

# GUHRING

Pilot milling, drilling, burnishing -  
with only one tool

NEW

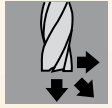


## Pilot end mill

GUHRING - YOUR WORLD-WIDE PARTNER

# Pilot end mill

- ⇒ for pilot milling and burnishing, especially oblique surfaces
- ⇒ for enlarging holes
- ⇒ for conventional milling operations



Guhring no.					6716
similar to DIN 6527 with reinforced shank to DIN 6535 HA 30° right hand spiral flutes VHM ultra fine TiAlN SuperA-coated					
d1 (m8)	d2 (h6)	l1	l2	Z	Availability
mm	mm	mm	mm		
1.400	3.000	38.00	3.00	4	●
1.500	3.000	38.00	4.00	4	●
1.800	3.000	38.00	6.00	4	●
2.000	3.000	38.00	7.00	4	●
2.100	3.000	38.00	7.00	4	●
2.300	3.000	38.00	7.00	4	●
2.500	3.000	38.00	7.00	4	●
2.800	3.000	38.00	7.00	4	●
3.000	6.000	57.00	8.00	4	●
3.500	6.000	57.00	10.00	4	●
4.000	6.000	57.00	11.00	4	●
4.500	6.000	57.00	11.00	4	●
5.000	6.000	57.00	13.00	4	●
5.500	6.000	57.00	13.00	4	●
6.000	8.000	63.00	13.00	4	●
6.500	8.000	63.00	13.00	4	●
7.000	8.000	63.00	16.00	4	●
7.500	8.000	63.00	16.00	4	●
8.000	10.000	72.00	19.00	4	●
8.500	10.000	72.00	19.00	4	●
9.000	10.000	72.00	19.00	4	●
10.000	12.000	83.00	22.00	4	●
11.000	12.000	83.00	26.00	4	●
12.000	14.000	83.00	26.00	4	●

## Cutting rates

Material/ISO material	Hardness	Drilling depth* (a <sub>p</sub> max.)	Cutting speed (v <sub>c</sub> )	fz (mm/min)							
				1	2	4	6	8	10	12	
<b>P</b>	Struct./free-cutting steels, unalloyed heat-treat./case hard. steels	up to 850 N/mm <sup>2</sup>	1.5 x d	100	0.010	0.015	0.025	0.030	0.045	0.060	0.075
	Free-cutting steels, unalloyed case hard. steels, nitriding steels	850 - 1200 N/mm <sup>2</sup>	1.5 x d	85	0.008	0.010	0.020	0.025	0.035	0.050	0.060
	Alloyed heat-treatable, tool and high speed steels	850 - 1400 N/mm <sup>2</sup>	1.0 x d	70	0.006	0.008	0.015	0.020	0.030	0.045	0.050
<b>M</b>	Stainless steel - easy to machine	up to 750 N/mm <sup>2</sup>	1.0 x d	50	0.005	0.006	0.012	0.015	0.020	0.030	0.040
<b>K</b>	Cast iron, grey cast iron, spher. graphite/malleable cast iron	up to 240 HB 30	1.5 x d	100	0.010	0.015	0.025	0.030	0.045	0.060	0.075
	Gusseisen, Grauguss, Temperguss und Kugelgraphitguss	above 240 HB 30	1.5 x d	85	0.008	0.010	0.020	0.025	0.035	0.050	0.060
<b>N</b>	Aluminium, Al-wrought alloys, Al-alloys	up to 3% Si	1.0 x d	140	0.010	0.015	0.025	0.030	0.045	0.060	0.075

\* peripheral cooling "Gührojet" recommended from drilling depth 0.5 x D

# GUHRING

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