6.00	66.00	28.00	36.00	●
3.570	9/64	6.00	66.00	28.00	36.00	●
3.600		6.00	66.00	28.00	36.00	●
3.700		6.00	66.00	28.00	36.00	●
3.800		6.00	74.00	36.00	36.00	●
3.900		6.00	74.00	36.00	36.00	●
3.970	5/32	6.00	74.00	36.00	36.00	●
4.000		6.00	74.00	36.00	36.00	●
4.040		6.00	74.00	36.00	36.00	●
4.100		6.00	74.00	36.00	36.00	●
4.200		6.00	74.00	36.00	36.00	●
4.300		6.00	74.00	36.00	36.00	●
4.370	11/64	6.00	74.00	36.00	36.00	●
4.400		6.00	74.00	36.00	36.00	●
4.500		6.00	74.00	36.00	36.00	●
4.600		6.00	74.00	36.00	36.00	●
4.650		6.00	74.00	36.00	36.00	●
4.700		6.00	74.00	36.00	36.00	●
4.760	3/16	6.00	82.00	44.00	36.00	●
4.800		6.00	82.00	44.00	36.00	●
4.900		6.00	82.00	44.00	36.00	●
5.000		6.00	82.00	44.00	36.00	●
5.100		6.00	82.00	44.00	36.00	●
5.110		6.00	82.00	44.00	36.00	●
5.160	13/64	6.00	82.00	44.00	36.00	●
5.200		6.00	82.00	44.00	36.00	●
5.300		6.00	82.00	44.00	36.00	●
5.400		6.00	82.00	44.00	36.00	●
5.410		6.00	82.00	44.00	36.00	●



Article no. 5498						Cutting direction (R)
Discount group 255						
d1		d2	l1	l2	l3	
mm	inch	mm	mm	mm	mm	Availability
5.500		6.00	82.00	44.00	36.00	●
5.550		6.00	82.00	44.00	36.00	●
5.560	7/32	6.00	82.00	44.00	36.00	●
5.600		6.00	82.00	44.00	36.00	●
5.700		6.00	82.00	44.00	36.00	●
5.800		6.00	82.00	44.00	36.00	●
5.900		6.00	82.00	44.00	36.00	●
5.950	15/64	6.00	82.00	44.00	36.00	●
6.000		6.00	82.00	44.00	36.00	●
6.100		8.00	91.00	53.00	36.00	●
6.200		8.00	91.00	53.00	36.00	●
6.300		8.00	91.00	53.00	36.00	●
6.350	1/4	8.00	91.00	53.00	36.00	●
6.400		8.00	91.00	53.00	36.00	●
6.500		8.00	91.00	53.00	36.00	●
6.530		8.00	91.00	53.00	36.00	●
6.550		8.00	91.00	53.00	36.00	●
6.600		8.00	91.00	53.00	36.00	●
6.700		8.00	91.00	53.00	36.00	●
6.750	17/64	8.00	91.00	53.00	36.00	●
6.800		8.00	91.00	53.00	36.00	●
6.900		8.00	91.00	53.00	36.00	●
7.000		8.00	91.00	53.00	36.00	●
7.100		8.00	91.00	53.00	36.00	●
7.140	9/32	8.00	91.00	53.00	36.00	●
7.200		8.00	91.00	53.00	36.00	●
7.300		8.00	91.00	53.00	36.00	●
7.400		8.00	91.00	53.00	36.00	●
7.500		8.00	91.00	53.00	36.00	●
7.540	19/64	8.00	91.00	53.00	36.00	●
7.550		8.00	91.00	53.00	36.00	●
7.600		8.00	91.00	53.00	36.00	●
7.650		8.00	91.00	53.00	36.00	●
7.700		8.00	91.00	53.00	36.00	●
7.800		8.00	91.00	53.00	36.00	●
7.900		8.00	91.00	53.00	36.00	●
7.940	5/16	8.00	91.00	53.00	36.00	●
8.000		8.00	91.00	53.00	36.00	●
8.100		10.00	103.00	61.00	40.00	●
8.200		10.00	103.00	61.00	40.00	●
8.300		10.00	103.00	61.00	40.00	●
8.330	21/64	10.00	103.00	61.00	40.00	●
8.400		10.00	103.00	61.00	40.00	●
8.500		10.00	103.00	61.00	40.00	●
8.600		10.00	103.00	61.00	40.00	●
8.700		10.00	103.00	61.00	40.00	●
8.730	11/32	10.00	103.00	61.00	40.00	●
8.800		10.00	103.00	61.00	40.00	●
8.900		10.00	103.00	61.00	40.00	●
9.000		10.00	103.00	61.00	40.00	●
9.100		10.00	103.00	61.00	40.00	●
9.130	23/64	10.00	103.00	61.00	40.00	●
9.200		10.00	103.00	61.00	40.00	●
9.250		10.00	103.00	61.00	40.00	●
9.300		10.00	103.00	61.00	40.00	●
9.340		10.00	103.00	61.00	40.00	●
9.400		10.00	103.00	61.00	40.00	●
9.500		10.00	103.00	61.00	40.00	●
9.520	3/8	10.00	103.00	61.00	40.00	●
9.550		10.00	103.00	61.00	40.00	●



Article no. 5498						Cutting direction (R)
Discount group 255						
d1		d2	l1	l2	l3	
mm	inch	mm	mm	mm	mm	Availability
9.600		10.00	103.00	61.00	40.00	●
9.700		10.00	103.00	61.00	40.00	●
9.800		10.00	103.00	61.00	40.00	●
9.900		10.00	103.00	61.00	40.00	●
9.920	25/64	10.00	103.00	61.00	40.00	●
10.000		10.00	103.00	61.00	40.00	●
10.100		12.00	118.00	71.00	45.00	●
10.200		12.00	118.00	71.00	45.00	●
10.300		12.00	118.00	71.00	45.00	●
10.320	13/32	12.00	118.00	71.00	45.00	●
10.400		12.00	118.00	71.00	45.00	●
10.500		12.00	118.00	71.00	45.00	●
10.600		12.00	118.00	71.00	45.00	●
10.700		12.00	118.00	71.00	45.00	●
10.720	27/64	12.00	118.00	71.00	45.00	●
10.800		12.00	118.00	71.00	45.00	●
10.900		12.00	118.00	71.00	45.00	●
11.000		12.00	118.00	71.00	45.00	●
11.100		12.00	118.00	71.00	45.00	●
11.110	7/16	12.00	118.00	71.00	45.00	●
11.200		12.00	118.00	71.00	45.00	●
11.300		12.00	118.00	71.00	45.00	●
11.400		12.00	118.00	71.00	45.00	●
11.500		12.00	118.00	71.00	45.00	●
11.510	29/64	12.00	118.00	71.00	45.00	●
11.550		12.00	118.00	71.00	45.00	●
11.600		12.00	118.00	71.00	45.00	●
11.700		12.00	118.00	71.00	45.00	●
11.800		12.00	118.00	71.00	45.00	●
11.900		12.00	118.00	71.00	45.00	●
11.910	15/32	12.00	118.00	71.00	45.00	●
12.000		12.00	118.00	71.00	45.00	●
12.100		14.00	124.00	77.00	45.00	●
12.200		14.00	124.00	77.00	45.00	●
12.300	31/64	14.00	124.00	77.00	45.00	●
12.400		14.00	124.00	77.00	45.00	●
12.500		14.00	124.00	77.00	45.00	●
12.600		14.00	124.00	77.00	45.00	●
12.700	1/2	14.00	124.00	77.00	45.00	●
12.800		14.00	124.00	77.00	45.00	●
12.900		14.00	124.00	77.00	45.00	●
13.000		14.00	124.00	77.00	45.00	●
13.100	33/64	14.00	124.00	77.00	45.00	●
13.200		14.00	124.00	77.00	45.00	●
13.300		14.00	124.00	77.00	45.00	●
13.400		14.00	124.00	77.00	45.00	●
13.490	17/32	14.00	124.00	77.00	45.00	●
13.500		14.00	124.00	77.00	45.00	●
13.600		14.00	124.00	77.00	45.00	●
13.700		14.00	124.00	77.00	45.00	●
13.800		14.00	124.00	77.00	45.00	●
13.890	35/64	14.00	124.00	77.00	45.00	●
13.900		14.00	124.00	77.00	45.00	●
14.000		14.00	124.00	77.00	45.00	●
14.100		16.00	133.00	83.00	48.00	●
14.200		16.00	133.00	83.00	48.00	●
14.290	9/16	16.00	133.00	83.00	48.00	●
14.300		16.00	133.00	83.00	48.00	●
14.400		16.00	133.00	83.00	48.00	●
14.500		16.00	133.00	83.00	48.00	●



Article no. 5498						Cutting direction (R)
Discount group 255						
d1		d2	l1	l2	l3	
mm	inch	mm	mm	mm	mm	Availability
14.600		16.00	133.00	83.00	48.00	●
14.680	37/64	16.00	133.00	83.00	48.00	●
14.700		16.00	133.00	83.00	48.00	●
14.800		16.00	133.00	83.00	48.00	●
14.900		16.00	133.00	83.00	48.00	●
15.000		16.00	133.00	83.00	48.00	●
15.080	19/32	16.00	133.00	83.00	48.00	●
15.100		16.00	133.00	83.00	48.00	●
15.200		16.00	133.00	83.00	48.00	●
15.300		16.00	133.00	83.00	48.00	●
15.400		16.00	133.00	83.00	48.00	●
15.480	39/64	16.00	133.00	83.00	48.00	●
15.500		16.00	133.00	83.00	48.00	●
15.550		16.00	133.00	83.00	48.00	●
15.600		16.00	133.00	83.00	48.00	●
15.700		16.00	133.00	83.00	48.00	●
15.800		16.00	133.00	83.00	48.00	●
15.870	5/8	16.00	133.00	83.00	48.00	●
15.900		16.00	133.00	83.00	48.00	●
16.000		16.00	133.00	83.00	48.00	●
16.270	41/64	18.00	143.00	93.00	48.00	●
16.300		18.00	143.00	93.00	48.00	●
16.500		18.00	143.00	93.00	48.00	●
16.670	21/32	18.00	143.00	93.00	48.00	●
16.700		18.00	143.00	93.00	48.00	●
16.900		18.00	143.00	93.00	48.00	●
17.000		18.00	143.00	93.00	48.00	●
17.070	43/64	18.00	143.00	93.00	48.00	●
17.460	11/16	18.00	143.00	93.00	48.00	●
17.500		18.00	143.00	93.00	48.00	●
17.550		18.00	143.00	93.00	48.00	●
17.700		18.00	143.00	93.00	48.00	●
17.860	45/64	18.00	143.00	93.00	48.00	●
18.000		18.00	143.00	93.00	48.00	●
18.260	23/32	20.00	153.00	101.00	50.00	●
18.500		20.00	153.00	101.00	50.00	●
18.700		20.00	153.00	101.00	50.00	●
18.900		20.00	153.00	101.00	50.00	●
19.000		20.00	153.00	101.00	50.00	●
19.050	3/4	20.00	153.00	101.00	50.00	●
19.250		20.00	153.00	101.00	50.00	●
19.300		20.00	153.00	101.00	50.00	●
19.446		20.00	153.00	101.00	50.00	●
19.500		20.00	153.00	101.00	50.00	●
19.550		20.00	153.00	101.00	50.00	●
19.700		20.00	153.00	101.00	50.00	●
19.800		20.00	153.00	101.00	50.00	●
19.840	25/32	20.00	153.00	101.00	50.00	●
20.000		20.00	153.00	101.00	50.00	●



Ratio drills with coolant ducts



Tool material **Solid carbide**

Surface **F**

Shank form HA

P ● relieved cone • main cutting edge form concave • optimised cutting geometry • maximum performance

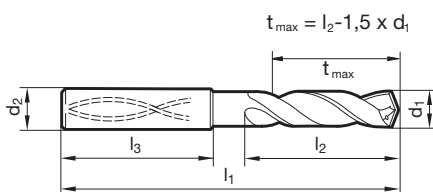
M ○

K ○

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

S ○

H ○



Article no. **5499**

Discount group **255**

Cutting direction **R**

d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
3.000		6.000	70.000	30.000	36.000	●
3.100		6.000	70.000	30.000	36.000	●
3.170	1/8	6.000	70.000	30.000	36.000	●
3.200		6.000	70.000	30.000	36.000	●
3.250		6.000	70.000	30.000	36.000	●
3.300		6.000	70.000	30.000	36.000	●
3.400		6.000	75.000	35.500	36.000	●
3.500		6.000	75.000	35.500	36.000	●
3.570	9/64	6.000	75.000	35.500	36.000	●
3.600		6.000	75.000	35.500	36.000	●
3.700		6.000	75.000	35.500	36.000	●
3.800		6.000	75.000	37.500	36.000	●
3.900		6.000	75.000	37.500	36.000	●
3.970	5/32	6.000	75.000	37.500	36.000	●
4.000		6.000	75.000	37.500	36.000	●
4.040		6.000	75.000	37.500	36.000	●
4.100		6.000	75.000	37.500	36.000	●
4.200		6.000	75.000	37.500	36.000	●
4.300		6.000	85.000	45.000	36.000	●
4.370	11/64	6.000	85.000	45.000	36.000	●
4.400		6.000	85.000	45.000	36.000	●
4.500		6.000	85.000	45.000	36.000	●
4.600		6.000	85.000	45.000	36.000	●
4.650		6.000	85.000	45.000	36.000	●
4.700		6.000	85.000	45.000	36.000	●
4.760	3/16	6.000	90.000	50.000	36.000	●
4.800		6.000	90.000	50.000	36.000	●
4.900		6.000	90.000	50.000	36.000	●
5.000		6.000	90.000	50.000	36.000	●
5.100		6.000	90.000	50.000	36.000	●
5.110		6.000	90.000	50.000	36.000	●
5.160	13/64	6.000	90.000	50.000	36.000	●
5.200		6.000	90.000	50.000	36.000	●
5.300		6.000	90.000	50.000	36.000	●
5.400		6.000	97.000	57.000	36.000	●
5.410		6.000	97.000	57.000	36.000	●



Article no.						5499
Discount group						255
Cutting direction						(R)
d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
5.500		6.000	97.000	57.000	36.000	●
5.550		6.000	97.000	57.000	36.000	●
5.560	7/32	6.000	97.000	57.000	36.000	●
5.600		6.000	97.000	57.000	36.000	●
5.700		6.000	97.000	57.000	36.000	●
5.800		6.000	97.000	57.000	36.000	●
5.900		6.000	97.000	57.000	36.000	●
5.950	15/64	6.000	97.000	57.000	36.000	●
6.000		6.000	97.000	57.000	36.000	●
6.100		8.000	106.000	66.000	36.000	●
6.200		8.000	106.000	66.000	36.000	●
6.300		8.000	106.000	66.000	36.000	●
6.350	1/4	8.000	106.000	66.000	36.000	●
6.400		8.000	106.000	66.000	36.000	●
6.500		8.000	106.000	66.000	36.000	●
6.530		8.000	106.000	66.000	36.000	●
6.550		8.000	106.000	66.000	36.000	●
6.600		8.000	106.000	66.000	36.000	●
6.700		8.000	106.000	66.000	36.000	●
6.750	17/64	8.000	106.000	66.000	36.000	●
6.800		8.000	106.000	66.000	36.000	●
6.900		8.000	116.000	76.000	36.000	●
7.000		8.000	116.000	76.000	36.000	●
7.100		8.000	116.000	76.000	36.000	●
7.140	9/32	8.000	116.000	76.000	36.000	●
7.200		8.000	116.000	76.000	36.000	●
7.300		8.000	116.000	76.000	36.000	●
7.400		8.000	116.000	76.000	36.000	●
7.500		8.000	116.000	76.000	36.000	●
7.540	19/64	8.000	116.000	76.000	36.000	●
7.600		8.000	116.000	76.000	36.000	●
7.700		8.000	116.000	76.000	36.000	●
7.800		8.000	116.000	76.000	36.000	●
7.900		8.000	116.000	76.000	36.000	●
7.940	5/16	8.000	116.000	76.000	36.000	●
8.000		8.000	116.000	76.000	36.000	●
8.100		10.000	131.000	87.000	40.000	●
8.200		10.000	131.000	87.000	40.000	●
8.300		10.000	131.000	87.000	40.000	●
8.330	21/64	10.000	131.000	87.000	40.000	●
8.400		10.000	131.000	87.000	40.000	●
8.500		10.000	131.000	87.000	40.000	●
8.600		10.000	131.000	87.000	40.000	●
8.700		10.000	131.000	87.000	40.000	●
8.730	11/32	10.000	131.000	87.000	40.000	●
8.800		10.000	131.000	87.000	40.000	●
8.900		10.000	131.000	87.000	40.000	●
9.000		10.000	131.000	87.000	40.000	●
9.100		10.000	139.000	95.000	40.000	●
9.130	23/64	10.000	139.000	95.000	40.000	●
9.200		10.000	139.000	95.000	40.000	●
9.250		10.000	139.000	95.000	40.000	●
9.300		10.000	139.000	95.000	40.000	●
9.340		10.000	139.000	95.000	40.000	●
9.400		10.000	139.000	95.000	40.000	●
9.500		10.000	139.000	95.000	40.000	●
9.520	3/8	10.000	139.000	95.000	40.000	●
9.600		10.000	139.000	95.000	40.000	●
9.700		10.000	139.000	95.000	40.000	●
9.800		10.000	139.000	95.000	40.000	●



Article no. 5499						Availability
Discount group 255						
Cutting direction (R)						
d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
9.900		10.000	139.000	95.000	40.000	●
9.920	25/64	10.000	139.000	95.000	40.000	●
10.000		10.000	139.000	95.000	40.000	●
10.100		12.000	155.000	106.000	45.000	●
10.200		12.000	155.000	106.000	45.000	●
10.300		12.000	155.000	106.000	45.000	●
10.320	13/32	12.000	155.000	106.000	45.000	●
10.400		12.000	155.000	106.000	45.000	●
10.500		12.000	155.000	106.000	45.000	●
10.600		12.000	155.000	106.000	45.000	●
10.700		12.000	155.000	106.000	45.000	●
10.720	27/64	12.000	155.000	106.000	45.000	●
10.800		12.000	155.000	106.000	45.000	●
10.900		12.000	155.000	106.000	45.000	●
11.000		12.000	155.000	106.000	45.000	●
11.100		12.000	163.000	114.000	45.000	●
11.110	7/16	12.000	163.000	114.000	45.000	●
11.200		12.000	163.000	114.000	45.000	●
11.300		12.000	163.000	114.000	45.000	●
11.400		12.000	163.000	114.000	45.000	●
11.500		12.000	163.000	114.000	45.000	●
11.510	29/64	12.000	163.000	114.000	45.000	●
11.600		12.000	163.000	114.000	45.000	●
11.700		12.000	163.000	114.000	45.000	●
11.800		12.000	163.000	114.000	45.000	●
11.900		12.000	163.000	114.000	45.000	●
11.910	15/32	12.000	163.000	114.000	45.000	●
12.000		12.000	163.000	114.000	45.000	●
12.100		14.000	182.000	133.000	45.000	●
12.200		14.000	182.000	133.000	45.000	●
12.300	31/64	14.000	182.000	133.000	45.000	●
12.400		14.000	182.000	133.000	45.000	●
12.500		14.000	182.000	133.000	45.000	●
12.600		14.000	182.000	133.000	45.000	●
12.700	1/2	14.000	182.000	133.000	45.000	●
12.800		14.000	182.000	133.000	45.000	●
12.900		14.000	182.000	133.000	45.000	●
13.000		14.000	182.000	133.000	45.000	●
13.100	33/64	14.000	182.000	133.000	45.000	●
13.490	17/32	14.000	182.000	133.000	45.000	●
13.500		14.000	182.000	133.000	45.000	●
13.700		14.000	182.000	133.000	45.000	●
13.890	35/64	14.000	182.000	133.000	45.000	●
14.000		14.000	182.000	133.000	45.000	●
14.100		16.000	204.000	152.000	48.000	●
14.200		16.000	204.000	152.000	48.000	●
14.290	9/16	16.000	204.000	152.000	48.000	●
14.300		16.000	204.000	152.000	48.000	●
14.500		16.000	204.000	152.000	48.000	●
14.700		16.000	204.000	152.000	48.000	●
14.800		16.000	204.000	152.000	48.000	●
15.000		16.000	204.000	152.000	48.000	●
15.100		16.000	204.000	152.000	48.000	●
15.300		16.000	204.000	152.000	48.000	●
15.480	39/64	16.000	204.000	152.000	48.000	●
15.500		16.000	204.000	152.000	48.000	●
15.700		16.000	204.000	152.000	48.000	●
15.800		16.000	204.000	152.000	48.000	●
15.870	5/8	16.000	204.000	152.000	48.000	●
16.000		16.000	204.000	152.000	48.000	●



Article no.						5499
Discount group						255
Cutting direction						(R)
d1		d2	l1	l2	l3	Availability
mm	inch	mm	mm	mm	mm	
16.300		18.000	223.000	171.000	48.000	●
16.500		18.000	223.000	171.000	48.000	●
16.700		18.000	223.000	171.000	48.000	●
16.900		18.000	223.000	171.000	48.000	●
17.000		18.000	223.000	171.000	48.000	●
17.500		18.000	223.000	171.000	48.000	●
17.700		18.000	223.000	171.000	48.000	●
18.000		18.000	223.000	171.000	48.000	●
18.500		20.000	244.000	190.000	50.000	●
18.900		20.000	244.000	190.000	50.000	●
19.000		20.000	244.000	190.000	50.000	●
19.050	3/4	20.000	244.000	190.000	50.000	●
19.500		20.000	244.000	190.000	50.000	●
19.800		20.000	244.000	190.000	50.000	●
20.000		20.000	244.000	190.000	50.000	●



GÜHRING NAVIGATOR

Tools with bold feed column no. are preferred choice.

To select the optimal tool and the recommended machining parameters for your application, please also use the electronic version of the GühringNavigator on the internet: www.guehring.com.

Article no.
Standard/DIN
Tool material
Carbide grade
Type
Surface finish
Coolant
Std. range page

Drill Ø mm	Feed column no.								
	1	2	3	4	5	6	7	8	9
	f (mm/rev.)								
0.50	0.004	0.006	0.007	0.008	0.010	0.012	0.014	0.016	0.019
1.00	0.006	0.008	0.012	0.014	0.016	0.018	0.020	0.023	0.025
2.00	0.020	0.025	0.032	0.040	0.050	0.063	0.080	0.100	0.125
2.50	0.025	0.032	0.040	0.050	0.063	0.080	0.100	0.125	0.160
3.15	0.032	0.040	0.050	0.063	0.080	0.100	0.125	0.160	0.160
4.00	0.040	0.050	0.063	0.080	0.100	0.125	0.160	0.200	0.200
5.00	0.040	0.050	0.063	0.080	0.100	0.125	0.160	0.200	0.250
6.30	0.050	0.063	0.080	0.100	0.125	0.160	0.200	0.250	0.315
8.00	0.063	0.080	0.100	0.125	0.160	0.200	0.250	0.315	0.315
10.00	0.080	0.100	0.125	0.160	0.200	0.250	0.315	0.400	0.400
12.50	0.080	0.100	0.125	0.160	0.200	0.250	0.315	0.400	0.500
16.00	0.100	0.125	0.160	0.200	0.250	0.315	0.400	0.500	0.630
20.00	0.125	0.160	0.200	0.250	0.315	0.400	0.500	0.630	0.630
25.00	0.160	0.200	0.250	0.315	0.400	0.500	0.630	0.800	0.800
31.50	0.160	0.200	0.250	0.315	0.400	0.500	0.630	0.800	1.000
40.00	0.200	0.250	0.315	0.400	0.500	0.630	0.800	1.000	1.250
50.00	0.250	0.310	0.400	0.500	0.630	0.800	1.000	1.250	1.250
63.00	0.315	0.400	0.500	0.630	0.800	1.000	1.250	1.600	1.600
80.00	0.400	0.500	0.630	0.800	1.000	1.250	1.600	2.000	2.000

Coolant:

- Air
● Neat oil
● Soluble oil

Cutting direction:

- Ⓜ right-hand cutting
Ⓛ left-hand cutting

Material group	Material examples Figures in bold = material no. to DIN EN 10 027	Tensile strength N/mm ²	Hardness	Coolant
Common structural steels	1.0035 S185(St33), 1.0486 P275N(StE285), 1.0345 P235GH(H1), 1.0425 P265GH(H2) 1.0050 E295 (St50-2), 1.0070 E360 (St70-2), 1.8937 P500NH (WStE500)	≤500 ≤1000		○
Free-cutting steels	1.0718 11SMnPb30 (9SMnPb28), 1.0736 11SMn37 (9SMn36) 1.0727 46S20 (45S20), 1.0728 (60S20), 1.0757 46SPb20 (45SPb20)	≤850 ≤1000		○
Unalloyed heat-treatable steels	1.0402 C22, 1.1178 C30E (Ck30) 1.0503 C45, 1.1191 C45E (Ck45) 1.0601 C60, 1.1221 C60E (Ck60)	≤700 ≤850 ≤1000		○
Alloyed heat-treatable steels	1.5131 50MnSi4, 1.7003 38Cr2, 1.7030 28Cr4 1.5710 36NiCr6, 1.7035 41Cr4, 1.7225 42CrMo4	≤1000 ≤1400		○
Unalloyed case hard. steels	1.0301 (C10), 1.1121 C10E (Ck10)	≤850		○
Alloyed case hardened steels	1.7276 10CrMo11, 1.5125 11MnSi6 1.5752 15NiCr13, 1.7131 16MnCr5, 1.7264 20CrMo5	≤1000 ≤1400		●
Nitriding steels	1.8504 34CrAl6 1.8519 31CrMoV9, 1.8550 34CrAlNi7	≤1000 ≤1400		●
Tool steels	1.1750 C75W, 1.2067 102Cr6, 1.2307 29CrMoV9 1.2080 X210Cr12, 1.2083 X42Cr13, 1.2419 105WCr6, 1.2767 X45NiCrMo4	≤850 ≤1400		○
High speed steels	1.3243 S 6-5-2-5, 1.3343 S 6-5-2, 1.3344 S 6-5-3	≤1400		●
Spring steels	1.5026 55Si7, 1.7176 55Cr3, 1.8159 51CrV4 (51CrV4)		≤350 HB	●
Hardened steels	-		≤48 HRC ≤66 HRC	●
Stainless steels, sulphured austenitic martensitic	1.4005 X12CrS13, 1.4104 X14CrMoS17, 1.4105 X6CrMoS17, 1.4305 X8CrNiS18-9 1.4301 X5CrNi18-10 (V2A), 1.4541 X6CrNiTi18-10, 1.4571 X6CrNiMoTi 17-12-2 (V4A) 1.4057 X20CrNi172 (X17CrNi16-2), 1.4122 X39CrMo17-1, 1.4521 X2CrMoTi18-2	≤900 ≤1100 ≤1500		●
Cast iron	0.6010 EN-GJL-100 (GG10), 0.6020 EN-GJL-200 (GG20) 0.6025 EN-GJL-250 (GG25), 0.6035 EN-GJL-350 (GG35)		≤240 HB ≤350 HB	○
Spheroidal graphite iron and malleable cast iron	0.7050 EN-GJS-500-7 (GGG50), 0.8035 EN-GJMW-350-4 (GTW35) 0.7070 EN-GJS-700-2 (GGG70), 0.8170 EN-GJMB-700-2 (GTS70)		≤240 HB ≤350 HB	○
Chilled cast iron	-		≤350 HB	○
New cast materials GGV	EN-GJV250 (GGV25), EN-GJV350 (GGV35) EN-GJV400 (GGV40), EN-GJV500 (GGV50), SiMo 6		≤220 HB ≤300 HB	○
New cast materials ADI	EN-GJS-800-8 (ADI800), EN-GJS-1000-5 (ADI1000) EN-GJS-1200-2 (ADI1200), EN-GJS-1400-1 (ADI1400)	≤1000 ≤1400		○
Special alloys	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
Ti and Ti-alloys	3.7024 Ti99.5, 3.7114 TiAl5Sn2.5, 3.7124 TiCu2 3.7154 TiAl6Zr5, 3.7165 TiAl6V4, 3.7184 TiAl4Mo4Sn2.5, - TiAl8Mo1V1	≤850 ≤1400		●
Aluminium and Al-alloys	3.0255 Al99.5, 3.2315 AlMgSi1, 3.3515 AlMg1	≤400		○
Al wrought alloys	3.0615 AlMgSiPb, 3.1325 AlCuMg1, 3.3245 AlMg3Si, 3.4365 AlZnMgCu1.5	≤650		○
Al cast alloys ≤ 10 % Si ≤ 24 % Si	3.2131 G-AlSi5Cu1, 3.2153 G-AlSi7Cu3, 3.2573 G-AlSi9 3.2581 G-AlSi12, 3.2583 G-AlSi12Cu, - G-AlSi12CuNiMg	≤600 ≤600		○
Magnesium alloys	3.5200 MgMn2, 3.5812.05 G-MgAl8Zn1, 3.5612.05 G-MgAl6Zn1	≤400		○
Copper, low-alloyed	2.0070 SE-Cu, 2.1020 CuSn6, 2.1096 G-CuSn5ZnPb	≤500		○
Brass, short-chipping long-chipping	2.0380 CuZn39Pb2, 2.0401 CuZn39Pb3, 2.0410 CuZn43Pb2 2.0250 CuZn20, 2.0280 CuZn33, 2.0332 CuZn37Pb0.5	≤600 ≤600		○
Bronze, short-chipping	2.1090 CuSn7ZnPb, 2.1170 CuPb5Sn5, 2.1176 CuPb10Sn 2.0790 CuNi18Zn19Pb	≤600 ≤850		○
Bronze, long-chipping	2.0916 CuAl5, 2.0960 CuAl9Mn, 2.1050 CuSn10 2.0980 CuAl11Ni, 2.1247 CuBe2	≤850 ≤1000		○
Duroplastics	Epoxy resin, Resopal, Pertinax, Moltopren	≤150		○
Thermoplastics	Plexiglass, Hostalen, Novodur, Makralon	≤100		○
Kevlar	Kevlar	≤1000		○
Glass, carbon concentr. plastics	GFK/CFK	≤1000		○



≤3xD drilling depth

6498
6537K
Solid carbide
K/P
RT 100 XF
F
axial
6



≤5xD drilling depth

5498
6537L
Solid carbide
K/P
RT 100 XF
F
axial
10



≤7xD drilling depth

5499
WN
Solid carbide
K/P
RT100 XF
F
axial
14



V _c m/min	Feed col. no.
200	8
200	7
200	8
200	8
180	8
160	8
130	8
120	8
120	7
180	8
120	8
110	7
110	7
100	5
90	7
65	6
60	5
60	5
55	3
80	5
60	5
180	9
160	9
140	9
140	8
140	8
140	8
80	7
80	7
30	4
40	4
35	3

V _c m/min	Feed col. no.
200	8
200	7
200	8
200	8
180	8
160	8
130	8
120	8
120	7
180	8
120	8
110	7
110	7
100	5
90	7
65	6
60	5
60	5
55	3
80	5
60	5
180	9
160	9
140	9
140	8
140	8
140	8
80	7
80	7
30	4
40	4
35	3

V _c m/min	Feed col. no.
180	8
180	7
180	8
180	8
160	8
140	8
120	8
110	8
110	7
160	8
110	8
100	7
100	7
90	5
80	7
60	6
55	5
55	5
45	3
70	5
50	5
165	9
145	9
130	9
130	8
130	8
130	8
70	7
70	7
25	4
35	4
30	3

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