



# RT 100 T

Solid carbide spiral-flute  
deep hole drills

**Edition  
2013**

**EXCLUSIVELINE<sup>®</sup>**

Made by Guhring

## RT 100 T – ex-stock range

Available ex-stock now: The spiral-flute deep hole drill RT 100T. The program includes standard drills for drilling depths up to 15 x D, 20 x D, 25 x D, 30 x D and 40 x D. The RT 100 T ex-stock range offers an outstanding cost-performance-ratio as well as availability. Moreover, the RT 100T drills permit highest cutting and feed rates and subsequently achieve a considerable reduction in machining time.

**These advantages are achieved thanks to the following attributes:**

### Optimised flute geometry

The spiral-flute deep hole drills possess a special flute geometry that is optimised to the specific demand for optimal chip evacuation from the deep hole. (fig. 1)

### Maximised coolant duct profile

To provide the cutting edge with an optimum coolant supply, the tools possess a maximised coolant duct profile. It ensures an efficient coolant supply to the cutting edge as well as excellent chip evacuation. (fig. 2)

### Problem-free swarf

The factors described above – in combination with the cutting parameters optimally adapted to the application task – result in chips that are evacuated problem-free even from deep holes. Chip congestion and a subsequent jamming of the tool is effectively prevented. (fig. 3)

### Wear resistant cutting edges

Thanks to the TiAlN-tip coating the cutting edges, that are exposed to maximum forces, are protected against wear.

Ultimate cost-efficiency:

Applied on machining centres, where the drilling operation is a time relevant criterion, RT 100T can display its superiority. Its high feed rates lead to a shorter production time, its long tool life reduces the number of tool changes.

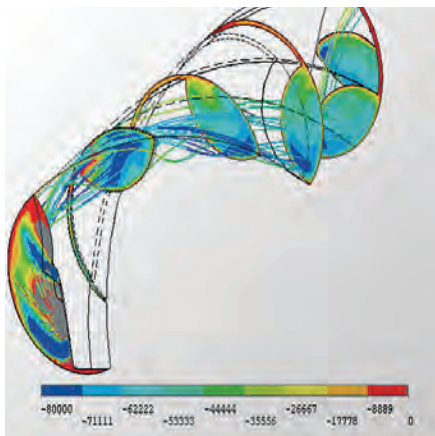
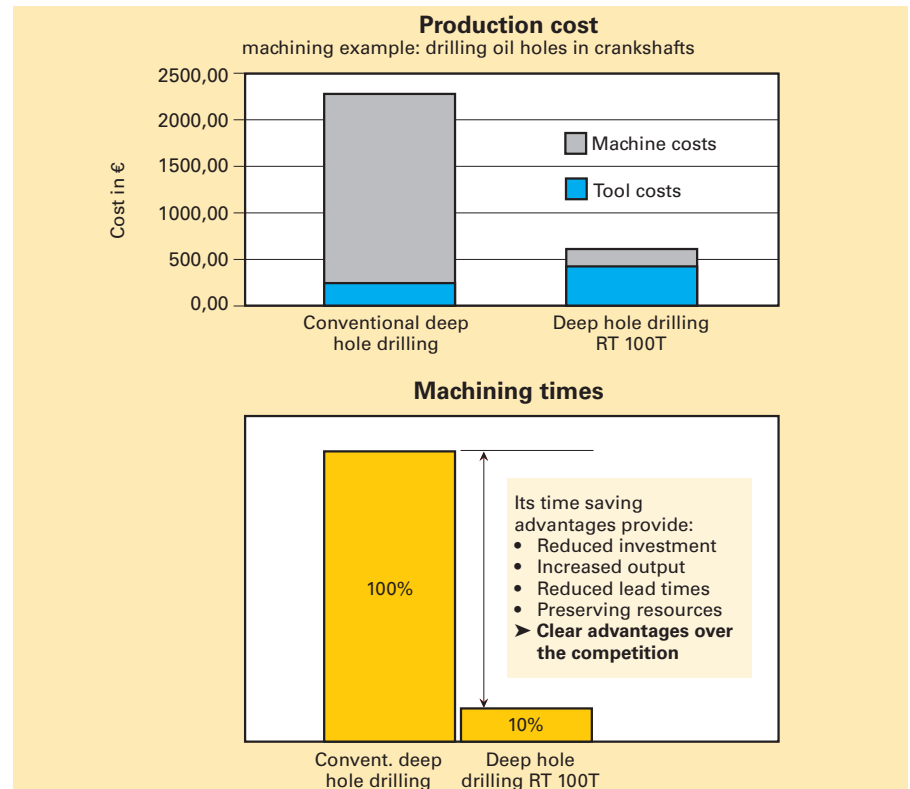


Fig. 1: Optimised flute geometry for optimal chip evacuation.



Fig. 2: Maximised coolant duct profile for effective cooling/lubrication.

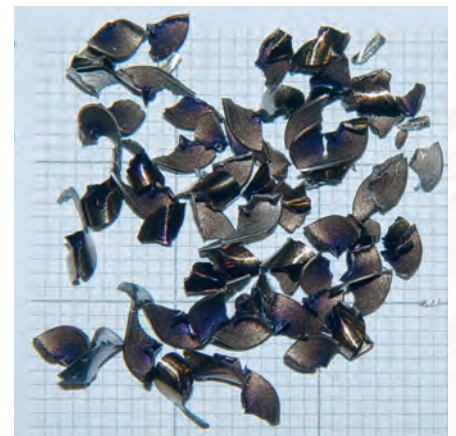


Fig. 3: Problem-free chips preventing chip congestion and jamming of the tool.

## RT 100 T – ex-stock range

### Reinforced shank for high precision clamping

Drills from the RT 100 T ex-stock range have a reinforced shank to DIN 6535 HA, tolerance h6. This enables the powerful clamping of the tools with hydraulic expansion chucks (fig. 4) from the Guhring GM 300 range. The combination RT 100 T plus hydraulic expansion chuck guarantees highest concentricity, extreme clamping forces, minimal imbalance and optimal efficiency.

### Intermediate diameters

In addition to the ex-stock range Guhring still offers RT 100 T drills as special tools to specific customer requirements. We realise intermediate diameters with maximum drilling depths up to  $40 \times D$  or a total length up to max. 400 mm. Please use the request form on page 18!

The modification of the shank to the MQL shank end makes the ex-stock range suitable for MQL machining, see page 16.

### Deep hole drilling? No problem!

The machining industry talks about deep hole drilling from a depth of  $10 \times D$  and above, shorter holes can also be produced with deep hole drills. Therefore, only a few special conditions must be applied:

### High-pressure cooling - now a matter of course

As in recent years internal cooling has prevailed with drilling tools, today every conventional machine tool is offered with high-pressure internal cooling and is therefore also suitable for deep hole drilling.

### Tool guidance - a must

All deep hole drills must be guided during initial drilling. Deep hole drills must never operate at full speed unsupported.

### RT 100 T - on deep hole drilling machines

After checking the clamping and the total length, the application of RT 100 T is possible on deep hole drilling machines with a guide bush.

### Procedure

To achieve optimal machining results in the production of deep holes with the RT 100 T particularly when piloting on radii and/or uneven surface we recommend the following machining steps:

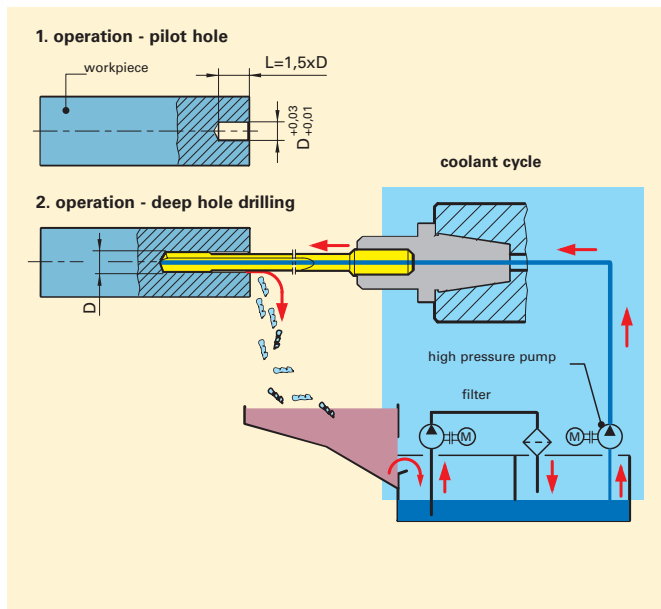
1. Milling of flat. The flat must be at right angles to the entry of the drilling operation.
2. Producing a cylindrical pilot hole (tolerance F9) with a minimum drilling depth of  $1 \times D$ .
3. Entering the RT 100 T slowly into the pilot hole.
4. Setting the cooling lubricant pressure and speed.
5. Continuous drilling to full drilling depth without pecking cycle.
6. For through holes with oblique exit reduce feed rate.
7. Upon reaching the drilling depth switch off speed and cooling lubricant, withdraw with rapid feed rate.

Detailed recommendations regarding the procedure on page 14.

Fig. 4: Optimal tool clamping in hydraulic chucks thanks to reinforced shank design



Fig. 5: Deep hole drilling on conventional machine tools



# EXCLUSIVE LINE<sup>®</sup>

## RT 100 T – ex-stock range 15 x D

Order no. = Guhring no. + code-no.

Guhring no.

Standard

Tool material

Carbide grade

Surface

Type

Shank

Drilling depth

Cutting direction

Tolerance

Discount group

6509

Guhring Std.

Solid Carbide

K30/K40

TiAlN-tip-coated

RT 100 T

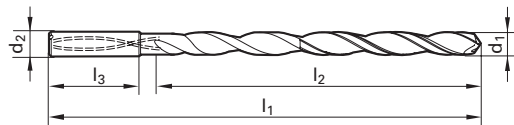
HA

15 x D

right-hand

h7

165



Code	d1	d1	d2 h6	l1	l2	l3
no.	inch	mm	mm	mm	mm	mm
3.000	13/64	3.000	6.000	95.00	55.00	36.00
3.170	1/8	3.170	6.000	106.00	67.00	36.00
3.500		3.500	6.000	116.00	76.00	36.00
3.570	9/64	3.570	6.000	116.00	76.00	36.00
3.970	5/32	3.970	6.000	116.00	76.00	36.00
4.000		4.000	6.000	116.00	76.00	36.00
4.370	11/64	4.370	6.000	133.00	93.00	36.00
4.500		4.500	6.000	133.00	93.00	36.00
4.760	3/16	4.760	6.000	133.00	93.00	36.00
5.000		5.000	6.000	133.00	93.00	36.00
5.100		5.100	6.000	150.00	110.00	36.00
5.160	13/64	5.160	6.000	150.00	110.00	36.00
5.410		5.410	6.000	150.00	110.00	36.00
5.500		5.500	6.000	150.00	110.00	36.00
5.560	7/32	5.560	6.000	150.00	110.00	36.00
5.950	15/64	5.950	6.000	150.00	110.00	36.00
6.000		6.000	6.000	150.00	110.00	36.00
6.350	1/4	6.350	8.000	167.00	127.00	36.00
6.500		6.500	8.000	167.00	127.00	36.00
6.750	17/64	6.750	8.000	167.00	127.00	36.00
7.000		7.000	8.000	167.00	127.00	36.00
7.140	9/32	7.140	8.000	183.00	143.00	36.00
7.500		7.500	8.000	183.00	143.00	36.00
7.540		7.540	8.000	183.00	143.00	36.00
7.940	19/64	7.940	8.000	183.00	143.00	36.00
8.000		8.000	8.000	183.00	143.00	36.00
8.330	21/64	8.330	10.000	204.00	160.00	40.00
8.500		8.500	10.000	204.00	160.00	40.00
8.730	11/32	8.730	10.000	204.00	160.00	40.00
9.000		9.000	10.000	204.00	160.00	40.00

### Availability



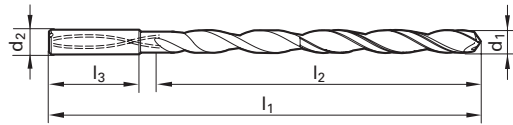
# EXCLUSIVELINE<sup>®</sup>

## RT 100 T – ex-stock range 15 x D

Order no. = Guhring no. + code-no.

- Guhring no.**
- Standard**
- Tool material**
- Carbide grade**
- Surface**
- Type**
- Shank**
- Drilling depth**
- Cutting direction**
- Tolerance**
- Discount group**

<b>6509</b>
<b>Guhring Std.</b>
<b>Solid Carbide</b>
<b>K30/K40</b>
<b>A TiAlN-tip-coated</b>
<b>RT 100 T</b>
<b>HA</b>
<b>15 x D</b>
<b>right-hand</b>
<b>h7</b>
<b>165</b>




Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
9.130	23/64	9.130	10.000	221.00	177.00	40.00
9.520	3/8	9.520	10.000	221.00	177.00	40.00
9.920	25/64	9.920	10.000	221.00	177.00	40.00
10.000		10.000	10.000	221.00	177.00	40.00
10.320	13/32	10.320	12.000	247.00	198.00	45.00
10.720	27/64	10.720	12.000	247.00	198.00	45.00
11.000		11.000	12.000	247.00	198.00	45.00
11.110	7/16	11.110	12.000	263.00	214.00	45.00
11.510	29/64	11.510	12.000	263.00	214.00	45.00
11.910	15/32	11.910	12.000	263.00	214.00	45.00
12.000		12.000	12.000	263.00	214.00	45.00
12.300	31/64	12.300	14.000	297.00	248.00	45.00
12.700	1/2	12.700	14.000	297.00	248.00	45.00
13.100	33/64	13.100	14.000	297.00	248.00	45.00
13.490	17/32	13.490	14.000	297.00	248.00	45.00
13.890	35/64	13.890	14.000	297.00	248.00	45.00
14.000		14.000	14.000	297.00	248.00	45.00

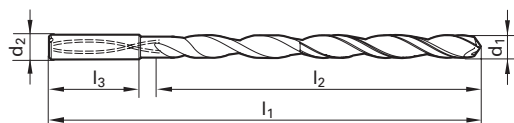
Availability	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	
●	

# EXCLUSIVE LINE<sup>®</sup>

## RT 100 T – ex-stock range 20 x D

Order no. = Guhring no. + code-no.

<b>Guhring no.</b>	<b>6511</b>
<b>Standard</b>	<b>Guhring Std.</b>
<b>Tool material</b>	<b>Solid Carbide</b>
<b>Carbide grade</b>	<b>K30/K40</b>
<b>Surface</b>	<b> TiAlN-tip-coated</b>
<b>Type</b>	<b>RT 100 T</b>
<b>Shank</b>	<b>HA</b>
<b>Drilling depth</b>	<b>20 x D</b>
<b>Cutting direction</b>	<b>right-hand</b>
<b>Tolerance</b>	<b>h7</b>
<b>Discount group</b>	<b>165</b>



Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3.000		3.000	6.000	110.00	70.00	36.00
3.100		3.100	6.000	123.00	83.00	36.00
3.170	1/8	3.170	6.000	123.00	83.00	36.00
3.500		3.500	6.000	136.00	96.00	36.00
3.570	9/64	3.570	6.000	136.00	96.00	36.00
3.970	5/32	3.970	6.000	136.00	96.00	36.00
4.000		4.000	6.000	136.00	96.00	36.00
4.200		4.200	6.000	158.00	118.00	36.00
4.370	11/64	4.370	6.000	158.00	118.00	36.00
4.500		4.500	6.000	158.00	118.00	36.00
4.760	3/16	4.760	6.000	158.00	118.00	36.00
5.000		5.000	6.000	158.00	118.00	36.00
5.100		5.100	6.000	180.00	140.00	36.00
5.160	13/64	5.160	6.000	180.00	140.00	36.00
5.410		5.410	6.000	180.00	140.00	36.00
5.500		5.500	6.000	180.00	140.00	36.00
5.560	7/32	5.560	6.000	180.00	140.00	36.00
5.950	15/64	5.950	6.000	180.00	140.00	36.00
6.000		6.000	6.000	180.00	140.00	36.00
6.350	1/4	6.350	8.000	202.00	162.00	36.00
6.500		6.500	8.000	202.00	162.00	36.00
6.750	17/64	6.750	8.000	202.00	162.00	36.00
7.000		7.000	8.000	202.00	162.00	36.00
7.140	9/32	7.140	8.000	223.00	183.00	36.00
7.500		7.500	8.000	223.00	183.00	36.00
7.540		7.540	8.000	223.00	183.00	36.00
7.940	19/64	7.940	8.000	223.00	183.00	36.00
8.000		8.000	8.000	223.00	183.00	36.00
8.330	21/64	8.330	10.000	249.00	205.00	40.00
8.500		8.500	10.000	249.00	205.00	40.00

### Availability





# EXCLUSIVE LINE®

## RT 100 T – ex-stock range 20 x D

Order no. = Guhring no. + code-no.

**Guhring no.**  
**Standard**  
**Tool material**  
**Carbide grade**  
**Surface**  
**Type**  
**Shank**  
**Drilling depth**  
**Cutting direction**  
**Tolerance**  
**Discount group**

6511

Guhring Std.

Solid Carbide

K30/K40

 TiAlN-tip-coated

RT 100 T

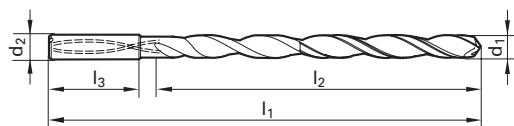
HA

20 x D

right-hand

h7

165



Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
8.730	11/32	8.730	10.000	249.00	205.00	40.00
9.000		9.000	10.000	249.00	205.00	40.00
9.130	23/64	9.130	10.000	271.00	227.00	40.00
9.520	3/8	9.520	10.000	271.00	227.00	40.00
9.920	25/64	9.920	10.000	271.00	227.00	40.00
10.000		10.000	10.000	271.00	227.00	40.00
10.320	13/32	10.320	12.000	302.00	253.00	45.00
10.720	27/64	10.720	12.000	302.00	253.00	45.00
11.000		11.000	12.000	302.00	253.00	45.00
11.110	7/16	11.110	12.000	323.00	274.00	45.00
11.510	29/64	11.510	12.000	323.00	274.00	45.00
11.910	15/32	11.910	12.000	323.00	274.00	45.00
12.000		12.000	12.000	323.00	274.00	45.00
12.300	31/64	12.300	14.000	367.00	318.00	45.00
12.700	1/2	12.700	14.000	367.00	318.00	45.00
13.100	33/64	13.100	14.000	367.00	318.00	45.00
13.490	17/32	13.490	14.000	367.00	318.00	45.00
13.890	35/64	13.890	14.000	367.00	318.00	45.00
14.000		14.000	14.000	367.00	318.00	45.00

### Availability

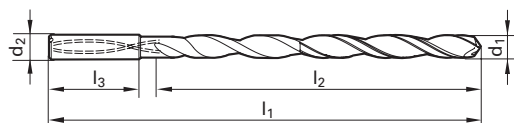


# EXCLUSIVE LINE®

## RT 100 T – ex-stock range 25 x D

Order no. = Guhring no. + code-no.

<b>Guhring no.</b>	<b>6512</b>
<b>Standard</b>	<b>Guhring Std.</b>
<b>Tool material</b>	<b>Solid Carbide</b>
<b>Carbide grade</b>	<b>K30/K40</b>
<b>Surface</b>	<b>A TiAlN-tip-coated</b>
<b>Type</b>	<b>RT 100 T</b>
<b>Shank</b>	<b>HA</b>
<b>Drilling depth</b>	<b>25 x D</b>
<b>Cutting direction</b>	<b>right-hand</b>
<b>Tolerance</b>	<b>h7</b>
<b>Discount group</b>	<b>165</b>



Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3.000		3.000	6.000	125.00	85.00	36.00
3.100		3.100	6.000	141.00	101.00	36.00
3.170	1/8	3.170	6.000	141.00	101.00	36.00
3.500		3.500	6.000	156.00	116.00	36.00
3.570	9/64	3.570	6.000	156.00	116.00	36.00
3.800		3.800	6.000	156.00	116.00	36.00
3.970	5/32	3.970	6.000	156.00	116.00	36.00
4.000		4.000	6.000	156.00	116.00	36.00
4.200		4.200	6.000	183.00	143.00	36.00
4.370	11/64	4.370	6.000	183.00	143.00	36.00
4.500		4.500	6.000	183.00	143.00	36.00
4.760	3/16	4.760	6.000	183.00	143.00	36.00
5.000		5.000	6.000	183.00	143.00	36.00
5.100		5.100	6.000	210.00	170.00	36.00
5.160	13/64	5.160	6.000	210.00	170.00	36.00
5.410		5.410	6.000	210.00	170.00	36.00
5.500		5.500	6.000	210.00	170.00	36.00
5.560	7/32	5.560	6.000	210.00	170.00	36.00
5.950	15/64	5.950	6.000	210.00	170.00	36.00
6.000		6.000	6.000	210.00	170.00	36.00
6.300		6.300	8.000	237.00	197.00	36.00
6.350	1/4	6.350	8.000	237.00	197.00	36.00
6.500		6.500	8.000	237.00	197.00	36.00
6.750	17/64	6.750	8.000	237.00	197.00	36.00
7.000		7.000	8.000	237.00	197.00	36.00
7.140	9/32	7.140	8.000	263.00	223.00	36.00
7.500		7.500	8.000	263.00	223.00	36.00
7.540		7.540	8.000	263.00	223.00	36.00
7.940	19/64	7.940	8.000	263.00	223.00	36.00
8.000		8.000	8.000	263.00	223.00	36.00

### Availability



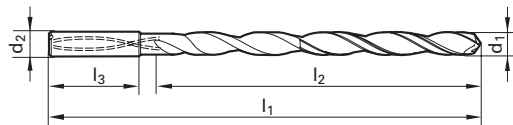


# EXCLUSIVE LINE®

## RT 100 T – ex-stock range 25 x D

Order no. = Guhring no. + code-no.

<b>Guhring no.</b>	<b>6512</b>
<b>Standard</b>	<b>Guhring Std.</b>
<b>Tool material</b>	<b>Solid Carbide</b>
<b>Carbide grade</b>	<b>K30/K40</b>
<b>Surface</b>	<b>TiAlN-tip-coated</b>
<b>Type</b>	<b>RT 100 T</b>
<b>Shank</b>	<b>HA</b>
<b>Drilling depth</b>	<b>25 x D</b>
<b>Cutting direction</b>	<b>right-hand</b>
<b>Tolerance</b>	<b>h7</b>
<b>Discount group</b>	<b>165</b>



Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
8.330	21/64	8.330	10.000	294.00	250.00	40.00
8.500		8.500	10.000	294.00	250.00	40.00
8.730	11/32	8.730	10.000	294.00	250.00	40.00
8.800		8.800	10.000	294.00	250.00	40.00
9.000		9.000	10.000	294.00	250.00	40.00
9.130	23/64	9.130	10.000	321.00	277.00	40.00
9.520	3/8	9.520	10.000	321.00	277.00	40.00
9.920	25/64	9.920	10.000	321.00	277.00	40.00
10.000		10.000	10.000	321.00	277.00	40.00
10.320	13/32	10.320	12.000	359.00	310.00	45.00
10.720	27/64	10.720	12.000	359.00	310.00	45.00
11.000		11.000	12.000	359.00	310.00	45.00
11.110	7/16	11.110	12.000	386.00	337.00	45.00
11.510	29/64	11.510	12.000	386.00	337.00	45.00
11.910	15/32	11.910	12.000	386.00	337.00	45.00
12.000		12.000	12.000	386.00	337.00	45.00

### Availability

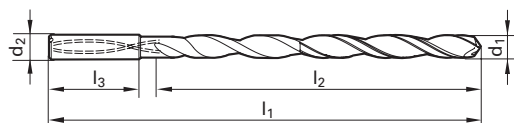


# EXCLUSIVE LINE®

## RT 100 T – ex-stock range 30 x D

Order no. = Guhring no. + code-no.

<b>Guhring no.</b>	<b>6513</b>
<b>Standard</b>	<b>Guhring Std.</b>
<b>Tool material</b>	<b>Solid Carbide</b>
<b>Carbide grade</b>	<b>K30/K40</b>
<b>Surface</b>	<b>A TiAlN-tip-coated</b>
<b>Type</b>	<b>RT 100 T</b>
<b>Shank</b>	<b>HA</b>
<b>Drilling depth</b>	<b>30 x D</b>
<b>Cutting direction</b>	<b>right-hand</b>
<b>Tolerance</b>	<b>h7</b>
<b>Discount group</b>	<b>165</b>



Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3.000		3.000	6.000	140.00	100.00	36.00
3.100		3.100	6.000	158.00	118.00	36.00
3.170	1/8	3.170	6.000	158.00	118.00	36.00
3.500		3.500	6.000	176.00	136.00	36.00
3.570	9/64	3.570	6.000	176.00	136.00	36.00
3.800		3.800	6.000	176.00	136.00	36.00
3.970	5/32	3.970	6.000	176.00	136.00	36.00
4.000		4.000	6.000	176.00	136.00	36.00
4.200		4.200	6.000	208.00	168.00	36.00
4.370	11/64	4.370	6.000	208.00	168.00	36.00
4.500		4.500	6.000	208.00	168.00	36.00
4.760	3/16	4.760	6.000	208.00	168.00	36.00
5.000		5.000	6.000	208.00	168.00	36.00
5.100		5.100	6.000	240.00	200.00	36.00
5.160	13/64	5.160	6.000	240.00	200.00	36.00
5.410		5.410	6.000	240.00	200.00	36.00
5.500		5.500	6.000	240.00	200.00	36.00
5.560	7/32	5.560	6.000	240.00	200.00	36.00
5.950	15/64	5.950	6.000	240.00	200.00	36.00
6.000		6.000	6.000	240.00	200.00	36.00
6.300		6.300	8.000	272.00	232.00	36.00
6.350	1/4	6.350	8.000	272.00	232.00	36.00
6.500		6.500	8.000	272.00	232.00	36.00
6.750	17/64	6.750	8.000	272.00	232.00	36.00
7.000		7.000	8.000	272.00	232.00	36.00
7.140	9/32	7.140	8.000	303.00	263.00	36.00
7.500		7.500	8.000	303.00	263.00	36.00
7.540		7.540	8.000	303.00	263.00	36.00
7.940	19/64	7.940	8.000	303.00	263.00	36.00
8.000		8.000	8.000	303.00	263.00	36.00

### Availability



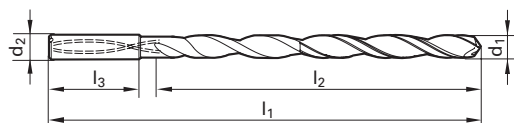


# EXCLUSIVE LINE®

## RT 100 T – ex-stock range 40 x D

Order no. = Guhring no. + code-no.

<b>Guhring no.</b>	<b>6514</b>
<b>Standard</b>	<b>Guhring Std.</b>
<b>Tool material</b>	<b>Solid Carbide</b>
<b>Carbide grade</b>	<b>K30/K40</b>
<b>Surface</b>	<b>A TiAlN-tip-coated</b>
<b>Type</b>	<b>RT 100 T</b>
<b>Shank</b>	<b>HA</b>
<b>Drilling depth</b>	<b>40 x D</b>
<b>Cutting direction</b>	<b>right-hand</b>
<b>Tolerance</b>	<b>h7</b>
<b>Discount group</b>	<b>165</b>



Code no.	d1 inch	d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3.000		3.000	6.000	170.00	130.00	36.00
3.100		3.100	6.000	193.00	153.00	36.00
3.170	1/8	3.170	6.000	193.00	153.00	36.00
3.500		3.500	6.000	193.00	153.00	36.00
3.570	9/64	3.570	6.000	216.00	176.00	36.00
3.800		3.800	6.000	216.00	176.00	36.00
3.970	5/32	3.970	6.000	216.00	176.00	36.00
4.000		4.000	6.000	216.00	176.00	36.00
4.200		4.200	6.000	238.00	198.00	36.00
4.370	11/64	4.370	6.000	238.00	198.00	36.00
4.500		4.500	6.000	238.00	198.00	36.00
4.760	3/16	4.760	6.000	258.00	218.00	36.00
5.000		5.000	6.000	258.00	218.00	36.00
5.100		5.100	6.000	280.00	240.00	36.00
5.160	13/64	5.160	6.000	280.00	240.00	36.00
5.410		5.410	6.000	280.00	240.00	36.00
5.500		5.500	6.000	280.00	240.00	36.00
5.560	7/32	5.560	6.000	300.00	260.00	36.00
5.950	15/64	5.950	6.000	300.00	260.00	36.00
6.000		6.000	6.000	300.00	260.00	36.00
6.300		6.300	8.000	322.00	282.00	36.00
6.350	1/4	6.350	8.000	322.00	282.00	36.00
6.500		6.500	8.000	322.00	282.00	36.00
6.750	17/64	6.750	8.000	342.00	302.00	36.00
7.000		7.000	8.000	342.00	302.00	36.00
7.140	9/32	7.140	8.000	363.00	323.00	36.00
7.500		7.500	8.000	363.00	323.00	36.00
7.540		7.540	8.000	383.00	343.00	36.00
7.940	19/64	7.940	8.000	383.00	343.00	36.00
8.000		8.000	8.000	383.00	343.00	36.00

### Availability



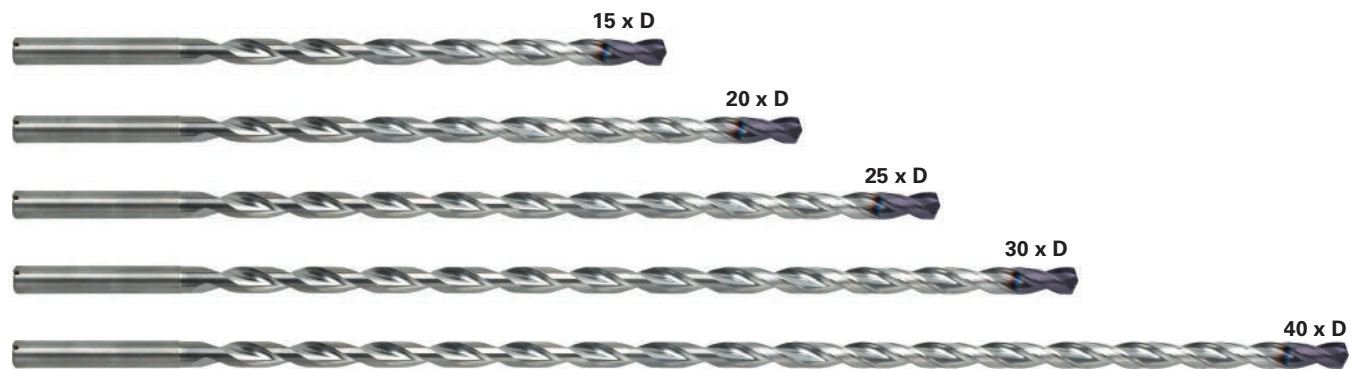
# EXCLUSIVE<sup>LINE</sup><sup>®</sup>

## RT 100 T – re-grinding and re-coating

Even the most wear-resistant tools will wear when subjected to rigorous use. Through professional re-grinding to original geometries and re-coating with original coatings Guhring re-produces the original performance so that the tools continue to optimally fulfil all quality parameters. At the same time the refurbishment extends the longevity of tooling which means reduced consumption of new tools hence lower costs.

### Our service centres

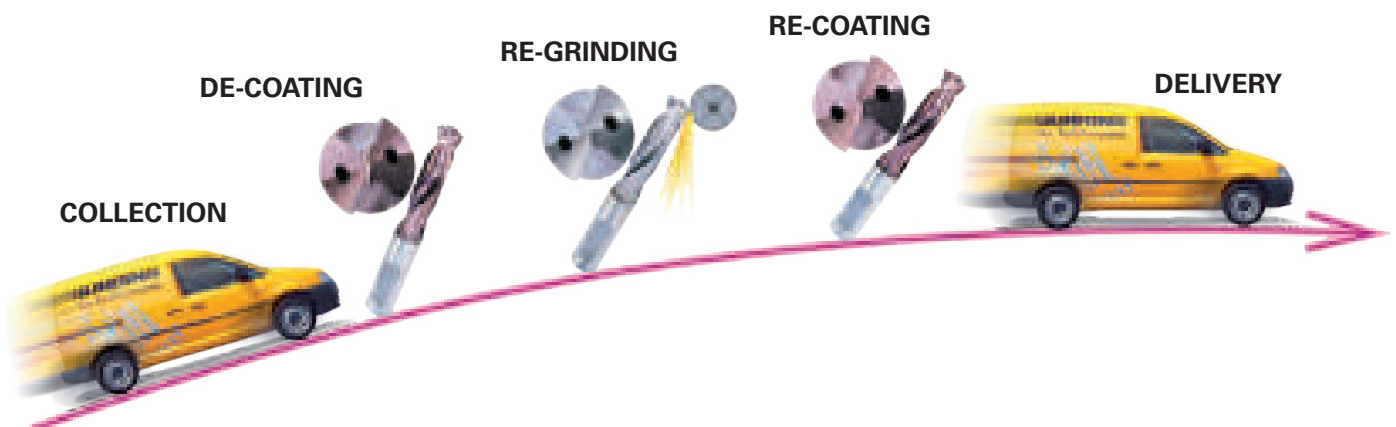
Fast service requires localised centres and this support is provided through 39 service centres world-wide. More will follow. All service centres are equipped with the latest production machines and Guhring developed coating plants. Every service centre provides a collection and delivery service to offer you our proven process for handling your orders in a flexible, fast and economical manner.



d1 mm	Re-grinding*	Tip-coating up to 20 x D      up to 40 x D		De-coating **
	Basic price per piece in €	Additional charge to the basic price in €		Additional charge to the basic price in €
up to Ø 6 mm	•	•	•	•
Ø > 6 - 8 mm	•	•	•	•
Ø > 8 - 10 mm	•	•	•	•
Ø > 10 - 12 mm	•	•	•	•
Ø > 12 - 14 mm	•	•	•	•

\* axial removal max. 1 mm, the diameter is reduced according to the back taper value. Please specify minimum length and Ø-tolerances when placing order.

\*\* it should be noted that continual re-coating of a tool without prior de-coating results in a diameter increase in the µm-range. Additional coatings are available on request.



## RT 100 T – machining steps

### Procedure

In order to achieve optimal machining results when producing deep holes with type RT 100T especially spotting on radii or on an uneven surface structure, we recommend the following machining steps:

1. Initial milling of surface, i.e. with Guhring's centre cutting Ratio end mill RF 100 U. The surface must be machined at right angles to the entry angle of the drilling operation.
2. Production of a cylindrical pilot hole (tolerance F9) with a minimum drilling depth of 1 x D. For this operation we recommend our Ratio drills RT 100 U or RT 100 F respectively. Thanks to a 140° point angle and a m7 tolerance on diameter these Ratio drills are especially suitable for this machining task.
3. Entry of spiral-flute deep hole drill RT 100T in the pilot hole at a speed of approx. 300 rev./min and with a feed rate of approx. 500 mm/min.
4. Setting of coolant pressure and speed.
5. Continuous drilling to complete hole depth without wood pecking.
6. For through holes with plain - i.e. 90° - exit, reduce feed rate  $v_f$  to 50 % approx. 1 mm prior to break-through.
7. For through holes with oblique exit, reduce the feed rate  $v_f$  to 40% approx. 1 mm prior to break-through.
8. After reaching hole depth stop machine spindle and coolant supply, withdrawal in top gear.

drill Ø mm	Feed column no.								
	1	2	3	4	5	6	7	8	9
	$f$ (mm/rev)								
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



### Ratio end mill type RF 100 U, Guhring no. 3736

Thanks to its unequal helix angle, Guhring's FIRE-coated Ratio end mill RF 100 U offers highest feed rates and tool life for finishing and roughing operations in steel and cast materials as well as Ti- and Ni-alloys. Further information about the range can be found in Guhring's current main catalogue.



### Ratio drill RT 100 U, Guhring no. 2477

### Ratio drill RT 100 F, Guhring no. 1660

Thanks to their special cutting edge geometry, Guhring's Ratio drills excel with very good self-centering characteristics and alignment accurate holes. Type U is especially suitable for the machining of steel and high-alloyed AISi-alloys, type F for high-alloyed, stainless, acid- and heat-resistant steels, Al and Al-alloys, Mg and Mg-alloys as well as Ti and Ti-alloys.



All deep hole drills must have support for the pilot hole. Deep hole drills must never operate at full speed without support in the machine shop.










Tool material	Material examples <i>Figures in bold = material no. to DIN EN</i>	Tensile strength MPa (N/mm <sup>2</sup> )	Hard- ness
Common structural steels	<b>1.0035</b> S185. <b>1.0486</b> StE P275N. <b>1.0345</b> P235GH. <b>1.0425</b> P265GH <b>1.0050</b> E295. <b>1.0070</b> E360. <b>1.8937</b> P500NH	≤ 500 > 500-850	
Free-cutting steels	<b>1.0718</b> 11SMnPb30. <b>1.0736</b> 115Mn37 <b>1.0727</b> 46 S20. <b>1.0728</b> 60 S20. <b>1.0757</b> 46SPb20	≤850 850-1000	
Unalloyed heat-treatable steels	<b>1.0402</b> C22. <b>1.1178</b> C30E <b>1.0503</b> C45. <b>1.1191</b> C45E <b>1.0601</b> C60. <b>1.1221</b> C60E	≤700 700-850 850-1000	
Alloyed heat-treatable steels	<b>1.5131</b> 50MnSi4. <b>1.7003</b> 38Cr2. <b>1.7030</b> 28Cr4 <b>1.5710</b> 36NiCr6. <b>1.7035</b> 41Cr4. <b>1.7225</b> 42CrMo4	850-1000 1000-1200	
Unalloyed case hardened steels	<b>1.0301</b> C10. <b>1.1121</b> C10E	≤750	
Alloyed case hardened steels	<b>1.7043</b> 38Cr4 <b>1.5752</b> 14NiCr14. <b>1.7131</b> 16MnCr5. <b>1.7264</b> 20CrMo5	850-1000 1000-1200	
Nitriding steels	<b>1.8504</b> 34CrAl6 <b>1.8519</b> 31CrMoV9. <b>1.8550</b> 34CrAlNi7	850-1000 1000-1200	
Tool steels	<b>1.1750</b> C75W. <b>1.2067</b> 102Cr6. <b>1.2307</b> 29CrMoV9 <b>1.2080</b> X210Cr12. <b>1.2083</b> X42Cr13. <b>1.2419</b> 105WCr6. <b>1.2767</b> X45NiCrMo4	≤850 850-1000	
High speed steels	<b>1.3243</b> S 6-5-2-5. <b>1.3343</b> S 6-5-2. <b>1.3344</b> 61CrV4	≥850-1000	
Spring steels	<b>1.5026</b> 55Si7. <b>1.7176</b> 55Cr3. <b>1.8159</b> 51CrV4		≤330 HB
Stainless steels. sulphured austenitic martensitic	<b>1.4005</b> X12CrS13. <b>1.4104</b> X14CrMoS17. <b>1.4105</b> X6CrMoS17. <b>1.4301</b> X5CrNi18 10. <b>1.4541</b> X6CrNiTi18 10. <b>1.4571</b> X6CrNiMoTi 17 12 2 <b>1.4057</b> X17CrNi16-1. <b>1.4122</b> X39CrMo17-1. <b>1.4521</b> X2CrMoTi18 2	≤850 ≤850 ≤850	
Hardened steels	-		≤40-60 HRC
Special alloys	Nimonic. Inconel. Monel. Hastelloy	≤1200	
Cast iron	<b>0.6010</b> EN-GJL-100 (GG10). <b>0.6020</b> EN-GJL-200 (GG20) <b>0.6025</b> EN-GJL-250 (GG25). <b>0.6035</b> EN-GJL-350 (GG35)		≤240 HB <300 HB
New cast materials GGV	EN-GJV250 (GGV25). EN-GJV350 (GGV35) EN-GJV400 (GGV40). EN-GJV500 (GGV50). SiMo 6		
New cast materials ADI	EN-GJS-800-8 (ADI800). EN-GJS-1000-5 (ADI1000) EN-GJS-1200-2 (ADI1200). EN-GJS-1400-1 (ADI1400)	800-1000 1200-1400	
Spheroidal graphite iron and malleable cast iron	<b>0.7050</b> EN-GJS-500-7 (GGG50). <b>0.8035</b> EN-GJMW-350-4 (GTW35) <b>0.7070</b> EN-GJS-700-2 (GGG70). <b>0.8170</b> EN-GJMB-700-2 (GTS70)		≤240 HB <300 HB
Chilled cast iron	-		≤350 HB
Ti and Ti-alloys	<b>3.7024</b> Ti99.5. <b>3.7114</b> TiAl5Sn2.5. <b>3.7124</b> TiCu2 <b>3.7154</b> TiAl6Zr5. <b>3.7164</b> TiAl6V4. <b>3.7184</b> TiAl4Mo4Sn2.5. - TiAl8Mo1V1	≤850 850-1200	
Aluminium and Al-alloys	<b>3.0255</b> Al99.5. <b>3.2315</b> AlMgSi1. <b>3.3515</b> AlMg1	≤400	
Al wrought alloys	<b>3.0615</b> AlMgSiPb. <b>3.1325</b> AlCuMg1. <b>3.3245</b> AlMg3Si	≤450	
Al cast iron ≤ 10 % Si > 10 % Si	<b>3.2131</b> G-ALSi5Cu1. <b>3.2153</b> G-ALSi7Cu3. <b>3.2573</b> G-ALSi9 <b>3.2581</b> G-ALSi12. <b>3.2583</b> G-ALSi12Cu. - G-ALSi12CuNiMg	≤600 ≤600	
Magnesium alloys	MgMn2. G-MgAl8Zn1. G-MgAl6Zn3	≤450	
Copper. low-alloyed	<b>2.0070</b> SE-Cu. <b>2.1020</b> CuSn6. <b>2.1096</b> G-CuSn5ZnPb	≤400	
Brass. short-chipping langspanend	<b>2.0380</b> CuZn39Pb2. <b>2.0401</b> CuZn39Pb3. <b>2.0410</b> CuZn43Pb2 <b>2.0250</b> CuZn20. <b>2.0280</b> CuZn33. <b>2.0332</b> CuZn37Pb0.5	≤600 ≤600	
Bronze. short-chipping	<b>2.1090</b> CuSn7ZnPb. <b>2.1170</b> CuPb5Sn5. <b>2.1176</b> CuPb10Sn <b>2.0790</b> CuNi18Zn19Pb	≤600 >600-850	
Bronze. long-chipping	<b>2.0916</b> CuAl5. <b>2.0960</b> CuAl9Mn. <b>2.1050</b> CuSn10 <b>2.0980</b> CuAl11Ni. <b>2.1247</b> CuBe2	≤850 850-1000	



# EXCLUSIVE LINE®

## GUHRING NAVIGATOR

Guhring no.  
 Tool material  
 Carbide grade  
 Surface finish  
 Drilling depth

6509		6511				6512				6513				6514	
Solid carbide		Solid carbide				Solid carbide				Solid carbide				Solid carbide	
K30/K40		K30/K40				K30/K40				K30/K40				K30/K40	
TiAlN-tip-coated		TiAlN-tip-coated				TiAlN-tip-coated				TiAlN-tip-coated				TiAlN-tip-coated	
15 x D		20 x D				25 x D				30 x D				40 x D	
															
conventional cooling cool. pressure min. 40 bar		conventional cooling cool. pressure min. 40 bar				conventional cooling cool. pressure min. 40 bar				conventional cooling cool. pressure min. 40 bar				conventional cooling coolant pressure min. 40 bar	
															
V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.	V <sub>c</sub> m/min	Feed col. no.
110	8			110	8			100	8			80	7		
110	8			110	8			100	8			80	7		
120	8			120	8			120	8			100-120	8		
120	8			120	8			100	8			100	8		
110	6			110	6			110	6			110	6		
110	8			110	8			100	8			80	7		
100	7			100	7			100	7			80	7		
110	7	80	7	110	7	80	7	100	7	70	7	80	7	60	6-7
110	6	80	7	110	6	80	7	100	6	70	7	80	6	60	6
110	8			110	8			100	8			80	7		
110	7	80	6-7	110	7	80	6-7	100	7	70	6-7	80	6	60	6-7
110	6	80	6-7	110	6	80	6-7	100	6	70	6-7	80	6	60	6-7
100	5			100	5			80	5			80	5		
80	5			80	5			60	5			60	5		
100	6-7			100	6-7			90	6-7			80	6-7		
80	5			80	5			70	4			70	4		
50	5			50	5			50	4			50	4		
50	5			50	5			50	4			50	4		
100	5			100	5			100	5			80	5		
60-80	2-3			60-80	2-3			60-80	2-3			60-80	2-3		
100	5			100	5			100	5			80	5		
50	4			50	4			50	4			50	4		
30	2			30	2			30	2			30	2		
140	8			140	8			120	8			100	8		
100	8			100	8			90	8			80	8		
100	6			100	6			90	6			80	6		
100	6			100	6			90	6			80	6		
90	8	90	8	90	8	90	8	80	8	80	8	70	8	70	8
140	8			140	8			120	8			100	8		
100	8			100	8			90	8			80	8	65	8
120	1			120	1			120	1			120	1		
120	8			120	8			110	8			100	8		

# EXCLUSIVE LINE®

## RT 100 T – special tools for MQL machining

### Special shank end: RT 100 T for MQL machining

RT 100 T is available as a special tool with the shank end optimised for MQL machining.

Because an extremely low volume of coolant is applied with minimal quantity lubrication, the delivery of these low coolant quantities to the effective area is of utmost importance. The Guhring developed conical shank end optimally satisfies the relevant MQL conditions: It prevents lubricant build-up or dead pockets and offers simple operation and cost-efficient production.

In combination with Guhring hydraulic or shrink fit chucks and the Guhring MQL delivery set, it offers the optimum and cost-efficient solution for MQL machining producing the highest hole quality and extremely long tool life.

### MQL machining opens up a considerable saving potential

A look at the total manufacturing cost shows that conventional cooling is a considerable percentage of it. It doesn't only include the cost of the cooling lubricant itself, but also cleaning the workpiece and systems as well as the disposal of the cooling lubricant. The application of MQL can clearly reduce this part of the cost. Guhring MQL tools offer the prerequisites for a changeover. The RT 100 T with MQL suitable shank end is, for example, optimally suitable for wet machining as well as MQL.

Therefore, changing over your production does not require new tools! In addition, the MQL suitable shank end is designed for 1- as well as 2-channel MQL systems. You do not have to fear any restrictions when applying Guhring MQL tools.



Shank end suitable for minimal quantity lubrication without build-up or dead pockets of coolant.

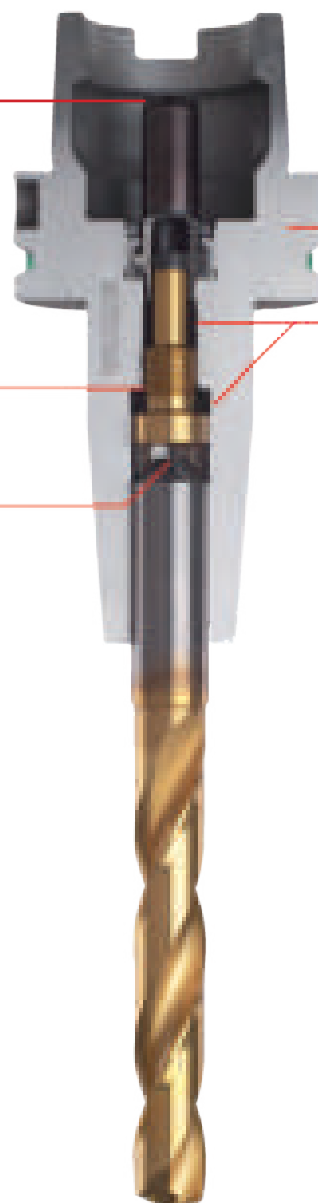
MQL coolant delivery set  
Guhring no. 4939

HSK-A shrink chuck  
Guhring no. 4741

Minimal dead area

Length adjustment screw

MQL suitable shank end



**The Guhring MQL system**  
A MQL optimised drilling tool with Guhring's MQL shank end is located in a hydraulic expansion chuck. The delivery of the coolant is realised by a MQL length adjustment screw with sealing lip.

Guhring has developed the spiral-flute deep hole drill RT 100 T ALU especially for the production of deep holes in aluminium materials. The drill is available as a special tool with immediate effect.

In addition to the correct choice of carbide suitable for the machining of aluminium, Guhring has paid special attention to the cutting edge geometry and the flute form when developing the RT 100 T ALU. They offer the following special features:

### Spiral flutes with 15° rake angle and improved surface quality

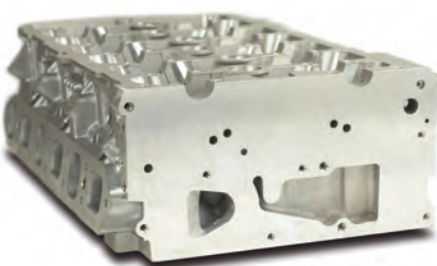


The flute design with a rake angle of 15° ensures a considerably shorter chip travel. In addition, the high surface quality of the flute offers the chips low friction resistance. The RT 100 T ALU evacuates the optimally formed chips efficiently from deep holes without problem.

### Application example cylinderhead

A typical field of application for aluminium materials is the automotive industry and especially engine manufacture. When machining a cylinderhead the spiral-flute deep hole drill RT 100 T ALU's level of performance is impressive:

- drilling the main oil gallery
- Ø 6.95 mm, drilling depth 2 x 210 mm
- drilling from both sides
- $v_c = 110$  m/min.
- $V_f = 1500$  mm/min.
- $p = 50$  bar (soluble oil)
- tool life: 500 m

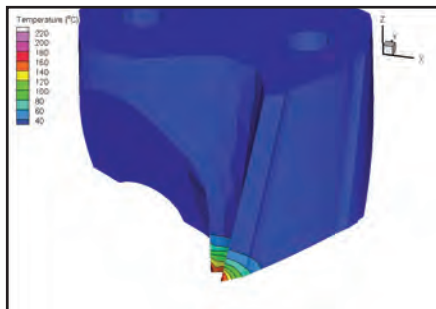


### Optimised cutting edge geometry for the machining of aluminium

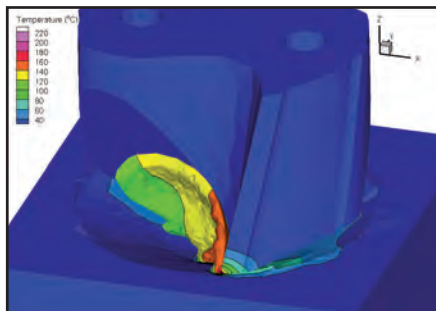
The cutting edge geometry of the spiral-flute deep hole drill RT 100 T ALU is optimised to produce chips that can be evacuated from deep holes as easily as possible.



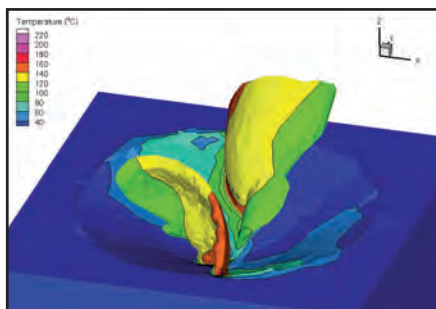
The special design of cutting edge geometry...



... provides optimally formed chips...



... and quick chip evacuation.



### The procedure for machining aluminium

To achieve optimal machining results in the production of deep holes with the RT 100 T ALU particularly when piloting on radii and/or uneven surface, we recommend the following machining steps:

1. Milling of flat, i. e. with Guhring Ratio end mill RF 100 U incl. centre cutting. The flat must be at right angles to the entry of the drilling operation.
2. Producing a cylindrical pilot hole (tolerance F9) with a minimum drilling depth of 1xD (up to 3xD). We recommend our Ratio drill RT 100 U. Thanks to its point angle of 140° and its Ø-tolerance m7 it is ideally suited for this machining step.
3. Entering the spiral-flute deep hole drill RT 100 T ALU in the pilot hole with a speed of appr. 300 rev./min and a feed rate of appr. 500 mm/min.
4. Setting the cooling lubricant pressure and speed.
5. Continuous drilling to full drilling depth without pecking cycle.
6. For through holes with oblique exit reduce the feed rate  $v_f$  appr. 1 mm prior to break-through by 40% .
7. Upon reaching the drilling depth switch off speed and cooling lubricant, withdraw with rapid feed rate.



All deep hole drills must be guided during pilot drilling. Deep hole drills must never operate at full speed unsupported.



Inquiry

Order

Repeat order. no. of initial order

Deep hole gun drill:

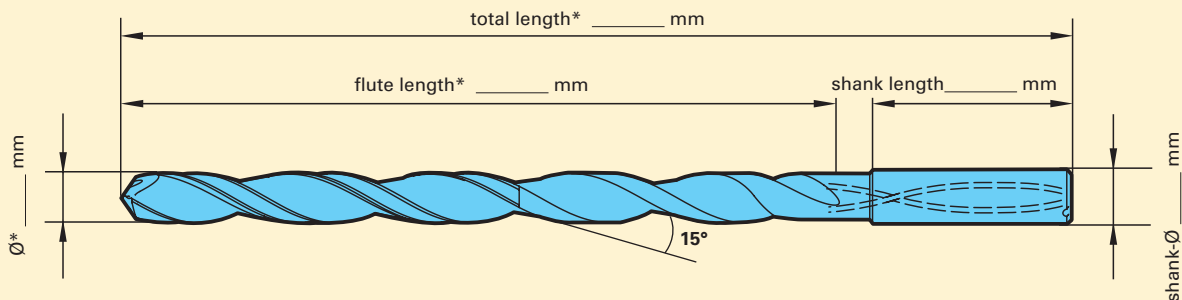
RT 100 T Alu



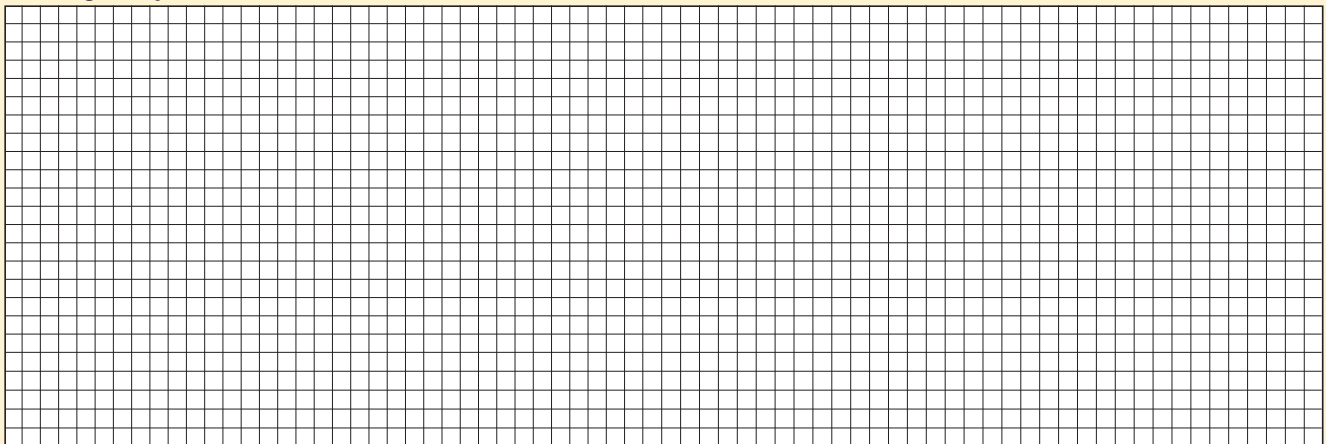
Required no. of pieces: Tool \_\_\_\_\_ pieces

\*  $\varnothing$  3.0 - 14.0 mm  
Drilling depth max. 30 x D  
Total length max. 384 mm

**Attention: not applicable without starting bushing!!**



Drawing of lay-out



required in special cases only

Shank:  HA (recommended)  \_\_\_\_\_

Workpiece: Drilling depth: \_\_\_\_\_ Hole tolerance: \_\_\_\_\_ Material/designation: \_\_\_\_\_  
Surface finish: \_\_\_\_\_ (Aluminium with content Si > 1%)

Machine type:  Machining centre  Turning centre  
 Pilot hole

Machining:  vertical  horizontal

Coolant:  Oil  Soluble oil  MQL  
Pressure \_\_\_\_\_ bar Quantity \_\_\_\_\_ l/min

Company: \_\_\_\_\_

Company stamp:

Telephone/fax: \_\_\_\_\_

Contact: \_\_\_\_\_

Signature: \_\_\_\_\_



## Guhring KG

P.O. Box 100247 · D-72423 Albstadt  
Herderstr. 50-54 · D-72458 Albstadt  
Telephone: +49 74 31 17-0 · www.guehring.de

Re-grinding  
with and without  
re-coating  
to original  
Guhring-quality  
worldwide!



## Our service centers

- |  |   |   |   |
|--|---|---|---|
| 1 Germany<br><i>Albstadt<br/>Sigmaringen-Laiz<br/>Berlin<br/>Chemnitz<br/>Eisenach<br/>Geislingen<br/>Gosheim<br/>Mindelheim<br/>Markt-Erlbach<br/>Saarbrücken</i> | 3 Brazil-Diadema<br>Brazil-Joinville                                | 11 Japan  | 21 Spain  |
| 2 Australia  | 4 China-Changzhou<br>China-Hubei<br>China-Liaoning<br>China-Liuzhou | 12 Korea-Chungcheongnam-do<br>Korea-Incheon<br>Korea-Ulsan City<br>Korea-Rizhao | 22 South Africa   |
|  | 5 France  | 13 Mexico   | 23 Taiwan   |
|  | 6 Great Britain   | 14 Netherlands  | 24 Thailand   |
|  | 7 Indien-Bangalore<br>Indien-Gurgaon<br>Indien-Pune                 | 15 Austria  | 25 Czech Republic   |
|  | 8 Indonesia   | 16 Poland-Dabrowa Gornicza<br>Poland-Bielsko Biala                              | 26 Turkey-Istanbul<br>Turkey-Ankara<br>Turkey-Izmir         |
|  | 9 Ireland   | 17 Rumania  | 27 Hungary  |
|  | 10 Italy  | 18 Russia   | 28 USA-Brookfield<br>USA-New Hudson<br>USA-Huntington Beach |
|  |   | 19 Sweden   | 29 Vietnam  |
|  |   | 20 Switzerland  | 30 Belarus  |

No liability can be accepted for printing errors or technical changes of any kind.  
Our Conditions of Sale and Terms of Payment apply. Available on request.