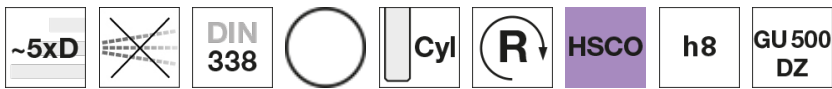


Product data sheet



Materialnumber	9055230010000
Diameter	1.000 mm
Diameter Range	1.000 - 14.290 mm
Maximum drilling depth	10.500 mm
Surface	bright
Type	GU 500 DZ
Internal Cooling	without

Characteristics

Internal Cooling	without
Surface	bright
Type	GU 500 DZ
Shank Form	straight shank
Norm	DIN 338
Tolerance Field	h8
Cutting Direction	right-hand
Diameter	1.000 mm
Diameter Shank	1.000 mm
Full Length	34.000 mm
Flute Length	12.000 mm
Useable Length	11.000 mm
Shank Length	22.000 mm
Mounting, machine side	

Hints

- ❗ CAD data and further information are available after registration in the shop.



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⚠ 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 ²	16 m/min	0.014 mm/rev.	5,093 rev./min	71 mm/min
Alloyed case hardened steels	1,400 N/mm ²	12 m/min	0.012 mm/rev.	3,820 rev./min	46 mm/min
Alloyed heat-treatable steels	1,000 N/mm ²	15 m/min	0.014 mm/rev.	4,775 rev./min	67 mm/min
Alloyed heat-treatable steels	1,400 N/mm ²	13 m/min	0.012 mm/rev.	4,138 rev./min	50 mm/min
Common structural steels	500 N/mm ²	35 m/min	0.018 mm/rev.	11,141 rev./min	201 mm/min
Common structural steels	1,000 N/mm ²	30 m/min	0.016 mm/rev.	9,549 rev./min	153 mm/min
Free-cutting steels	850 N/mm ²	40 m/min	0.018 mm/rev.	12,732 rev./min	229 mm/min
Free-cutting steels	1,000 N/mm ²	30 m/min	0.018 mm/rev.	9,549 rev./min	172 mm/min
High speed steels	1,400 N/mm ²	10 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Nitriding Steels	1,000 N/mm ²	15 m/min	0.014 mm/rev.	4,775 rev./min	67 mm/min
Nitriding Steels	1,400 N/mm ²	10 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Stainless steels, austenitic	1,100 N/mm ²	10 m/min	0.014 mm/rev.	3,183 rev./min	45 mm/min
Stainless steels, martensitic	1,200 N/mm ²	12 m/min	0.014 mm/rev.	3,820 rev./min	53 mm/min
Stainless steels, sulphured	900 N/mm ²	14 m/min	0.014 mm/rev.	4,456 rev./min	62 mm/min
Tool Steels	850 N/mm ²	15 m/min	0.014 mm/rev.	4,775 rev./min	67 mm/min
Tool Steels	1,400 N/mm ²	10 m/min	0.012 mm/rev.	3,183 rev./min	38 mm/min
Unalloyed heat-treatable steels	700 N/mm ²	32 m/min	0.018 mm/rev.	10,186 rev./min	183 mm/min
Unalloyed heat-treatable steels	850 N/mm ²	28 m/min	0.018 mm/rev.	8,913 rev./min	160 mm/min
Unalloyed heat-treatable steels	1,000 N/mm ²	20 m/min	0.016 mm/rev.	6,366 rev./min	102 mm/min
Unalloyed case hardened steels	850 N/mm ²	30 m/min	0.018 mm/rev.	9,549 rev./min	172 mm/min
Cast Iron	240 HB	36 m/min	0.018 mm/rev.	11,459 rev./min	206 mm/min
Cast Iron	350 HB	30 m/min	0.018 mm/rev.	9,549 rev./min	172 mm/min
Spheroidal graphite iron and malleable cast iron	240 HB	30 m/min	0.018 mm/rev.	9,549 rev./min	172 mm/min
Spheroidal graphite iron and malleable cast iron	350 HB	22 m/min	0.018 mm/rev.	7,003 rev./min	126 mm/min
Brass long-chipping	600 N/mm ²	30 m/min	0.016 mm/rev.	9,549 rev./min	153 mm/min
Brass short-chipping	600 N/mm ²	45 m/min	0.016 mm/rev.	14,324 rev./min	229 mm/min
Bronze long-chipping	850 N/mm ²	30 m/min	0.014 mm/rev.	9,549 rev./min	134 mm/min
Bronze long-chipping	1,000 N/mm ²	25 m/min	0.014 mm/rev.	7,958 rev./min	111 mm/min
Bronze short-chipping	600 N/mm ²	36 m/min	0.014 mm/rev.	11,459 rev./min	160 mm/min



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Subgroup	Strength/Hardness	Cutting speed	Feed	Drive	Feed Rate
Bronze short-chipping	850 N/mm ²	30 m/min	0.014 mm/rev.	9,549 rev./min	134 mm/min
Copper, low-alloyed	500 N/mm ²	70 m/min	0.016 mm/rev.	22,282 rev./min	357 mm/min
Al cast alloys	10 %	65 m/min	0.020 mm/rev.	20,690 rev./min	414 mm/min
Al cast alloys	20 %	60 m/min	0.018 mm/rev.	19,099 rev./min	344 mm/min
Al wrought alloys	650 N/mm ²	50 m/min	0.020 mm/rev.	15,915 rev./min	318 mm/min
Aluminum and Al-alloys	400 N/mm ²	50 m/min	0.020 mm/rev.	15,915 rev./min	318 mm/min
Magnesium Alloys	450 N/mm ²	60 m/min	0.018 mm/rev.	19,099 rev./min	344 mm/min
Duroplastics	150 N/mm ²	20 m/min	0.014 mm/rev.	6,366 rev./min	89 mm/min
Thermoplastics	100 N/mm ²	15 m/min	0.014 mm/rev.	4,775 rev./min	67 mm/min



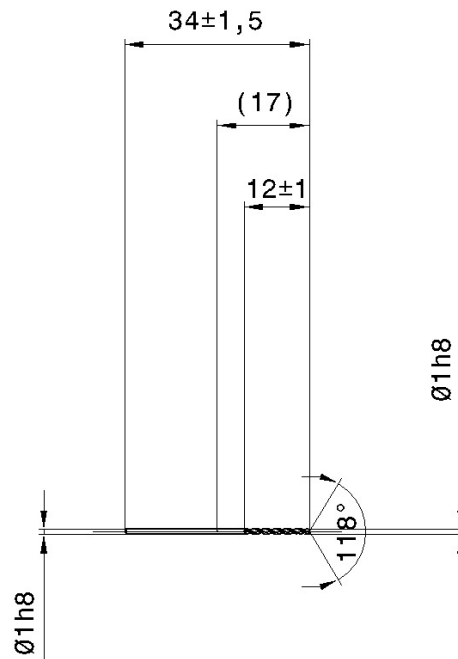
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Technical drawing



GÜHRING	
Artikel-Nr.	5523 1,000
Beschreibung	SPIRALBOHRER
Schneidstoff	HSCO
Beschichtung	BLANK
Kuehlung	-
Schneiden	2

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