GÜHRING

SuperLine

HIGH PERFORMANCE

EFFIZIENTE BEARBEITUNG UND LANGE LEBENSDAUER IM UNIVERSELLEN EINSATZ

NEU

Noch leistungsstärker dank PM-HSS-E und Multilayer-Beschichtung

GU 500 PM

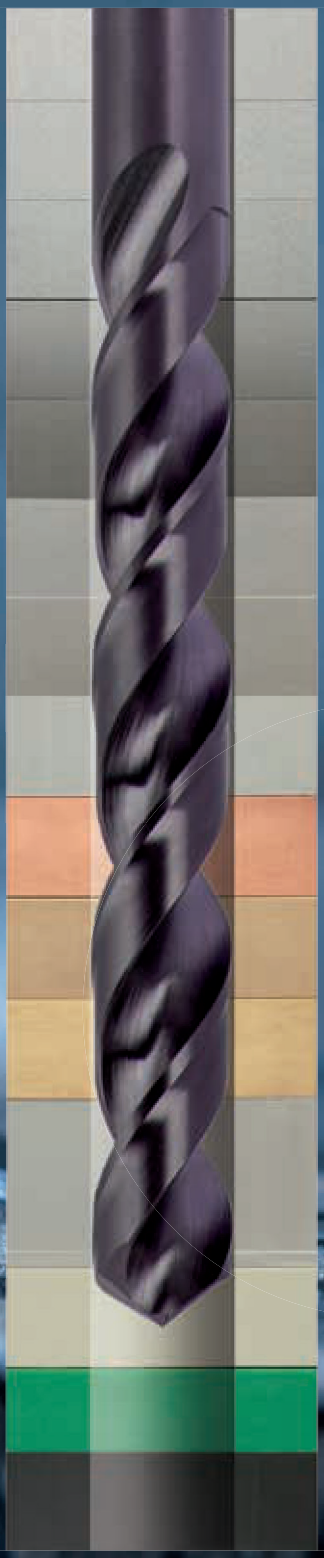
GU 500 Universalbohrer

GÜHRING – WELTWEIT IHR PARTNER

GU 500
UNIVERSALBOHRER

GU 500
UNIVERSELL EINSETZBAR
IN NAHEZU ALLEN WERKSTOFFEN

Bau- und Kohlenstoffstähle, höherlegierte Stähle bis 1200 N/mm², rostfreie Stähle, Gusswerkstoffe, NE-Metalle, Aluminium, Magnesium-Legierungen, Kunststoffe



16MnCr5
11SMn30+C
St37
GG
GGG
C45
VA
Aluminium
Kupfer
Bronzen
Messing
Plexiglas
PVC
PE 1000
Makrolon

GU 500 PM

4-Flächenanschliff für
ausgezeichnete Selbstzentrierung
und besonders maßhaltige
Bohrungen

hochgenaues Spannen
und Bohren durch verstärkten
HB-Schaft mit h6-Toleranz

optimale Spanabfuhr
durch rundes
Spannutprofil

118°-Spitzenwinkel,
dadurch längere Hauptschneiden,
reduzierte Flächenpressung,
weniger Verschleißbildung,
längere Lebensdauer

NEU
GU 500 PM

hohe Leistung und Verschleißfestigkeit
durch pulvermetallurgischen Stahl
und Multilayer-Beschichtung

geringe Vorschubkräfte
und Drehmomente dank
Präzisionsanschliff

EINSATZBEREICH GU 500

P	M	K	N	S	H	Werkzeug-Darstellung	Bohrtiefe	Norm	Typ	Schneid-richtung	Schneid-stoff	Ober-fläche	d1/mm	Artikel-Nr.	Schnitt-werte Seite	Seite
Spiralbohrer mit verst. Zylinderschaft																
•	•	•	•	○		NEW	~3xD	WN	GU 500 PM	R	HSS-E-PM	F	1,000 - 20,000	6005	16	5
•	•	•	•	○		NEW	~5xD	WN	GU 500 PM	R	HSS-E-PM	F	2,000 - 20,000	6006	16	7
Spiralbohrer extra kurz																
•	•	•	•				~3xD	DIN 1897	GU 500 DZ	R	HSCO	○	1,000 - 14,290	5524	16	9
•	•	•	•				~3xD	DIN 1897	GU 500 DZ	R	HSCO	S	1,000 - 14,290	5520	16	9
Spiralbohrer kurz																
•	•	•	•				~5xD	DIN 338	GU 500 DZ	R	HSCO	○	1,000 - 14,290	5523	16	11
•	•	•	•				~5xD	DIN 338	GU 500 DZ	R	HSCO	S	1,000 - 14,290	5519	16	11
Spiralbohrer lang																
•	•	•	•				~10xD	DIN 340	GU 500 DZ	R	HSCO	○	1,000 - 14,290	5536	16	13
•	•	•	•				~10xD	DIN 340	GU 500 DZ	R	HSCO	S	1,000 - 14,290	5537	16	13
Spiralbohrer-Sätze																
•	•	•	•				~5xD	DIN 338	GU 500 DZ	R	HSCO	○		12		15

Spiralbohrer mit verst. Zylinderschaft

~3xD | WN | GU 500 PM | 118° | h8

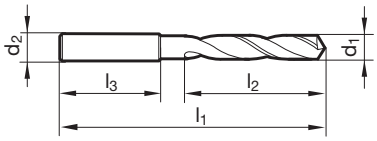
Schneidstoff	HSS-E-PM
Oberfläche	F
Schneidrichtung	R

NEW

P	•	Ausspitzung ≥ Ø 1,000 • High Performance-Spiralbohrer • pulvermetallurgischer Stahl • 4-Flächenanschliff • geringe Vorschubkraft • geringes Drehmoment
M	•	
K	•	
N	•	
S	○	universell einsetzbar
H		

GÜHRINGNAVIGATOR

Schnittwerte siehe Seite 16



Artikel-Nr. **6005**

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
1,000		3,000	38,000	6,000	28,000
1,100		3,000	39,000	7,000	28,000
1,200		3,000	40,000	8,000	28,000
1,300		3,000	40,000	8,000	28,000
1,400		3,000	41,000	9,000	28,000
1,500		3,000	41,000	9,000	28,000
1,600		3,000	42,000	10,000	28,000
1,700		3,000	42,000	10,000	28,000
1,800		3,000	43,000	11,000	28,000
1,900		3,000	43,000	11,000	28,000
2,000		3,000	44,000	12,000	28,000
2,100		3,000	44,000	12,000	28,000
2,200		3,000	45,000	13,000	28,000
2,300		3,000	45,000	13,000	28,000
2,380	3/32	3,000	46,000	14,000	28,000
2,400		3,000	46,000	14,000	28,000
2,500		3,000	46,000	14,000	28,000
2,600		3,000	46,000	14,000	28,000
2,700		3,000	48,000	16,000	28,000
2,780	7/64	3,000	48,000	16,000	28,000
2,800		3,000	48,000	16,000	28,000
2,900		3,000	48,000	16,000	28,000
3,000		3,000	48,000	16,000	28,000
3,100		4,000	50,000	18,000	28,000
3,170	1/8	4,000	50,000	18,000	28,000
3,200		4,000	50,000	18,000	28,000
3,300		4,000	50,000	18,000	28,000
3,400		4,000	52,000	20,000	28,000
3,500		4,000	52,000	20,000	28,000
3,570	9/64	4,000	52,000	20,000	28,000
3,600		4,000	52,000	20,000	28,000
3,700		4,000	52,000	20,000	28,000
3,800		4,000	54,000	22,000	28,000
3,900		4,000	54,000	22,000	28,000
3,970	5/32	4,000	54,000	22,000	28,000
4,000		4,000	54,000	22,000	28,000
4,100		6,000	66,000	22,000	36,000
4,200		6,000	66,000	22,000	36,000
4,300		6,000	68,000	24,000	36,000
4,370	11/64	6,000	68,000	24,000	36,000
4,400		6,000	68,000	24,000	36,000
4,500		6,000	68,000	24,000	36,000

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
4,600		6,000	68,000	24,000	36,000
4,650		6,000	68,000	24,000	36,000
4,700		6,000	68,000	24,000	36,000
4,760	3/16	6,000	70,000	26,000	36,000
4,800		6,000	70,000	26,000	36,000
4,900		6,000	70,000	26,000	36,000
5,000		6,000	70,000	26,000	36,000
5,100		6,000	70,000	26,000	36,000
5,160	13/64	6,000	70,000	26,000	36,000
5,200		6,000	70,000	26,000	36,000
5,300		6,000	70,000	26,000	36,000
5,400		6,000	72,000	28,000	36,000
5,500		6,000	72,000	28,000	36,000
5,550		6,000	72,000	28,000	36,000
5,560	7/32	6,000	72,000	28,000	36,000
5,600		6,000	72,000	28,000	36,000
5,700		6,000	72,000	28,000	36,000
5,800		6,000	72,000	28,000	36,000
5,900		6,000	72,000	28,000	36,000
5,950	15/64	6,000	72,000	28,000	36,000
6,000		6,000	72,000	28,000	36,000
6,100		8,000	75,000	31,000	36,000
6,200		8,000	75,000	31,000	36,000
6,300		8,000	75,000	31,000	36,000
6,350	1/4	8,000	75,000	31,000	36,000
6,400		8,000	75,000	31,000	36,000
6,500		8,000	75,000	31,000	36,000
6,600		8,000	75,000	31,000	36,000
6,700		8,000	75,000	31,000	36,000
6,750	17/64	8,000	78,000	34,000	36,000
6,800		8,000	78,000	34,000	36,000
6,900		8,000	78,000	34,000	36,000
7,000		8,000	78,000	34,000	36,000
7,100		8,000	78,000	34,000	36,000
7,140	9/32	8,000	78,000	34,000	36,000
7,200		8,000	78,000	34,000	36,000
7,300		8,000	78,000	34,000	36,000
7,400		8,000	78,000	34,000	36,000
7,500		8,000	78,000	34,000	36,000
7,540	19/64	8,000	81,000	37,000	36,000
7,550		8,000	81,000	37,000	36,000
7,600		8,000	81,000	37,000	36,000

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
7,700		8,000	81,000	37,000	36,000
7,800		8,000	81,000	37,000	36,000
7,900		8,000	81,000	37,000	36,000
7,940	5/16	8,000	81,000	37,000	36,000
8,000		8,000	81,000	37,000	36,000
8,100		10,000	87,000	37,000	40,000
8,200		10,000	87,000	37,000	40,000
8,300		10,000	87,000	37,000	40,000
8,330	21/64	10,000	87,000	37,000	40,000
8,400		10,000	87,000	37,000	40,000
8,500		10,000	87,000	37,000	40,000
8,600		10,000	91,000	40,000	40,000
8,700		10,000	91,000	40,000	40,000
8,730	11/32	10,000	91,000	40,000	40,000
8,800		10,000	91,000	40,000	40,000
8,900		10,000	91,000	40,000	40,000
9,000		10,000	91,000	40,000	40,000
9,100		10,000	91,000	40,000	40,000
9,130	23/64	10,000	91,000	40,000	40,000
9,200		10,000	91,000	40,000	40,000
9,300		10,000	91,000	40,000	40,000
9,400		10,000	91,000	40,000	40,000
9,500		10,000	91,000	40,000	40,000
9,520	3/8	10,000	93,000	43,000	40,000
9,550		10,000	93,000	43,000	40,000
9,600		10,000	93,000	43,000	40,000
9,700		10,000	93,000	43,000	40,000
9,800		10,000	93,000	43,000	40,000
9,900		10,000	93,000	43,000	40,000
9,920	25/64	10,000	93,000	43,000	40,000
10,000		10,000	93,000	43,000	40,000
10,100		12,000	100,000	43,000	45,000
10,200		12,000	100,000	43,000	45,000
10,300		12,000	100,000	43,000	45,000
10,320	13/32	12,000	100,000	43,000	45,000
10,400		12,000	100,000	43,000	45,000
10,500		12,000	100,000	43,000	45,000
10,600		12,000	100,000	43,000	45,000
10,700		12,000	104,000	47,000	45,000
10,720	27/64	12,000	104,000	47,000	45,000
10,800		12,000	104,000	47,000	45,000
10,900		12,000	104,000	47,000	45,000
11,000		12,000	104,000	47,000	45,000
11,100		12,000	104,000	47,000	45,000
11,110	7/16	12,000	104,000	47,000	45,000
11,200		12,000	104,000	47,000	45,000
11,300		12,000	104,000	47,000	45,000
11,400		12,000	104,000	47,000	45,000

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
11,500		12,000	104,000	47,000	45,000
11,510	29/64	12,000	104,000	47,000	45,000
11,600		12,000	104,000	47,000	45,000
11,700		12,000	104,000	47,000	45,000
11,800		12,000	104,000	47,000	45,000
11,900		12,000	108,000	51,000	45,000
11,910	15/32	12,000	108,000	51,000	45,000
12,000		12,000	108,000	51,000	45,000
12,100		16,000	111,000	51,000	48,000
12,200		16,000	111,000	51,000	48,000
12,300	31/64	16,000	111,000	51,000	48,000
12,400		16,000	111,000	51,000	48,000
12,500		16,000	111,000	51,000	48,000
12,600		16,000	111,000	51,000	48,000
12,700	1/2	16,000	111,000	51,000	48,000
12,800		16,000	111,000	51,000	48,000
12,900		16,000	111,000	51,000	48,000
13,000		16,000	111,000	51,000	48,000
13,100	33/64	16,000	111,000	51,000	48,000
13,490	17/32	16,000	114,000	54,000	48,000
13,500		16,000	114,000	54,000	48,000
13,890	35/64	16,000	114,000	54,000	48,000
14,000		16,000	114,000	54,000	48,000
14,290	9/16	16,000	116,000	56,000	48,000
14,500		16,000	116,000	56,000	48,000
15,000		16,000	116,000	56,000	48,000
15,500		16,000	118,000	58,000	48,000
15,870	5/8	16,000	118,000	58,000	48,000
16,000		16,000	118,000	58,000	48,000
16,500		20,000	126,000	60,000	50,000
16,670	21/32	20,000	126,000	60,000	50,000
17,000		20,000	126,000	60,000	50,000
17,500		20,000	128,000	62,000	50,000
18,000		20,000	128,000	62,000	50,000
18,500		20,000	130,000	64,000	50,000
19,000		20,000	130,000	64,000	50,000
19,500		20,000	132,000	66,000	50,000
20,000		20,000	132,000	66,000	50,000

Spiralbohrer mit verst. Zylinderschaft

~5xD | WN | GU 500 PM | 118° | h8

Schneidstoff	HSS-E-PM
Oberfläche	F
Schneidrichtung	R

NEW

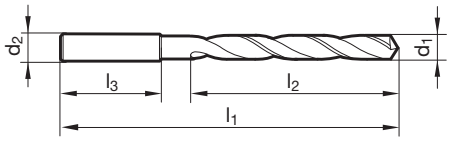
P	•
M	•
K	•
N	•
S	○
H	

Ausspitzung ≥ Ø 1,000 • High Performance-Spiralbohrer • pulvermetallurgischer Stahl • 4-Flächenanschliff • geringe Vorschubkraft • geringes Drehmoment

universell einsetzbar

GÜHRINGNAVIGATOR

Schnittwerte siehe Seite 16



Artikel-Nr. **6006**

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
2,000		3,000	56,000	24,000	28,000
2,100		3,000	56,000	24,000	28,000
2,200		3,000	59,000	27,000	28,000
2,300		3,000	59,000	27,000	28,000
2,380	3/32	3,000	62,000	30,000	28,000
2,400		3,000	62,000	30,000	28,000
2,500		3,000	62,000	30,000	28,000
2,600		3,000	62,000	30,000	28,000
2,700		3,000	65,000	33,000	28,000
2,780	7/64	3,000	65,000	33,000	28,000
2,800		3,000	65,000	33,000	28,000
2,900		3,000	65,000	33,000	28,000
3,000		3,000	65,000	33,000	28,000
3,100		4,000	68,000	36,000	28,000
3,170	1/8	4,000	68,000	36,000	28,000
3,200		4,000	68,000	36,000	28,000
3,300		4,000	68,000	36,000	28,000
3,400		4,000	71,000	39,000	28,000
3,500		4,000	71,000	39,000	28,000
3,570	9/64	4,000	71,000	39,000	28,000
3,600		4,000	71,000	39,000	28,000
3,700		4,000	71,000	39,000	28,000
3,800		4,000	75,000	43,000	28,000
3,900		4,000	75,000	43,000	28,000
3,970	5/32	4,000	75,000	43,000	28,000
4,000		4,000	75,000	43,000	28,000
4,100		6,000	87,000	43,000	36,000
4,200		6,000	87,000	43,000	36,000
4,300		6,000	91,000	47,000	36,000
4,370	11/64	6,000	91,000	47,000	36,000
4,400		6,000	91,000	47,000	36,000
4,500		6,000	91,000	47,000	36,000
4,600		6,000	91,000	47,000	36,000
4,650		6,000	91,000	47,000	36,000
4,700		6,000	91,000	47,000	36,000
4,760	3/16	6,000	96,000	52,000	36,000
4,800		6,000	96,000	52,000	36,000
4,900		6,000	96,000	52,000	36,000
5,000		6,000	96,000	52,000	36,000
5,100		6,000	96,000	52,000	36,000
5,160	13/64	6,000	96,000	52,000	36,000
5,200		6,000	96,000	52,000	36,000

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
5,300		6,000	96,000	52,000	36,000
5,400		6,000	101,000	57,000	36,000
5,500		6,000	101,000	57,000	36,000
5,550		6,000	101,000	57,000	36,000
5,560	7/32	6,000	101,000	57,000	36,000
5,600		6,000	101,000	57,000	36,000
5,700		6,000	101,000	57,000	36,000
5,800		6,000	101,000	57,000	36,000
5,900		6,000	101,000	57,000	36,000
5,950	15/64	6,000	101,000	57,000	36,000
6,000		6,000	101,000	57,000	36,000
6,100		8,000	107,000	63,000	36,000
6,200		8,000	107,000	63,000	36,000
6,300		8,000	107,000	63,000	36,000
6,350	1/4	8,000	107,000	63,000	36,000
6,400		8,000	107,000	63,000	36,000
6,500		8,000	107,000	63,000	36,000
6,600		8,000	107,000	63,000	36,000
6,700		8,000	107,000	63,000	36,000
6,750	17/64	8,000	113,000	69,000	36,000
6,800		8,000	113,000	69,000	36,000
6,900		8,000	113,000	69,000	36,000
7,000		8,000	113,000	69,000	36,000
7,100		8,000	113,000	69,000	36,000
7,140	9/32	8,000	113,000	69,000	36,000
7,200		8,000	113,000	69,000	36,000
7,300		8,000	113,000	69,000	36,000
7,400		8,000	113,000	69,000	36,000
7,500		8,000	113,000	69,000	36,000
7,540	19/64	8,000	119,000	75,000	36,000
7,550		8,000	119,000	75,000	36,000
7,600		8,000	119,000	75,000	36,000
7,700		8,000	119,000	75,000	36,000
7,800		8,000	119,000	75,000	36,000
7,900		8,000	119,000	75,000	36,000
7,940	5/16	8,000	119,000	75,000	36,000
8,000		8,000	119,000	75,000	36,000
8,100		10,000	125,000	75,000	40,000
8,200		10,000	125,000	75,000	40,000
8,300		10,000	125,000	75,000	40,000
8,330	21/64	10,000	125,000	75,000	40,000
8,400		10,000	125,000	75,000	40,000

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
8,500		10,000	125,000	75,000	40,000
8,600		10,000	131,000	81,000	40,000
8,700		10,000	131,000	81,000	40,000
8,730	11/32	10,000	131,000	81,000	40,000
8,800		10,000	131,000	81,000	40,000
8,900		10,000	131,000	81,000	40,000
9,000		10,000	131,000	81,000	40,000
9,100		10,000	131,000	81,000	40,000
9,130	23/64	10,000	131,000	81,000	40,000
9,200		10,000	131,000	81,000	40,000
9,300		10,000	131,000	81,000	40,000
9,400		10,000	131,000	81,000	40,000
9,500		10,000	131,000	81,000	40,000
9,520	3/8	10,000	137,000	87,000	40,000
9,550		10,000	137,000	87,000	40,000
9,600		10,000	137,000	87,000	40,000
9,700		10,000	137,000	87,000	40,000
9,800		10,000	137,000	87,000	40,000
9,900		10,000	137,000	87,000	40,000
9,920	25/64	10,000	137,000	87,000	40,000
10,000		10,000	137,000	87,000	40,000
10,100		12,000	144,000	87,000	45,000
10,200		12,000	144,000	87,000	45,000
10,300		12,000	144,000	87,000	45,000
10,320	13/32	12,000	144,000	87,000	45,000
10,400		12,000	144,000	87,000	45,000
10,500		12,000	144,000	87,000	45,000
10,600		12,000	144,000	87,000	45,000
10,700		12,000	151,000	94,000	45,000
10,720	27/64	12,000	151,000	94,000	45,000
10,800		12,000	151,000	94,000	45,000
10,900		12,000	151,000	94,000	45,000
11,000		12,000	151,000	94,000	45,000
11,100		12,000	151,000	94,000	45,000
11,110	7/16	12,000	151,000	94,000	45,000
11,200		12,000	151,000	94,000	45,000
11,300		12,000	151,000	94,000	45,000
11,400		12,000	151,000	94,000	45,000
11,500		12,000	151,000	94,000	45,000
11,510	29/64	12,000	151,000	94,000	45,000
11,600		12,000	151,000	94,000	45,000
11,700		12,000	151,000	94,000	45,000

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
11,800		12,000	151,000	94,000	45,000
11,900		12,000	158,000	101,000	45,000
11,910	15/32	12,000	158,000	101,000	45,000
12,000		12,000	158,000	101,000	45,000
12,100		16,000	161,000	101,000	48,000
12,200		16,000	161,000	101,000	48,000
12,300	31/64	16,000	161,000	101,000	48,000
12,400		16,000	161,000	101,000	48,000
12,500		16,000	161,000	101,000	48,000
12,600		16,000	161,000	101,000	48,000
12,700	1/2	16,000	161,000	101,000	48,000
12,800		16,000	161,000	101,000	48,000
12,900		16,000	161,000	101,000	48,000
13,000		16,000	161,000	101,000	48,000
13,100	33/64	16,000	161,000	101,000	48,000
13,490	17/32	16,000	166,000	106,000	48,000
13,500		16,000	166,000	106,000	48,000
13,890	35/64	16,000	166,000	106,000	48,000
14,000		16,000	166,000	106,000	48,000
14,290	9/16	16,000	169,000	109,000	48,000
14,500		16,000	169,000	109,000	48,000
15,000		16,000	169,000	109,000	48,000
15,500		16,000	172,000	112,000	48,000
15,870	5/8	16,000	172,000	112,000	48,000
16,000		16,000	172,000	112,000	48,000
16,500		20,000	181,000	115,000	50,000
16,670	21/32	20,000	181,000	115,000	50,000
17,000		20,000	181,000	115,000	50,000
17,460	11/16	20,000	184,000	118,000	50,000
17,500		20,000	184,000	118,000	50,000
18,000		20,000	184,000	118,000	50,000
18,500		20,000	188,000	122,000	50,000
19,000		20,000	188,000	122,000	50,000
19,500		20,000	191,000	125,000	50,000
20,000		20,000	191,000	125,000	50,000

Spiralbohrer extra kurz

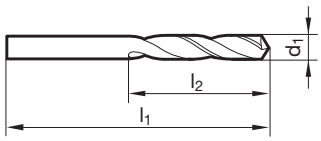
~3xD | DIN 1897 | GU 500 DZ | 118° | h8

	Schneidstoff	HSCO	
	Oberfläche	○	Ⓢ
	Schneidrichtung	Ⓡ	Ⓡ

P	•	Ausspitzung ≥ Ø 1,000 • Flächenanschliff • Co-legierter HSS-Stahl • geringe Vorschubkraft notwendig • geringes Drehmoment notwendig • universell einsetzbar
M	•	
K	•	
N	•	Stähle (legiert/unleg.) bis 800 N/mm² • Kalt-/Warmarbeitsstähle • Wälzlagerstähle • NE-Metalle • Gusswerkstoffe • rostfreie Stähle • Kunststoffe
S		
H		

GÜHRINGNAVIGATOR

Schnittwerte siehe Seite 16



Artikel-Nr.	5524	5520

d1 mm	inch	l1 mm	l2 mm
1,000		26,00	6,00
1,020		26,00	6,00
1,040		26,00	6,00
1,070		28,00	7,00
1,090		28,00	7,00
1,100		28,00	7,00
1,180		28,00	7,00
1,190	3/64	30,00	8,00
1,200		30,00	8,00
1,300		30,00	8,00
1,320		30,00	8,00
1,400		32,00	9,00
1,500		32,00	9,00
1,510		34,00	10,00
1,590	1/16	34,00	10,00
1,600		34,00	10,00
1,610		34,00	10,00
1,700		34,00	10,00
1,780		36,00	11,00
1,800		36,00	11,00
1,850		36,00	11,00
1,900		36,00	11,00
1,930		38,00	12,00
1,980	5/64	38,00	12,00
1,990		38,00	12,00
2,000		38,00	12,00
2,060		38,00	12,00
2,080		38,00	12,00
2,100		38,00	12,00
2,180		40,00	13,00
2,200		40,00	13,00
2,260		40,00	13,00
2,300		40,00	13,00
2,370		43,00	14,00
2,380	3/32	43,00	14,00
2,400		43,00	14,00
2,440		43,00	14,00
2,490		43,00	14,00
2,500		43,00	14,00
2,530		43,00	14,00
2,580		43,00	14,00
2,600		43,00	14,00

d1 mm	inch	l1 mm	l2 mm
2,640		43,00	14,00
2,700		46,00	16,00
2,710		46,00	16,00
2,780	7/64	46,00	16,00
2,790		46,00	16,00
2,800		46,00	16,00
2,820		46,00	16,00
2,870		46,00	16,00
2,900		46,00	16,00
2,950		46,00	16,00
3,000		46,00	16,00
3,050		49,00	18,00
3,100		49,00	18,00
3,170	1/8	49,00	18,00
3,200		49,00	18,00
3,260		49,00	18,00
3,300		49,00	18,00
3,400		52,00	20,00
3,450		52,00	20,00
3,500		52,00	20,00
3,570	9/64	52,00	20,00
3,600		52,00	20,00
3,660		52,00	20,00
3,700		52,00	20,00
3,730		52,00	20,00
3,800		55,00	22,00
3,860		55,00	22,00
3,900		55,00	22,00
3,910		55,00	22,00
3,970	5/32	55,00	22,00
3,990		55,00	22,00
4,000		55,00	22,00
4,040		55,00	22,00
4,090		55,00	22,00
4,100		55,00	22,00
4,200		55,00	22,00
4,220		55,00	22,00
4,300		58,00	24,00
4,370	11/64	58,00	24,00
4,390		58,00	24,00
4,400		58,00	24,00
4,500		58,00	24,00

d1		l1	l2
mm	inch	mm	mm
4,570		58,00	24,00
4,600		58,00	24,00
4,620		58,00	24,00
4,700		58,00	24,00
4,760	3/16	62,00	26,00
4,800		62,00	26,00
4,850		62,00	26,00
4,900		62,00	26,00
4,920		62,00	26,00
4,980		62,00	26,00
5,000		62,00	26,00
5,060		62,00	26,00
5,100		62,00	26,00
5,110		62,00	26,00
5,160	13/64	62,00	26,00
5,180		62,00	26,00
5,200		62,00	26,00
5,220		62,00	26,00
5,300		62,00	26,00
5,310		66,00	28,00
5,400		66,00	28,00
5,410		66,00	28,00
5,500		66,00	28,00
5,560	7/32	66,00	28,00
5,600		66,00	28,00
5,610		66,00	28,00
5,700		66,00	28,00
5,790		66,00	28,00
5,800		66,00	28,00
5,900		66,00	28,00
5,940		66,00	28,00
5,950	15/64	66,00	28,00
6,000		66,00	28,00
6,040		70,00	31,00
6,100		70,00	31,00
6,150		70,00	31,00
6,200		70,00	31,00
6,250		70,00	31,00
6,300		70,00	31,00
6,350	1/4	70,00	31,00
6,400		70,00	31,00
6,500		70,00	31,00
6,530		70,00	31,00
6,600		70,00	31,00
6,630		70,00	31,00
6,700		70,00	31,00
6,750	17/64	74,00	34,00
6,800		74,00	34,00
6,900		74,00	34,00
7,000		74,00	34,00
7,030		74,00	34,00
7,100		74,00	34,00
7,140	9/32	74,00	34,00
7,200		74,00	34,00
7,300		74,00	34,00
7,370		74,00	34,00
7,400		74,00	34,00
7,490		74,00	34,00
7,500		74,00	34,00
7,540	19/64	79,00	37,00
7,600		79,00	37,00
7,670		79,00	37,00
7,700		79,00	37,00
7,800		79,00	37,00
7,900		79,00	37,00
7,940	5/16	79,00	37,00

d1		l1	l2
mm	inch	mm	mm
8,000		79,00	37,00
8,030		79,00	37,00
8,100		79,00	37,00
8,200		79,00	37,00
8,300		79,00	37,00
8,330	21/64	79,00	37,00
8,400		79,00	37,00
8,430		79,00	37,00
8,500		79,00	37,00
8,600		84,00	40,00
8,610		84,00	40,00
8,700		84,00	40,00
8,730	11/32	84,00	40,00
8,800		84,00	40,00
8,840		84,00	40,00
8,900		84,00	40,00
9,000		84,00	40,00
9,090		84,00	40,00
9,100		84,00	40,00
9,130	23/64	84,00	40,00
9,200		84,00	40,00
9,300		84,00	40,00
9,340		84,00	40,00
9,400		84,00	40,00
9,500		84,00	40,00
9,520	3/8	89,00	43,00
9,580		89,00	43,00
9,600		89,00	43,00
9,700		89,00	43,00
9,800		89,00	43,00
9,900		89,00	43,00
9,920	25/64	89,00	43,00
10,000		89,00	43,00
10,080		89,00	43,00
10,100		89,00	43,00
10,200		89,00	43,00
10,260		89,00	43,00
10,300		89,00	43,00
10,320	13/32	89,00	43,00
10,400		89,00	43,00
10,490		89,00	43,00
10,500		89,00	43,00
10,720	27/64	95,00	47,00
11,000		95,00	47,00
11,110	7/16	95,00	47,00
11,500		95,00	47,00
11,510	29/64	95,00	47,00
11,910	15/32	102,00	51,00
12,000		102,00	51,00
12,300	31/64	102,00	51,00
12,500		102,00	51,00
12,700	1/2	102,00	51,00
13,000		102,00	51,00
13,100	33/64	102,00	51,00
13,490	17/32	107,00	54,00
13,500		107,00	54,00
14,000		107,00	54,00
14,290	9/16	111,00	56,00

Spiralbohrer kurz

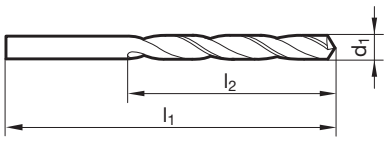
~5xD | DIN 338 | GU 500 DZ | 118° | h8

	Schneidstoff	HSCO	
	Oberfläche	○	Ⓢ
	Schneidrichtung	Ⓡ	Ⓡ

P •	Ausspitzung ≥ Ø 1,000 • Flächenanschliff • Co-legierter HSS-Stahl • geringe Vorschubkraft notwendig • geringes Drehmoment notwendig • universell einsetzbar
M •	
K •	
N •	Stähle (legiert/unleg.) bis 800 N/mm² • Kalt-/Warmarbeitsstähle • Wälzlagerstähle • NE-Metalle • Gusswerkstoffe • rostfreie Stähle • Kunststoffe
S	
H	

GÜHRINGNAVIGATOR

Schnittwerte siehe Seite 16



	Artikel-Nr.	5523	5519

d1 mm	inch	l1 mm	l2 mm
1,000		34,000	12,000
1,020		34,000	12,000
1,040		34,000	12,000
1,070		36,000	14,000
1,090		36,000	14,000
1,100		36,000	14,000
1,180		36,000	14,000
1,190	3/64	38,000	16,000
1,200		38,000	16,000
1,300		38,000	16,000
1,320		38,000	16,000
1,400		40,000	18,000
1,500		40,000	18,000
1,510		43,000	20,000
1,590	1/16	43,000	20,000
1,600		43,000	20,000
1,610		43,000	20,000
1,700		43,000	20,000
1,780		46,000	22,000
1,800		46,000	22,000
1,850		46,000	22,000
1,900		46,000	22,000
1,930		49,000	24,000
1,980	5/64	49,000	24,000
1,990		49,000	24,000
2,000		49,000	24,000
2,060		49,000	24,000
2,080		49,000	24,000
2,100		49,000	24,000
2,180		53,000	27,000
2,200		53,000	27,000
2,260		53,000	27,000
2,300		53,000	27,000
2,370		57,000	30,000
2,380	3/32	57,000	30,000
2,400		57,000	30,000
2,440		57,000	30,000
2,490		57,000	30,000
2,500		57,000	30,000
2,530		57,000	30,000
2,580		57,000	30,000
2,600		57,000	30,000

d1 mm	inch	l1 mm	l2 mm
2,640		57,000	30,000
2,700		61,000	33,000
2,710		61,000	33,000
2,780	7/64	61,000	33,000
2,790		61,000	33,000
2,800		61,000	33,000
2,820		61,000	33,000
2,870		61,000	33,000
2,900		61,000	33,000
2,950		61,000	33,000
3,000		61,000	33,000
3,050		65,000	36,000
3,100		65,000	36,000
3,170	1/8	65,000	36,000
3,200		65,000	36,000
3,260		65,000	36,000
3,300		65,000	36,000
3,400		70,000	39,000
3,450		70,000	39,000
3,500		70,000	39,000
3,570	9/64	70,000	39,000
3,600		70,000	39,000
3,660		70,000	39,000
3,700		70,000	39,000
3,730		70,000	39,000
3,800		75,000	43,000
3,860		75,000	43,000
3,900		75,000	43,000
3,910		75,000	43,000
3,970	5/32	75,000	43,000
3,990		75,000	43,000
4,000		75,000	43,000
4,040		75,000	43,000
4,090		75,000	43,000
4,100		75,000	43,000
4,200		75,000	43,000
4,220		75,000	43,000
4,300		80,000	47,000
4,370	11/64	80,000	47,000
4,390		80,000	47,000
4,400		80,000	47,000
4,500		80,000	47,000

d1		l1	l2
mm	inch	mm	mm
4,570		80,000	47,000
4,600		80,000	47,000
4,620		80,000	47,000
4,700		80,000	47,000
4,760	3/16	86,000	52,000
4,800		86,000	52,000
4,850		86,000	52,000
4,900		86,000	52,000
4,920		86,000	52,000
4,980		86,000	52,000
5,000		86,000	52,000
5,060		86,000	52,000
5,100		86,000	52,000
5,110		86,000	52,000
5,160	13/64	86,000	52,000
5,180		86,000	52,000
5,200		86,000	52,000
5,220		86,000	52,000
5,300		86,000	52,000
5,310		93,000	57,000
5,400		93,000	57,000
5,410		93,000	57,000
5,500		93,000	57,000
5,560	7/32	93,000	57,000
5,600		93,000	57,000
5,610		93,000	57,000
5,700		93,000	57,000
5,790		93,000	57,000
5,800		93,000	57,000
5,900		93,000	57,000
5,940		93,000	57,000
5,950	15/64	93,000	57,000
6,000		93,000	57,000
6,040		101,000	63,000
6,100		101,000	63,000
6,150		101,000	63,000
6,200		101,000	63,000
6,250		101,000	63,000
6,300		101,000	63,000
6,350	1/4	101,000	63,000
6,400		101,000	63,000
6,500		101,000	63,000
6,530		101,000	63,000
6,600		101,000	63,000
6,630		101,000	63,000
6,700		101,000	63,000
6,750	17/64	109,000	69,000
6,800		109,000	69,000
6,900		109,000	69,000
7,000		109,000	69,000
7,030		109,000	69,000
7,100		109,000	69,000
7,140	9/32	109,000	69,000
7,200		109,000	69,000
7,300		109,000	69,000
7,370		109,000	69,000
7,400		109,000	69,000
7,490		109,000	69,000
7,500		109,000	69,000
7,540	19/64	117,000	75,000
7,600		117,000	75,000
7,670		117,000	75,000
7,700		117,000	75,000
7,800		117,000	75,000
7,900		117,000	75,000
7,940	5/16	117,000	75,000

d1		l1	l2
mm	inch	mm	mm
8,000		117,000	75,000
8,030		117,000	75,000
8,100		117,000	75,000
8,200		117,000	75,000
8,300		117,000	75,000
8,330	21/64	117,000	75,000
8,400		117,000	75,000
8,430		117,000	75,000
8,500		117,000	75,000
8,600		125,000	81,000
8,610		125,000	81,000
8,700		125,000	81,000
8,730	11/32	125,000	81,000
8,800		125,000	81,000
8,840		125,000	81,000
8,900		125,000	81,000
9,000		125,000	81,000
9,090		125,000	81,000
9,100		125,000	81,000
9,130	23/64	125,000	81,000
9,200		125,000	81,000
9,300		125,000	81,000
9,340		125,000	81,000
9,400		125,000	81,000
9,500		125,000	81,000
9,520	3/8	133,000	87,000
9,580		133,000	87,000
9,600		133,000	87,000
9,700		133,000	87,000
9,800		133,000	87,000
9,900		133,000	87,000
9,920	25/64	133,000	87,000
10,000		133,000	87,000
10,080		133,000	87,000
10,100		133,000	87,000
10,200		133,000	87,000
10,260		133,000	87,000
10,300		133,000	87,000
10,320	13/32	133,000	87,000
10,400		133,000	87,000
10,490		133,000	87,000
10,500		133,000	87,000
10,720	27/64	142,000	94,000
11,000		142,000	94,000
11,110	7/16	142,000	94,000
11,500		142,000	94,000
11,510	29/64	142,000	94,000
11,910	15/32	151,000	101,000
12,000		151,000	101,000
12,300	31/64	151,000	101,000
12,500		151,000	101,000
12,700	1/2	151,000	101,000
13,000		151,000	101,000
13,100	33/64	151,000	101,000
13,490	17/32	160,000	108,000
13,500		160,000	108,000
14,000		160,000	108,000
14,290	9/16	169,000	114,000

Spiralbohrer lang

~10xD | DIN 340 | GU 500 DZ | 118° | h8

P	•
M	•
K	•
N	•
S	
H	

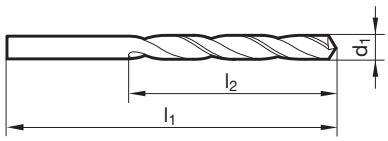
Ausspitzung ≥ Ø 1,000 • Flächenanschliff • Co-legierter HSS-Stahl • geringe Vorschubkraft notwendig • geringes Drehmoment notwendig • höhere Verschleißfestigkeit • universell einsetzbar • nur für kleine Bohrtiefen bei vertieft liegenden Bearbeitungsstellen oder Störkonturen geeignet

Stähle (legiert/unleg.) bis 800 N/mm² • Kalt-/Warmarbeitsstähle • Wälzlagerstähle • NE-Metalle • Gusswerkstoffe • rostfreie Stähle • Kunststoffe

GÜHRINGNAVIGATOR

Schnittwerte siehe Seite 16

Schneidstoff	HSCO	
Oberfläche	○	S
Schneidrichtung	R	R



Artikel-Nr.	5536	5537

d1 mm	inch	l1 mm	l2 mm
1,000		56,000	33,000
1,020		56,000	33,000
1,040		56,000	33,000
1,070		60,000	37,000
1,090		60,000	37,000
1,100		60,000	37,000
1,180		60,000	37,000
1,190	3/64	65,000	41,000
1,200		65,000	41,000
1,300		65,000	41,000
1,320		65,000	41,000
1,400		70,000	45,000
1,500		70,000	45,000
1,510		76,000	50,000
1,590	1/16	76,000	50,000
1,600		76,000	50,000
1,610		76,000	50,000
1,700		76,000	50,000
1,780		80,000	53,000
1,800		80,000	53,000
1,850		80,000	53,000
1,900		80,000	53,000
1,930		85,000	56,000
1,980	5/64	85,000	56,000
1,990		85,000	56,000
2,000		85,000	56,000
2,060		85,000	56,000
2,080		85,000	56,000
2,100		85,000	56,000
2,180		90,000	59,000
2,200		90,000	59,000
2,260		90,000	59,000
2,300		90,000	59,000
2,370		95,000	62,000
2,380	3/32	95,000	62,000
2,400		95,000	62,000
2,440		95,000	62,000
2,490		95,000	62,000
2,500		95,000	62,000
2,530		95,000	62,000
2,580		95,000	62,000
2,600		95,000	62,000

d1 mm	inch	l1 mm	l2 mm
2,640		95,000	62,000
2,700		100,000	66,000
2,710		100,000	66,000
2,780	7/64	100,000	66,000
2,790		100,000	66,000
2,800		100,000	66,000
2,820		100,000	66,000
2,870		100,000	66,000
2,900		100,000	66,000
2,950		100,000	66,000
3,000		100,000	66,000
3,050		106,000	69,000
3,100		106,000	69,000
3,170	1/8	106,000	69,000
3,200		106,000	69,000
3,260		106,000	69,000
3,300		106,000	69,000
3,400		112,000	73,000
3,450		112,000	73,000
3,500		112,000	73,000
3,570	9/64	112,000	73,000
3,600		112,000	73,000
3,660		112,000	73,000
3,700		112,000	73,000
3,730		112,000	73,000
3,800		119,000	78,000
3,860		119,000	78,000
3,900		119,000	78,000
3,910		119,000	78,000
3,970	5/32	119,000	78,000
3,990		119,000	78,000
4,000		119,000	78,000
4,040		119,000	78,000
4,090		119,000	78,000
4,100		119,000	78,000
4,200		119,000	78,000
4,220		119,000	78,000
4,300		126,000	82,000
4,370	11/64	126,000	82,000
4,390		126,000	82,000
4,400		126,000	82,000
4,500		126,000	82,000

d1		l1	l2
mm	inch	mm	mm
4,570		126,000	82,000
4,600		126,000	82,000
4,620		126,000	82,000
4,700		126,000	82,000
4,760	3/16	132,000	87,000
4,800		132,000	87,000
4,850		132,000	87,000
4,900		132,000	87,000
4,920		132,000	87,000
4,980		132,000	87,000
5,000		132,000	87,000
5,060		132,000	87,000
5,100		132,000	87,000
5,110		132,000	87,000
5,160	13/64	132,000	87,000
5,180		132,000	87,000
5,200		132,000	87,000
5,220		132,000	87,000
5,300		132,000	87,000
5,310		139,000	91,000
5,400		139,000	91,000
5,410		139,000	91,000
5,500		139,000	91,000
5,560	7/32	139,000	91,000
5,600		139,000	91,000
5,610		139,000	91,000
5,700		139,000	91,000
5,790		139,000	91,000
5,800		139,000	91,000
5,900		139,000	91,000
5,940		139,000	91,000
5,950	15/64	139,000	91,000
6,000		139,000	91,000
6,040		148,000	97,000
6,100		148,000	97,000
6,150		148,000	97,000
6,200		148,000	97,000
6,250		148,000	97,000
6,300		148,000	97,000
6,350	1/4	148,000	97,000
6,400		148,000	97,000
6,500		148,000	97,000
6,530		148,000	97,000
6,600		148,000	97,000
6,630		148,000	97,000
6,700		148,000	97,000
6,750	17/64	156,000	102,000
6,800		156,000	102,000
6,900		156,000	102,000
7,000		156,000	102,000
7,030		156,000	102,000
7,100		156,000	102,000
7,140	9/32	156,000	102,000
7,200		156,000	102,000
7,300		156,000	102,000
7,370		156,000	102,000
7,400		156,000	102,000
7,490		156,000	102,000
7,500		156,000	102,000
7,540	19/64	165,000	109,000
7,600		165,000	109,000
7,670		165,000	109,000
7,700		165,000	109,000
7,800		165,000	109,000
7,900		165,000	109,000
7,940	5/16	165,000	109,000

d1		l1	l2
mm	inch	mm	mm
8,000		165,000	109,000
8,030		165,000	109,000
8,100		165,000	109,000
8,200		165,000	109,000
8,300		165,000	109,000
8,330	21/64	165,000	109,000
8,400		165,000	109,000
8,430		165,000	109,000
8,500		165,000	109,000
8,600		175,000	115,000
8,610		175,000	115,000
8,700		175,000	115,000
8,730	11/32	175,000	115,000
8,800		175,000	115,000
8,840		175,000	115,000
8,900		175,000	115,000
9,000		175,000	115,000
9,090		175,000	115,000
9,100		175,000	115,000
9,130	23/64	175,000	115,000
9,200		175,000	115,000
9,300		175,000	115,000
9,340		175,000	115,000
9,400		175,000	115,000
9,500		175,000	115,000
9,520	3/8	184,000	121,000
9,580		184,000	121,000
9,600		184,000	121,000
9,700		184,000	121,000
9,800		184,000	121,000
9,900		184,000	121,000
9,920	25/64	184,000	121,000
10,000		184,000	121,000
10,080		184,000	121,000
10,100		184,000	121,000
10,200		184,000	121,000
10,260		184,000	121,000
10,300		184,000	121,000
10,320	13/32	184,000	121,000
10,400		184,000	121,000
10,490		184,000	121,000
10,500		184,000	121,000
10,720	27/64	195,000	128,000
11,000		195,000	128,000
11,110	7/16	195,000	128,000
11,500		195,000	128,000
11,510	29/64	195,000	128,000
11,910	15/32	205,000	134,000
12,000		205,000	134,000
12,300	31/64	205,000	134,000
12,500		205,000	134,000
12,700	1/2	205,000	134,000
13,000		205,000	134,000
13,100	33/64	205,000	134,000
13,490	17/32	214,000	140,000
13,500		214,000	140,000
14,000		214,000	140,000
14,290	9/16	220,000	144,000

Spiralbohrer-Sätze

~5xD | DIN 338 | GU 500 DZ | 118° | h8

Schneidstoff	HSCO
Oberfläche	○
Schneidrichtung	®

P	•
M	•
K	•
N	•
S	
H	

Ausspitzung ≥ Ø 1,000 • Flächenanschliff • Für Monteure und Handwerker stehen Sätze mit den gebräuchlichsten Bohrerabmessungen zur Verfügung, die mit Bakelitständer und Kassetten geliefert werden können. Auf Wunsch sind andere Satz-Zusammenstellungen möglich.

Artikel-Nr. **12**

d1	steigend um	Stück/Satz	Code-Nr.
mm	mm		
1,0-13,0	0,5	25	7,014
1,0-10,5	0,5	24	7,018

Alle Angaben sind Richtwerte. Die tatsächlich erreichbaren Schnittgeschwindigkeiten und Vorschübe hängen von den jeweiligen Bearbeitungsbedingungen ab. Wir empfehlen entsprechende Bohrversuche.

Zur Auswahl des optimalen Werkzeugs und der empfohlenen Schnittwerte für Ihre Anwendung steht Ihnen unter www.guehring.com auch eine elektronische Version des GühringNavigator zur Verfügung.

Artikel-Nr.
Norm/DIN
Schneidstoff
Oberfläche
Typ
Programm Seite

Bohrer-Ø mm	Vorschubreihen-Code								
	1	2	3	4	5	6	7	8	9
	f (mm/U)								
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	1,600	2,000

Werkstoffbezogene Kühlmittel:
○ Luft
● Öl
● Emulsion

Werkstoffgruppe	Werkstoffbeispiele, neue Bezeichnung (in Klammern alte Bezeichnung) Fettgedruckte Zahlen = Werkstoff-Nr. nach DIN EN	Zugfestigkeit MPa (N/mm²)	Härte	Kühlmittel
Allgemeine Baustähle	**1.0035** S185(St33), **1.0486** P275N(StE285), **1.0345** P235GH(H1), **1.0425** P265GH(H2)	≤500		●
	1.0050 E295 (St50-2), **1.0070** E360 (St70-2), **1.8937** P500NH (WStE500)	≤1000		●
Automatenstähle	**1.0718** 11SMnPb30 (9SMnPb28), **1.0736** 11SMn37 (9SMn36)	≤850		●
	1.0727 46S20 (45S20), **1.0728** (60S20), **1.0757** 46SPb20 (45SPb20)	≤1000		●
Unlegierte Vergütungsstähle	**1.0402** C22, **1.1178** C30E (Ck30)	≤700		●
	1.0503 C45, **1.1191** C45E (Ck45)	≤850		●
	1.0601 C60, **1.1221** C60E (Ck60)	≤1000		●
Legierte Vergütungsstähle	**1.5131** 50MnSi4, **1.7003** 38Cr2, **1.7030** 28Cr4	≤1000		●
	1.5710 36NiCr6, **1.7035** 41Cr4, **1.7225** 42CrMo4	≤1400		●
Unlegierte Einsatzstähle	**1.0301** (C10), **1.1121** C10E (Ck10)	≤850		●
Legierte Einsatzstähle	**1.7276** 10CrMo11, **1.5125** 11MnSi6	≤1000		●
	1.5752 15NiCr13, **1.7131** 16MnCr5, **1.7264** 20CrMo5	≤1400		●
Nitrierstähle	**1.8504** 34CrAl6	≤1000		●
	1.8519 31CrMoV9, **1.8550** 34CrAlNi7	≤1400		●
Werkzeugstähle	**1.1750** C75W, **1.2067** 102Cr6, **1.2307** 29CrMoV9	≤850		●
	1.2080 X210Cr12, **1.2083** X42Cr13, **1.2419** 105WCr6, **1.2767** X45NiCrMo4	≤1400		●
Schnellarbeitsstähle	**1.3243** S 6-5-2-5, **1.3343** S 6-5-2, **1.3344** S 6-5-3	≤1400		●
Federstähle	**1.5026** 55Si7, **1.7176** 55Cr3, **1.8159** 51CrV4 (51CrV4)		≤350 HB	●
Gehärtete Stähle	–		≤48 HRC	●
			≤66 HRC	●
Rostfreie Stähle, geschwefelt	**1.4005** X12CrS13, **1.4104** X14CrMoS17, **1.4105** X6CrMoS17, **1.4305** X8CrNiS18-9	≤900		●
austenitisch	**1.4301** X5CrNi18-10 (V2A), **1.4541** X6CrNiTi18-10, **1.4571** X6CrNiMoTi 17-12-2 (V4A)	≤1100		●
martensitisch	**1.4057** X20CrNi172 (X17CrNi16-2), **1.4122** X39CrMo17-1, **1.4521** X2CrMoTi18-2	≤1500		●
Gusseisen	**0.6010** EN-GJL-100 (GG10), **0.6020** EN-GJL-200 (GG20)		≤240 HB	○ ○
	0.6025 EN-GJL-250 (GG25), **0.6035** EN-GJL-350 (GG35)		≤350 HB	○ ○
Kugelgraphit- und Temperguss	**0.7050** EN-GJS-500-7 (GGG50), **0.8035** EN-GJMW-350-4 (GTW35)		≤240 HB	●
	0.7070 EN-GJS-700-2 (GGG70), **0.8170** EN-GJMB-700-2 (GTS70)		≤350 HB	●
Hartguss	–		≤350 HB	●
Neue Gusswerkstoffe GGV	**EN-GJV250** (GGV25), **EN-GJV350** (GGV35)		≤220 HB	○ ○
	EN-GJV400 (GGV40), **EN-GJV500** (GGV50), SiMo 6		≤300 HB	○ ○
Neue Gusswerkstoffe ADI	**EN-GJS-800-8** (ADI800), **EN-GJS-1000-5** (ADI1000)	≤1000		○ ○
	EN-GJS-1200-2 (ADI1200), **EN-GJS-1400-1** (ADI1400)	≤1400		○ ○
Sonderlegierungen	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
Titan und Titan-Legierungen	**3.7024** Ti99,5, **3.7114** TiAl5Sn2,5, **3.7124** TiCu2	≤850		●
	3.7154 TiAl6Zr5, **3.7165** TiAl6V4, **3.7184** TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		●
Aluminium und Al-Legierungen	**3.0255** Al99,5, **3.2315** AlMgSi1, **3.3515** AlMg1	≤400		●
Al-Knetlegierungen	**3.0615** AlMgSiPb, **3.1325** AlCuMg1, **3.3245** AlMg3Si, **3.4365** AlZnMgCu1,5	≤650		●
Al-Gusslegierungen ≤ 10 % Si	**3.2131** G-AlSi5Cu1, **3.2153** G-AlSi7Cu3, **3.2573** G-AlSi9	≤600		●
≤ 24 % Si	**3.2581** G-AlSi12, **3.2583** G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		●
Magnesium-Legierungen	**3.5200** MgMn2, **3.5812.05** G-MgAl8Zn1, **3.5612.05** G-MgAl6Zn1	≤400		○
Kupfer, niedriglegiert	**2.0070** SE-Cu, **2.1020** CuSn6, **2.1096** G-CuSn5ZnPb	≤500		●
Messing, kurzspanend	**2.0380** CuZn39Pb2, **2.0401** CuZn39Pb3, **2.0410** CuZn43Pb2	≤600		●
langspanend	**2.0250** CuZn20, **2.0280** CuZn33, **2.0332** CuZn37Pb0,5	≤600		●
Bronzen, kurzspanend	**2.1090** CuSn7ZnPb, **2.1170** CuPb5Sn5, **2.1176** CuPb10Sn	≤600		● ●
	2.0790 CuNi18Zn19Pb	≤850		●
Bronzen, langspanend	**2.0916** CuAl5, **2.0960** CuAl9Mn, **2.1050** CuSn10	≤850		●
	2.0980 CuAl11Ni, **2.1247** CuBe2	≤1000		●
Kunststoffe, duroplastisch	Bakelit, Resopal, Pertinax, Moltopren	≤150		○
thermoplastisch	Plexiglas, Hostalen, Novodur, Makralon	≤100		● ○
aramidfaserverstärkt	Kevlar	≤1000		○
glas-/kohlefaserverstärkt	GFK/CFK	≤1000		○

≤3xD

5524	5520	6005
1897	1897	WN
HSCO	HSCO	HSS-E-PM
○	Ⓢ	Ⓕ
GU 500 DZ	GU 500 DZ	GU 500
9	9	5

v_c m/min	VR-Code	v_c m/min	VR-Code	v_c m/min	VR-Code
35	6	45	6	47	6
30	5	35	5	37	5
40	6	50	6	53	6
30	6	40	6	42	6
32	6	44	6	46	6
28	6	44	6	46	6
20	5	40	5	42	5
15	4	27	4	28	4
13	3	22	3	23	3
30	6	44	6	46	6
16	4	22	4	23	4
12	3	18	3	19	3
15	4	22	4	23	4
10	3	16	3	17	3
15	4	20	4	21	4
10	3	15	3	16	3
10	3	13	2	14	2
		9	2	9	2
14	4	20	4	21	4
10	4	16	4	17	4
12	4	18	4	19	4
36	6	45	6	47	6
30	6	40	6	42	6
30	6	40	6	42	6
22	6	30	6	32	6
				5	2
50	7	70	7	74	7
50	7	70	7	74	7
65	7	85	7	89	7
60	6	70	6	74	6
60	6	80	6	84	6
70	5	80	5	84	5
45	5	77	5	81	5
30	5	44	5	46	5
36	4	50	4	53	4
30	4	40	4	42	4
30	4	32	4	34	4
25	4	28	4	29	4
20	4	25	4	26	4
15	4	27	4	28	4

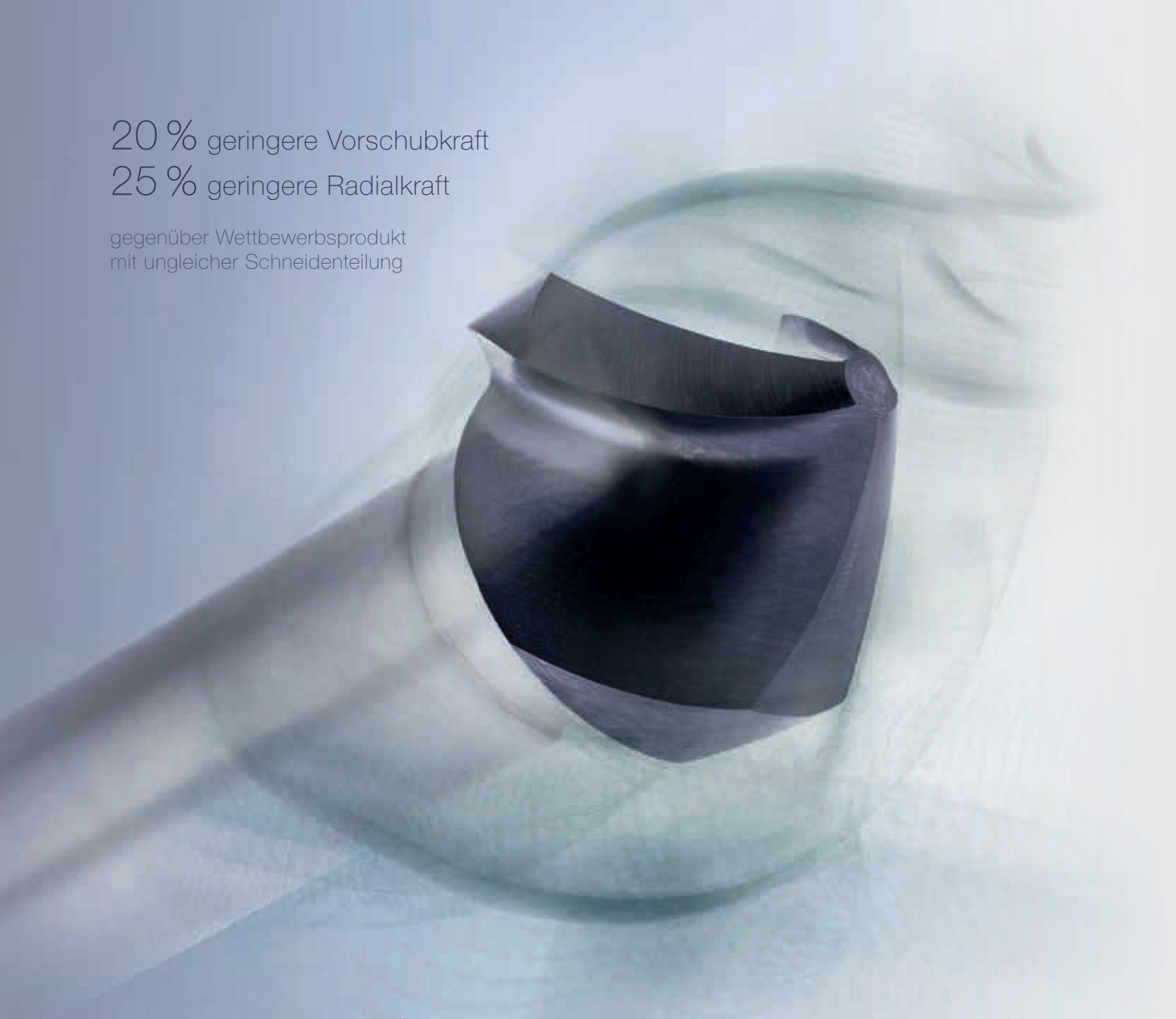
≤5xD

5523	5519	6006	5536	5537
338	338	WN	340	340
HSCO	HSCO	HSS-E-PM	HSCO	HSCO
○	Ⓢ	Ⓕ	○	Ⓢ
GU 500 DZ	GU 500 DZ	GU 500	GU 500 DZ	GU 500 DZ
11	11	7	13	13

v_c m/min	VR-Code	v_c m/min	VR-Code	v_c m/min	VR-Code	v_c m/min	VR-Code	v_c m/min	VR-Code
35	6	45	6	47	6	29	5	32	5
30	5	35	5	37	5	22	4	25	4
40	6	50	6	53	6	32	5	35	5
30	6	40	6	42	6	25	5	28	5
32	6	44	6	46	6	25	5	28	5
28	6	44	6	46	6	22	5	25	5
20	5	40	5	42	5	13	4	15	4
15	4	27	4	28	4	12	3	13	3
13	3	22	3	23	3	11	2	12	2
30	6	44	6	46	6	25	5	28	5
16	4	22	4	23	4	12	3	14	3
12	3	18	3	19	3	11	2	12	2
15	4	22	4	23	4	12	3	13	3
10	3	16	3	17	3	7	2	8	2
15	4	20	4	21	4	12	3	13	3
10	3	15	3	16	3	9	2	10	2
10	3	13	3	14	2	9	2	10	2
		9	2	9	2				
14	4	20	4	21	4	12	3	13	3
10	4	16	4	17	4	7	3	8	3
12	4	18	4	19	4	11	3	12	3
36	6	45	6	47	6	29	6	32	6
30	6	40	6	42	6	23	6	26	6
30	6	40	6	42	6	25	6	28	6
22	6	30	6	32	6	18	6	20	6
				5	2				
50	7	70	7	74	7	45	7	50	7
50	7	70	7	74	7	45	7	50	7
65	7	85	7	89	7	54	7	60	7
60	6	70	6	74	6	45	6	50	6
60	6	80	6	84	6	45	6	50	6
70	5	80	5	84	5	60	5	70	5
45	5	77	5	81	5	40	5	50	5
30	5	44	5	46	5	25	5	28	5
36	4	50	4	53	4	31	4	35	4
30	4	40	4	42	4	22	4	25	4
30	4	32	4	34	4	22	4	24	4
25	4	28	4	29	4	18	4	20	4
20	4	25	4	26	4	16	4	18	4
15	4	27	4	28	4	11	4	12	4

20 % geringere Vorschubkraft
25 % geringere Radialkraft

gegenüber Wettbewerbsprodukt
mit ungleicher Schneidenteilung



Spiralisierter Kegelsenker

SpyroTec

Konvexe Schneiden verringern Kräfte

Die Axial- und Radialkräfte, die bei Senkoperationen auftreten, werden durch die neu entwickelte Schneidengeometrie des SpyroTec stark reduziert. Dadurch ist auch ein komfortables Senken mit Handbohrmaschinen möglich. Die konvexen, ungleichen Radien der Schneiden mit variabler Spiralsteigung sorgen zusätzlich für einen ruhigen, vibrationsarmen Senkvorgang. Ergebnis ist eine runde, exakte und ratterfreie Senkung. Zusätzlich erhöht die speziell ausgelegte TiAlN-Beschichtung die Verschleißfestigkeit und Warmhärte, wodurch hohe Standzeiten in nahezu allen Materialien und Anwendungen erreicht werden können.

ISO-Codes

P	Stahl, hochlegierter Stahl
M	Rostfreier Stahl
K	Grauguss, Sphäroguss und Temperguss
N	Aluminium und andere Nichteisenmetalle
S	Sonder-, Super- und Titanlegierungen
H	Gehärteter Stahl und Hartguss

Angaben zur Eignung der Werkzeuge in versch. Materialklassen sowie max. Zugfestigkeit und Härte finden Sie auf den Produktseiten.

● optimal geeignet
○ bedingt geeignet

Piktogramme

Schneidstoff	HSCO, HSS-E-PM Schnellstahl
Bearbeitungstiefe	~3xD, ~5xD, ~10xD
Ø-Toleranz	h8
Schaftform	HA nach DIN 6535
Schneidrichtung	R rechts
Spitzenwinkel	118°
Ausspitzung	
Norm	DIN 338, DIN 340, DIN 1897 nach DIN WN nach Gühring Standard
Typ	GU 500 DZ, GU 500 PM

Oberflächen

○ blank
F FIRE/nano FIRE
S TiN

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