

GÜHRING

SuperLine

GU500 PM 粉末高速钢钻头

高效，高寿命，应用广泛



NEW

采用高性能粉末高速钢
采用钴钎经典复合涂层Fire

GU 500 PM

GU 500 PM 通用钻头

GÜHRING – YOUR WORLDWIDE PARTNER

GU 500

通用钻头

GU 500粉末高速钢钻头
应用于大部分材料

结构钢, 碳钢

高合金钢 (拉伸强度小于 1200 N/mm^2)

不锈钢, 铸铁

非铁合金, 铝合金

镁合金, 塑料等



16MnCr5

11SMn30+C

St37

GG

GGG

C45

VA

Aluminium

Copper

Bronze

Brass

Plexiglass

PVC

PE 1000

Makrolon

GU 500 RPM

双后刀面
定心好，孔精度高



精度为h6圆柱柄,实现高精度夹持

优化的槽型，排屑好

118° 顶角，切削刃长，
切削力小，延长刀具寿命

No.6005 ~3D
No.6006~5D
GU 500 PM

高性能粉末高速钢和钴领经典
Fire复合涂层，高的耐磨性

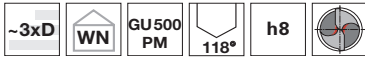
优化的头部几何参数
实现低的切削力和切削扭矩

GU 500 适用场合





加强柄麻花钻

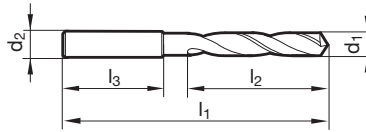


刀具材料 **HSS-E-PM**

涂层 **F**

切削方向 **(R)**

- P** ● 高性能麻花钻
- M** ● 粉末高速钢
- K** ● 双后刀面
- N** ● 低的切削力与扭矩
- S** ○
- H**



产品代码 **6005**

d1		d2 h6	l1	l2	l3	d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm	mm	inch	mm	mm	mm	mm
1,000		3,000	38,000	6,000	28,000	3,250		4,000	50,000	18,000	28,000
1,050		3,000	38,000	6,000	28,000	3,300		4,000	50,000	18,000	28,000
1,100		3,000	39,000	7,000	28,000	3,350		4,000	50,000	18,000	28,000
1,150		3,000	39,000	7,000	28,000	3,400		4,000	52,000	20,000	28,000
1,200		3,000	40,000	8,000	28,000	3,450		4,000	52,000	20,000	28,000
1,250		3,000	40,000	8,000	28,000	3,500		4,000	52,000	20,000	28,000
1,300		3,000	40,000	8,000	28,000	3,550		4,000	52,000	20,000	28,000
1,350		3,000	40,000	8,000	28,000	3,570	9/64	4,000	52,000	20,000	28,000
1,400		3,000	41,000	9,000	28,000	3,600		4,000	52,000	20,000	28,000
1,450		3,000	41,000	9,000	28,000	3,650		4,000	52,000	20,000	28,000
1,500		3,000	41,000	9,000	28,000	3,700		4,000	52,000	20,000	28,000
1,550		3,000	41,000	9,000	28,000	3,750		4,000	52,000	20,000	28,000
1,600		3,000	42,000	10,000	28,000	3,800		4,000	54,000	22,000	28,000
1,650		3,000	42,000	10,000	28,000	3,850		4,000	54,000	22,000	28,000
1,700		3,000	42,000	10,000	28,000	3,900		4,000	54,000	22,000	28,000
1,750		3,000	42,000	10,000	28,000	3,950		4,000	54,000	22,000	28,000
1,800		3,000	43,000	11,000	28,000	3,970	5/32	4,000	54,000	22,000	28,000
1,850		3,000	43,000	11,000	28,000	4,000		4,000	54,000	22,000	28,000
1,900		3,000	43,000	11,000	28,000	4,050		4,000	54,000	22,000	28,000
1,950		3,000	43,000	11,000	28,000	4,100		6,000	66,000	22,000	36,000
2,000		3,000	44,000	12,000	28,000	4,150		6,000	66,000	22,000	36,000
2,050		3,000	44,000	12,000	28,000	4,200		6,000	66,000	22,000	36,000
2,100		3,000	44,000	12,000	28,000	4,250		6,000	66,000	22,000	36,000
2,150		3,000	44,000	12,000	28,000	4,300		6,000	68,000	24,000	36,000
2,200		3,000	45,000	13,000	28,000	4,350		6,000	68,000	24,000	36,000
2,250		3,000	45,000	13,000	28,000	4,370	11/64	6,000	68,000	24,000	36,000
2,300		3,000	45,000	13,000	28,000	4,400		6,000	68,000	24,000	36,000
2,350		3,000	45,000	13,000	28,000	4,450		6,000	68,000	24,000	36,000
2,380	3/32	3,000	46,000	14,000	28,000	4,500		6,000	68,000	24,000	36,000
2,400		3,000	46,000	14,000	28,000	4,550		6,000	68,000	24,000	36,000
2,450		3,000	46,000	14,000	28,000	4,600		6,000	68,000	24,000	36,000
2,500		3,000	46,000	14,000	28,000	4,650		6,000	68,000	24,000	36,000
2,550		3,000	46,000	14,000	28,000	4,700		6,000	68,000	24,000	36,000
2,600		3,000	46,000	14,000	28,000	4,750		6,000	68,000	24,000	36,000
2,650		3,000	46,000	14,000	28,000	4,760	3/16	6,000	70,000	26,000	36,000
2,700		3,000	48,000	16,000	28,000	4,800		6,000	70,000	26,000	36,000
2,750		3,000	48,000	16,000	28,000	4,850		6,000	70,000	26,000	36,000
2,780	7/64	3,000	48,000	16,000	28,000	4,900		6,000	70,000	26,000	36,000
2,800		3,000	48,000	16,000	28,000	4,950		6,000	70,000	26,000	36,000
2,850		3,000	48,000	16,000	28,000	5,000		6,000	70,000	26,000	36,000
2,900		3,000	48,000	16,000	28,000	5,050		6,000	70,000	26,000	36,000
2,950		3,000	48,000	16,000	28,000	5,100		6,000	70,000	26,000	36,000
3,000		3,000	48,000	16,000	28,000	5,150		6,000	70,000	26,000	36,000
3,050		3,000	48,000	16,000	28,000	5,160	13/64	6,000	70,000	26,000	36,000
3,100		4,000	50,000	18,000	28,000	5,200		6,000	70,000	26,000	36,000
3,150		4,000	50,000	18,000	28,000	5,250		6,000	70,000	26,000	36,000
3,170	1/8	4,000	50,000	18,000	28,000	5,300		6,000	70,000	26,000	36,000
3,200		4,000	50,000	18,000	28,000	5,350		6,000	70,000	26,000	36,000



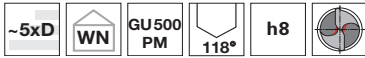
GU 500 通用钻头

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
5,400		6,000	72,000	28,000	36,000
5,450		6,000	72,000	28,000	36,000
5,500		6,000	72,000	28,000	36,000
5,550	7/32	6,000	72,000	28,000	36,000
5,560		6,000	72,000	28,000	36,000
5,600		6,000	72,000	28,000	36,000
5,650		6,000	72,000	28,000	36,000
5,700		6,000	72,000	28,000	36,000
5,750		6,000	72,000	28,000	36,000
5,800		6,000	72,000	28,000	36,000
5,850		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
6,050		6,000	72,000	28,000	36,000
6,100		8,000	75,000	31,000	36,000
6,150		8,000	75,000	31,000	36,000
6,200		8,000	75,000	31,000	36,000
6,250		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
6,450		8,000	75,000	31,000	36,000
6,500		8,000	75,000	31,000	36,000
6,550		8,000	75,000	31,000	36,000
6,600		8,000	75,000	31,000	36,000
6,650		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
6,850		8,000	78,000	34,000	36,000
6,900		8,000	78,000	34,000	36,000
6,950		8,000	78,000	34,000	36,000
7,000		8,000	78,000	34,000	36,000
7,050		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
7,150		8,000	78,000	34,000	36,000
7,200		8,000	78,000	34,000	36,000
7,250		8,000	78,000	34,000	36,000
7,300		8,000	78,000	34,000	36,000
7,350		8,000	78,000	34,000	36,000
7,400		8,000	78,000	34,000	36,000
7,450		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
7,650		8,000	81,000	37,000	36,000
7,700		8,000	81,000	37,000	36,000
7,750		8,000	81,000	37,000	36,000
7,800		8,000	81,000	37,000	36,000
7,850		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
7,950		8,000	81,000	37,000	36,000
8,000		8,000	81,000	37,000	36,000
8,050		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

d1		d2 h6	l1	l2	l3	
mm	inch	mm	mm	mm	mm	
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	
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	



加强柄麻花钻

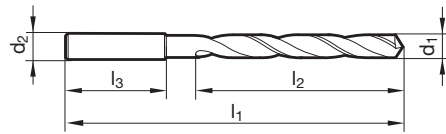


- P** • 高性能麻花钻
- M** • 粉末高速钢
- K** • 双后刀面
- N** • 低的切削力与扭矩
- S** ○
- H**

刀具材料 **HSS-E-PM**

涂层 **F**

切削方向 **(R)**



产品代码 **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

d1		d2 h6	l1	l2	l3
mm	inch	mm	mm	mm	mm
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
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

GU 500 PM 加工参数推荐

直径 Ø (mm)	普通结构钢 易切削钢 非合金热处理钢 非合金表面淬硬钢 拉伸强度 ≤ 1,000 N/mm ²		合金热处理钢 合金表面淬硬钢 渗氮钢 工具钢 拉伸强度 ≤ 1,400 N/mm ²	
	转速 (min ⁻¹)	每转进给 (mm/rev.)	转速 (min ⁻¹)	每转进给 (mm/rev.)
1.00	12,740 - 14,650 - 16,560	0.016 - 0.018 - 0.020	5,100 - 6,370 - 7,640	0.012 - 0.014 - 0.016
2.00	6,370 - 7,320 - 8,280	0.050 - 0.063 - 0.080	2,550 - 3,180 - 3,820	0.032 - 0.040 - 0.050
3.00	4,250 - 4,880 - 5,520	0.080 - 0.100 - 0.100	1,700 - 2,120 - 2,550	0.050 - 0.063 - 0.080
4.00	3,180 - 3,660 - 4,140	0.100 - 0.125 - 0.160	1,270 - 1,590 - 1,910	0.063 - 0.080 - 0.100
5.00	2,550 - 2,930 - 3,310	0.100 - 0.125 - 0.160	1,020 - 1,270 - 1,530	0.063 - 0.080 - 0.100
8.00	1,590 - 1,830 - 2,070	0.160 - 0.200 - 0.250	640 - 800 - 960	0.100 - 0.125 - 0.160
10.00	1,270 - 1,460 - 1,650	0.200 - 0.250 - 0.315	510 - 640 - 760	0.125 - 0.160 - 0.200
12.00	1,060 - 1,220 - 1,380	0.200 - 0.250 - 0.315	430 - 530 - 640	0.125 - 0.160 - 0.200
16.00	800 - 920 - 1,030	0.250 - 0.315 - 0.400	320 - 400 - 480	0.160 - 0.200 - 0.250
20.00	640 - 730 - 830	0.315 - 0.400 - 0.500	260 - 320 - 380	0.200 - 0.250 - 0.315

直径 Ø (mm)	不锈钢		铸铁	
	转速 (min ⁻¹)	每转进给 (mm/rev.)	转速 (min ⁻¹)	每转进给 (mm/rev.)
1.00	5,410 - 6,050 - 6,690	0.012 - 0.014 - 0.016	10,190 - 13,380 - 14,970	0.016 - 0.018 - 0.020
2.00	2,710 - 3,030 - 3,340	0.032 - 0.040 - 0.050	5,100 - 6,690 - 7,480	0.050 - 0.063 - 0.080
3.00	1,800 - 2,020 - 2,230	0.050 - 0.063 - 0.080	3,400 - 4,460 - 4,990	0.080 - 0.100 - 0.125
4.00	1,350 - 1,510 - 1,670	0.063 - 0.080 - 0.100	2,550 - 3,340 - 3,740	0.100 - 0.125 - 0.160
5.00	1,080 - 1,210 - 1,340	0.063 - 0.080 - 0.100	2,040 - 2,680 - 2,990	0.100 - 0.125 - 0.160
8.00	680 - 760 - 840	0.100 - 0.125 - 0.160	1,270 - 1,670 - 1,870	0.160 - 0.200 - 0.250
10.00	540 - 610 - 670	0.125 - 0.160 - 0.200	1,020 - 1,340 - 1,500	0.200 - 0.250 - 0.315
12.00	450 - 500 - 560	0.125 - 0.160 - 0.200	850 - 1,120 - 1,250	0.200 - 0.250 - 0.315
16.00	340 - 380 - 420	0.160 - 0.200 - 0.250	640 - 840 - 940	0.250 - 0.315 - 0.400
20.00	270 - 300 - 330	0.200 - 0.250 - 0.315	510 - 670 - 750	0.315 - 0.400 - 0.500

直径 Ø (mm)	铝/铜		塑料	
	转速 (min ⁻¹)	每转进给 (mm/rev.)	转速 (min ⁻¹)	每转进给 (mm/rev.)
1.00	20,380 - 23,560 - 26,750	0.014 - 0.017 - 0.020	8,250 - 8,600 - 8,920	0.012 - 0.014 - 0.016
2.00	10,190 - 11,780 - 13,380	0.040 - 0.057 - 0.080	4,130 - 4,300 - 4,460	0.032 - 0.040 - 0.050
3.00	6,800 - 7,860 - 8,920	0.063 - 0.090 - 0.125	2,750 - 2,870 - 2,970	0.050 - 0.063 - 0.080
4.00	5,100 - 5,890 - 6,690	0.080 - 0.110 - 0.160	2,060 - 2,150 - 2,230	0.063 - 0.080 - 0.100
5.00	4,080 - 4,710 - 5,350	0.080 - 0.110 - 0.160	1,650 - 1,720 - 1,780	0.063 - 0.080 - 0.100
8.00	2,550 - 2,950 - 3,350	0.125 - 0.180 - 0.250	1,030 - 1,080 - 1,120	0.100 - 0.125 - 0.160
10.00	2,040 - 2,360 - 2,670	0.160 - 0.225 - 0.315	830 - 860 - 890	0.125 - 0.160 - 0.200
12.00	1,700 - 1,960 - 2,230	0.160 - 0.225 - 0.315	690 - 720 - 740	0.125 - 0.160 - 0.200
16.00	1,270 - 1,470 - 1,670	0.200 - 0.275 - 0.400	520 - 540 - 560	0.160 - 0.200 - 0.250
20.00	1,020 - 1,180 - 1,340	0.250 - 0.360 - 0.500	410 - 430 - 450	0.200 - 0.250 - 0.315

螺旋槽铰刀

SpyroTec

降低 20% 的进给力

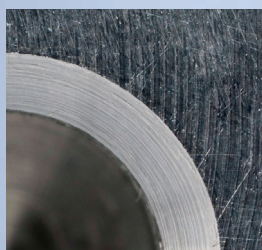
降低 25% 的径向力



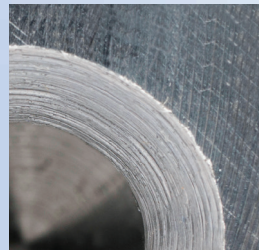
圆弧切削刃

降低轴向及径向切削力

钴领新开发的SpyroTec螺旋槽铰刀，特殊的切削刃，减小了铰孔产生的轴向力和径向力。即使使用手枪钻，也可以轻松便捷地进行铰孔加工。由于外凸的主切削刃，不等分螺旋槽，因此可以提供稳定且低振动的铰孔加工过程。实现高精度，圆度，无振动的铰孔。特殊设计的TiAlN涂层可确保更高的耐磨性和高温硬度，从而在几乎所有材料和应用中保证更长的刀具寿命。



SpyroTec的铰孔效果



标准铰钻的铰孔效果

GTMS Gühring Tool Management Software

GTMS

概览

新的工艺优化思路



TM Tool Management
Powered by
GUHRING



SuperLine



No.4662 液压刀柄 HSK63-A 20.063

No.4663 液压刀柄 SK40 20.040

No.4664 液压刀柄 BT40 20.040



GÜHRING

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