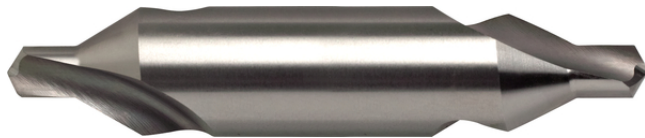


## Product data sheet



Materialnumber	9005810008000
Diameter	0.800 mm
Diameter Range	0.500 - 12.500 mm
Full Length	25.000 mm
Surface	bright
Form	A
Internal Cooling	without

### Characteristics

Internal Cooling	without
Surface	bright
Form	A
Shank Form	straight shank
Norm	DIN 333
Cutting Direction	right-hand
Diameter	0.800 mm
Diameter Shank	0.000 mm
Full Length	25.000 mm
Thickness Clamping	0.000 mm
Angle Step 1	60 °
Angle Step 2	0 °

### Hints

- i** CAD data and further information are available after registration in the shop.
- A** All information is indicative. The actual achievable cutting speeds and feeds depend on the respective processing conditions. We recommend appropriate cutting tests.



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## Cutting data

Subgroup	Strength/Hardness	Cutting speed	Feed	Drive	Feed Rate
Alloyed case hardened steels	1,000 N/mm <sup>2</sup>	15 m/min	0.014 mm/rev.	5,968 rev./min	84 mm/min
Alloyed case hardened steels	1,400 N/mm <sup>2</sup>	8 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Alloyed heat-treatable steels	1,000 N/mm <sup>2</sup>	15 m/min	0.014 mm/rev.	5,968 rev./min	84 mm/min
Alloyed heat-treatable steels	1,400 N/mm <sup>2</sup>	8 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Common structural steels	500 N/mm <sup>2</sup>	30 m/min	0.014 mm/rev.	11,937 rev./min	167 mm/min
Common structural steels	1,000 N/mm <sup>2</sup>	25 m/min	0.014 mm/rev.	9,947 rev./min	139 mm/min
Free-cutting steels	850 N/mm <sup>2</sup>	30 m/min	0.014 mm/rev.	11,937 rev./min	167 mm/min
Free-cutting steels	1,000 N/mm <sup>2</sup>	30 m/min	0.014 mm/rev.	11,937 rev./min	167 mm/min
High speed steels	1,400 N/mm <sup>2</sup>	6 m/min	0.012 mm/rev.	2,387 rev./min	29 mm/min
Nitriding Steels	1,000 N/mm <sup>2</sup>	10 m/min	0.014 mm/rev.	3,979 rev./min	56 mm/min
Nitriding Steels	1,400 N/mm <sup>2</sup>	8 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Spring Steels	350 HB	5 m/min	0.008 mm/rev.	1,989 rev./min	16 mm/min
Stainless steels, austenitic	1,100 N/mm <sup>2</sup>	8 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Stainless steels, martensitic	1,200 N/mm <sup>2</sup>	6 m/min	0.012 mm/rev.	2,387 rev./min	29 mm/min
Stainless steels, sulphured	900 N/mm <sup>2</sup>	10 m/min	0.012 mm/rev.	3,979 rev./min	48 mm/min
Tool Steels	850 N/mm <sup>2</sup>	10 m/min	0.012 mm/rev.	3,979 rev./min	48 mm/min
Tool Steels	1,400 N/mm <sup>2</sup>	6 m/min	0.012 mm/rev.	2,387 rev./min	29 mm/min
Unalloyed heat-treatable steels	700 N/mm <sup>2</sup>	25 m/min	0.014 mm/rev.	9,947 rev./min	139 mm/min
Unalloyed heat-treatable steels	850 N/mm <sup>2</sup>	20 m/min	0.014 mm/rev.	7,958 rev./min	111 mm/min
Unalloyed heat-treatable steels	1,000 N/mm <sup>2</sup>	20 m/min	0.012 mm/rev.	7,958 rev./min	95 mm/min
Unalloyed case hardened steels	850 N/mm <sup>2</sup>	25 m/min	0.016 mm/rev.	9,947 rev./min	159 mm/min
Cast Iron	240 HB	20 m/min	0.018 mm/rev.	7,958 rev./min	143 mm/min
Cast Iron	350 HB	20 m/min	0.016 mm/rev.	7,958 rev./min	127 mm/min
Spheroidal graphite iron and malleable cast iron	240 HB	25 m/min	0.018 mm/rev.	9,947 rev./min	179 mm/min
Spheroidal graphite iron and malleable cast iron	350 HB	20 m/min	0.016 mm/rev.	7,958 rev./min	127 mm/min
Brass long-chipping	600 N/mm <sup>2</sup>	40 m/min	0.016 mm/rev.	15,915 rev./min	255 mm/min
Brass short-chipping	600 N/mm <sup>2</sup>	60 m/min	0.016 mm/rev.	23,873 rev./min	382 mm/min
Bronze long-chipping	850 N/mm <sup>2</sup>	15 m/min	0.014 mm/rev.	5,968 rev./min	84 mm/min
Bronze long-chipping	1,000 N/mm <sup>2</sup>	15 m/min	0.014 mm/rev.	5,968 rev./min	84 mm/min



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Subgroup	Strength/Hardness	Cutting speed	Feed	Drive	Feed Rate
Bronze short-chipping	600 N/mm <sup>2</sup>	30 m/min	0.014 mm/rev.	11,937 rev./min	167 mm/min
Bronze short-chipping	850 N/mm <sup>2</sup>	25 m/min	0.014 mm/rev.	9,947 rev./min	139 mm/min
Copper, low-alloyed	500 N/mm <sup>2</sup>	50 m/min	0.016 mm/rev.	19,894 rev./min	318 mm/min
Al cast alloys	10 %	40 m/min	0.018 mm/rev.	15,915 rev./min	286 mm/min
Al cast alloys	20 %	40 m/min	0.018 mm/rev.	15,915 rev./min	286 mm/min
Al wrought alloys	650 N/mm <sup>2</sup>	70 m/min	0.020 mm/rev.	27,852 rev./min	557 mm/min
Aluminum and Al-alloys	400 N/mm <sup>2</sup>	70 m/min	0.020 mm/rev.	27,852 rev./min	557 mm/min
Magnesium Alloys	450 N/mm <sup>2</sup>	60 m/min	0.018 mm/rev.	23,873 rev./min	430 mm/min
Ti and Ti-alloys	850 N/mm <sup>2</sup>	5 m/min	0.008 mm/rev.	1,989 rev./min	16 mm/min
Ti and Ti-alloys	1,400 N/mm <sup>2</sup>	4 m/min	0.008 mm/rev.	1,592 rev./min	13 mm/min
Duroplastics	150 N/mm <sup>2</sup>	15 m/min	0.014 mm/rev.	5,968 rev./min	84 mm/min
Thermoplastics	100 N/mm <sup>2</sup>	25 m/min	0.016 mm/rev.	9,947 rev./min	159 mm/min
Special Alloys	1,600 N/mm <sup>2</sup>	3 m/min	0.006 mm/rev.	1,194 rev./min	7 mm/min



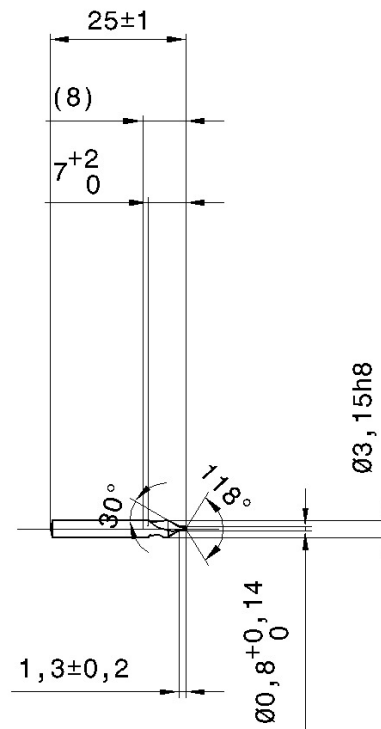
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## Technical drawing



GÜHRING		<p>Diese Zeichnung ist Eigentum der Fa. Gühring KG und darf nicht an Dritte weitergegeben werden.  Bearbeitungs- und Zeichnungsprüfung (auf Richtigkeit und Vollständigkeit) obliegen dem Kunden.</p>
Artikel-Nr.	581 0,800	
Beschreibung	ZENTRIERBOHRER	
Schneidstoff	HSS	
Beschichtung	BLANK	
Kuehlung	-	
Schneiden	2	



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